

**PP&L**

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September 13, 1979

Mr. Robert T. Carlson  
Chief FS & ES Branch  
U. S. Nuclear Regulatory Commission  
631 Park Avenue  
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SUSQUEHANNA STEAM ELECTRIC STATION  
NRC INSPECTION OF MAY 15-18, 1979  
REPORT NO. 50-387/79-19  
ERs 100450                      FILE 840-4  
PLA-400

Dear Mr. Carlson:

Reference is to your letter of August 20, 1979 forwarding IE Inspection Report No. 50-387/79-19 and Enclosure (1) thereto, "Appendix A, Notice of Violation".

Your letter advised that PP&L was to submit, within thirty (30) days of receipt, a written explanation addressing (1) corrective steps which have been taken and the results achieved, (2) corrective steps which have been taken to avoid further items of noncompliance, and (3) the date when full compliance will be achieved.

The Notice of Violation (Infraction) states as follows and the corrective measures are detailed below:

Criterion V of 10 CFR 50, Appendix B, states, in part, that: "Activities affecting quality shall be prescribed by documented instructions...and shall be accomplished in accordance with these instructions...".

The Susquehanna PSAR, Appendix D.3.3.7, states, in part: "Use of qualified procedures and application thereof as required by established standards will be rigidly enforced...".

The Technical Specification for Field Fabrication and Installation of Nuclear Service Piping, M-204, Paragraph 6.2.3, states, in part: "...all welding shall meet the following requirements. (f) Where piping or fittings to be joined have equal outside diameters, the weld shall be crowned at the center and tapered on each side to the surface being joined."

Contrary to the above, on May 15, 1979, the 20-inch diameter, nuclear class 1 weld joint DCA-108-1-FW-1 was not tapered from the crown to the surfaces being joined."

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(1) Corrective steps which have been taken and the results achieved:

Nonconformance Report 3879 was written by Bechtel Welding Quality Control during the NRC inspection to address the notch effect of DCA-108-1, field weld 1. The following rework of DCA-108-1, FW1 was performed in accordance with the Field Engineering disposition of NCR-3879.

- (a) Ultrasonic thickness measurements were taken of the field weld and all to determine the actual thickness..
- (b) The weld cap was ground and the toe of the weld tee was blended to remove the notch effect.
- (c) After the notch effect was removed, ultrasonic thickness measurements were taken of the weld to verify that the minimum wall (.902") requirement had not been violated.
- (d) A liquid penetrant examination of the ground areas of the weld was performed.

The NCR disposition was concurred with and rework activities were inspected and accepted by Bechtel Quality Control and Bechtel's Authorized Nuclear Inspector.

(2) Corrective steps which have been taken to avoid further items of noncompliance:

An additional six similar Nuclear, ASME Section III Class 1 welds were visually reexamined by Bechtel Welding Quality Control to determine if a notch condition existed. Weld crown and tapers of the selected welds were found to be acceptable. The results of this visual inspection were documented on Field Inspection Report CAR/NCR-3879 which is attached to NCR-3879. Therefore, the discrepant weld, DCA-108-1, FW1, is considered to have been an isolated incident.

A training session was presented to all Bechtel Quality Control engineers assigned to ASME weld inspection activities. The subject of the training session was "Stress Riser Geometry and Notch Effect Conditions on Transition Welds".

(3) The date when full compliance was achieved:

The Bechtel Quality Control training session was conducted on 5/17/79. The reexamination of the six additional welds was completed on 5/17/79. The rework of DCA-108-1, FW-1, was completed on 5/18/79 and signed off on 5/21/79.

We trust the Commission will concur that the actions taken to date are adequate.

Very truly yours,



A. R. Sabol

Manager-Nuclear Quality Assurance

Mr. Robert T. Carlson

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ARS:mcb

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