



Houston Lighting & Power Company

Electric Tower
P.O. Box 1700
Houston, Texas 77001

November 3, 1978

ST-HL-AE-300
SFN: C-0570

Mr. W. C. Seidle, Chief
Reactor Construction & Engineering
Support Branch
U.S. Nuclear Regulatory Commission
Office of Inspection and Enforcement
Region IV
611 Ryan Plaza Drive, Suite 1000
Arlington, TX 76012

SUBJECT: RESPONSE TO NRC INSPECTION FINDINGS
SOUTH TEXAS PROJECT ELECTRIC GENERATING STATION
DOCKET NOS. 50-498/78-15 AND 50-499/78-15

Dear Mr. Seidle:

The following is Houston Lighting & Power Company's (HL&P) response to the items of noncompliance identified in IE Inspection Report Nos. 50-498/78-15 and 50-499/78-15 dated October 6, 1978.

A) Failure to Follow Cadweld Procedures

1) Corrective Action Taken

A visual cadweld reinspection program was instituted by both Brown & Root (B&R) and HL&P QA. An aggregate total of 1268 cadwelds were reinspected. B&R's reinspection effort was specifically limited to cadwelds shot at night during the period of September 6, 7, 8, and 11 totaling 535 cadwelds. HL&P's effort was directed at reinspecting all cadwelds accessible in both Unit 1 & 2, totaling 733 cadwelds. Additionally, two cadwelds produced by each second shift cadwelder during this time frame were cut out and pull-tested. Included in this sample were the cadwelds of cadwelder nos. 33 and 54. Cadweld 54V47, which contained the rejectable void concealed by a piece of wire, was cut out and pull-tested. Of the 1268 cadwelds visually inspected only one failed, however, all that were pull-tested met the acceptance criteria.

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As part of the visual examination, a check for centering was performed but actual centering could not be verified. Nevertheless, since cadwelding operations commenced in April of 1976 a total of 553 cadweld splices have been pull-tested and only one pull out failure (at 72,435 psi) has occurred. Because of these test results, we are confident that the installed cadwelds meet our project design requirements.

2) Recurrence Control

A training session for both cadwelders and inspectors has been given to assure proper understanding of the procedural requirements. The cadweld procedures have been revised after discussions with the cadweld material manufacturer to control those parameters which are essential to production of acceptable cadwelds. Additional inspectors have been assigned to both day and night shifts to perform surveillance on the cadweld process.

B) Failure to Provide Specified Inprocess Inspection

1) Corrective Action Taken

Cadweld inspectors have been assigned to both shifts.

2) Recurrence Control

The B&R procedure now requires that cadwelder surveillance be performed on a "per shift" basis rather than on a "per 24 hour day" basis.

Full compliance with the described corrective action has been achieved since September 20, 1978.

Very truly yours,



E. A. Turner, Vice President
Power Plant Construction &
Technical Services

EAT/cas

cc: Messrs. R. A. Frazar
D. G. Barker
H. L. Key