

ENCLOSURE  
HARTSVILLE NUCLEAR PLANTS A AND B AND PHIPPS BEND NUCLEAR PLANT  
INCORRECT ROOT FACE ON SKEWED CADWELD SLEEVES  
NCR CEB 80-11  
10CFR50.55(e)  
REPORT NO. 1 (INTERIM)

On March 14, 1980, TVA informed NRC-OIE Region II Inspector, R. W. Wright, of a potentially reportable condition under 10CFR50.55(e) regarding the adequacy of welds on skewed cadweld sleeves due to the incorrect root face. This is the first interim report on this deficiency. TVA anticipates transmitting the next report on or before June 20, 1980.

Description of Deficiency

Root face on No. 18 skewed cadweld sleeves, manufactured by ERICO, Cleveland, Ohio, varies from 3/32 inch to 1/2 inch. Since the design was based on an assumed 1/16-inch root face, the necessary weld penetration has not been achieved. The cadweld sleeves in question are welded to drywell-framed embedments and main steam tunnel embedments at an angle of 45 degrees. These embedments are fabricated by Atlas Machine and Iron Works, Gainesville, Virginia. The ERICO drawing shows a 1/16-inch root face.

Corrective Action

The cadweld sleeves to be used in future fabrications have been delivered to Atlas. Atlas has fabricated some representative structures using the same welding process used for structures already fabricated and sleeves with the worst case root face (1/2 inch). Because the geometry of the skewed cadweld precludes ordinary material or bend tests, a destructive pull test will be performed. The structure to be pulled will be made of two counterposed skewed cadweld sleeves, both welded to an A572 V55, 1-1/2-inch plate (see attachment). The pull tests will be witnessed by GE/C. F. Braun, who will determine the adequacy of the welds and what corrective action, if any, is required. The results of this evaluation will be provided in the final report.

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