

December 1, 1980  
L-80-394

*Central file*

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Mr. James P. O'Reilly, Director, Region II  
Office of Inspection and Enforcement  
U. S. Nuclear Regulatory Commission  
101 Marietta Street, Suite 3100  
Atlanta, Georgia 30303

Dear Mr. O'Reilly:

Re: RII:JPO  
50-389  
IE Bulletin 80-08

On September 29, 1980 (L-80-323), Florida Power & Light Company (FPL) submitted a final response to the NRC regarding the information requested in IE Bulletin 80-08. During a site inspection on October 27, 1980, several questions were raised by the NRC inspectors regarding the interpretation of information included in the response.

In order to clarify the previously submitted information and eliminate any further misinterpretation, we have provided below and in the attached figures, all the necessary data requested in the bulletin.

- (1) Both flued head designs and other designs with containment boundary butt weld(s) between the penetration sleeve and process piping are utilized in St. Lucie Unit 2.
- (2a) ASME Section III Code utilized by the vendor: 1971 edition through Winter 1973 addenda.  
ASME Section II Code utilized by construction: 1977 edition through Summer of 1977 addenda.
- (2b) As a minimum, all subject welds have been or will be radiographed.
- (2c) All subject butt welds are shown on the attached figures. These figures provide the base metal and size for the process pipe, sleeve and/or flued head, as appropriate. Backing bars are not used on the subject butt welds.
- (2d) The results of nondestructive examinations are shown on the attached figures.
- (3) This item is not applicable since one of the volumetric examinations performed is radiography.

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Department of Justice

Office of Inspection and Enforcement  
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As indicated in the previous letter, FPL considers all items of IE Bulletin 80-08 to be closed out on the basis that ultrasonic testing is not conducted, that no backing bars are utilized, and that radiography is one of the methods required for acceptance of all subject butt welds.

Very truly yours,

*J. A. De Mastry*  
*for*

Robert E. Uhrig  
Vice President  
Advanced Systems & Technology

REU/TCG/ah

Attachments

cc: U. S. Nuclear Regulatory Commission  
Director, Division of Reactor Construction and Inspection  
Washington, D. C. 20555

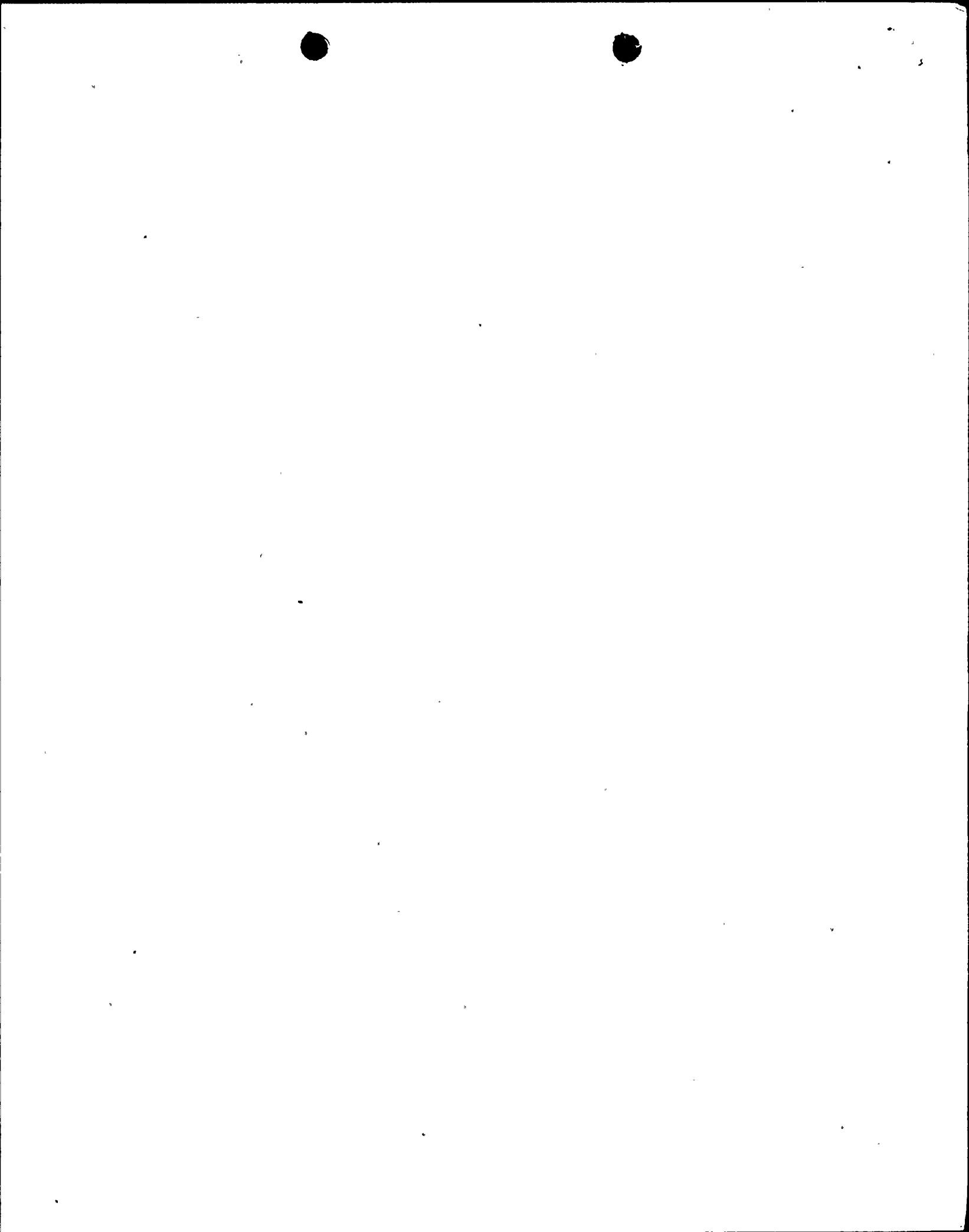
Harold F. Reis, Esquire

Florida Power & Light Company  
St Lucie Unit 2

Index to Containment Vessel  
Piping Penetrations

INDEX

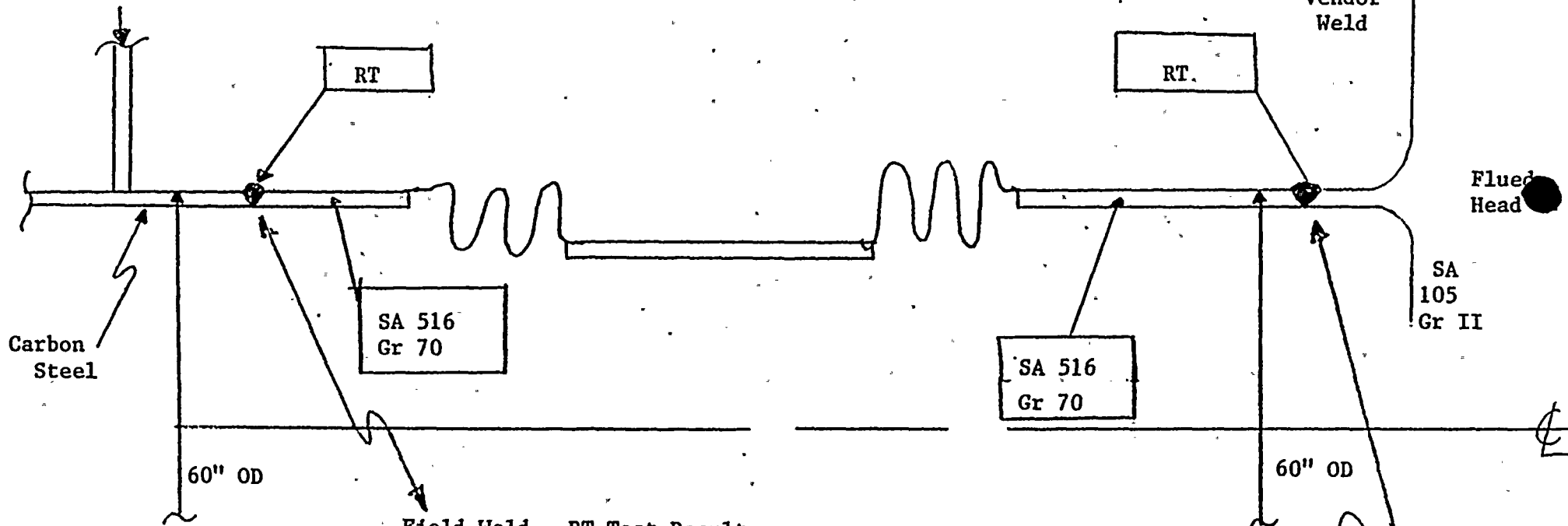
<u>Penetration #</u>	<u>System</u>	<u>For Details, see sheet</u>
1	Main Steam	1
2	Main Steam	1
3	Feedwater	2
4	Feedwater	2
5	Blowdown	3
6	Blowdown	3
7	Primary Water Supply	4
8	Station Air Supply	5
9	Instrument Air Supply	6
10	H&V Containment Purge	Not Applicable
11	H&V Containment Purge	Not Applicable
12	This number is not used	Not Applicable
13	This number is not used	Not Applicable
14	Nitrogen Supply	7
15	CCW Return Fan Cooler	Not Applicable
16	CCW Supply Fan Cooler	Not Applicable
17	CCW Return Fan Cooler	Not Applicable
18	CCW Supply Fan Cooler	Not Applicable
19	CCW Return Fan Cooler	Not Applicable
20	CCW Supply Fan Cooler	Not Applicable
21	CCW Return Fan Cooler	Not Applicable
22	CCW Supply Fan Cooler	Not Applicable
23	Water Supply to RCP's	Not Applicable
24	Water Return from RCP's	Not Applicable
25	Fuel Transfer Tube	8
26	Letdown Line	9
27	Charging Line	10
28	Sampling Hot Leg	11
29	Sampling Pressurizer Steam Space	11
30	Blowdown	11
31	Containment Vent Header	Not Applicable
32	Containment Sump Suction	12
33	Containment Sump Suction	12
34 A&B	Containment Spray	Not Applicable
35 A&B	Containment Spray	Not Applicable
36	Containment Spray	13
37	Safety Injection Loop	13
38	Safety Injection Loop	13
39	Safety Injection Loop	13
40	Shutdown Cooling	14
41	SIT Test	15
42	Containment Sump Pump Discharge	Not Applicable
43	Reactor Drain Pump Suction	16



Penetration #SystemFor Details, see sheet

44	RCP's Controlled Bleedoff	17
45	Diff Pressure between inside Containment & Annulus	11
46	Refueling Cavity Purification inlet	18
47	Refueling Cavity Purification outlet	18
48	H <sub>2</sub> Sampling	11
49	Blowdown	11
50	Spare	Not Applicable
51	H <sub>2</sub> Sampling	11
52	IKLT Instrumentation	19
53	Diff Pressure between Inside Containment & Annulus	11
54	ILRT	20
55	Spare	Not Applicable
56	H&V Purge Inlet	Not Applicable
57	H&V Purge Outlet	Not Applicable
58	Spare	Not Applicable
59	SBVS	Not Applicable
60	SBVS	Not Applicable
61	Spare	Not Applicable
62	Instrument Air to Construction Hatch	Not Applicable
63	This number is not used	Not Applicable
64	Shutdown Cooling	14
65	Spare	Not Applicable
66	Spare	Not Applicable
67	H&V Vacuum Relief	Not Applicable
68	H&V Vacuum Relief	Not Applicable
69	Hot Leg 2B Injection	21
70	Hot Leg 2B Injection	21
71	Spare	Not Applicable
72	Spare	Not Applicable

Inside Containment Outside  
Vessel



Field Weld - RT Test Results

- Pen 1 - Not Complete
- Pen 2 - Not Complete

Vendor Weld - RT Test Results

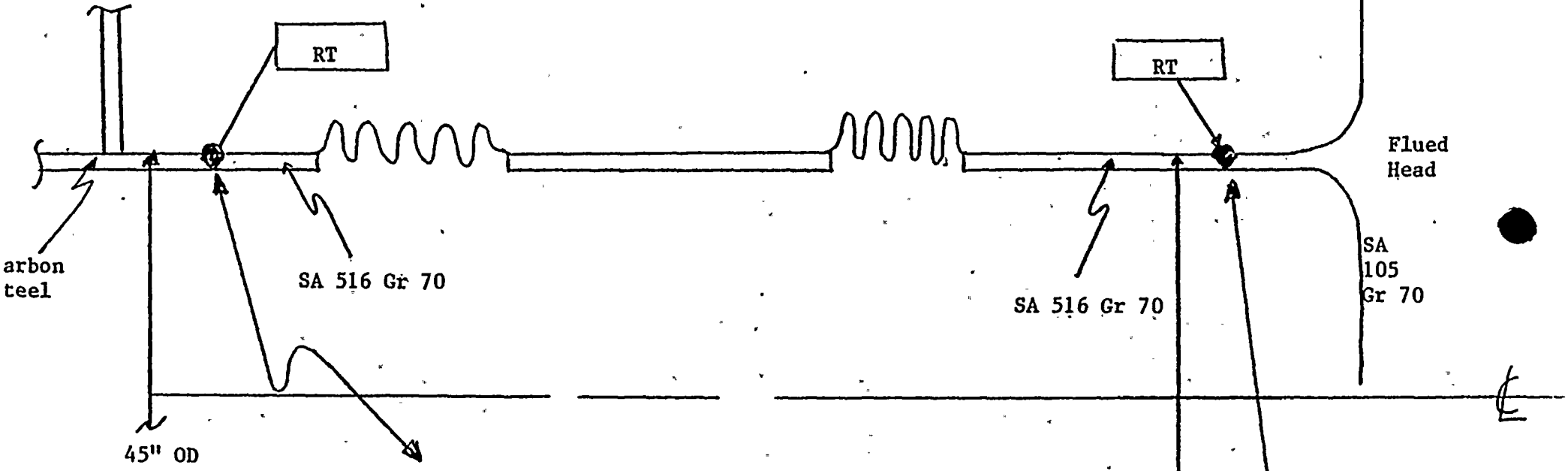
- Pen 1 - Repair for lack of fusion, penetration and slag
- Pen 2 - Repaired for lack of fusion, slag

For Details refer to Mfg. Dwgs.

- 998-1983
- 998-1985
- 998-1987
- 998-1989

Penetrations 1 and 2  
Sheet 1 of 21

Inside Containment Vessel Outside



Field Weld - RT Test Results

Pen 3 - Not Complete  
Pen 4 - Not Complete

45" OD

Vendor Weld - RT Test Results

Pen 3 - No Repair  
Pen 4 - Repaired for unmelted ins

For Details Refer to Mfg. Dwgs.

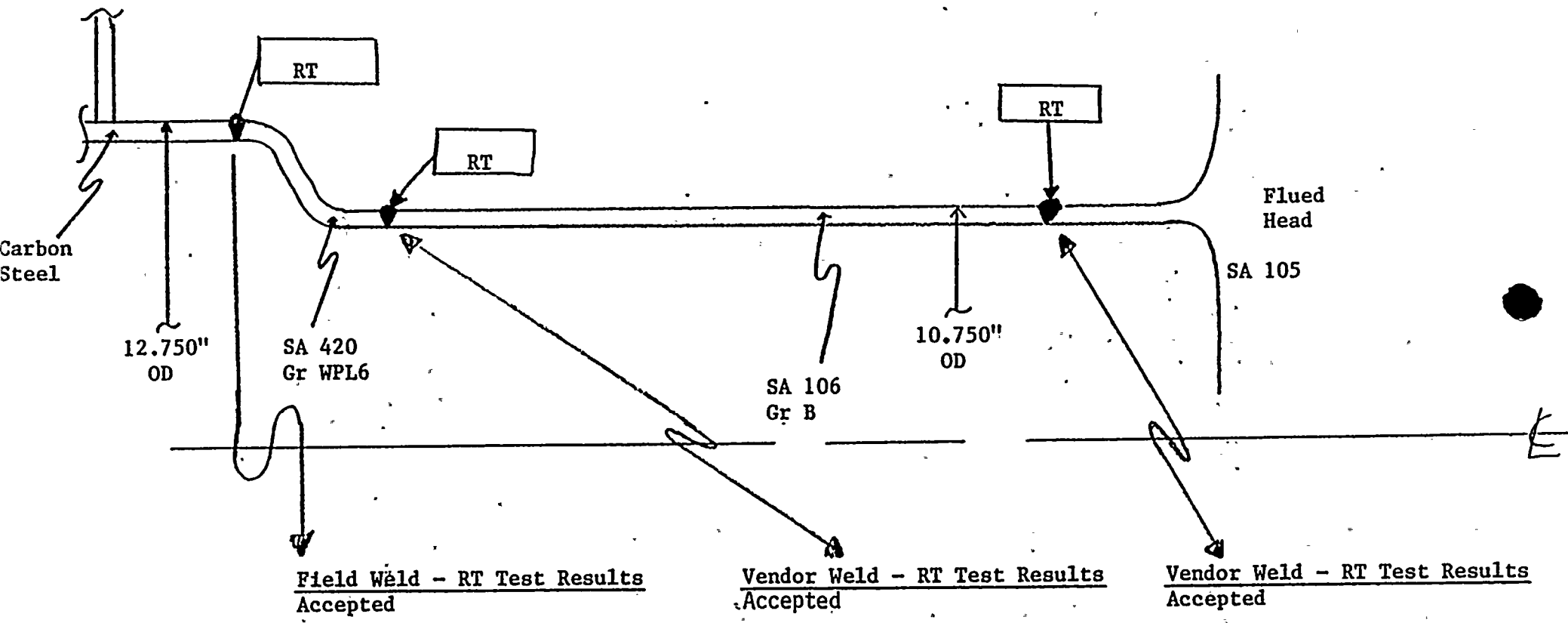
2998-1991	2998-1995
2998-1993	2998-1997

Penetrations 3 and 4

Sheet 2 of 21



Inside Containment Outside  
Vessel



Field Weld - RT Test Results Accepted

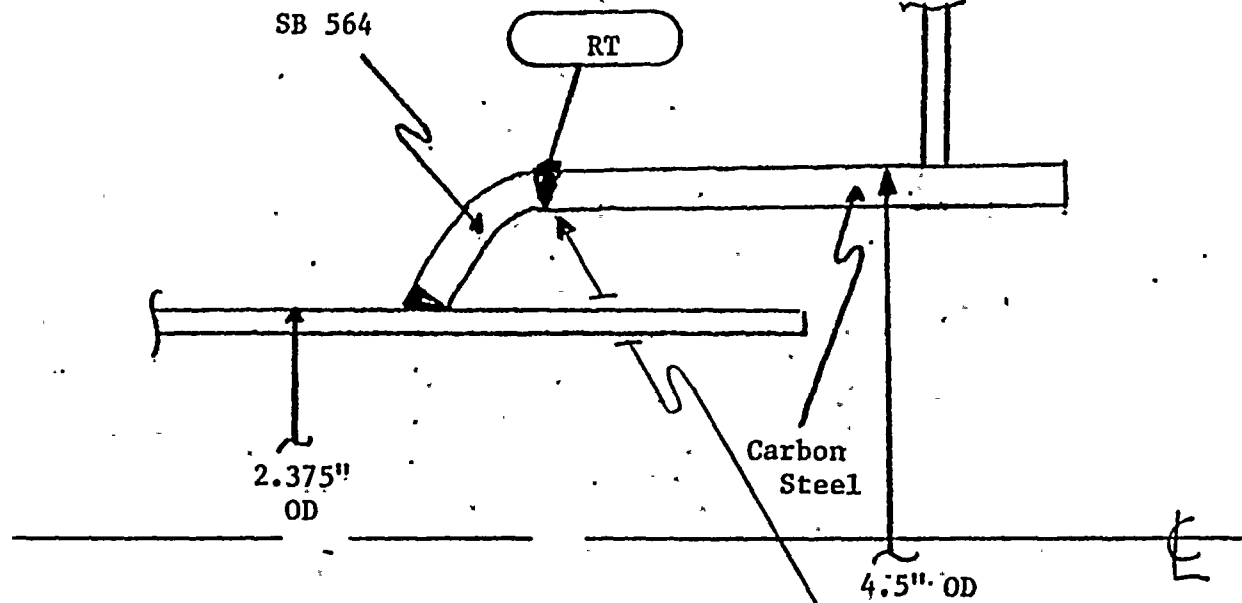
Vendor Weld - RT Test Results Accepted

Vendor Weld - RT Test Results Accepted

For Details refer to Mfg. Dwgs.  
2998-1999

Penetrations 5 and 6  
Sheet 3 of 21

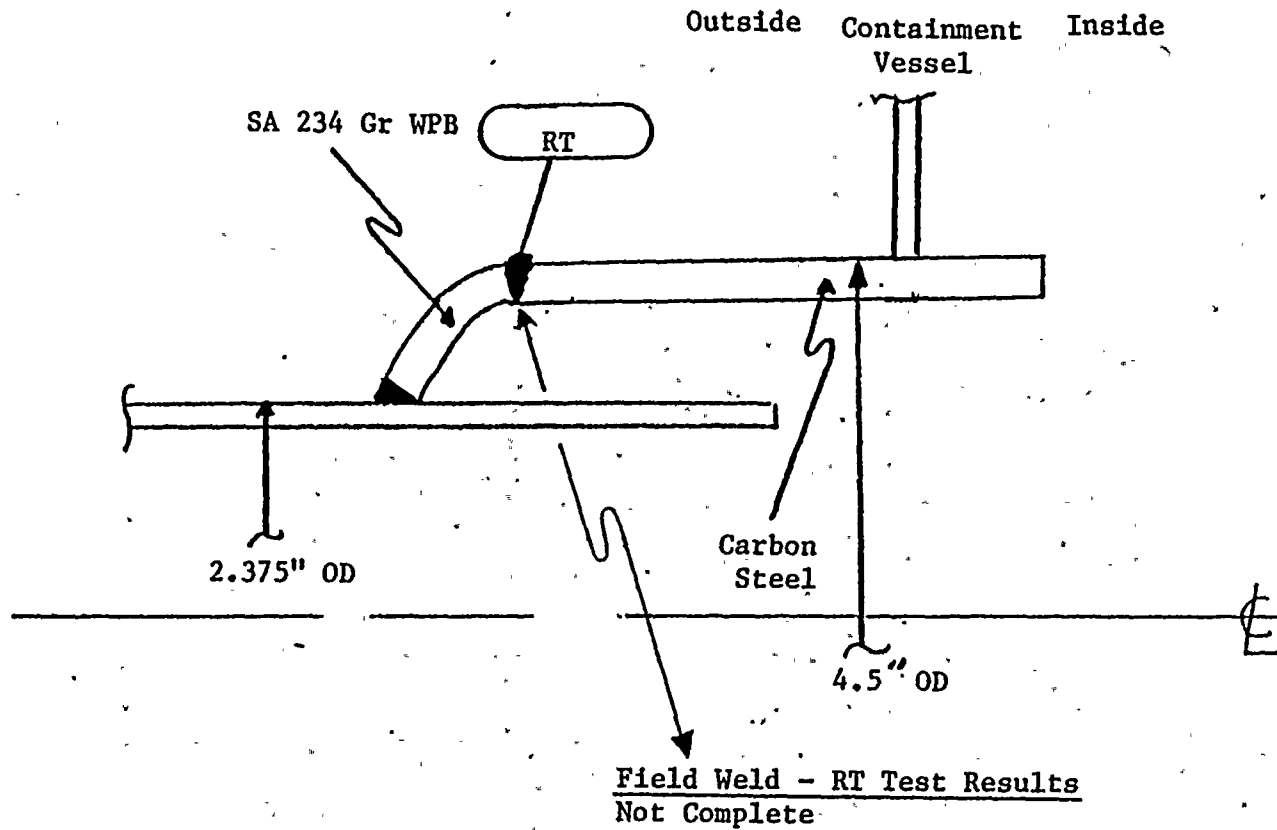
Outside Containment Inside  
Vessel



Field Weld - RT Test Results  
Not Complete

For Details refer to Mfg. Dwgs.  
2998-2000

Penetration 7  
Sheet 4 of 21

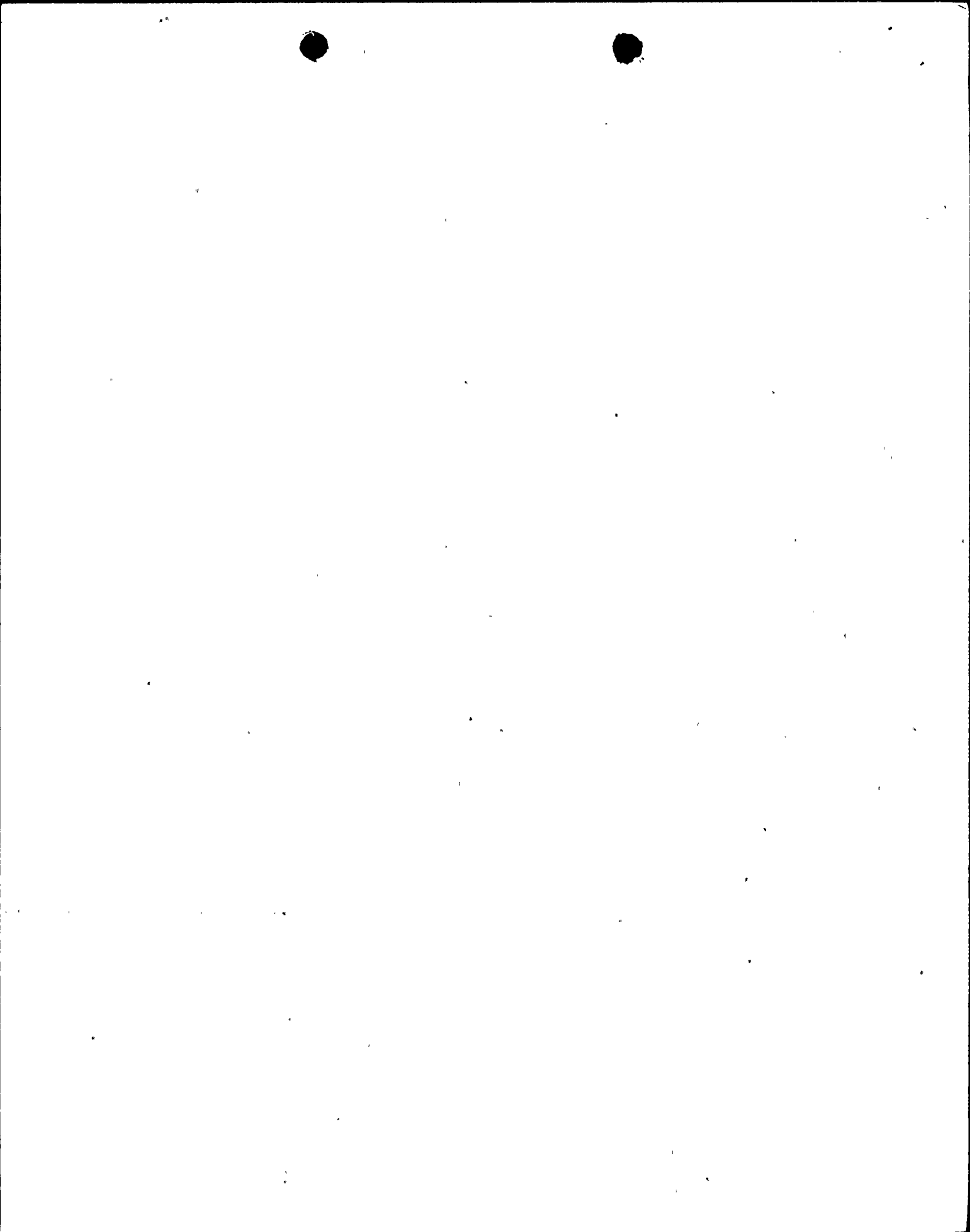


For Details refer to Mfg. Dwgs.

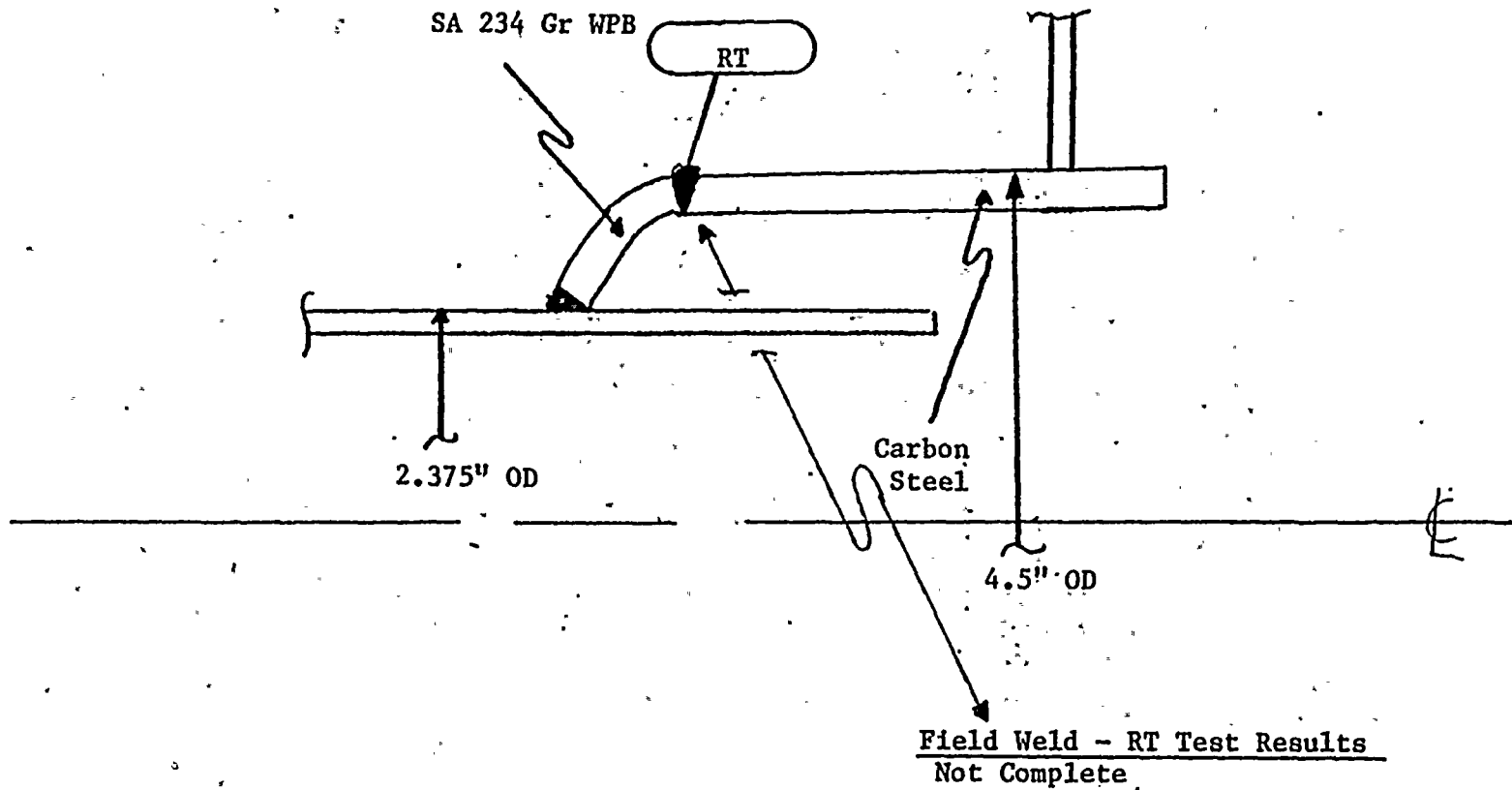
2998-2001

Penetration 8

Sheet 5 of 21

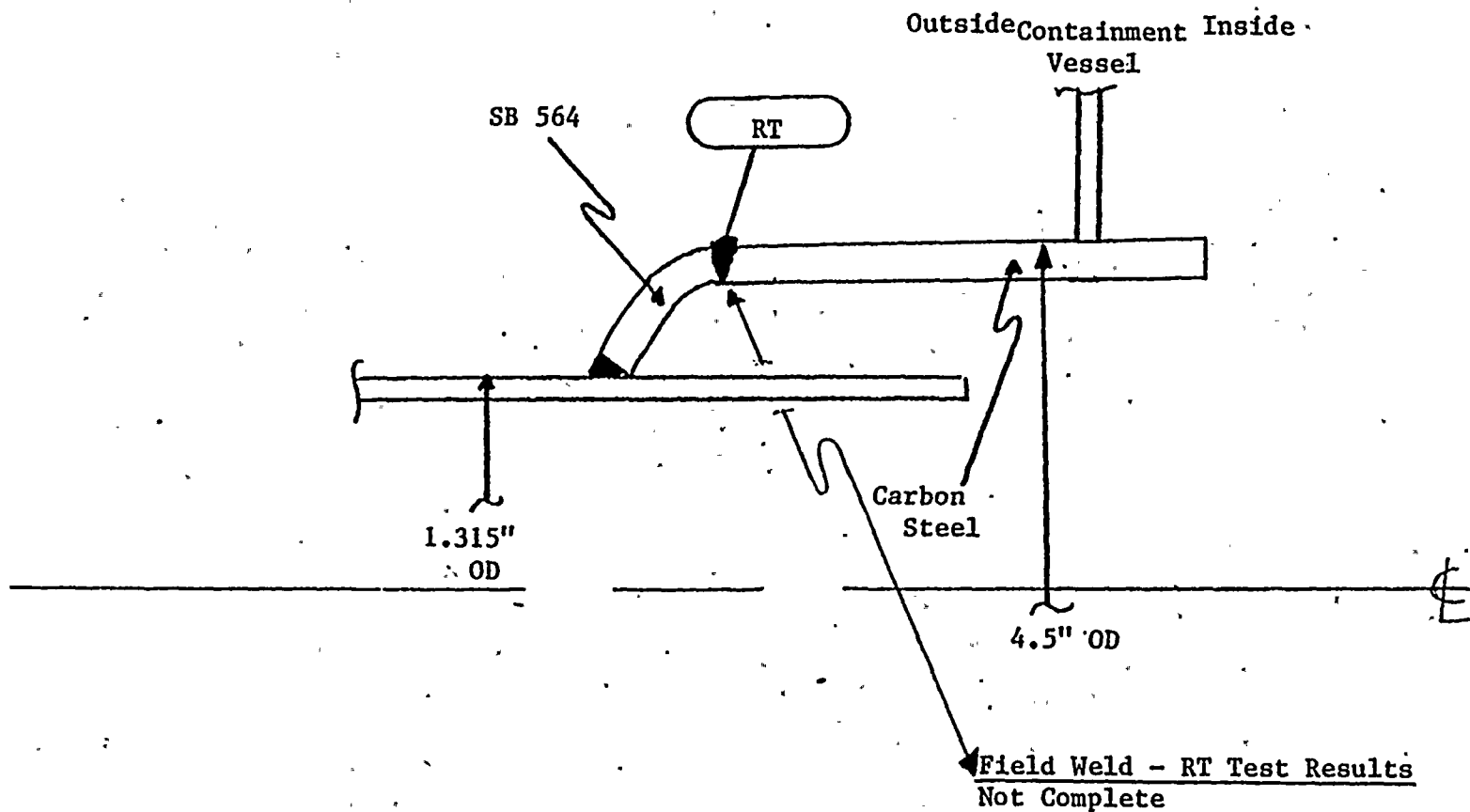


Outside Containment Vessel Inside



For Details refer to Mfg. Dwgs.  
2998-2929

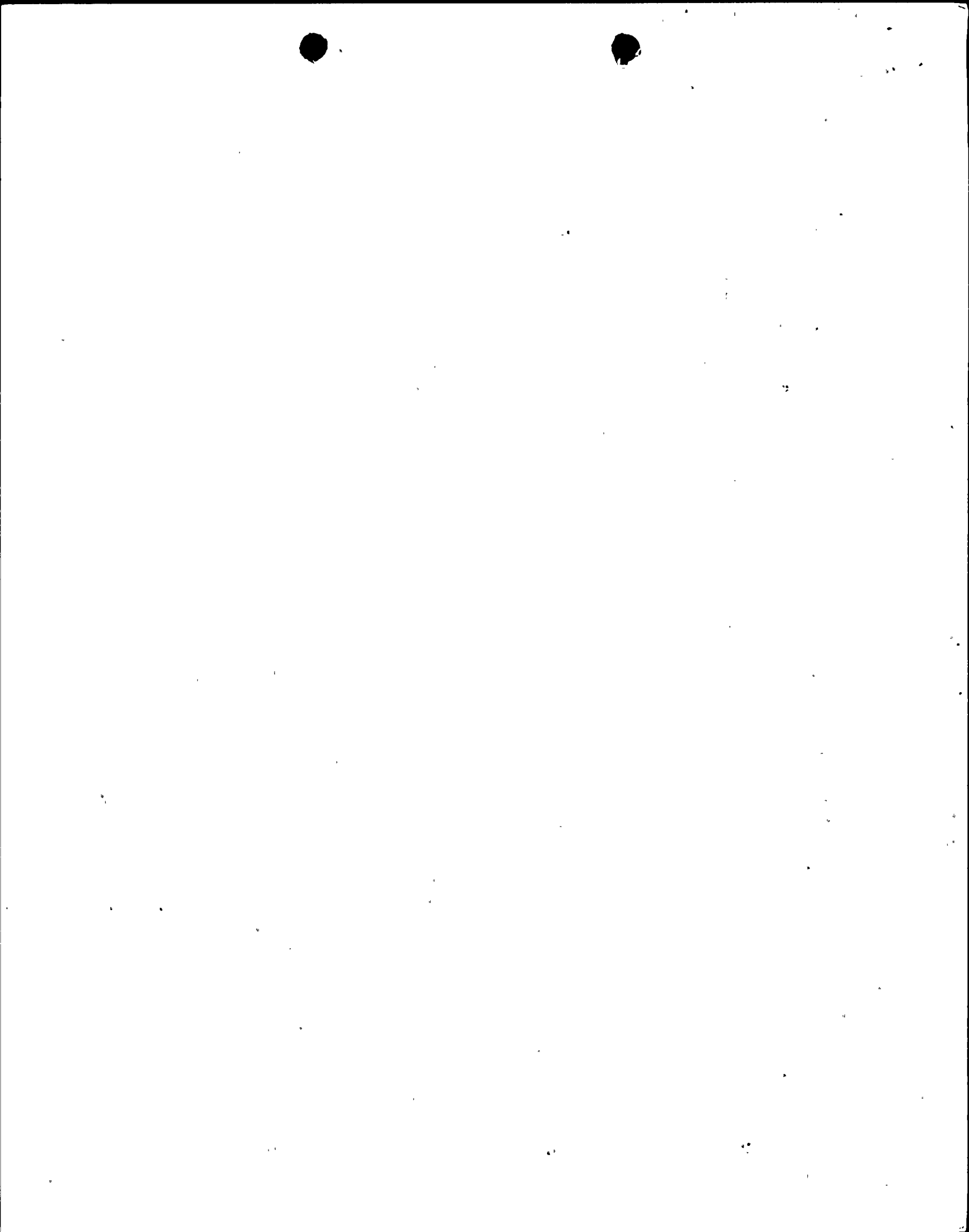
Penetration 9  
Sheet 6 of 21

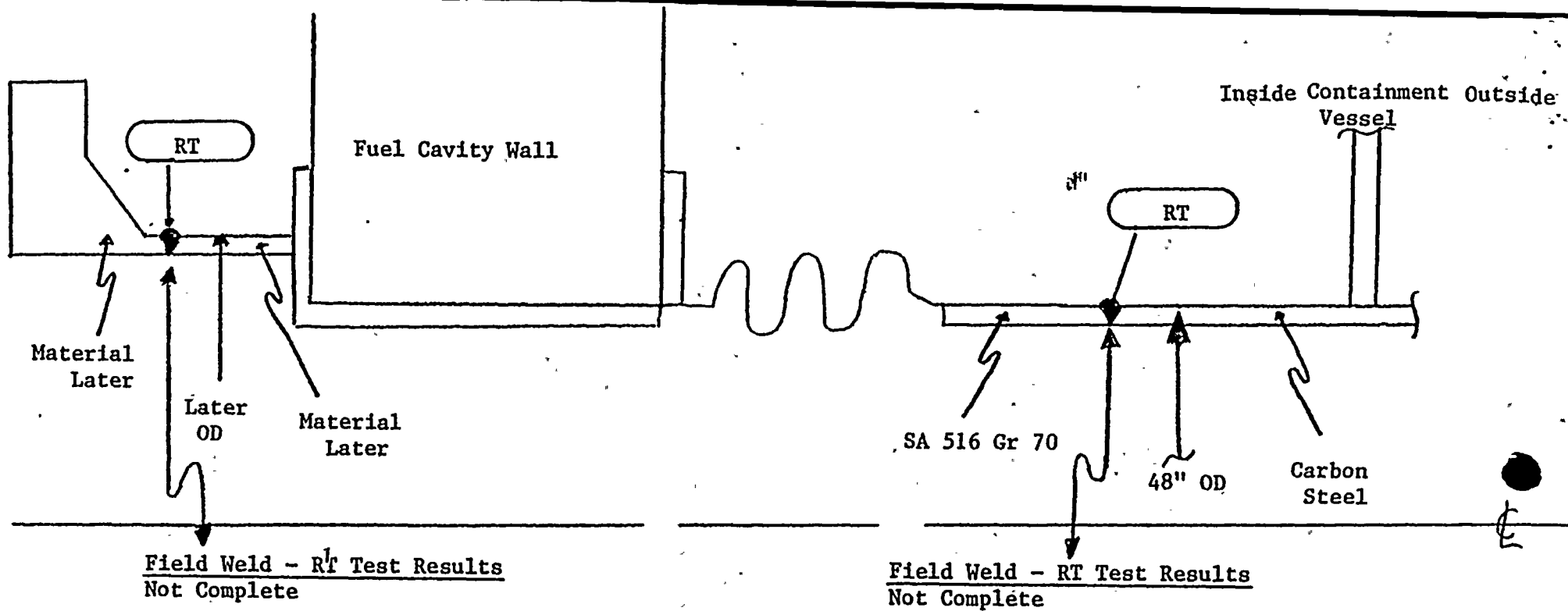


For Details refer to Mfg. Dwgs.  
2998-2003

Penetration 14

Sheet 7 of 21



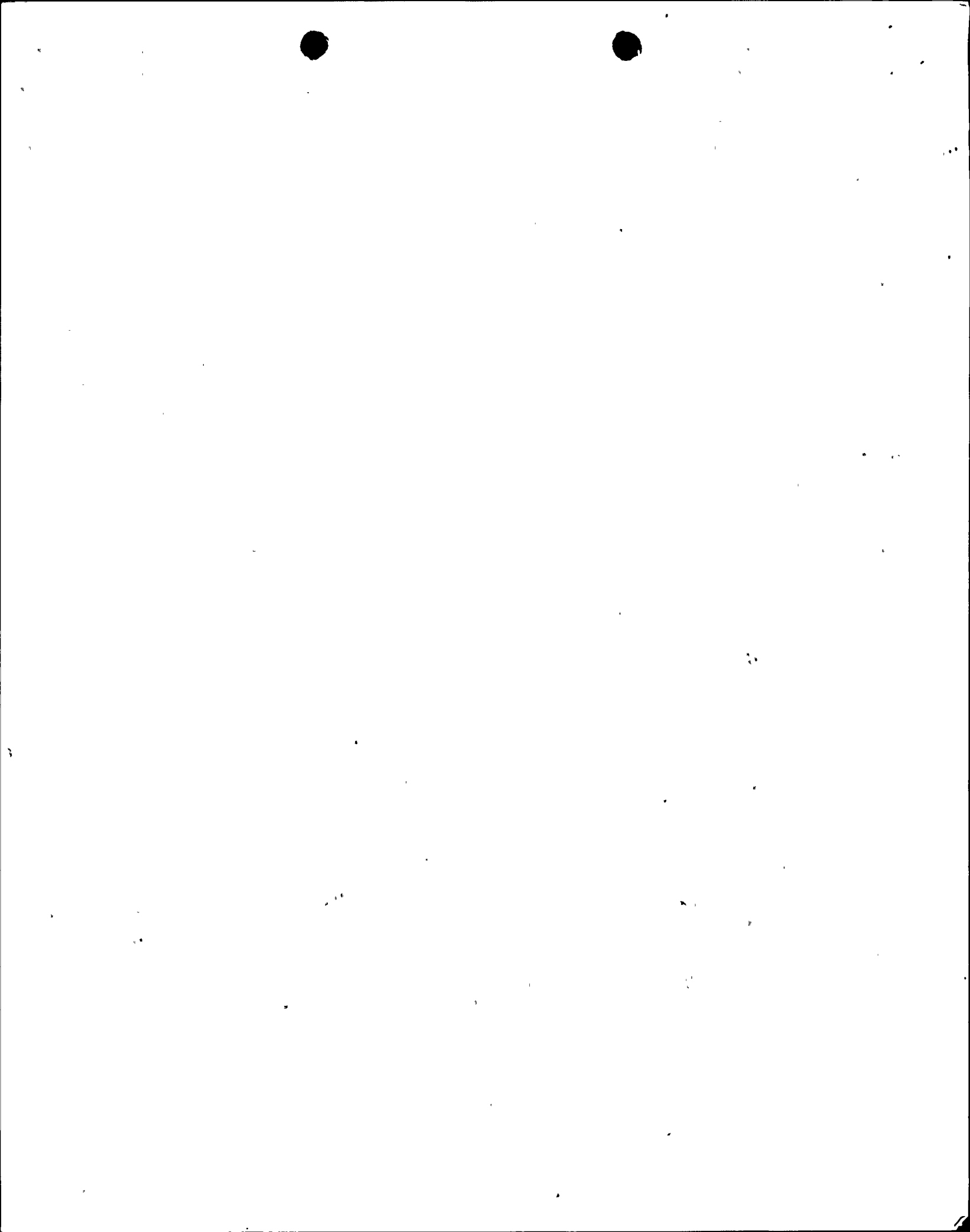


For Details refer to Mfg. Dwgs.  
2998-1557

Penetration 25

Sheet 8 of 21





Inside Containment  
Vessel

Outside

RT

RT

Flued  
Head

SA 182 Gr F304

Carbon  
Steel

SA 106 Gr B

12.750" OD

Field Weld - RT Test Results  
Accepted

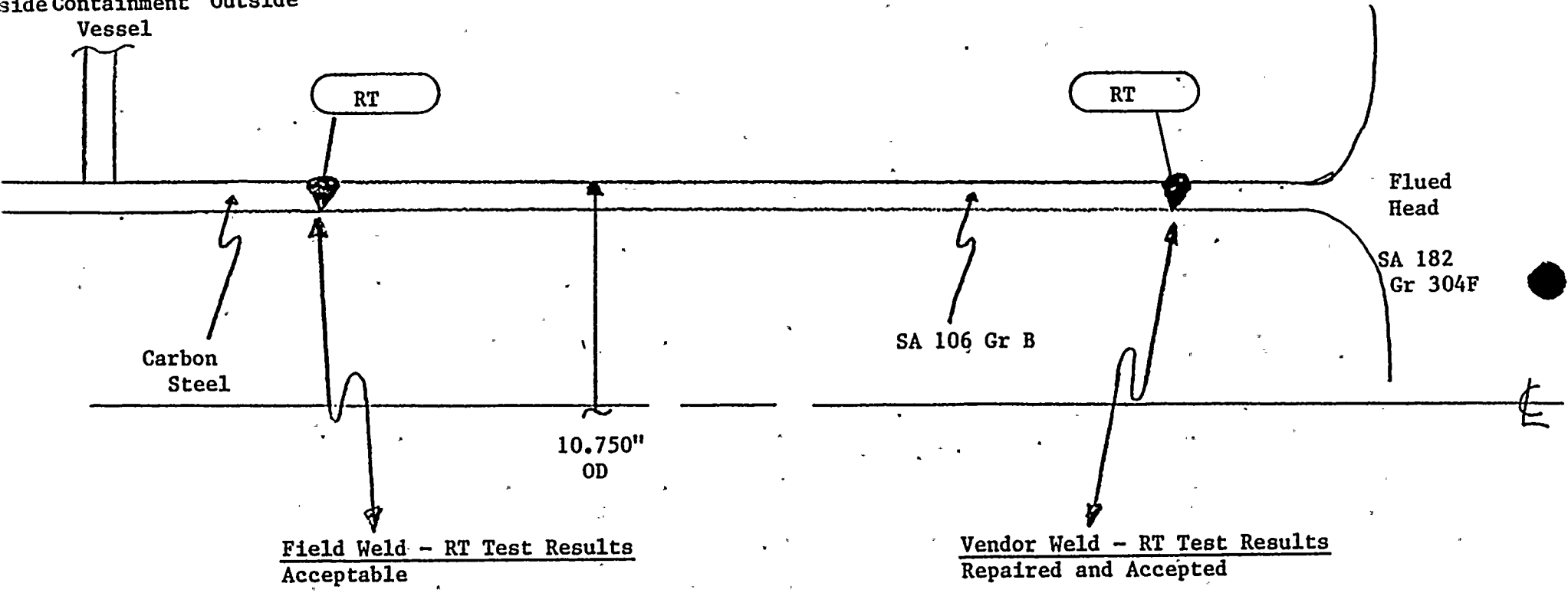
Vendor Weld - RT Test Results  
Accepted

For Details refer to Mfg. Dwgs.  
998-2006

Penetration 26

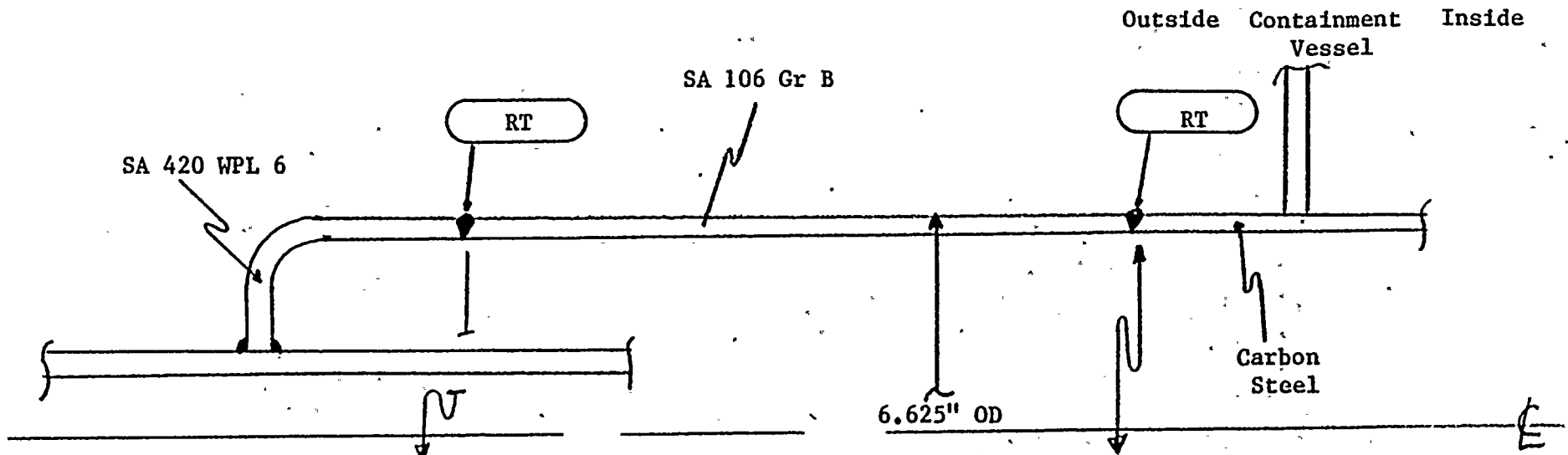
Sheet 9 of 21

side Containment Outside  
Vessel



For Details refer to Mfg. Dwgs  
2998-2007

Penetration 27  
Sheet 10 of 21



Vendor Weld - RT Test Results

- Pen 29 - Accepted
- Pen 30 - Repaired for porosity
- Pen 49 - Accepted
- Pen 28 - Accepted
- Pen 45 - Accepted
- Pen 48 - Accepted
- Pen 51 - Accepted
- Pen 53 - Accepted

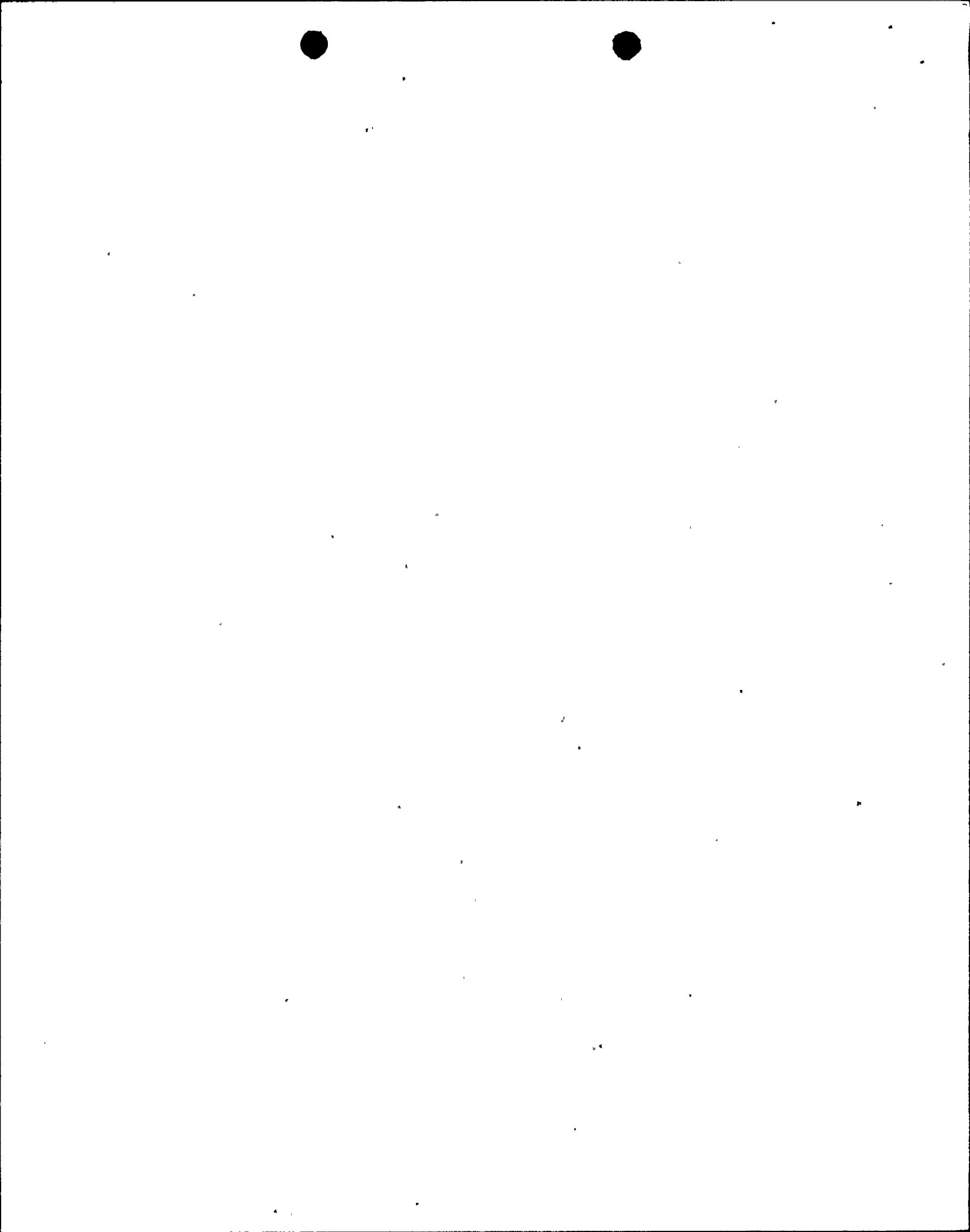
Field Weld - RT Test Results

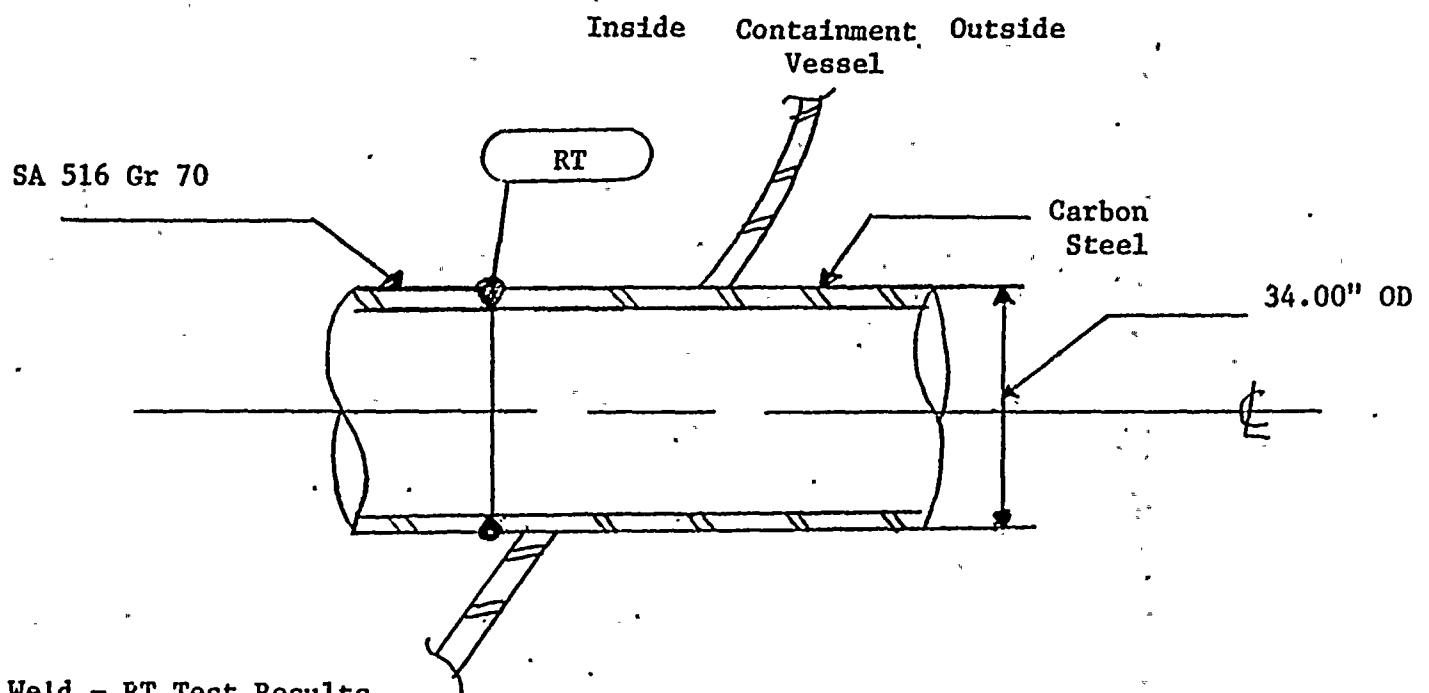
- Pen 29 - Accepted
- Pen 30 - Accepted
- Pen 49 - Not Complete
- Pen 28 - Accepted
- Pen 45 - Accepted
- Pen 48 - Not Complete
- Pen 51 - Accepted
- Pen 53 - Not Complete

For Details refer to Mfg. Dwgs.

2998-2009	2998-2021
2998-2010	2998-2022
2998-2008	2998-2023
2998-2018	

Penetrations 28, 29, 30, 45, 48,  
49, 51, 53





Field Weld - RT Test Results

Pen 32	Accepted
Pen 33	Accepted

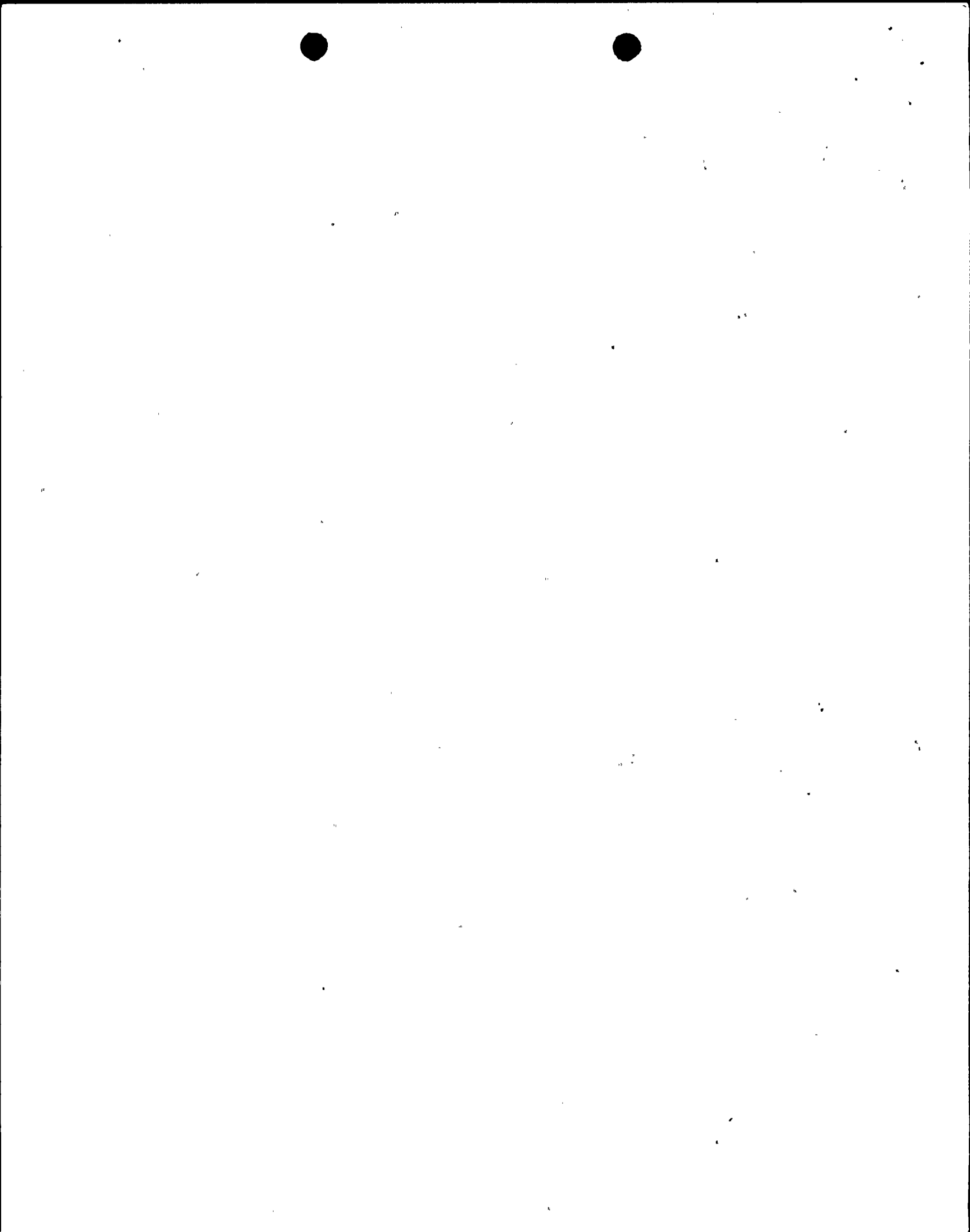
For Details refer to Mfg. Dwgs.

2998-3779

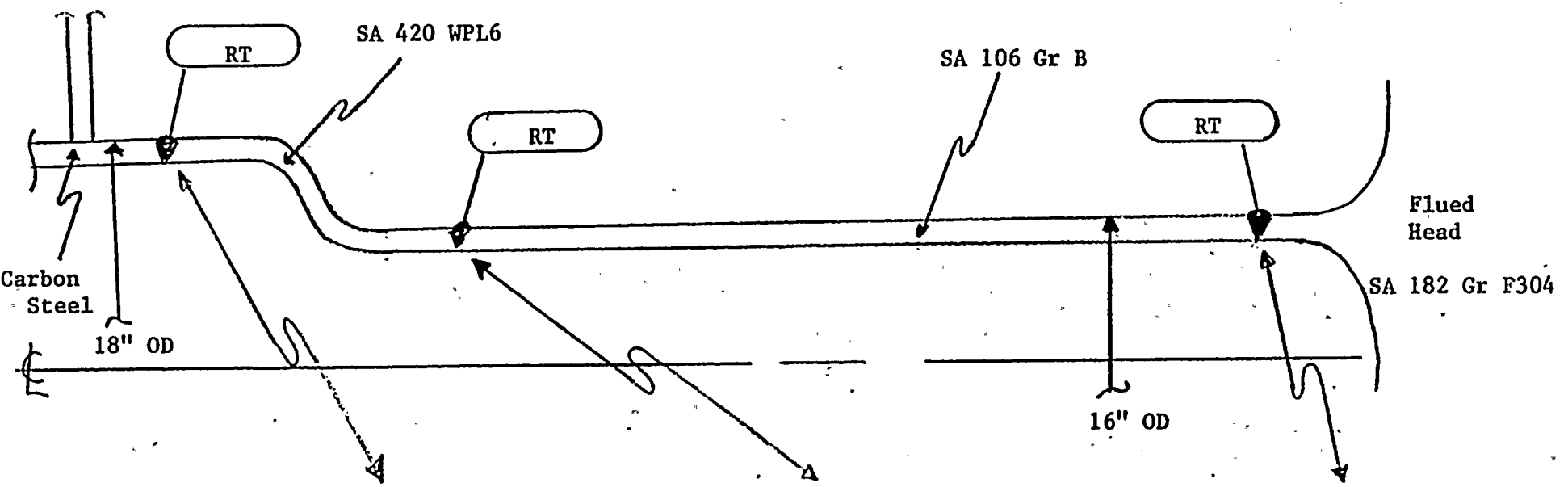
2998-1559

Penetrations 32 and 33

Sheet 12 of 21



Side Containment Outside Vessel



Field Weld - RT Test Results

Pen 36 Accepted  
 Pen 37 Not Complete  
 Pen 38 Accepted  
 Pen 39 Not Complete

Vendor Weld - RT Test Results

Pen 36 Accepted  
 Pen 37 Accepted  
 Pen 38 Accepted  
 Pen 39 Accepted

Vendor Weld- RT Test Results

Pen 36 Accepted  
 Pen 37 Repaired for slag  
 Pen 38 Repaired for slag  
 Pen 39 Repaired for slag

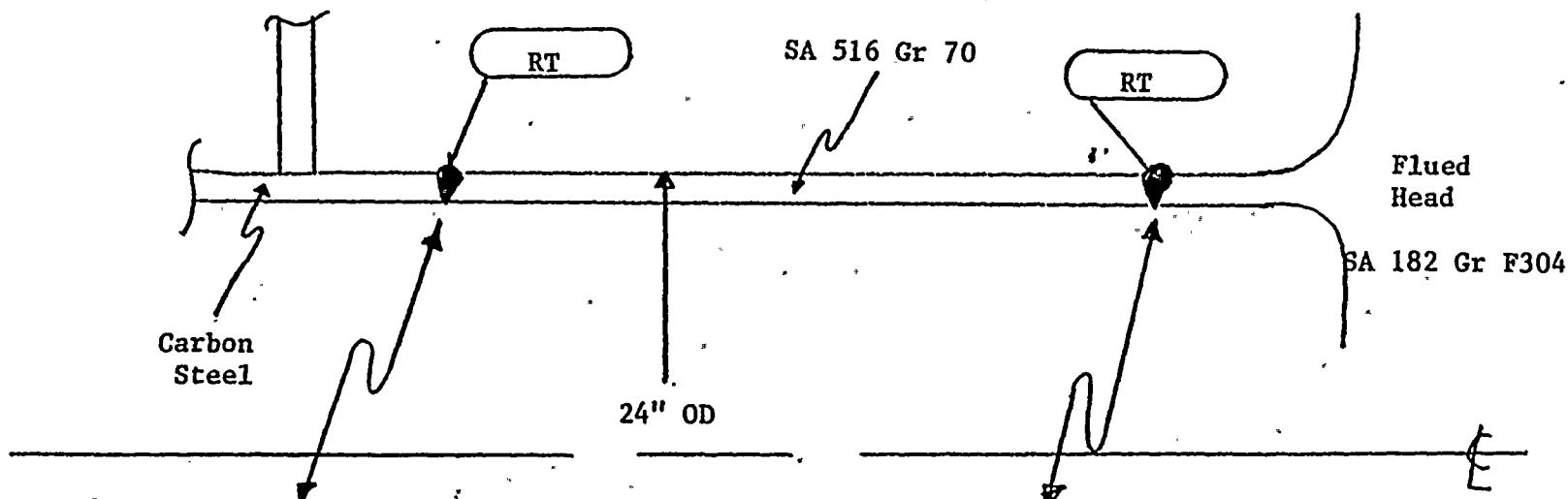
For Details refer to Mfg. Dwgs.  
 2998-2013

Penetrations 36, 37, 38 and 39

Sheet 13 of 21



Inside Containment Outside  
Vessel



Field Weld - RT Test Results  
Pen 64 Accepted  
Pen 40 Accepted.

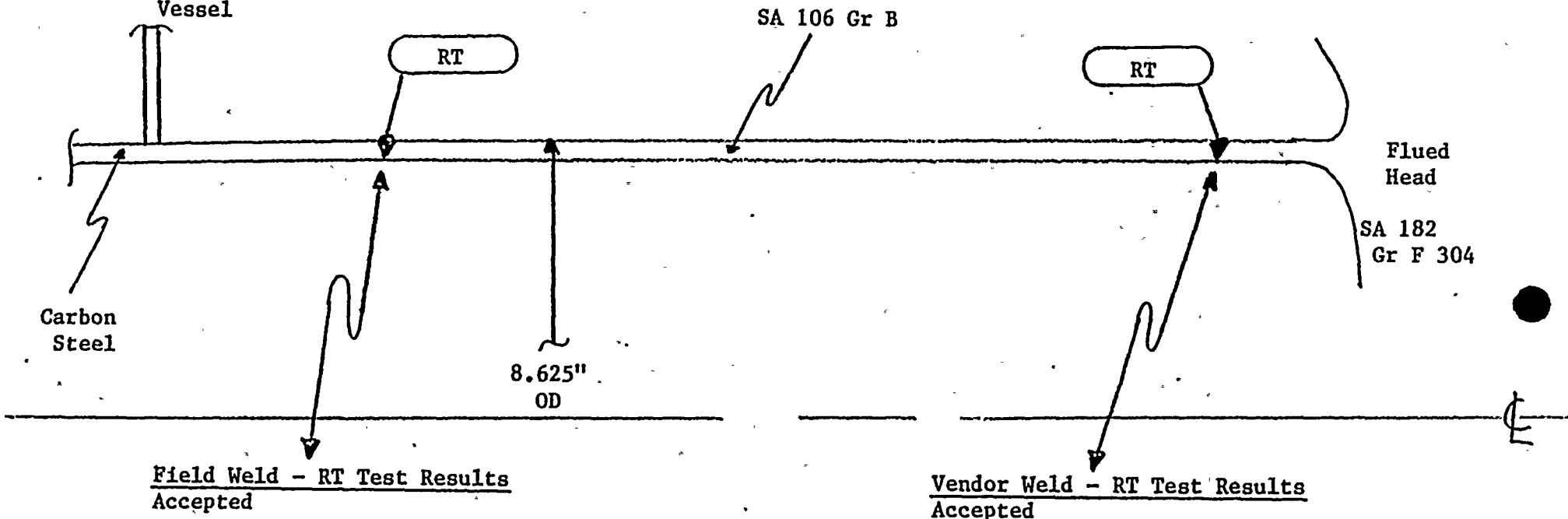
Vendor Weld - RT Test Results  
Pen 64 Accepted  
Pen 40 Accepted.

For Details refer to Mfg. Dwgs.  
2998-2025  
2998-2014

Penetrations 40 and 64

Sheet 14 of 20

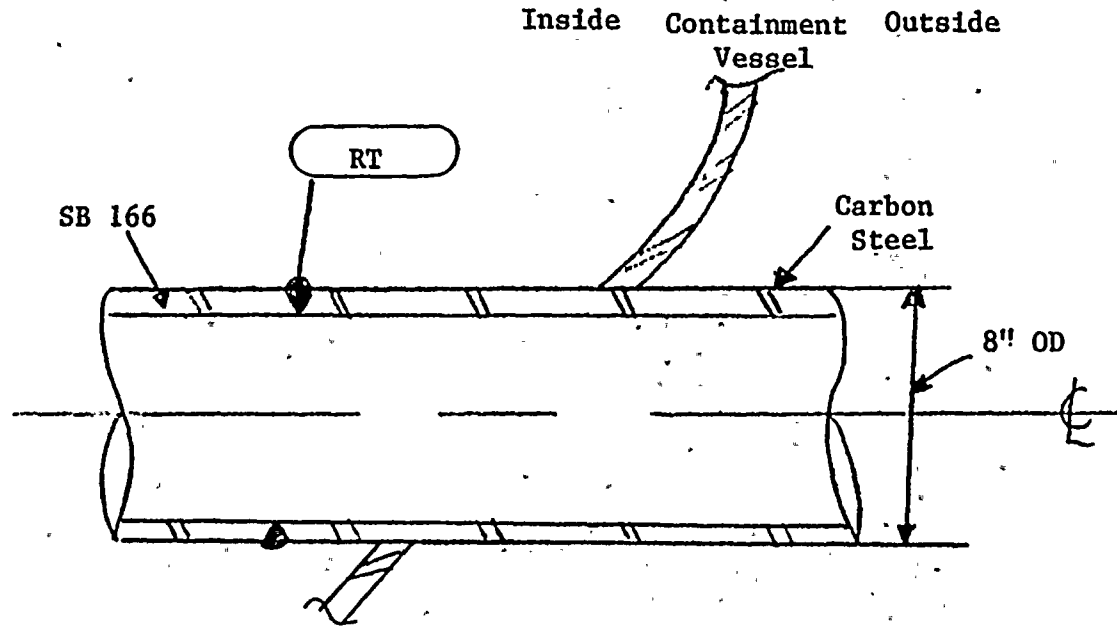
Inside Containment Outside  
Vessel



For Details refer to Mfg. Dwgs.  
2998-2015

Penetration 41

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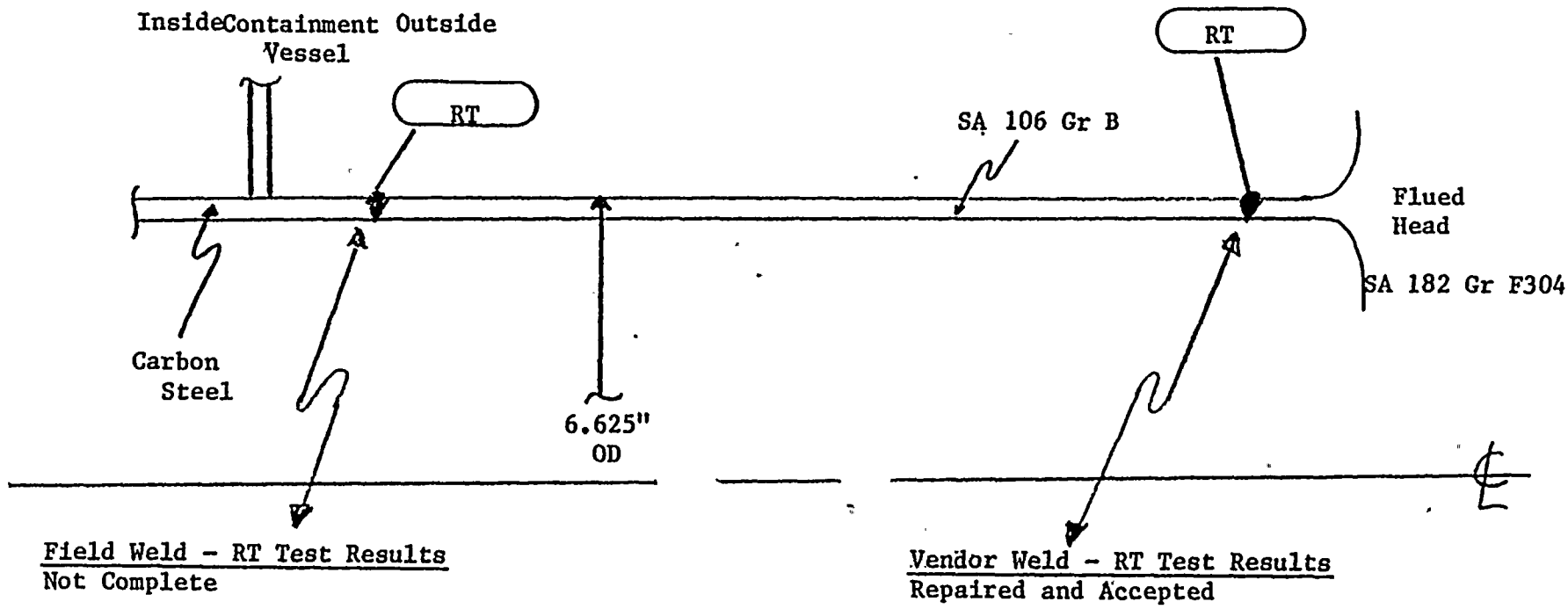
Field Weld - RT Test Results  
Not Complete

For Details refer to Mfg. Dwgs.

2998-763  
2998-764

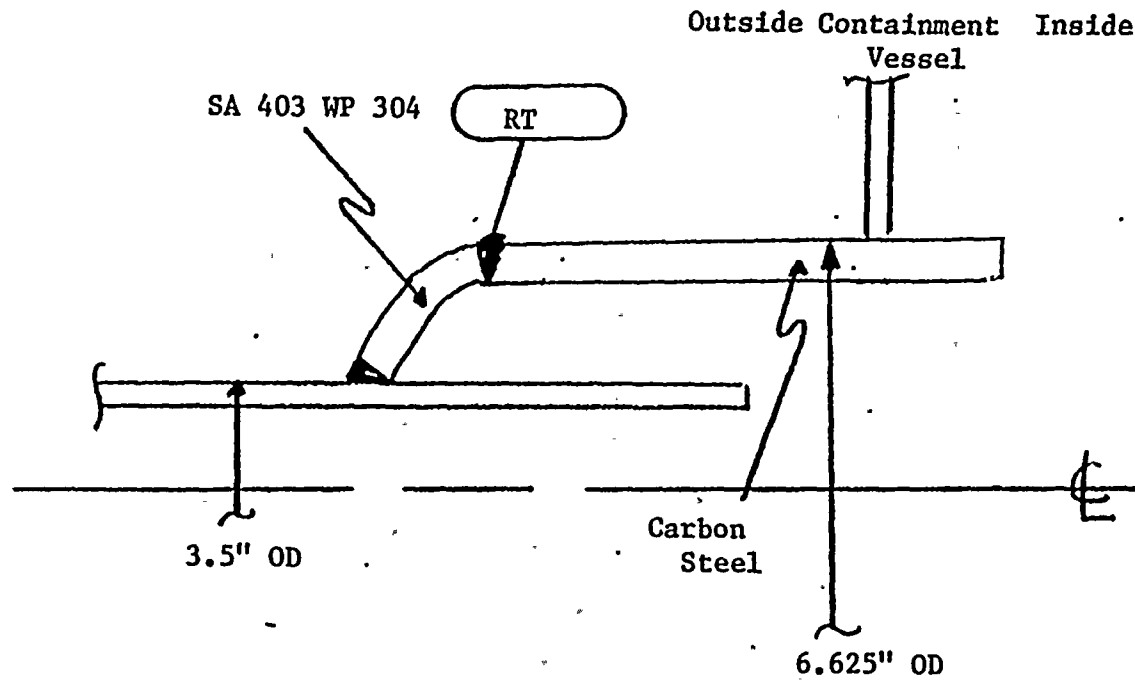
Penetration 43

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For Details refer to Mfg. Dwgs.  
 1998-2017

Penetration 44  
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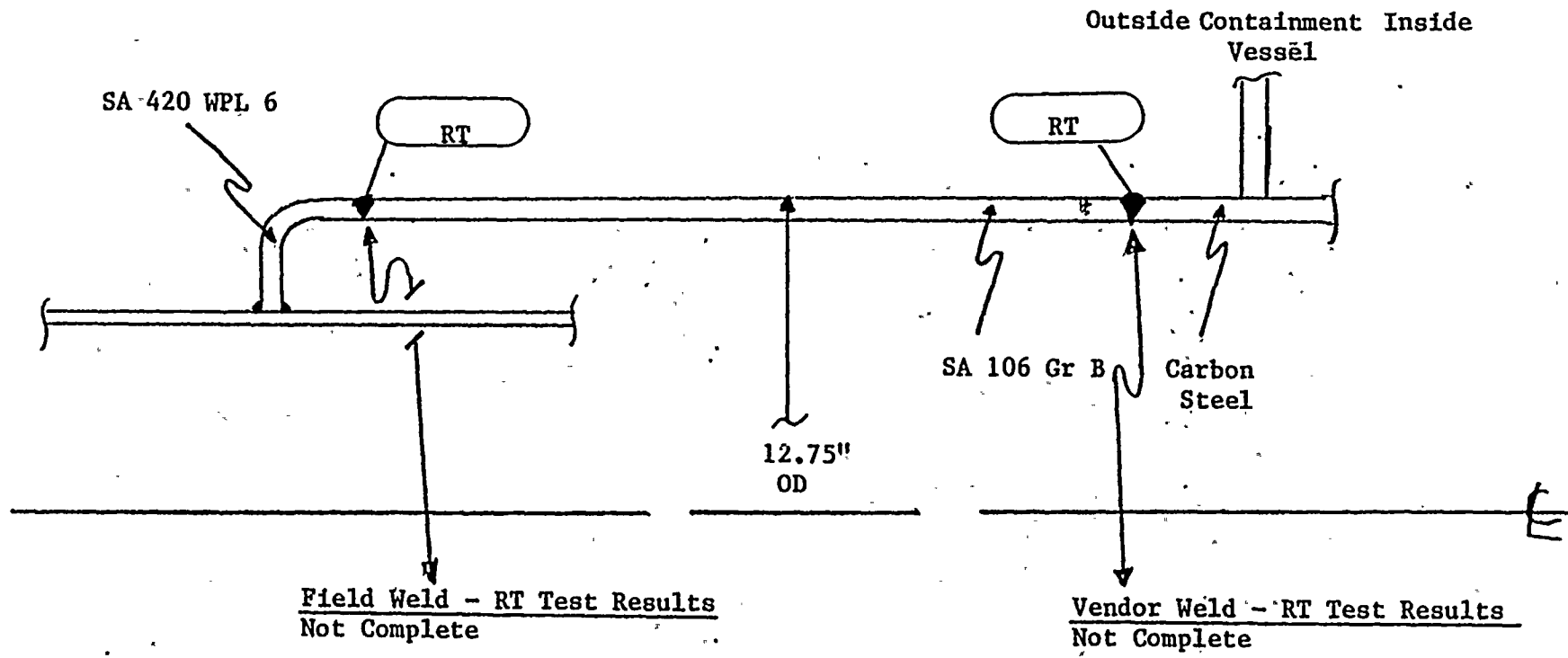


Field Weld - RT Test Results:  
 Pen 46 Not Complete  
 Pen 47 Not Complete

For Details refer to Mfg. Dwgs.  
 2998-2019  
 2998-2020

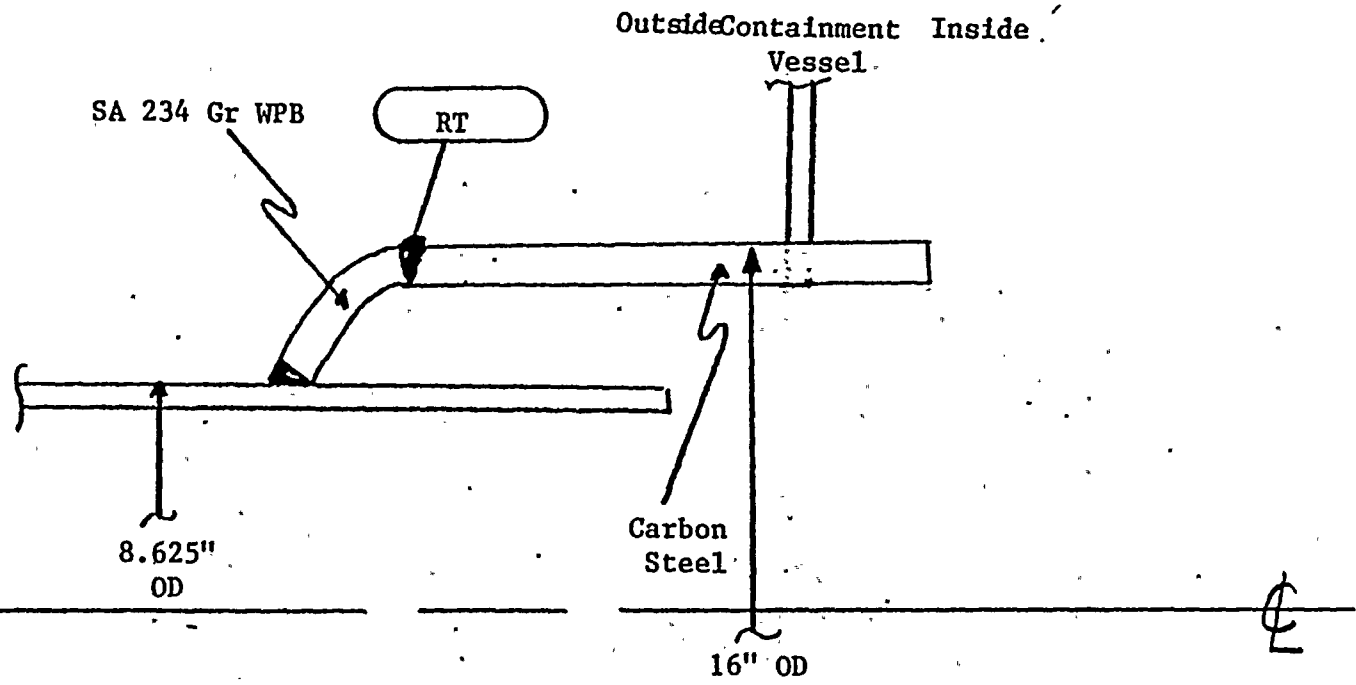
Penetrations 46 & 47

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For Details refer to Mfg. Dwgs.  
 2998-7945

Penetration 52  
 Sheet 19 of 21

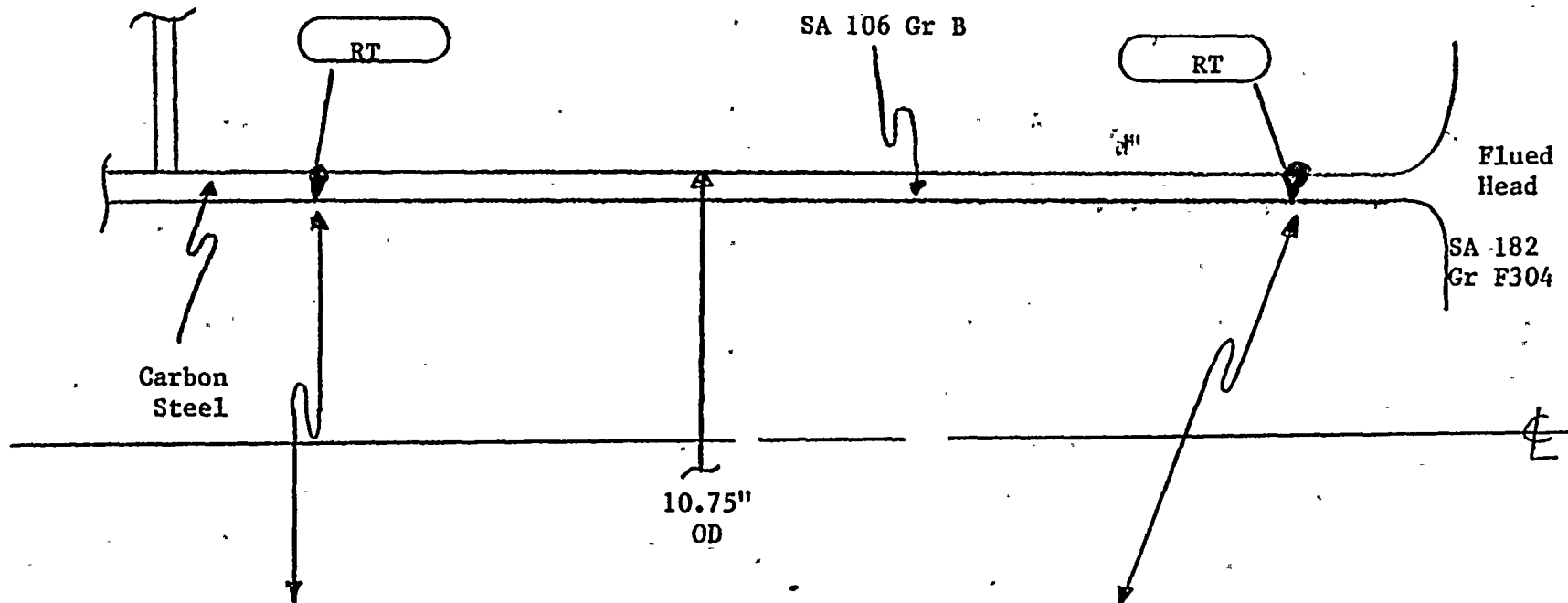


Field Weld - RT Test Results:  
Not Complete

For Details refer to Mfg. Dwgs.  
998-7946

Penetration 54  
Sheet 20 of 21

Inside Containment Outside  
Vessel



Field Weld - RT Test Results  
Pen 69 Not Complete  
Pen 70 Accepted

Vendor Weld - RT Test Results  
Pen 69 Repaired for slag  
Pen 70 Accepted

For Details refer to Mfg. Dwgs.  
2998-2928

Penetrations 69 and 70  
Sheet 21 of 21