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SUBJECT: Requests approval to use ASME Code Case 2143, "F-Number Grouping for Ni-Cr-Fe, Classification UNS W86152 Welding Electrode" in fabrication of facility replacement SGs. Approval requested by 941201 on behalf of B&W.

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November 29, 1993

L-93-295
10 CFR 50.4
10 CFR 50.55a

U. S. Nuclear Regulatory Commission
Attn: Document Control Desk
Washington, D. C. 20555

Gentlemen:

RE: St. Lucie Unit 1
Docket No. 50-335
ASME Code Case 2143 - Request for Use

Pursuant to 10 CFR 50.55a(a)(3), Florida Power and Light Company requests approval to use ASME Section IX Code Case 2143 "F-Number Grouping for Ni-Cr-Fe, Classification UNS W86152 Welding Electrode" in the fabrication of the St. Lucie Unit 1 replacement steam generators. The code case was approved for use by the ASME Board of Pressure Technology on November 25, 1992. Since the Code Case is not endorsed by the current revision of Regulatory Guide 1.85, specific approval is requested on behalf of the vendor, Babcock and Wilcox. In order to prevent production delays approval is requested by December 1, 1994.

A copy of Code Case 2143 is attached for your information.

Please contact us if there are any questions about this submittal.

Very truly yours,

D. A. Sager
Vice President
St. Lucie Plant

DAS/GRM/kw

cc: Stewart D. Ebnetter, Regional Administrator, Region II, USNRC
Senior Resident Inspector, USNRC, St. Lucie Plant

DAS/PSL #1019-93

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CASES OF ASME BOILER AND PRESSURE VESSEL CODE

Approval Date: November 25, 1992

See Numerical Index for expiration
and any reaffirmation dates.

Case 2143
F-Number Grouping for Ni-Cr-Fe, Classification
UNS W86152 Welding Electrode
Section IX

Inquiry: What alternate rules may be applied to grouping UNS W86152 Ni-Cr-Fe welding electrodes meeting the chemical and mechanical properties of Tables 1 and 2 but otherwise conforming to AWS A5.11 to reduce the number of welding procedure and performance qualifications?

Reply: It is the opinion of the Committee that UNS W86152 Ni-Cr-Fe welding electrodes meeting the chemical and mechanical properties of Tables 1 and 2 but otherwise conforming to AWS A5.11 may be considered as F-No. 43 for both procedure and performance qualification purposes. Further, this material shall be identified as UNS W86152 in the Welding Procedure Specification, Procedure Qualification Record and Performance Qualification Records.

This Case number shall be shown on the Manufacturer's Data Report.

TABLE 1
CHEMICAL REQUIREMENTS (UNS W86152)

Element	Composition, %
Carbon, max.	0.05
Manganese, max.	5.00
Phosphorus, max.	0.030
Sulfur, max.	0.015
Silicon, max.	0.75
Chromium	28.0-31.5
Molybdenum, max.	0.50
Nickel	Bal.
Columbium, max.	1.0-2.5
Aluminum, max.	0.50
Copper, max.	0.50
Iron	7.0-12.0
Titanium, max.	0.50
Other Elements, max.	0.50

TABLE 2
MECHANICAL PROPERTY REQUIREMENTS
(UNS W86152)
(All Weld Metal Tension Test)

Tensile strength, min., ksi	80
Elongation in 2 in., min., %	30

