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SUBJECT: Requests generic approval to incorporate ASME Code Cases 2142 & 2143 for use in const,repair or replacement of code class components at plant for ISI programs second 10-yr interval.

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PRIORITY 1 DOCUMENT

FPL

P.O. Box 128, Ft. Pierce, FL 34954-0128

July 15, 1994

L-94-185
10 CFR 50.4
10 CFR 50.55a

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

RE: St. Lucie Units 1 and 2
Docket No. 50-335 and 50-389
In-Service-Inspection Programs
Second Ten-Year Interval - Request for Approval
ASME Section IX Code Cases 2142 and 2143

Pursuant to 10 CFR 50.55a (a)(3), Florida Power and Light Company (FPL) requests generic approval to incorporate ASME Code Case 2142 and Code Case 2143 for use in the construction, repair or replacement of code class components at St. Lucie Unit 1 and Unit 2. ASME Code Case 2142 is titled *F-Number Grouping for Ni-Cr-Fe, Classification UNS N06052 Filler Metal Section IX* and ASME Code Case 2143 is titled *F-Number Grouping for Ni-Cr-Fe, Classification UNS W86152 Welding Electrode Section IX*. Approval is requested by Janualry 31, 1995.

Code Cases 2142 and 2143 were approved by the ASME on November 25, 1992. Both Code Cases introduce and classify new nickel-base weld metals that closely match and are intended for welding Alloy 690. Because these code cases were incorporated into code case supplements of the 1992 edition of the ASME Code, the code cases can not be used without prior NRC staff review. The 1992 edition of the ASME code has not been incorporated by reference into the regulations.

Code Case 2142 was previously approved by the NRC(TAC M89060)on May 30, 1992, for use in the repair of pressurizer instrument nozzles on St. Lucie Unit 2. Code Case 2143 was previously approved by the NRC(TAC M88439)on May 17, 1994, for use in the fabrication of replacement steam generators for St. Lucie Unit 1. The St. Lucie Unit 1 replacement steam generator vendor has recently identified welds where the use of Code Case 2142 weld material would be appropriate.

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St. Lucie Units 1 and 2
Docket No. 50-335 and 50-389
In-Service-Inspection Programs
Second Ten-Year Intervals - Request for Approval
ASME Section IX Code Cases 2142 and 2143

Use of the code cases are advantageous to FPL because they eliminate the burden of requiring qualification of separate welding procedures for these weld metals, as is the case for non-Code welding materials. FPL believes that the use of the new weld metals will enhance the service life of construction, repair and replacement welds when use of the new materials is appropriate. General approval of the Code Cases for use in construction, repair, or replacement welds on both units relieves the burden and expense of repeated code case approvals for individual activities at the site.

FPL has determined pursuant to 10 CFR 50.55a (a)(3) that the proposed alternatives would provide an acceptable level of quality and safety, and that compliance with the specified requirements would result in hardship or unusual difficulty without a compensating increase in the level of quality and safety.

Copies of the code cases are included 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. Ebneter, Regional Administrator, Region II, USNRC
Senior Resident Inspector, USNRC, St. Lucie Plant

DAS/PSL # 1161-94

Approval Date: November 25, 1992
See Numerical Index for expiration and any reaffirmation dates.

Case 2142
F-Number Grouping for Ni-Cr-Fe, Classification UNS N06052 Filler Metal
Section IX

Inquiry: What alternate rules may be applied to grouping UNS N06052 Ni-Cr-Fe welding filler metal meeting the chemical requirements of Table 1 but otherwise conforming to AWS 5.14 to reduce the number of welding procedure and performance qualifications?

Reply: It is the opinion of the Committee that UNS N06052 Ni-Cr-Fe welding filler metal meeting the chemical requirements of Table 1 but otherwise conforming to AWS A5.14 may be considered as F-No. 43 for both procedure and performance qualification purposes. Further, this material shall be identified as UNS N06052 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 N06052)

Element	Composition, %
Carbon, max.	0.04
Manganese, max.	1.00
Phosphorus, max.	0.020
Sulphur, max.	0.015
Silicon, max.	0.50
Chromium	28.0–31.5
Molybdenum, max.	0.50
Nickel	Bal.
Columbium, max.	0.10
Aluminum, max.	1.10
Aluminum & Titanium, max.	1.50
Copper, ,max.	0.30
Iron	7.0–11.0
Titanium, max.	1.0
Other Elements, max.	0.50

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