

CATEGORY 1

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 FACIL: 50-335 St. Lucie Plant, Unit 1, Florida Power & Light Co. 05000335
 50-389 St. Lucie Plant, Unit 2, Florida Power & Light Co. 05000389
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 MALEC, K. J.
 RECIPIENT NAME RECIPIENT AFFILIATION
 HODGE, V.

SUBJECT: Part 21 rept re potential defect in Swagelok stainless steel front ferrule, part number SS-503-1, which was machined with improper length. Insp equipment that will 100% identify short length.

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 TITLE: Part 21 Rept (50 DKT)

NOTES:

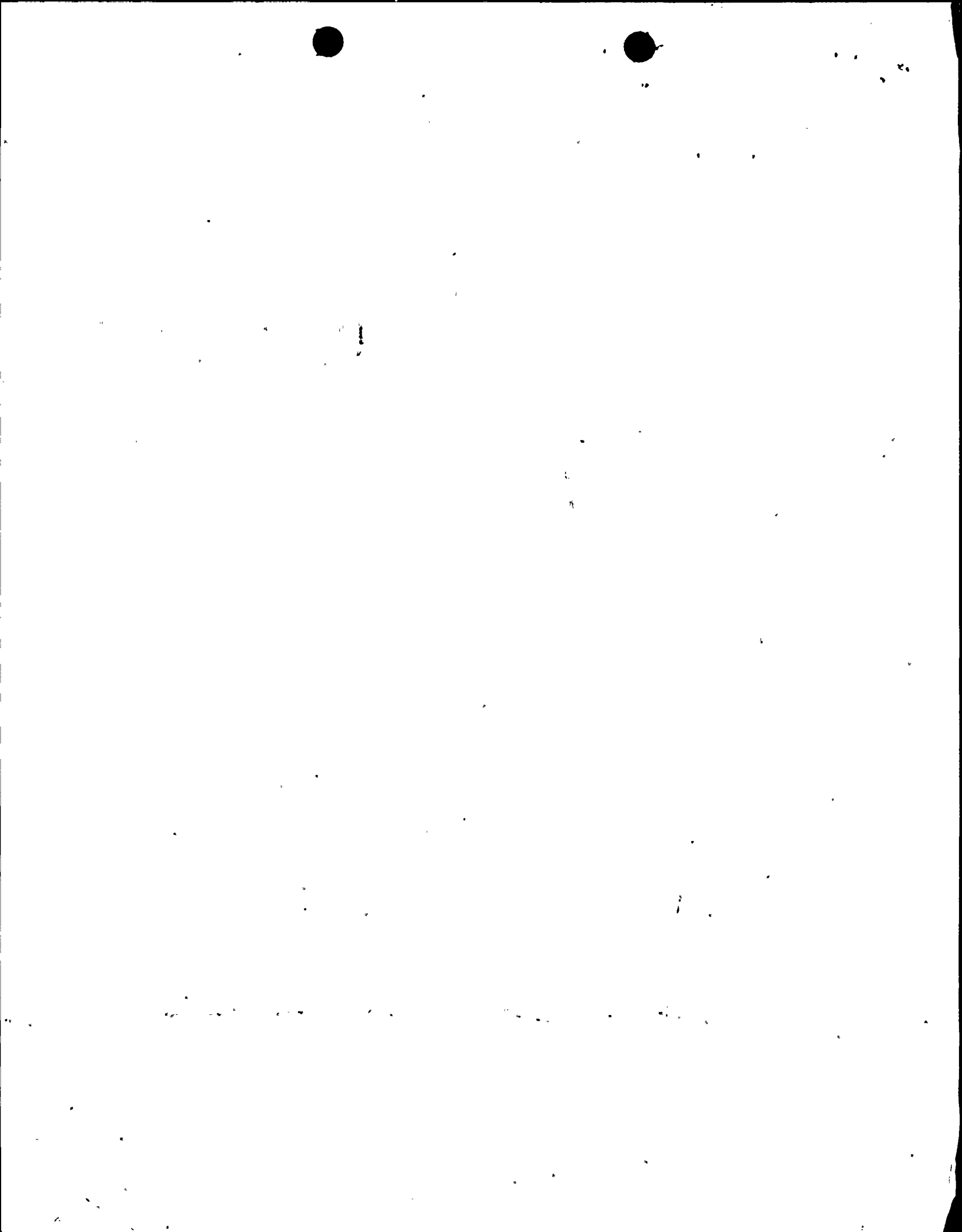
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| | ID CODE/NAME | | LTR | ENCL | | ID CODE/NAME | | LTR | ENCL |
| | PD2-3 PD | | 1 | 1 | | GLEAVES, W | | 1 | 1 |
| INTERNAL: | FILE CENTER 01 | | 1 | 1 | | NRR/DRPM/PECB | | 1 | 1 |
| | NRR/DRPM/PECB/B | | 1 | 1 | | PDR WARD, M. | | 1 | 1 |
| | RES/DET/EIB | | 1 | 1 | | RGN1 | | 1 | 1 |
| | RGN2 | | 1 | 1 | | RGN3 | | 1 | 1 |
| | RGN4 | | 1 | 1 | | | | | |
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Swagelok

SWAGELOK COMPANY

29500 Solon Road, Solon, Ohio 44139-3492 U.S.A.

October 19, 1998

Document Control Desk
Office of Reactor Regulation
Nuclear Regulatory Commission
Washington, DC 20555

Subject: Defects Potentially Reportable under 10CFR part 21

We are writing about a potential defect in a Swagelok stainless steel front ferrule, part number SS-503-1. The part is marked with the heat code IVD on it. The front ferrule is shipped as a component in a Swagelok tube fitting, or sold as a replacement part.

The list of utilities to whom we have sold these parts is enclosed. We are notifying each licensee concurrently with this notice.

The potential problem is that the ferrule was machined with an improper length, resulting in the 45 degree chamfer at the trailing edge to be missing. Laboratory testing of this part has shown that it will leak immediately on gas service, and will hold to about 2.5 times working pressure of the tubing during a hydraulic pressure test.

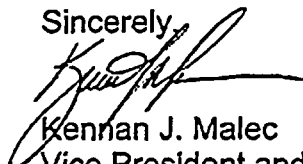
The improper length was caused by insufficient feedout of the bar on a multiple spindle machine. Our analysis shows that this would be a first part error and that only a small number of ferrules are affected. Our automated assembly equipment is set to reject this condition, and of the parts that were not sent through automated assembly, about one per cent of the lot is included.

Corrective action includes inspection equipment that will 100 per cent identify this short length.

A sales drawing that shows a proper ferrule and one with the short length is enclosed.

If there are any questions, please do not hesitate to contact us.

Sincerely,



Kennan J. Malec
Vice President and General Manager

9810210180 981019
PDR ADOCK 05000335
S PDR

Telephone: 440-248-4600 Fax: 440-349-5970

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I.E. 19



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Swagelok®

34934

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FACSIMILE COVER SHEET

Date: October 19, 1998
To: Document Control Desk
From: Bruce Flusche
Total Pages: 5
Subject: 10 CFR 21 notification

Original to follow by certified mail

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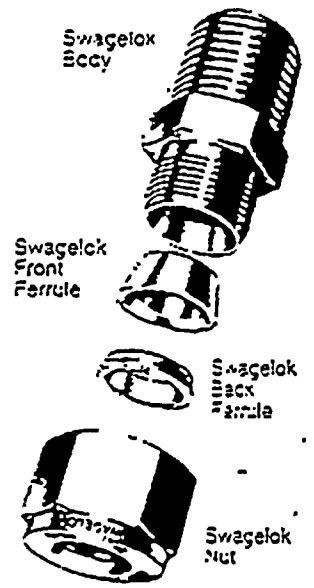
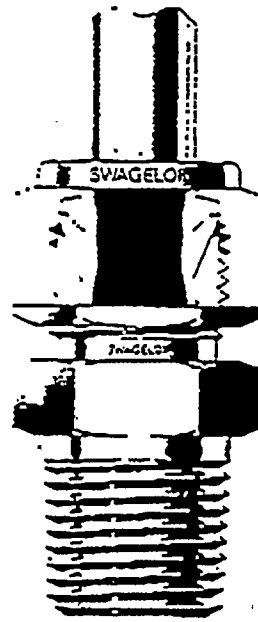
SS-503-1 (IVD)

Westinghouse Electric Corp. P.O. # MB-33772 43 pcs. SS-500-6-2BT
Product ID # D18GV0197S
Repair Replacement Service

Florida Power & Light PO # 00032836 10 pcs. SS-500-SET
Product ID # R18FN0151
St. Lucie Nuclear Plant

Mitsubishi Heavy Industries Ltd.
Product ID # R17IE0516
Kobe Shipyard & Machinery #2303944-KG-865564 38 pcs. SS-503-1



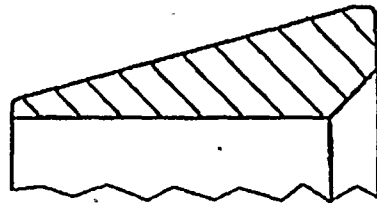




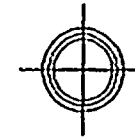
PART NO.

503-1

ACCEPTABLE

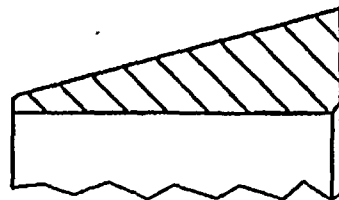


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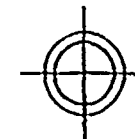


FULL SIZE

NOT ACCEPTABLE



10x SIZE



FULL SIZE

CUSTOMER DRAWING

Swagelok
SWAGELOK COMPANY

- DRAWING NOT TO SCALE.
- DIMENSIONS ARE INCHES OVER (MILLIMETERS).
- DRAWING IS SUBJECT TO CHANGE WITHOUT NOTICE.

DRAWN BY

DATE

JN

APPROVED BY

DATE

JN

10/17/98

TITLE

PART NO.

503-1

GENERAL INFORMATION or OTHER

EVENT NUMBER: 34934

LICENSEE: SWAGELOK COMPANY, SOLON, OH
 CITY: SOLON REGION: 3
 COUNTY: STATE: OH
 LICENSE#: AGREEMENT: N
 DOCKET:

NOTIFICATION DATE: 10/19/98
 NOTIFICATION TIME: 16:58 [ET]
 EVENT DATE: 10/19/98
 EVENT TIME: 12:00 [EDT]
 LAST UPDATE DATE: 10/19/98

NOTIFICATIONS

MARK LESSER, REG 2 RDO
 VERN HODGE NRR

NRC NOTIFIED BY: BRUCE FLUSCHE
 HQ OPS OFFICER: DICK JOLLIFFE

EMERGENCY CLASS: NOT APPLICABLE
 10 CFR SECTION:
 CCCC 21.21 UNSPECIFIED PARAGRAPH

EVENT TEXT

- 10CFR PART 21 REPORT - DEFECTIVE SWAGELOK TUBE FITTING FRONT FERRULE -

SWAGELOK COMPANY PERSONNEL REPORTED A POTENTIAL DEFECT IN A SWAGELOK STAINLESS STEEL FRONT FERRULE, PART NUMBER SS-503-1. THE PART IS MARKED WITH THE HEAT CODE "IVD" ON IT. THE FRONT FERRULE IS SHIPPED AS A COMPONENT IN A SWAGELOK TUBE FITTING, OR SOLD AS A REPLACEMENT PART.

THE POTENTIAL PROBLEM IS THAT THE FERRULE WAS MACHINED WITH AN IMPROPER LENGTH, RESULTING IN A 45 DEGREE CHAMFER AT THE TRAILING EDGE TO BE MISSING. SWAGELOK LABORATORY TESTING OF THIS PART HAS SHOWN THAT IT WILL LEAK IMMEDIATELY ON GAS SERVICE AND WILL HOLD TO ABOUT 2.5 TIMES WORKING PRESSURE OF THE TUBING DURING A HYDRAULIC PRESSURE TEST. THE IMPROPER LENGTH WAS CAUSED BY INSUFFICIENT FEEDOUT OF THE BAR ON A MULTIPLE SPINDLE MACHINE. SWAGELOK ANALYSIS SHOWS THAT THIS WOULD BE A FIRST PART ERROR AND THAT ONLY A SMALL NUMBER OF FERRULES ARE AFFECTED. SWAGELOK AUTOMATED ASSEMBLY EQUIPMENT IS SET TO REJECT THIS CONDITION AND OF THE PARTS THAT WERE NOT SENT THROUGH AUTOMATED ASSEMBLY, ABOUT 1% OF THE LOT IS INCLUDED.

SWAGELOK CORRECTIVE ACTION INCLUDES INSPECTION EQUIPMENT THAT WILL 100% IDENTIFY THIS SHORT LENGTH.

THE SWAGELOK REPORT INCLUDES A SALES DRAWING THAT SHOWS A PROPER FERRULE AND ONE WITH THE SHORT LENGTH.

SWAGELOK COMPANY OFFICIALS HAVE NOTIFIED ORGANIZATIONS THAT HAVE PURCHASED SWAGELOK FITTINGS WITH THESE FERRULES - ST LUCIE PLANT, WESTINGHOUSE, AND MITSUBISHI KOBE SHIPYARD & MACHINERY, JAPAN.

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