



UNITED STATES  
NUCLEAR REGULATORY COMMISSION  
REGION II  
101 MARIETTA ST., N.W., SUITE 3100  
ATLANTA, GEORGIA 30303

Report No. 50-250/81-23 and 50-251/81-23

Licensee: Florida Power and Light Company  
P. O. Box 529100  
Miami, FL 33152

Facility Name: Turkey Point

Docket Nos. 50-250 and 50-251

License Nos. DPR-31 and DPR-41

Inspection at Turkey Point Site near Homestead, FL

Inspector: J. J. Blake 11/2/81  
Date Signed

Accompanying Personnel: A. R. Herdt (October 14, 1981)

Approved by: A. R. Herdt 11/2/81  
Date Signed  
A. R. Herdt, Section Chief  
Engineering Inspection Branch  
Engineering and Technical Inspection Division

SUMMARY

Inspection on October 13 - 16, 1981

Areas Inspected

This routine, unannounced inspection involved 30 inspector-hours on site in the areas of Unit 3 Steam Generator Outage, Licensee Action on Previous Inspection Findings, IE Bulletin 80-08, ISI Data Review.

Results

Of the four areas inspected, no violations or deviations were identified.

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## REPORT DETAILS

### 1. Persons Contacted

#### Licensee Employees

- \*J. K. Hays, Plant Manager, Nuclear
- \*P. W. Haase, Operations Superintendent, Nuclear (Acting)
- \*D. W. Jones, QC Supervisor
- \*S. M. Feith, QA Operations Supervisor
- \*M. J. Crisler, QA Backfit
- \*R. E. Tucker, QA Operations
- \*J. Ferrare, QA Operations
- R. F. Englmeier, QA Manager
- \*J. P. Mendicta, Maintenance Supervisor, Nuclear
- \*J. Lowman, Maintenance
- \*D. Chaney, Nuclear Licensing
- \*H. T. Young, Project Management/Backfit

Other licensee employees contacted included several craftsmen, technicians, mechanics, security force members, and office personnel.

#### Other Organizations

- R. Pruitt, Daniel Construction Company
- D. M. Swann, Welding & QA Supervisor, CB&I

#### NRC Resident Inspector

- \*R. Vogt-Lowell - SRI
- \*Attended exit interview

### 2. Exit Interview

The inspection scope and findings were summarized on October 16, 1981 with those persons indicated in paragraph 1 above. The inspector informed the licensee that there would be one new inspector followup item concerning Unit 4. This item is as follows:

50-251/81-23-01 Replacement of Valve No 4-132A (See Paragraph 5)

### 3. Licensee Action on Previous Inspection Findings

- a. (Closed) Unresolved Item (50-250/80-14-01; 50-251/80-14-01) Management attention to corrective action in welding control problem areas. The inspector reviewed the corrective actions which had been or were being taken to clear the finding of the licensee's QA Audit No. QAO-PTP-81-05-346 concerning the control of special processes. Based on this



review and discussions with QA and Maintenance Personnel involved, it appears that the welding procedure, personnel and material control problems are receiving more attention than they have been in the past. This item is closed.

(Closed) Unresolved Item (50-250/79-25-02; 50-251/79-25-02) Overexpanded Tubes. The inspector reviewed the licensee's records concerning this problem. This documentation included Westinghouse Report WTD-DE-79-007 "Hydraulic Expansion of Steam Generator Tubes in Units 2991, 2992, and 2993. A report to Florida Power and Light Company." This report analyzed the conditions in the generators fabricated for Turkey Point Unit 4. (TP4 generators were fabricated before TP3 and represent the worst case of Hydraulic Overexpansion of Tubes.) The licensee's records showed the the locations of all overexpanded tubes had been mapped and would be a part of the Data Base for Future Steam Generator Inservice Inspections.

4. Unresolved Items

Unresolved items were not identified during this inspection.

5. Independent Inspection

a. Valve Wall Thickness Program

During the early 1970's the Commission and licensees conducted a major inspection and evaluation effort to verify that cast valve bodies did in fact have the Wall-Thicknesses required by Piping System Design.

The result of this effort at Turkey Point was that there was one 3-inch valve in the Primary System of Unit 4 that had a marginal wall thickness. The licensee has scheduled this valve (Valve No. 4-312A in the Charging System) to be replaced during the Steam Generator Repair Outage next year. (Replacement requires that the reactor be de-fueled and the Primary System drained to below the level of the charging line. (Discussions concerning this valve appear in 1974 Inspection Reports- Particularly Report No. 50-251/74-10).

In that the item was listed as a commitment in the 1974 inspection reports the inspector informed the licensee that the item would be assigned an inspector follow-up item number to document the replacement and finally close out the thin-wall valve problem at Turkey Point. This will be listed as IFI No. 50-251/81-23-01, Replacement of Valve No. 4-312A.

6. IE Bulletins

(Open) IE Bulletin 80-08. The licensee submitted an updated response to the bulletin on September 15, 1981 (SER L-81-404) discussing the Unit 3 Penetration Inspection Results. This response states that all penetrations except one had radiographs on file. Penetration No. 32 was radiographed on July 29



1981 and rejected for indication of the construction related weld problem. The submittal also states that the penetration will be repaired prior to startup. The inspector reviewed the radiographs and associated documentation. The licensee informed the inspector that the weld was being reviewed by FP&L Engineering and no direction concerning repair action had been received at the site.

This bulletin will remain open pending resolution concerning penetration No. 32.

#### 7. Inservice Inspection Records. (Unit 3)

The inspector reviewed the ISI Records for the Unit 3 Reactor Vessel. The records on file in the site vault included the scan plans; the procedures and other parameters of the test. The data and analysis had not yet been submitted to the QA Records Vault. This inspection will be completed after the data has been submitted to the vault.

There were no violations or deviations noted during this area of inspection.

#### 8. Steam Generator Repair (Unit 3)

FP&L is in the process of repair of the Unit 3 Steam Generators by Repair/Replacement of the lower assemblies. The method being used is the Channel Head Cut Method described in Revision 7 of the FP&L Steam Generator Repair Report, dated March 1980. The governing overall code for the Steam Generator Replacement is the ASME B&PV Code, Section XI 1977 Edition with Addenda through the summer of 1978. Chicago Bridge and Iron Company (CBI) has been contracted to performed the cutting and welding operations on the Steam Generators.

At the time of this inspection Steam Generator "A" Lower Assembly had been removed from the containment and Steam Generator "C" had been cut and the Lower Assembly was being prepared for removal.

The inspector reviewed the CBI Program for the Steam Generator work. This review included the QA manual and all of the welding and NDE Procedures included in the CBI QA Program.

Welding and NDE procedures reviewed included the following.

CPIN, Rev.1	-	Cleaning Procedure-Nuclear Steam Generator
GRIN, Rev.0	-	General Repair Procedure for Welds and Base Metal-Class 1 Nuclear Vessels
GWPS-SMAW, Rev.13 (WPS-800)	-	General Welding Procedure Specification for the Shielding Metal ARC Process-Nuclear Power Plant Components.





- MT-9, Rev.0 - Magnetic Particle Examination Procedure, Continuous Yoke/Prod, Dry, Visible Particles, Class 1 Nuclear Products.
- MT-10, Rev.3 - Magnetic Particle Examination Procedure, Continuous Prod, Dry, Visible Particles, Class 1 Nuclear Products.
- MT-11, Rev.3 - Magnetic Particle Examination Procedure. Continuous Yoke, Dry, Visible Particles, Class 1 Nuclear Products.
- PT-9, Rev.5 - Liquid Penetrant Examination Procedure, Color Contrast, Water Washable, Wet Developer.
- PT-14, Rev.4 - Liquid Penetrant Examination Procedure Color Contrast, Solvent Removable, Wet Developer.
- PT-22, Rev.3 - Liquid Penetrant Examination Procedure, High Temperature, Color Contrast, Wet Developer.
- RT1, Rev.4 - Radiographic Examination Procedure, Class 1 Vessels, Core Support Structures, Components Supports.
- UT1, Rev.0 - Ultrasonic Examination Procedure for Low Alloy Steel Welds.

Implementation of the CBI QA Program was inspected by observation of welding operations inside containment; discussions with CBI Welding and QA Personnel; and review of documentation packages.

There were no violations or deviations identified during this part of the inspection.

