

CATEGORY 1

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50-331 Duane Arnold Energy Center, Iowa Electric Light & Pow 05000331
50-354 Hope Creek Nuclear Station, Unit 1, Public Service El 05000354

AUTH. NAME AUTHOR AFFILIATION
MALEC, K. J.
RECIP. NAME RECIPIENT AFFILIATION

SUBJECT: Part 21 rept re possible machining defect in certain one inch stainless steel Swagelok front ferrules, part number SS-1613-1. Caused by tubing slipping out of fitting at three times working pressure of tubing. Notified affected utils.

DISTRIBUTION CODE: IE19T COPIES RECEIVED: LTR 1 ENCL 1 SIZE: 4
TITLE: Part 21 Rept (50 DKT)

NOTES: Application for permit renewal filed. 05000354

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SECRET
NO ON

Swagelok

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

September 9, 1998

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

Subject: Defects Potentially Reportable Under 10CFR21

We are writing to inform you about a possible machining defect in certain one inch stainless steel Swagelok front ferrules, part number SS-1613-1.

The front ferrule is shipped as a component in a Swagelok tube fitting, or sold separately as a replacement part.

A list containing the part numbers of assembled fittings and nuclear safety related certifications under which these ferrules have been sold is enclosed. All of these customers have already been notified by us about this possible problem. Only front ferrules with the heat codes ILA, JVA and JYL stamped on the part are affected; and only one inch ferrules are involved.

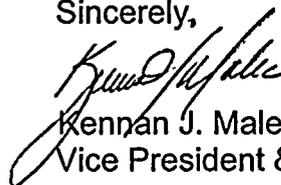
The possible defect is that the 45 degree chamfer on the trailing edge of the ferrule may not be correct. A drawing is enclosed that shows this dimension, along with a drawing that illustrates the front ferrules' position in the Swagelok tube fitting. When these ferrules were machined, an improper set-up allowed a few pieces to be manufactured with an inappropriate dimension. Our inspection of the lots involved shows that about 0.019 per cent of the ferrules manufactured in these lots were affected.

Laboratory testing of these parts with this incorrect dimension had the tubing slip out of the fitting at three times working pressure of the tubing.

Our corrective action includes doubling our sample size on these parts and implementing a long term project to 100 per cent inspect using automation.

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

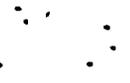
Sincerely,


Kennan J. Malec

Vice President & General Manager

IE19/1

142000
9809150166 980909
PDR ADOCK 05000250
S PDR



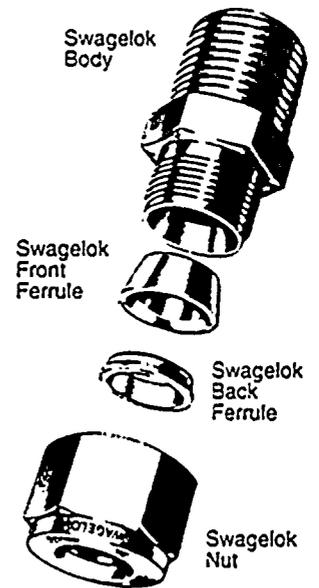
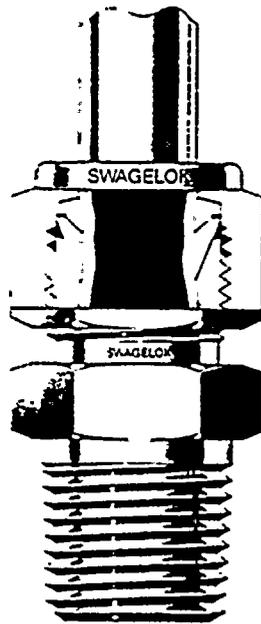
SWAGELOK COMPANY

SS-1613-1

Company	Purchase Order	Part Number	QTY	Product ID
Florida Power & Light (Turkey Point)	00032839	SS-1610-1-16	5	R18G20183
Public Service Electric & Gas	P2 0957644 1850	SS-1610-1-16	10	R18FJ0055B
Mechanical Engineering Workshop	SF/CRX/198/433	SS-1613-1	50	R17IC0521B
IES Utilities (Duane Arnold)	T30228	SS-1613-1	4	R17IC0521B
Duke Power (Oconee)	ON33500007310100	SS-1610-1-16	24	R17GX0505B
Westinghouse Savannah River	AC04139A #8	SS-1610-1-16	1	R17GX0505



TUBE FITTINGS

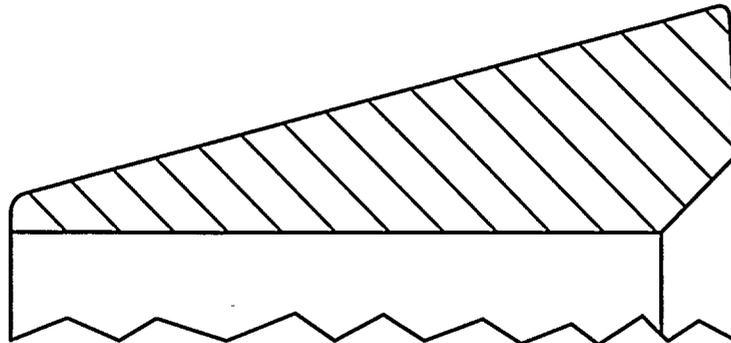




11

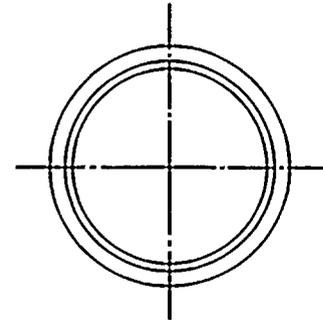
PART NO.

1613-1

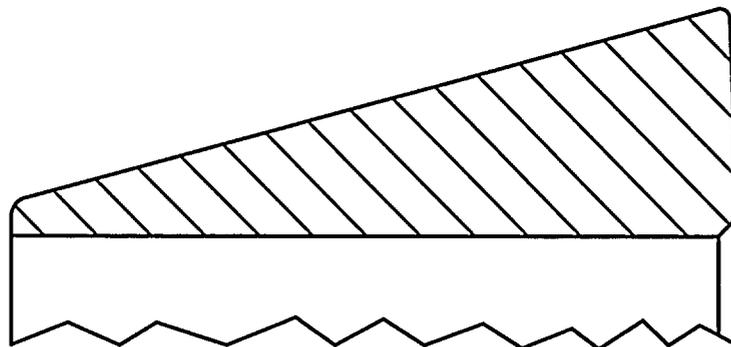


10x SIZE

ACCEPTABLE

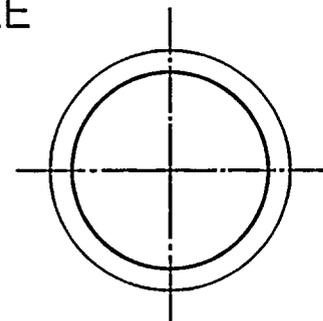


FULL SIZE



10x SIZE

NOT ACCEPTABLE



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

TITLE

APPROVED BY

DATE

PART NO.

1613-1

11
12
13

50-250
50-251

GENERAL INFORMATION or OTHER

EVENT NUMBER: 34761

LICENSEE: SWAGELOK
CITY: SOLON
COUNTY: CUYAHOGA
LICENSE#:
DOCKET:

REGION: 3
STATE: OH
AGREEMENT: N

NOTIFICATION DATE: 09/11/98
NOTIFICATION TIME: 08:11 [ET]
EVENT DATE: 09/11/98
EVENT TIME: 08:11 [EDT]
LAST UPDATE DATE: 09/11/98

NOTIFICATIONS

JIM GAVULA, REG 3 RDO

JOHN ZEILER, REG 2 FEMA
VERN HODGE, PCEB NRR

NRC NOTIFIED BY: BRUCE FLUSCHE
HQ OPS OFFICER: JOHN MACKINNON

EMERGENCY CLASS: NOT APPLICABLE
10 CFR SECTION:
CDEG 21.21(c) (3) (i) DEFECTS/NONCOMPLIANCE

EVENT TEXT

Swagelok submitted the following Part 21 about a possible machining defect in certain one inch stainless steel Swagelok front ferrules

"We are writing to inform you about a possible machining defect in certain one inch stainless steel Swagelok front ferrules, part number SS-1613-1.

"The front ferrule is shipped as a component in a Swagelok tube fitting, or sold separately as a replacement part.

"A list containing the part numbers of assembled fittings and nuclear safety related certifications under which these ferrules have been sold is enclosed. All of these customers have already been notified by us about this possible problem. Only front ferrules with the heat codes ILA, JVA and JYL stamped on the part are affected; and only one inch ferrules are involved.

"The possible defect is that the 45 degree chamfer on the trailing edge of the ferrule may not be correct. A drawing is enclosed that shows this dimension, along with a drawing that illustrates the front ferrules' position in the Swagelok tube fitting. When these ferrules were machined, an improper set-up allowed a few pieces to be manufactured with an inappropriate dimension. Our inspection of the lots involved shows that about 0.019 per cent of the ferrules manufactured in these lots were affected.

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(Continued on next page)



tubing.

"Our corrective action includes doubling our sample size on these parts and implementing a long term project to 100 per cent inspect using automation."

Turkey Point, Oconee, and Duane Arnold were contacted by Swagelok of the Part 21 submitted by Swagelok.



Swagelok®

Swagelok Company
29500 Solon Road, Solon, OH 44139
Phone: 440-248-4600
Fax: 440-349-5970.

FACSIMILE COVER SHEET

Date: September 11, 1998
To: Document Control Desk/ NRC
From: Bruce Flusche
Total Pages: 5
Subject: Potential 10cfr21 notification

Original to follow by certified mail

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