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MCDUFFIE,M.A. Carolina Power & Light Co.
RECIP.NAME RECIPIENT AFFILIATION
DENTON,H.R. Office of Nuclear Reactor Regulation, Director

SUBJECT: Forwards response to Matls Engineering Branch draft SER Open Item 36 re beltline matl test requirements of 10CFR50,App G, Paragraph III.C.2.

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JUL 01 1983

Mr. Harold R. Denton, Director
Office of Nuclear Reactor Regulation
United States Nuclear Regulatory Commission
Washington, DC 20555

SHEARON HARRIS NUCLEAR POWER PLANT
UNIT NOS. 1 AND 2
DOCKET NOS. 50-400 AND 50-401
DRAFT SAFETY EVALUATION REPORT RESPONSES
MATERIALS ENGINEERING BRANCH

Dear Mr. Denton:

Carolina Power & Light Company (CP&L) hereby transmits one original and forty copies of the response to the Shearon Harris Nuclear Power Plant Draft Safety Evaluation Report (DSER) CP&L Open Item 36.

Carolina Power & Light Company will be providing responses to other Open Items in the DSER shortly.

Yours very truly,

M. A. McDuffie
Senior Vice President
Engineering & Construction

PS/kjr (7097PSA)
Attachment

cc: Mr. B. J. Elliot (NRC-MTEB)
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Mr. G. F. Maxwell (NRC-SHNPP)
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Shearon Harris Nuclear Power Plant
Draft Safety Evaluation Report (DSER)
Materials Engineering Branch
Open Item 36 (DSER Section 5.3.1.2, pages 5-12 and 5-19)

To demonstrate compliance with the beltline material test requirements of Paragraph III.C.2 of Appendix G, 10 CFR 50:

Indicate the post-weld heat treatment used in the fabrication of the beltline production and test welds.

Indicate the plates used to fabricate the test welds.

Indicate whether the test specimens for the beltline weld seams were removed from excess material in the vessel shell course following completion of the weld joint.

Response

The post weld heat treatment used in fabrication of the beltline production and test welds is as follows:

	Production Weld	Test Weld
Unit 1	1150°F - 10-1/4 Hr-FC	1150°F - 10 Hr-FC
Unit 2	1150°F - 9 Hr-FC	1150°F - 9-1/2 Hr-FC

Plates used to fabricate test welds are as follows:

Unit 1 Plate B4197-2 and A9153-1
Unit 2 Plate B4197-1 and A9154-2

Test specimens for beltline weld seams were removed from a separate weldment since the same welding process was used for longitudinal and circumferential welds in the plates.

The same weld procedure was used in fabricating the production welds and test weld. The following weld parameters were used to fabricate the welds.

Submerged Arc Weld	Electrode Size	Electrode Type	Current (Amps)	Voltage (Volts)	Travel (1 PM)
Single Wire*	3/16" dia.	RACD INMM	550-650	28-32	10-18
Tandem Wire (head)	3/16" dia.	RACD INMM	650-750	32-36	24 (Min.)
(trail)	3/16" dia.	RACD INMM	550-650	34-37	

*Single wire used until joint was wide enough for tandem wire welding.