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SUBJECT: Requests relief from ASME Code Section III NC-5230,Category C for field weld on line HBB-110-4.

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Drawings located in central files

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DEC 29 1994

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U.S. Nuclear Regulatory Commission
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SUSQUEHANNA STEAM ELECTRIC STATION
REQUEST FOR RELIEF FROM ASME CODE
SECTION III NC-5230, CATEGORY C FOR
LINE HBB-110-4, FIELD WELD 6
PLA-4219 FILE R41-2 **Docket No. 50-387**

The purpose of this letter is to request relief from ASME Code Section III NC-5230, Category C for field weld 6 on line HBB-110-4. During a review of radiograph microfilm on March 14, 1994, the Code required radiograph for a repair on HBB-110-4 field weld #6 station 26-39 could not be located.

The weld in question did not have radiographic examination (RT) records for one segment where a weld repair was performed. The weld is located on the 1D RHR Pump suction line (24") inside the Suppression Pool just above the lower suction strainer. From a review of the records, no record of a final RT being performed after weld repair could be found for station 26-39, one of 6 segments (approximately 13 inches each) around the circumference of the pipe. Liquid Penetrant Reports (PT-3614 and PT-3708) indicate there were two two-inch segments within station 26-39 that were in the process of being repaired. This report indicates that the Penetrant test of these two areas was acceptable following the grinding. However, there is no record of a final RT being performed following the repair. Records of final RTs performed at all of the other stations were located and found to be acceptable. Although there is no record of a final RT for Station 26-39, there is no reason to believe the weld is unacceptable given the information available at this time. The repair was performed in 1978 and the piping has been in service for a significant period of time with no known problems. Although no detailed inspections have been performed on this piping, a general visual inspection was performed during the Unit 1 sixth refueling and inspection outage by divers in this specific area of the Suppression Pool. The divers did not identify any problems with this piping. In addition, this weld is on a section of pipe that is not subjected to a differential pressure of any significance since the pipe is essentially open ended except as restricted by the suction strainers.

The location of this weld is shown on the attached design drawings (ISI-HBB-110-4 and M-151).

A047

9501040155 941229
PDR ADOCK 05000387
P PDR

Drawings located in Central Files.

We believe that this relief is acceptable based upon:

- The weld is located under water in the wetwell. The ISI examination selection criteria allow for excluding components that are not accessible. Radiographic examinations are used to evaluate ISI (NDE) indications; however, since this weld will not be NDE examined during its service life, a final radiograph will not be used for comparison purposes.

- The liquid penetrant tests show no indications.

- The final radiographs on the other stations were acceptable.

- During a general visual inspection of the suppression pool, no problems were identified.

If you have any questions, please contact Mr. C. T. Coddington at (610) 774-7915.

Very truly yours,

R. G. Byram

Attachments

cc: NRC Region I
Ms. M. Banerjee, NRC Sr. Resident Inspector
Mr. C. Poslusny Jr., NRC Sr. Project Manager

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A-005

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INTERIM DRAWING CHANGE NOTICE

1. PAGE 1 OF 1

2. DATE 2-10-86

3. QUALITY CLASSIFICATION

- [x] SAFETY RELATED
- [ ] NON-QUALITY
- [x] ASME III OR XI
- [ ] OTHER QUALITY

OTHER QUALITY DEFINITION NA

4. CONFIGURATION DATA

(a) PMR NO. 84-9018 (b) MP NO. 84-9018

(c) DRAWING NO. HBB-110-4

(d) SHEET NO. 1 (e) REVISION 3

(f) IDCN NO. 1

(g) SYSTEM AFFECTED NO. 149

(h) SUPERSEDES/CANCELS IDCN NO. NA

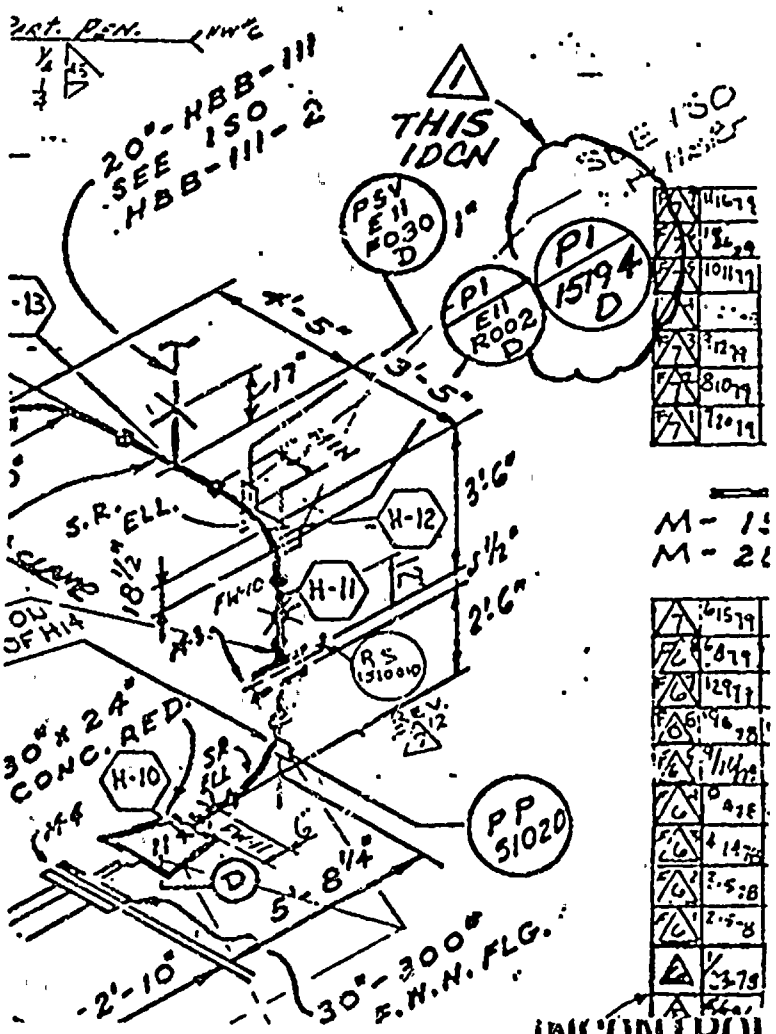
5. PREPARED BY [signature] DATE 2-10-86

6. ISSUED BY [signature] DATE 2-14-86

7. VERIFIED BY [signature] DATE 3/20/86

8. APPROVED BY [signature] DATE 1/7/87

9.



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ASMR N-5 SYS ITEM 1-49A

ASME AS BUILT
N-5 PACKAGE PREP.
ALL CHANGES AFTER REV. 7 F9
THIS DRAWING MUST BE ACCOMPANIED BY CODE DATA ENGINEER.

Rev.	Init.
F9	
F8	
F7	
F6	
F5	
F4	
F3	
F2	
F1	

SYSTEMS
THIS DWG. 1-49A

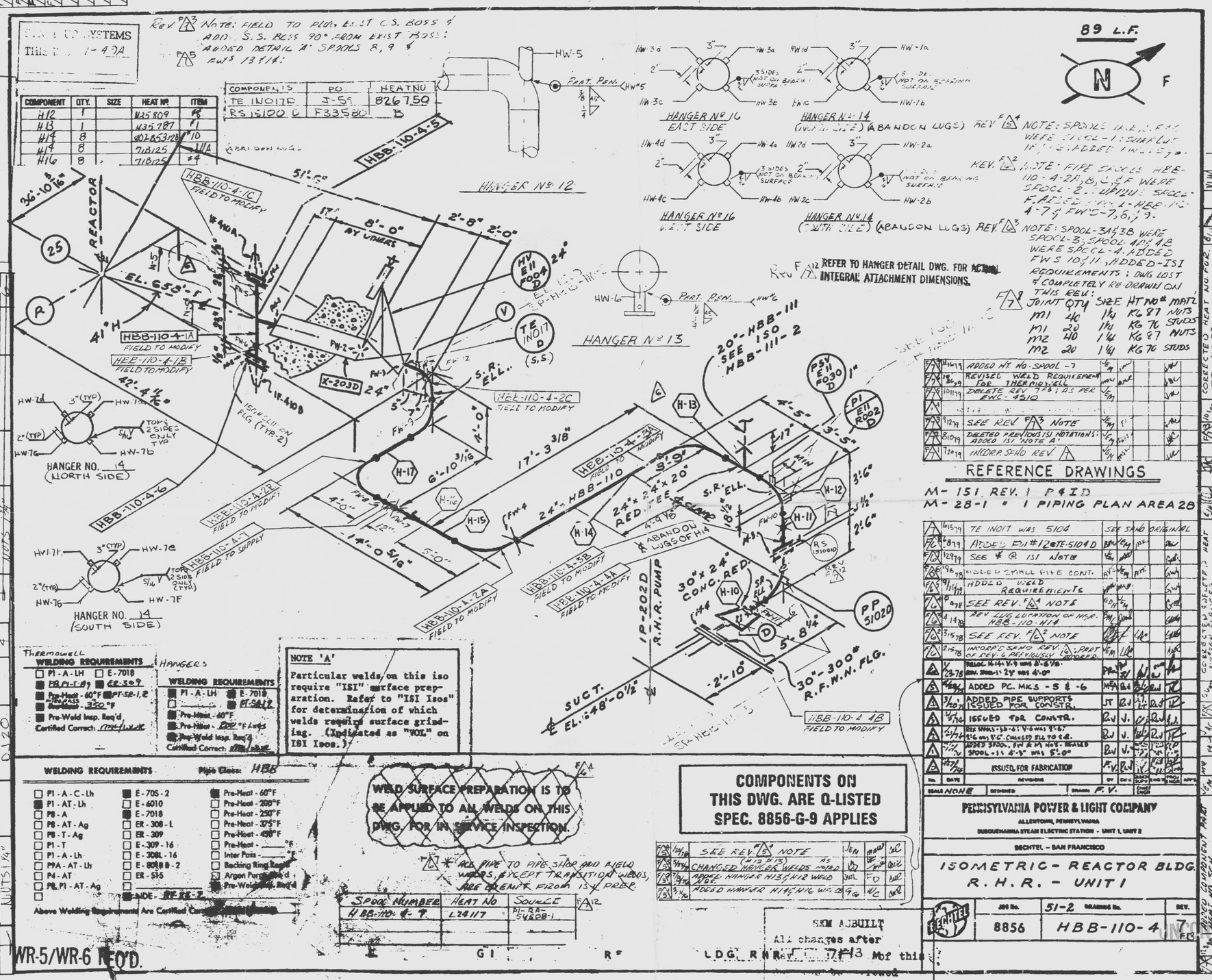
REV F3 NOTE: FIELD TO PLUG EXIST C.S. BOSS & ADD S.S. BOSS 90° FROM EXIST BOSS: ADDED DETAIL 'A' SPOOLS 8, 9 & FWS 13 & 14.

REV F5 FWS 13 & 14.

COMPONENTS	PO	HEAT NO
TE IN017D	J-59	826750
RS 15100 D	F33580	B

COMPONENT	QTY.	SIZE	HEAT Nº	ITEM
H12	1		M25809	#8
H13	1		M35787	#1
H14	8		802-853/120	#10
H15	8		7/8/125	N/A
H16	8		7/8/125	#9

(ABANDON LUGS)



Joint	Qty	Size	Ht No#	Matl
M1	40	1 1/4	KG87	NUTS
M1	20	1 1/4	KG76	STUDS
M2	40	1 1/4	KG87	NUTS
M2	20	1 1/4	KG76	STUDS

Rev.	Date	Revisions	By	Chk	Design Eng.	Proj. Eng.	Appr.
F7	11/16/99	ADDED HT No. SPOOL -7					
F6	10/28/99	REVISED WELD REQUIREMENT FOR THERMOWELL					
F5	10/11/99	DELETE REV. 7 F8; AS PER EWC-4510					
F4							
F3	9/12/99	SEE REV. F3 NOTE					
F2	8/10/99	DELETED PREVIOUS ISI NOTATIONS: ADDED ISI 'NOTE A'					
F1	7/20/99	INCORP. SEND REV. 1					

REFERENCE DRAWINGS

M-151 REV. 1 P&ID
M-28-1 " 1 PIPING PLAN AREA 28

Rev.	Date	Revisions	By	Chk	Design Eng.	Proj. Eng.	Appr.
F6	11/15/79	TE INO17 WAS 5104		SEE SEND	ORIGINAL		
F5	12/8/79	ADDED FW #12 & TE-5104D					
F4	12/9/79	SEE * @ 151 NOTE					
F3	9/26/79	ADDED SMALL PIPE CONT.					
F2	9/11/79	ADDED WELD REQUIREMENTS					
F1	4/9/79	SEE REV. F4 NOTE					
G	1/4/78	REV LUG LOCATION OF HGR. HBB-110-H14					
F	3/15/78	SEE REV. F2 NOTE					
E	2/15/78	INCORP. SEND REV. 1; PART OF REV. G PREVIOUSLY INCORP'D.					
D	12/23/78	RELOC. H-14: V-9 WAS 8'-6 3/8"; DIM. HBB-11 2'-9" WAS 4'-0"					
C	8/24/78	ADDED PC. MKS -5 & -6					
B	7/20/78	ADDED PIPE SUPPORTS ISSUED FOR CONSTR.					
A	5/26/78	ISSUED FOR CONSTR.					
1	2/17/78	REV. SPOOL-10-4: V-8 WAS 8'-6"; 216 WAS 8'-6"; CHANGED ELL TO S.R.					
0	1/24/78	ADDED SPOOL, FW 6 & M1 NOS.; REVISED SPOOL-11: 4'-9" WAS 5'-0"					
	12/7/77	ISSUED FOR FABRICATION					

SCALE NONE | DESIGNED | DRAWN F. V.

PENNSYLVANIA POWER & LIGHT COMPANY
ALLENTOWN, PENNSYLVANIA
SUSQUEHANNA STEAM ELECTRIC STATION - UNIT 1, UNIT 2
BECHTEL - SAN FRANCISCO

ISOMETRIC - REACTOR BLDG.
R.H.R. - UNIT 1

Job No.	Drawing No.	Rev.
8856	HBB-110-4	7

Rev.	Date	Revisions	By	Chk	Design Eng.	Proj. Eng.	Appr.
F5	1/4/78	SEE REV. F5 NOTE	JEN				
F4	5/24/78	CHANGED HANGER WELDS (H13 & H15) AS NOTED					
F3	7/9/78	ADDED HANGER H15 & H12 WELD	JWL		FD		
F2	7/5/78	ADDED HANGER H14, H16 WELDS					

Rev.	Date	Revisions	By	Chk	Design Eng.	Proj. Eng.	Appr.
F1	6/27/78	CORRECTED FINISHED HEAT NO. FOR TE INO17D					
F	6/21/78	CORRECTED RS 15100D TO BOT ADDED HANGER PIPE NO.					
E	3/15/78	CHANGED RS 15100D TO BOT. HANGER PIPE NO.					
D	12/12/77	ADDED COMPONENT PART HEAT AND SEQ.					
C	11/30/77	CORRECTED FINISHED HEAT NO. FOR HANGER PIPE					
B	11/15/77	DRAWING REVISED PER DATA REQUIREMENTS					
A	11/14/77	ADDED N-5 BOUNDARY					

Docket # 50-387
Accession # 9501042153-01
Date 12/29/94 of Ltr.
Regulatory Docket File

950100269

D

Component	Qty.	Source	Heat No.	Trace No.	Stud/Nut Size	Flange
	6					
	12		D871			
	28					
	56		E264			
	56		E275			
	1					
	1					
	2					
	1					
	29					
	1					
	4					
	1					
	16					
	1					
	2					
	1					
	1					
	1