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 SCHWERCER, A. Licensing Branch 2

SUBJECT: Forwards updated preservice insp program info re SER
 Issue 19. Revision includes preservice exams performed
 subsequent to util 810519, 0616 & 820523 submittals.

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AUG 20 1982

Mr. A. Schwencer, Chief
Licensing Branch No. 2
Division of Licensing
U.S. Nuclear Regulatory Commission
Washington, D.C. 20555

SUSQUEHANNA STEAM ELECTRIC STATION
SER ISSUE NO. 19
PRESERVICE INSPECTION PROGRAM REVISIONS
ER 100450 FILE 841-2
PLA-1228

Docket Nos. 50-387
50-388

References: letter dated 5/19/81 (PLA-813, Curtis to Schwencer)
letter dated 6/16/81 (PLA-846, Curtis to Schwencer)
letter dated 5/23/82 (PLA-1053, Curtis to Schwencer)

Dear Mr. Schwencer:

The attached information updates the preservice inspection program transmitted via the above referenced correspondence. Pages from the initial transmittal have been revised to include current information obtained as a result of preservice examinations performed subsequent to the last revision.

The following items are attached:

1. Revision 3 of Relief Request #4
2. Revision 2 of Relief Request #5
3. Revision 2 of Relief Request #6
4. Relief Request #11
5. Relief Request #12
6. Relief Request #13

Please call if you have any questions.

Very truly yours,

N. W. Curtis
Vice President-Engineering & Construction-Nuclear

Attachment 8208240151 Q

BOO!

WELD IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	% OF SCAN OBSTRUCTED	ASME SECTION III EXAMINATION	SAFETY IMPACT -
VNB-B21-1-20B	BJ B4.5	NUCLEAR BOILER	PIPE TO ELBOW	PIPE SUPPORT	20%	RT, PT	Weld cannot be isolated from the reactor coolant pressure boundary; however, leak detection systems detect leakage. Plant technical specifications require shutdown with leakage greater than 5 gpm.
DBB-114-1-1L	CF C2.1	HPCI	PIPE TO ELBOW	4 LUGS	35%	RT	Leak detection systems detect weld leakage, resulting in either manual or automatic isolation of the leak. These lines are not required for normal safe shutdowns and alternate shutdown methods are available.
HBB-101-1-FW9	CG C2.1	RCIC	ELBOW TO VALVE	BRANCH CONNECTION	10%	RT	Leak detection system detects significant leakage; containment isolation valves perform weld isolation function. HPCI performs back-up function for RPV water addition for safe shutdown.

WELD IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	% OF SCAN OBSTRUCTED	ASME SECTION III EXAMINATION	SAFETY IMPACT
VNB-B21-1-19B	BJ B4.5	MAIN STEAM	ELBOW TO PIPE	ADJACENT WELD	16%	RT, PT	Weld cannot be isolated from the reactor coolant pressure boundary; however, RCPB leak detection systems detect leakage. Plant technical specifications require shutdown with leakage greater than 5 gpm.
VNB-B21-1-19A	BJ B4.5	MAIN STEAM	ELBOW TO PIPE	ADJACENT WELD	16%	RT, PT	" " "
VNB-B21-2-18A	BJ B4.5	MAIN STEAM	ELBOW TO PIPE	ADJACENT	16%	RT, PT	" " "
VNB-B21-2-18B	BJ B4.5	MAIN STEAM	ELBOW TO PIPE	ADJACENT WELD	16%	RT, PT	" " "
VRR-B31-2-9G	BJ B4.5	RECIRCULATION	LONGITUDINAL WELD	PIPE WHIP RESTRAINT	7%	RT and PT	Reactor coolant pressure boundary leak detection system detect leakage. Plant technical specifications require plant shutdown with leakage greater than 5 gpm.
VNB-B21-1-20F	BJ B4.6	MAIN STEAM	PIPE TO BRANCH	LUG	25%	RT and PT	Weld is located within reactor coolant pressure boundary. Leak detection system detects leakage. Plant technical specifications require plant shutdown with leakage greater than 5 gpm.

3

3

WELD IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	% OF SCAN OBSTRUCTED	ASME SECTION III EXAMINATION	SAFETY IMPACT
GBB-104-3-FW10	CF C2.1	RHR	PIPE TO VALVE	WELDOLET	5%	RT	During normal plant power operation, welds are not under pressure. During normal system operation, significant leakage can effect pressure boundary of one RHR loop. Leakage is detectable by leak detection systems or loss of system function. Plant can be safely cooled down by unaffected RHR loop or main condenser.
DBB-114-1-7C	CF C2.1	HPCI	PIPE TO ELBOW	4 LUGS	25%	RT	Leak detection systems detect weld leakage, resulting in either manual or automatic isolation of the leak. These lines are not required for normal safe shutdowns and alternate shutdown methods are available.
GBB-115-1-FW4	CG C2.1	RHR	VALVE TO PIPE	LAMINATIONS	13%	RT	During plant power operation, weld not pressurized. During normal system operation, significant leakage detected by leak detection systems. Alternate shutdown cooling path is unaffected and condenser is available for cooldown.

WELD IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	% OF SCAN OBSTRUCTED	ASME SECTION III EXAMINATION	SAFETY IMPACT.
VNB-B21-2-17F	BJ B4.6	MAIN STEAM	PIPE TO BRANCH CONNECTION	LUG	25%	RT and PT	Weld is located within the reactor coolant pressure boundary, weld cannot be isolated. Reactor coolant pressure boundary leak detection system detects leakage. Plant technical specs require plant shutdown with leakage greater than 5 gpm.
VNB-B21-2-17B	BJ	MAIN STEAM	PIPE TO ELBOW	PIPE SUPPORT	17%	RT and PT	" " "

3

WELD IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	% OF SCAN OBSTRUCTED	ASME SECTION III EXAMINATION	SAFETY IMPACT
VBB-102-2-FW6	CG C2.1	CRD	PIPE TO ELBOW	PIPE SUPPORT	TOTALLY	RT	During normal operation of the CRD system, significant leakage will be detected by area radiation monitors. Leakage can be manually isolated.
DBB-122-2-FW13	*	RWCU	PIPE TO PIPE	WALL PENETRATION	TOTALLY	RT	Leak detection system detects weld leakage resulting in either manual or automatic isolation of the leak. These lines are not required for normal safe shutdowns; alternate shutdown methods are available.

*Augmented Examination Per Susquehanna SES FSAR Section 6.6.8.

RELIEF REQUEST # 6

I. IDENTIFICATION OF COMPONENTS:

Class 1, Category BJ, pressure retaining welds in piping.

Class 2, Category CF and CG pressure retaining welds in piping.

II. CODE REQUIREMENT:

Category BJ - Table IWB-2600, Item Numbers B4.5, B4.6, B4.7 - of the ASME Code, 1974 Edition to Summer 1975 Addenda requires volumetric examination of 100%* of circumferential welds, longitudinal welds, and branch connections be performed completely as a preservice examination requirement prior to initial plant start-up.

Category CF/GG - Table IWC-2600, Item Numbers C2.1, C2.2, C2.3 - of the ASME Code, 1974 Edition to Summer 1975 Addenda requires volumetric examination of 100% and 50%*, respectively of circumferential discontinuity welds, longitudinal welds, and branch connection welds be performed completely as a preservice examination requirement prior to initial plant start-up.

*excluding those exempt per IWB-1220, IWC-1220.

ASME Appendix III, Winter 1975 Addenda, requires an angle beam examination of the weld and required volume (the lesser of $\frac{1}{4}t$ or 1") be performed scanning both normal and parallel to the weld.

III. BASIS FOR RELIEF:

Relief is required from the ASME Section XI examination requirements on the basis of inaccessibility of the weld and required volume due to geometric configuration.

WELD IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	% OF SCAN OBSTRUCTED	ASME SECTION III EXAMINATION	SAFETY IMPACT
VRR-B31-1-2U	BJ B4.5	REACTOR RECIRCULATION	FITTING LONGITUDINAL WELD	PART GEOMETRY	7%	RT and PT	Weld is within the reactor pressure boundary and cannot be isolated. RCPB leak detection systems detect leakage. Plant technical specifications require plant shutdown with leakage greater than 5 gpm.
VRR-B31-1-2V	BJ B4.5	REACTOR RECIRCULATION	FITTING LONGITUDINAL WELD	PART GEOMETRY	7%	RT and PT	" " "
VRR-B31-1-3L	BJ B4.5	REACTOR RECIRCULATION	FITTING LONGITUDINAL WELD	PART GEOMETRY	7%	RT and PT	" " "
VRR-B31-1-3K	BJ B4.5	REACTOR RECIRCULATION	FITTING LONGITUDINAL WELD	PART GEOMETRY	7%	RT and PT	" " "
VNB-B21-2-2C	BJ B4.6	MAIN STEAM	PIPE TO BRANCH	PART GEOMETRY	TOTALLY	RT and PT	" " "

WELD IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	% OF SCAN OBSTRUCTED	ASME SECTION III EXAMINATION	SAFETY IMPACT
VRR-B31-2-2U	BJ B4.5	REACTOR RECIRCULATION	FITTING LONGITUDINAL WELD	PART GEOMETRY	7%	RT and PT	Weld is within reactor coolant pressure boundary and cannot be isolated. RCPB leak detection systems detect leakage. Plant technical specifications require plant shutdown with leakage greater than 5 gpm.
HBB-111-1-1A	CF C2.1	RHR	ELBOW TO REDUCER	PART GEOMETRY	TOTALLY	RT	During plant power operation, weld is not pressurized. During normal system operation, significant leakage is detected by leak detection systems. Alternate shutdown cooling path is unaffected and condenser is also available for cooldown.
VRR-B31-2-10R	BJ B4.5	REACTOR RECIRCULATION	FITTING LONGITUDINAL WELD	PART GEOMETRY	18%	RT and PT	Weld is within the reactor pressure boundary and cannot be isolated. RCPB leak detection systems detect leakage. Plant technical specifications require plant shutdown with leakage greater than 5 gpm.
VRR-B31-2-10S	BJ B4.5	REACTOR RECIRCULATION	FITTING LONGITUDINAL WELD	PART GEOMETRY	18%	RT and PT	" " "

WELD IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	% OF SCAN OBSTRUCTED	ASME SECTION III EXAMINATION	SAFETY IMPACT
GBB-101-4-15BP	CG C2.1	CORE SPRAY	PIPE TO PIPE	PIPE SCHEDULE VARIATION	50%	RT	During normal plant power operation, weld is not pressurized. During normal system operation, weld is under a maximum pressure of 460 psig. Leak detection system detects significant leakage; plant can be safely cooled down by unaffected core spray loop.
DBB-122-1-FW25	*	RWCU	ELBOW TO VALVE	PART GEOMETRY	TOTALLY	RT	Leak detection systems detect weld leakage, resulting in either manual or automatic isolation of leak. These lines are not required for normal safe shutdowns and alternate shutdown methods are available.
DCB-102-1-FW2	BJ B4.5	RHR	FLUED HEAD VALVE	PART GEOMETRY	15%	RT	Weld is not pressurized during plant power operation. During normal system operation, (RHR, HPCI, RCIC), leak detection systems detect significant leakage. HPCI and RCIC are not required for normal shutdowns; cooldown can be achieved by unaffected RHR loop or the main condenser.
DCA-109-2-FW2	BJ B4.5	CORE SPRAY	FLUED HEAD TO VALVE	PART GEOMETRY	12%	RT	" " "

WELD IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	% OF SCAN OBSTRUCTED	ASME SECTION III EXAMINATION	SAFETY IMPACT
DCA-109-1-FW2	BJ B4.5	CORE SPRAY	FLUED HEAD TO VALVE	PART GEOMETRY	12%	RT	" " "
HBB-118-2-FW3	CG C2.1	CONTAINMENT ATMOSPHERE CONTROL	VALVE TO FLUED HEAD	PART GEOMETRY	TOTALLY	RT	Weld is not pressurized during normal power plant operation. During normal system operation, weld is exposed to a pressure of less than 10 inches of water. Leakage is detectable during ILRT. System is not required for plant shutdown.
DBA-108-1-FW8	BJ B4.5	NUCLEAR BOILER	FLUED HEAT TO VALVE	PART GEOMETRY	TOTALLY	RT, PT	Affects the reactor coolant pressure boundary; however, inside containment isolation valve performs RCPB isolation function. Leakage would be detected by leak detection systems; plant may be shut-down using unaffected systems.
DBA-108-1-FW5	BJ B4.5	NUCLEAR BOILER	VALVE TO ELBOW	PART GEOMETRY	TOTALLY	RT, PT	" " "
VRR-B31-2-3N	BJ B4.5	REACTOR RECIRCULATION	FITTING LONGITUDINAL WELD	PART GEOMETRY	7%	RT, PT	Weld is within reactor coolant pressure boundary and cannot be isolated. RCPB leak detection system detects leakage. Plant technical specifications require plant shutdown with leakage greater than 5 gpm.

WELD IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	% OF SCAN OBSTRUCTED	ASME SECTION III EXAMINATION	SAFETY IMPACT
VRR-B31-2-3P	BJ B4.5	REACTOR RECIRCULATION	FITTING LONGITUDINAL WELD	PART GEOMETRY	7%	RT, PT	Weld is within reactor coolant pressure boundary and cannot be isolated. RCPB leak detection system detects leakage. Plant technical specifications require plant shutdown with leakage greater than 5 gpm.
VRR-B31-2-2V	BJ B4.5	REACTOR RECIRCULATION	FITTING LONGITUDINAL WELD	PART GEOMETRY	7%	RT, PT	" " "

*Augmented Examination Per Susquehanna SES FSAR Section 6.6.8.

PRESERVICE INSPECTION
RELIEF REQUEST #11

I. IDENTIFICATION OF COMPONENTS:

Class 2, Category CF and CG pressure retaining welds in Core Spray (1P206A,B,C,D) and RHR (1P202A,B,C,D) pumps.

II. CODE REQUIREMENT:

Category CF/CG - Table IWC-2600, Item Number C3.1 of ASME Section XI, 1974 Edition to Summer 1975 Addenda requires full volumetric examination of 100% and 50%*, respectively, of pump casing welds. These examinations must be performed completely as a preservice examination requirement prior to initial plant start-up.

*Excluding those exempt per IWC-1220.

III. BASIS FOR RELIEF:

Relief is required from the ASME Section XI examination requirements on the basis of inaccessibility of the weld and required volume due to pump installation.

IV. JUSTIFICATION:

The justification for requesting relief from ASME Section XI examination requirements is as follows:

1. The structural integrity of the pump pressure boundary has been established by ASME Section III testing requirements.
2. Accessible pump casing welds have been satisfactorily inspected to ASME Section XI.
3. Pump installation meets manufacturer requirements.

V. ALTERNATE PROVISIONS:

Welds are inaccessible for alternate NDE methods.

RELIEF REQUEST #11

WELD IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	% OF SCAN OBSTRUCTED (APPROXIMATE)
1P-206A,B,C-359-2-L2	CG C3.1	Core Spray	Shell Longitudinal Seam	Encased in Concrete	Totally
1P-206B,D-359-1-2	CG C3.1	Core Spray	Hub Flange to Shell	Encased in Concrete	Totally
1P-206A-359-2-L1	CG C3.1	Core Spray	Shell Longitudinal Seam	Encased in Concrete	Totally
1P202A,B,C,D-359-1-2	CF C3.1	RHR	Hub Flange to Shell	Encased in Concrete	Totally
1P202A,B,C,D-359-2-L2	CF C3.1	RHR	Shell Longitudinal Seam	Encased in Concrete	Totally
1P202A,B,C,D-359-2-2	CF C3.1	RHR	Shell Circumferential Seam	Encased in Concrete	Totally
1P202A,B,C,D-359-2-L1	CF C3.1	RHR	Shell Longitudinal Seam	Encased in Concrete	Totally
1P202A,B,C,D-359-2-3	CF C3.1	RHR	Shell to Bottom Head	Encased in Concrete	Totally
1P202A,B,C,D-359-3-7	CF C3.1	RHR	Bottom Head to Bearing Housing	Encased in Concrete	Totally
1P202A,B,C,D-361-2-6	CF C3.1	RHR	Discharge Elbow to Bottom Plate Flange	Encased in Concrete	Totally
1P202A,B,C,D-361-6-7	CF C3.1	RHR	Discharge Elbow to Sleeve Forging	Encased in Concrete	Totally
1P202A,B,C,D-361-7-8	CF C3.1	RHR	Sleeve Forging to Top Closure Plate	Encased in Concrete	Totally

RELIEF REQUEST #11

ASME
SECTION III
EXAMINATION

SAFETY IMPACT

PT, RT	During normal plant power operation, weld is not pressurized. During normal system operation, weld is under a maximum pressure of 475 psig. Leak detection system detects significant leakage; plant can be safely cooled down by unaffected core spray loop.		
PT, RT	"	"	"
PT, RT	"	"	"
PT, RT	During normal plant power operation, weld is not pressurized. During normal system operation, weld is under a maximum pressure of 460 psig. Leakage can be detected by leak detection system and can affect one RHR loop. Plant can be safely cooled down by unaffected RHR loop.		
PT, RT	"	"	"
PT, RT	"	"	"
PT, RT	"	"	"
PT, RT	"	"	"
PT, RT	"	"	"
PT, RT	"	"	"
PT, RT	"	"	"
PT, RT	"	"	"

PRESERVICE INSPECTION
RELIEF REQUEST #12

I. IDENTIFICATION OF COMPONENTS:

All Class 1 and Class 2 integrally welded support members for piping, pumps, valves, and pressure vessels.

II. CODE REQUIREMENT:

The examination requirements for Code Category B-K-1 and C-E-1 have been upgraded to meet the requirements of ASME Section XI 1977 Edition to the Summer 1978 Addenda as follows:

Item Number	Examination Category	Component	Method	Test Requirements
B4.9, B6.5	B-K-1	Integrally Welded Support Attachments	Volumetric or Surface*	Table IWB-2500-1
C3.10, C3.40, C3.70, C3.100	C-E	Integrally Welded Support Attachments	Surface**	Table IWC-2500-1

* See Figures IWB-2500-13,14,15.

** See Figure IWC-2520-5.

III. BASIS FOR RELIEF:

Relief is required from the ASME Section XI examination requirements for the listed integrally welded support attachment on the basis of partial inaccessibility of the support for examination.

IV. JUSTIFICATION:

The justification for requesting relief from ASME Section XI preservice examination requirements is as follows:

1. The structural integrity of the piping pressure boundary has been verified by ASME Section III testing requirements.
2. Accessible portions of the welded attachments have been satisfactorily inspected to ASME Section XI.
3. Limited inspection does not impact plant safety.

COMPONENT IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	TOTAL AREA OBSTRUCTED (APPROXIMATE)	ASME SECTION III EXAMINATION	SAFETY IMPACT
GBB-106-1-H22	C-E C3.40	RHR	4 LUGS	HANGER STRAP	25%	SURFACE	Stress analysis calculations performed assuming the portion of inaccessible weld is non-existent indicate all lugs and local stresses are within allowable limits.
GBB-106-1-H5	C-E C3.40	RHR	8 LUGS	HANGER STRAP	25%	SURFACE	Stress analysis calculations performed assuming the portion of inaccessible weld is non-existent indicate all lugs and local stresses are within allowable limits.
HBB-110-3-H23	C-E C3.40	RHR	8 LUGS	HANGER STRAP	25%	SURFACE	Stress analysis calculations performed assuming the portion of inaccessible weld is non-existent indicate all lugs and local stresses are within allowable limits.
HBB-110-1-H5	C-E C3.40	RHR	8 LUGS	HANGER STRAP	25%	SURFACE	Stress analysis calculations performed assuming the portion of inaccessible weld is non-existent indicate all lugs and local stresses are within allowable limits.
GBB-101-4-H16	C-E C3.40	CS	LUG	PART GEOMETRY	5%	SURFACE	Stress analysis calculations performed assuming the portion of inaccessible weld is non-existent indicate all lugs and local stresses are within allowable limits.

V. ALTERNATE PROVISIONS:

Alternate nondestructive examination methods are not feasible due to restricted access.

MS:saw
SA-1

Relief Request #12
Rev. 0, 6/18/82

PRESERVICE INSPECTION
RELIEF REQUEST #13

I. IDENTIFICATION OF COMPONENTS:

Class 2 pressure retaining welds and pressure retaining nozzle welds in the Residual Heat Removal heat exchangers.

II. CODE REQUIREMENT:

Category C-A of ASME Section XI, 1974 Edition to Summer 1975 Addenda requires volumetric examination of shell and head circumferential discontinuity welds and base material for one plate thickness beyond the edge of the weld joint.

Category C-B of ASME Section XI, 1974 Edition to Summer 1975 Addenda requires volumetric examination of 100% of the nozzle-to-vessel attachment welds.

These examinations must be performed completely, once, as a preservice examination requirement prior to initial plant startup.

III. BASIS FOR RELIEF:

Relief is required from the ASME Section XI examination requirements on the basis of partial inaccessibility of the weld due to design of the component.

IV. JUSTIFICATION:

The justification for requesting relief from ASME Section XI preservice examination requirements is as follows:

1. The structural integrity of the pressure boundary has been verified by ASME Section III construction code testing requirements.
2. Accessible portions of the welded attachments have been satisfactorily inspected to ASME Section XI.

V. ALTERNATE PROVISIONS:

A surface examination will be performed on the unexamined areas.

WELD IDENTIFICATION NUMBER	CODE CATEGORY AND ITEM NUMBER	SYSTEM	CONFIGURATION	NATURE OF OBSTRUCTION	% OF SCAN OBSTRUCTED (APPROXIMATED)
IE-205-A-R	CA Cl.1	RHR	SHELL TO HEAD	WELDED ATTACHMENT	15%
IE-205-A-A	CB Cl.2	RHR	SHELL TO NOZZLE	ADJACENT WELD	8%
IE-205-A-AC	CA Cl.1	RHR	SHELL TO FLANGE	OUTLET NOZZLE	7%
IE-205-B-R	CA Cl.1	RHR	SHELL TO HEAD	WELDED ATTACHMENT	15%
IE-205-B-A	CB Cl.2	RHR	SHELL TO NOZZLE	ADJACENT WELD	8%
IE-205-B-AC	CA Cl.1	RHR	SHELL TO FLANGE	OUTLET NOZZLE	7%

Relief Request #13
Rev. 0 6/14/82

ASME
SECTION III
EXAMINATION

SAFETY IMPACT

PT, UT, RT

During normal plant power operation, weld is not pressurized. During normal system operation, weld is under a maximum pressure of 460 psig. Leak detection system detects significant leakage and can affect one RHR loop. Plant can be safely cooled down by unaffected RHR loop.

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PT, UT, RT

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