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 RECIP. NAME RECIPIENT AFFILIATION
 CARLSON, R. Region 1, Philadelphia, Reactor Construction & Engineeri

SUBJECT: Interim deficiency rept re reactor pedestal embedment PB-37.
 Welding procedure deviations found in eight sections of
 rebar which were field welded to shear bars. Procedures for
 welding not qualified or tested. Final rept submitted 801208.

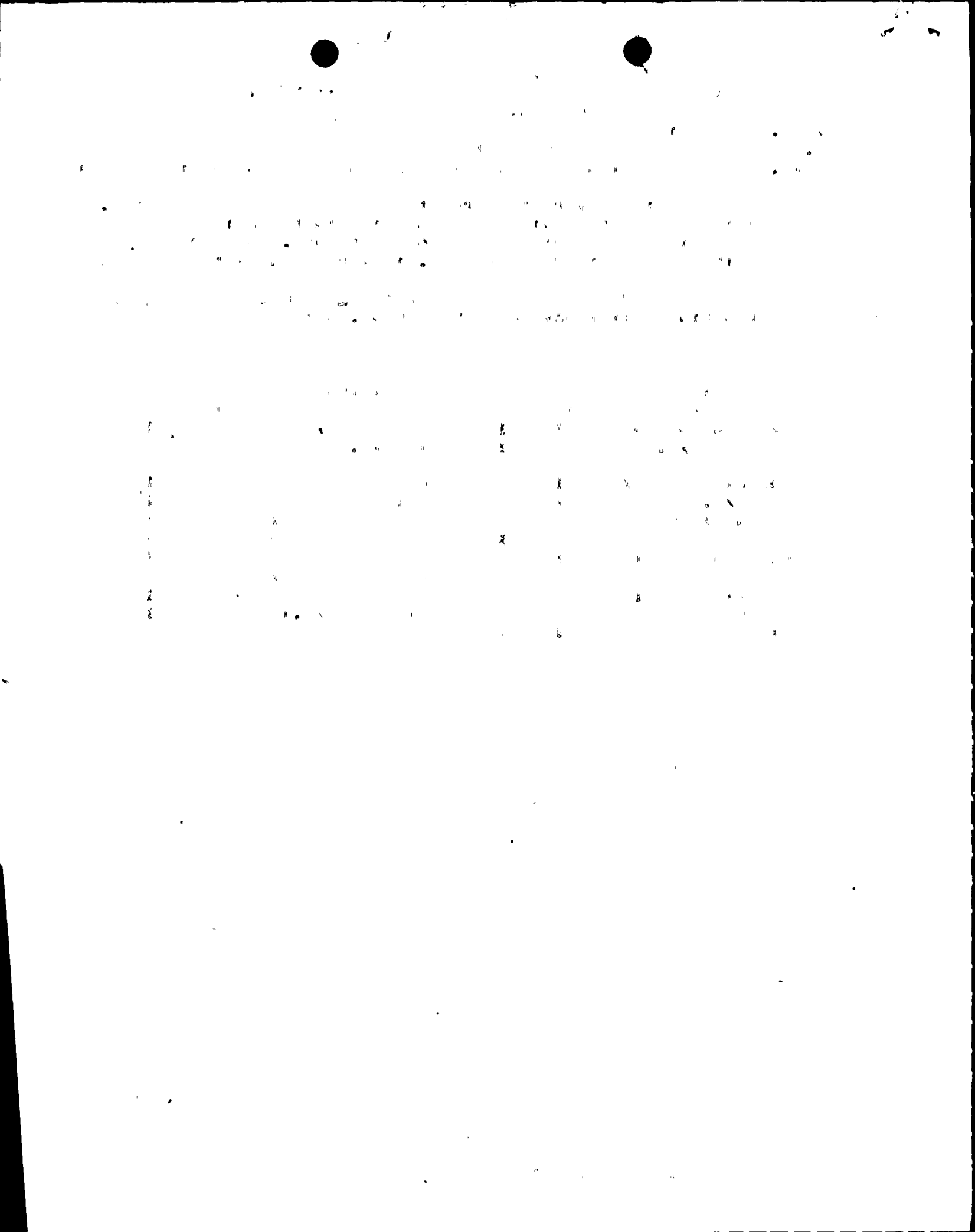
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October 8, 1980

Office of Inspection and Enforcement
Region I
Att: Mr. R. Carlson, Chief
Reactor Construction and Engineering
Support Branch
U.S. Nuclear Regulatory Commission
631 Park Avenue
King of Prussia, PA 19406

Dear Mr. Carlson:

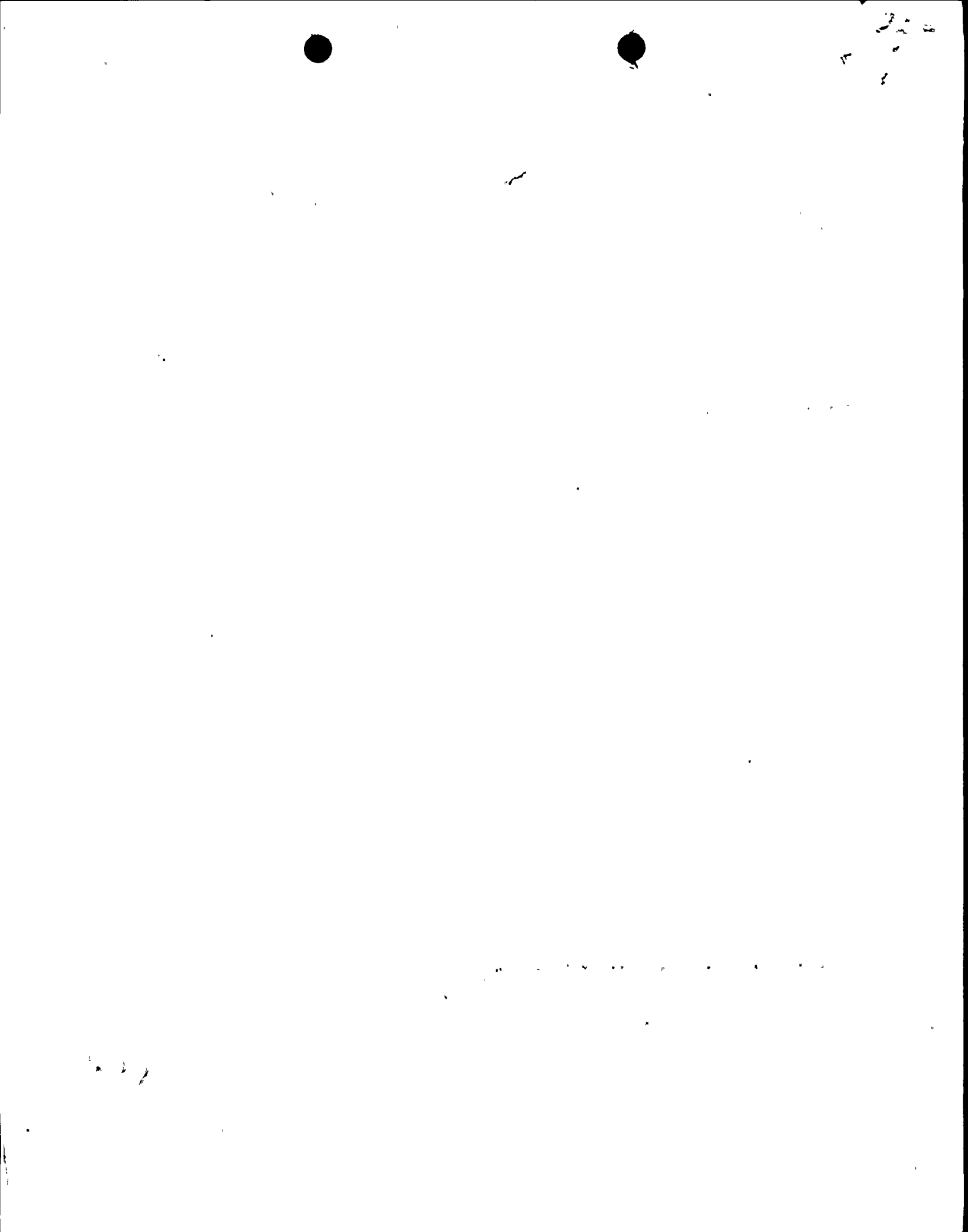
Re: Nine Mile Point Unit 2
Docket 50-410

On September 8, 1980 Mr. McGaughy of your staff was notified of a potential reportable deficiency under 10CFR50.55(e) at Nine Mile Point Unit 2 involving reactor pedestal embedment PB-37. The following deviations have been identified with eight sections of No. 14 rebar which were field welded to shear bars on reactor pedestal embedment PB-37:

1. The welding procedure used was an ASME Section III procedure but was not qualified to the code applicable for the work performed (i.e. AWS D12.1).
2. The welder was qualified to ASME Section IX but not to the applicable code (i.e. AWS D12.1).
3. The welds were not tested using sister splices as required by the specification.

This particular cadwelding was limited to these eight rebar welds and has been evaluated as follows:

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1. The welding procedure used for the welding of No. 14 rebar to plate PB-37 is qualified to ASME Section III and was used with 300°F preheat. This procedure is adequate for the work performed and will provide acceptable results. This has been verified by comparing the welding parameters specified in the procedure used with those specified in a procedure qualified to AWS D12.1.
2. The welding procedure used is comparable to an approved AWS D12.1 procedure and the welder was qualified to the same procedure. A review of the welder's previous qualifications indicates that the rebar and plate that he actually welded are of essentially the same chemistry as the materials he was qualified to weld.
3. A visual inspection was performed and documented for these rebar welds indicating that surface cracks or discontinuities were not present.
4. Initially, the design of embdement PB-37 was based on a pullout load of 405 Kips. Subsequently, the actual pullout load to be resisted by this plate for the worst loading condition has been determined to be 336 Kips. Eight No. 14 rebar welded to the plate can provide maximum pullout capacity of 704 kips. Therefore, the welds in question will not be stressed to full design load. Design calculations of the plate indicate that maximum pullout load on any single No. 14 rebar is 31.4 kips for the worst loading condition, which is far less than the allowable load of 88 kips.

In order to further assure the adequacy of the welding procedure used, three sister splices will be prepared using the aforementioned ASME Section III procedure and tested for tensile stress. Action to prevent recurrence is being evaluated. A final report containing this information will be sent to you by December 8, 1980.

Very truly yours,

NIAGARA MOHAWK POWER CORPORATION



Gerald K. Rhode
Vice President

System Project Management

PEF:bd

~~xc: Director of Inspection & Enforcement~~
U. S. Nuclear Regulatory Commission
Washington, D. C. 20555

