

FISHER CONTROLS COMPANY

MARSHALLTOWN, IOWA 50158

AUTOMATIC CONTROL EQUIPMENT
SINCE 1880

DON D. ESTILL
VICE PRESIDENT
MARSHALLTOWN DIVISION

November 9, 1979

United States Regulatory Commission
Region IV
611 Ryan Plaza Drive, Suite 1000
Arlington, Texas 76011

Attention: Mr. U. Potatous, Chief
Vendor Inspection Branch

Subject: Docket No. 99900105/79-01

Reference: Report Docket No. 99900105
U. Potatous to D. Estill

Dear Sir:

In response to the referenced report, we present the following information for your consideration:

- 1) The valve seat ring, S.O. RD2814, was considered as non-conforming material, the hardfacing was removed, a liquid penetrant examination was performed on the weld prep surface, and the part was rehardfaced per Fisher Manufacturing Procedure 5E3.10, Amendment AM-23 with pre-heat temperature maintained at $1200^{\circ}\text{F} \pm 100^{\circ}\text{F}$. The rehardfacing was witnessed by the Authorized Nuclear Inspector.
- 2) The Weld Shop Foremen have instructed all qualified welders that the preheat temperature specified in our procedures must be maintained. The Inspection Foremen have also instructed the Weld Shop Inspectors that the preheat temperature specified in our procedures must be maintained and if the preheat temperature is not maintained the part is to be rejected. On a valve seat ring of this size, a third torch has been added for preheat.
- 3) The corrective actions indicated in 1) and 2) above were completed prior to November 8, 1979.

We hope this corrective action will meet with your approval.

Very truly yours,
FISHER CONTROLS COMPANY

D. D. Estill
D. D. Estill
Vice President
Marshalltown Division

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