JUL 8 1980

Point Beach Units No. 1&2
Docket Nos. 50-266
-301

Wisconsin Electric Power Company
231 West Michigan Avenue
Milwaukee, Wisconsin 53203

Gentlemen:

SUBJECT: POTENTIAL WELDING DEFICIENCIES IN TANKS FABRICATED BY GRAVER TANK AND MANUFACTURING COMPANY

You were informed by the NRC resident inspector on June 25, 1980 of potential welding deficiencies in tanks fabricated by Graver Tank and Manufacturing Co. that could possibly result in loss of piping integrity at the pipe to tank connection during ASME Service Level D loading conditions (e.g., seismic). Welds in tanks were found at the Beaver Valley plant which, at the pipe to tank connection, were not in accordance with drawings and, at seam locations, contained unacceptable discontinuities. Quality assurance records stated the welds were in accordance with the drawings and of acceptable quality.

You are requested to determine if the weldments in safety-related tanks at Point Beach Units No. 1&2 fabricated by Graver Tank meet design specifications and fabrication requirements. Verification of weld type (i.e., seal or full penetration) and soundness must be done by independent nondestructive inspection and review of available construction radiographs, not through reliance on Graver inspection records. Should NDE of the pipe connections be impractical during plant operation, the inspections may be deferred to a scheduled refueling outage if the piping integrity can be demonstrated by analysis assuming a joint configuration such as that labeled "as found" in Enclosure 1 or there is evidence of independent inspections of work in progress by the licensee during the fabrication of the tank. If welds are found which do not meet design specifications or fabrication requirements, describe the corrective actions that will be taken.

This information is requested under the provisions of 10 CFR 50.54(f). Accordingly, you are requested to provide within twenty (20) days of the

OFFICE ▶						
SURNAME ▶						
DATE ▶						

date of this letter, written statements of the above information, signed under oath or affirmation, to the NRC Regional Office with a copy to IE:HQ which will enable the staff to determine whether or not your NRC license to operate your nuclear power generating facility should be modified, suspended or revoked.

Sincerely,

Norman C. Moseley,
Director
Division of Reactor
Operations Inspection
Office of Inspection
and Enforcement

Enclosure: As stated

bcc: H. D. Thornburg, IE
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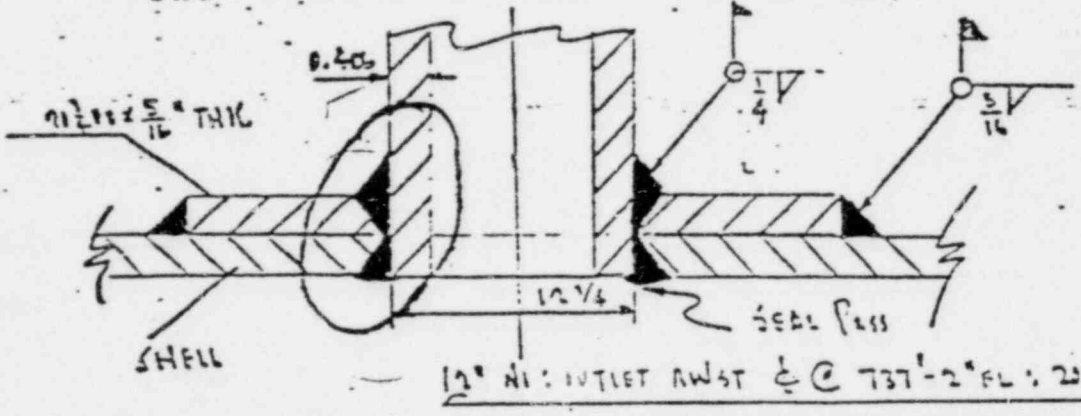
CALCULATION IDENTIFICATION NUMBER				
J.O. OR W.O. NO.	DIVISION & GROUP	CALCULATION NO.	OPTIONAL TASK CODE	PAGE 3
12649.44	EMD - MECHANICAL	81-12A		

INTRODUCTION

CONNECTION N1 OF R.V. UNIT 1 REFUELING WATER STORAGE TK. WAS NOT INSTALLED AS REQUIRED BY ~~F~~12-650 OR BY STONE & WEBSTER PROCUREMENT SPEC. R.V.S-183. THE SPEC. REQUIRES A FULL PENETRATION WELD BETWEEN THE NOZZLE NECK & SHELL AND BETWEEN THE NOZZLE NECK & REINFORCING PAD; IT ADDITIONALLY REQUIRES THAT THE PAD-NECK FULL PENETRATION BE CAPPED WITH A FILLET & REQUIRES A CIRCUMFERENTIAL PAD-SHELL FILLET ~~AROUND~~ AROUND THE OUTSIDE OF THE PAD.

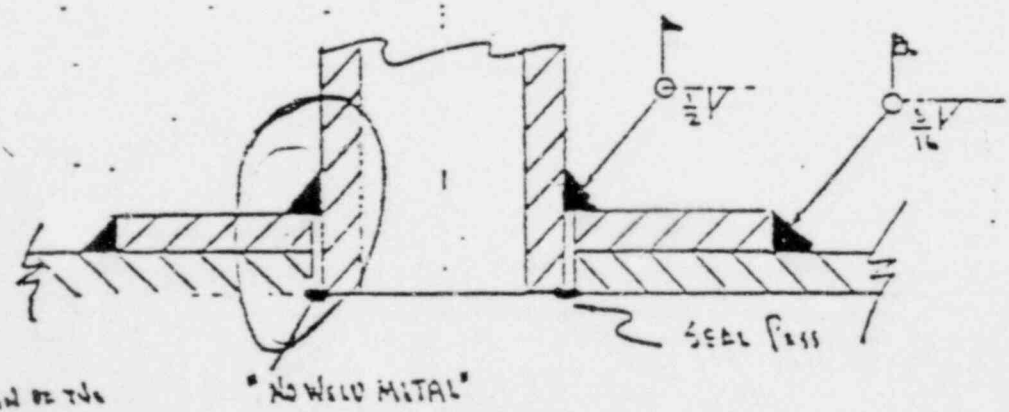
THE TK. MFGR. DID NOT COMPLETE THE PENETRATION WELDS; THEREFORE THE ONLY WELDS HOLDING N1 TO THE PAD & SHELL, ARE THE FILLETS.

CONNECTION N1 AS REQUIRED BY RVS-183



12" N1 : OUTLET NOZZ @ 737'-2" EL : 25° FROM BA

"As-Found" Condition



SECTION OF TK.

→ THIS CALCULATION CHECKS THE STRESSES IN THE FILLETS CAUSED BY DBE PIPING LOADS