Consumers Power Company

Stephen H. Howell
Vice President

General Offices: 1945 West Parnall Road, Jackson, Michigan 49201 • Area Code 517 788-0453

August 4, 1978
Howe-137-78

Mr J G Keppler, Regional Director
Office of Inspection and Enforcement
Region III
US Nuclear Regulatory Commission
799 Roosevelt Road
Glen Ellyn, IL 60137

MIDLAND NUCLEAR PLANT -
UNIT NO 1, DOCKET NO 50-329
UNIT NO 2, DOCKET NO 50-330
CONTAINMENT BUILDING PERSONNEL AIR LOCKS

Reference: S H Howell letters to J G Keppler, Midland Nuclear Plant - Unit No 1, Docket No 50-329; Unit No 2, Docket No 50-330; Containment Building Personnel Air Locks -

1) Serial Howe-22-78, dated March 3, 1978

2) Serial Howe-58-78, dated April 19, 1978

3) Serial Howe-86-78, dated May 26, 1978

4) Serial Howe-106-78, dated June 30, 1978

The referenced letters and this letter are interim 50.55(e) reports. The enclosure provides the status of corrective actions as of July 6, 1978. Consumers Power Company is presently evaluating the proposed repair procedure for the eight cracked welds.

Interim Report No 5 to MCAR-20 (attachment to Reference 4) indicated that Bechtel QC was to reinspect to determine the extent of the undersized welds. In lieu of that, reinspection of fillet welds on personnel locks installed at the Midland job site was performed by a team consisting of: Dick Bair, Bechtel Engineer (AAO); Ed Harwart, Manager of QA for W J Woolley Company; Larry Morris, Bechtel Engineer (job site); Charles A O'Deay, W J Woolley QA Engineer; Don Walls, Bechtel Field SQR. W J Woolley's detailed drawings, approved by Bechtel Engineering, were used as a reference. A Cambridge weld gauge was used to perform the weld inspection. The inspection was performed on June 12, 1978.

Inspection of accessible 1/2" fillet welds on the bulkhead and doors of personnel locks verified that approximately 10% of the fillet welds inspected were between 1/16" - 1/8" undersize, the majority being 1/16" undersize. Also, inspection of 1/2" fillet welds revealed oversize welding in approximately 10% of the weld

areas. Oversize welds were found to be mostly 1/16" over with infrequent cases up to 1/8" oversize.

W J Woolley Company is evaluating the information on undersize welds with respect to the effect on stress reports. Bechtel Engineering is assuring that the W J Woolley Company evaluation includes the assumption that the undersize conditions are present on all welds and not only on those which were verified because they were accessible for inspection. A report is scheduled to be submitted to Bechtel Engineering by August 11, 1978.

Another report, either interim or final, will be sent on or before September 29, 1978.

B. W. Marguette for S H Howell

Enclosure: Letter, P A Martinez (Bechtel Power Corporation) to G S Keeley (Consumers Power Company), MCAR-20 Interim Report 6, BLC-6207, dated July 6, 1978; with MCAR-20 Interim Report 6 dated June 30, 1978 as an attachment.

CC: Director, Office of Inspection & Enforcement
Att: Mr John G Davis, Acting Director, USNRC (15)

Director, Office of Management
Information and Program Control, USNRC (1)

A 08/11/78

REGULATORY INFORMATION DISTRIBUTION SYSTEM (RIDS)
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NRC CONSUMERS PWR DATE RCVD: 08/10/78

DOCTYPE: LETTER NOTARIZED: NO COPIES RECEIVED
SUBJECT: LTR 1 ENCL 15
FORWARDING STATUS OF CORRECTIVE ACTIONS RE CONSTRUCTION DEFICIENCY INTERIM REPT NO 5 TO MCAR-20 CONCERNING CONTAINMENT BLDG PERSONNEL AIR LOCKS...W/ATT CONSTRUCTION DEFICIENCY REPT AND SUPPORTING INFO.

PLANT NAME: MIDLAND - UNIT 1 REVIEWER INITIAL: XJM
MIDLAND - UNIT 2 DISTRIBUTER INITIAL:

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CONSTRUCTION DEFICIENCY REPORT (10CFR50.55E)
(DISTRIBUTION CODE R019)

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BR CHIEF LWR#4 BC**W/ENCL
LIC ASST LWR#4 LA**W/ENCL

INTERNAL:
REG FILE**W/ENCL
I & E**W/2 ENCL
GOSSICK & STAFF**W/ENCL
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Enclosure to
Howe-137-78

Bechtel Power Corporation

777 East Eisenhower Parkway
Ann Arbor, Michigan

Mail Address: P.O. Box 1000, Ann Arbor, Michigan 48106

July 6, 1978

BLC-6207

Consumers Power Company
1945 West Parnall Road
Jackson, Michigan 49201
ATTN: Mr. G. S. Keeley
Project Manager

Midland Units 1 and 2
Consumers Power Company
Bechtel Job 7220
MCAR-20 INTERIM REPORT 6
Files 2417/2801

Dear Mr. Keeley:

Attached Interim Report 6 of MCAR-20 is for your information and use. The inspection of the personnel locks undersized welds has been completed and the analysis by W. J. Woolley to determine the safety implications is in process. The documentation for the personnel locks is currently being re-examined by the supplier quality representative.

Repair procedure (agreement) No. 7220-C50B-224 for the cracked welds of the personnel locks has been approved by Project Engineering. The repair will be in accordance with the repair procedure and specifications 7220-C-111(Q) and 7220-G-27(Q) and will be inspected by magnetic particle inspection.

Since no significant information pertaining to the undersized welds will be available until the analysis is completed by W. J. Woolley, Project Engineering suggests that this be the last interim report for MCAR-20 prior to the final report scheduled for September 15, 1978. Your concurrence in this matter is requested.

Very truly yours,

P. A. Martinez
Project Manager

PAM/SKC/pp
Attachment: 6 pages.
cc: Mr. R. C. Bauman
Mr. W. R. Bird
Mr. J. L. Corley
Mr. B. W. Marguglio

Bechtel Associates Professional Corporation

SUBJECT: MCAR #20 (Issued 2/1/78)

Cracked weld between stiffener and welding ring of personnel lock

INTERIM REPORT #6

DATE: June 30, 1978

PROJECT: Consumers Power Company
Midland Plant Units 1 & 2
Bechtel Job 7220

Introduction

This report is submitted to advise of the interim status and course of action required pursuant to MCAR #20 and NCR 1185.

NCR 1185 was dispositioned by project engineering on June 29, 1978. The final report will be issued when the evaluation for the undersize welds is completed.

The final report is scheduled for September 15, 1978.

Cause

The cause was discussed in Interim Report #5 dated June 19, 1978.

Deficiency

The extent of the undersized welds reported in Interim Report #5 are as shown in the attached sketches.

Safety Implications

The safety implications of the deficiencies discussed in the preceding interim report are being analyzed by W.J. Woolley Company. On completion of the analysis by Woolley, any safety implications will be discussed in the final reports.

Corrective Action

The documentation for the personnel locks is currently being reviewed by the supplier quality representative. The undersized welds have been documented during inspection and are under analysis by Woolley as reported previousiy in this report.

The repair procedure for the deficiencies described in NCR 1185 has been completed by the W. J. Woolley Company. This procedure has been reviewed and approved by project engineering. The disposition of NCR 1185 specified that the cracked welds be repaired per this procedure and Specifications 7220-C-111(Q) and 7220-G-27(Q). The repair welds are also to be inspected by magnetic particle examination per Specification 7220-C-111(Q).

Bechtel Associates Professional Corporation

MCAR #20 INTERIM REPORT 6, June 30, 1978
Page 2

This will be the last interim report for MCAR #20 because there will be no significant information pertaining to the undersize welds available until the stress analysis is completed by the W. J. Woolley Company. The status and course of action required for the undersize welds will be discussed in detail in the final report, scheduled for September 15, 1978.

Submitted By: RNB D.YUAN

Reviewed By:

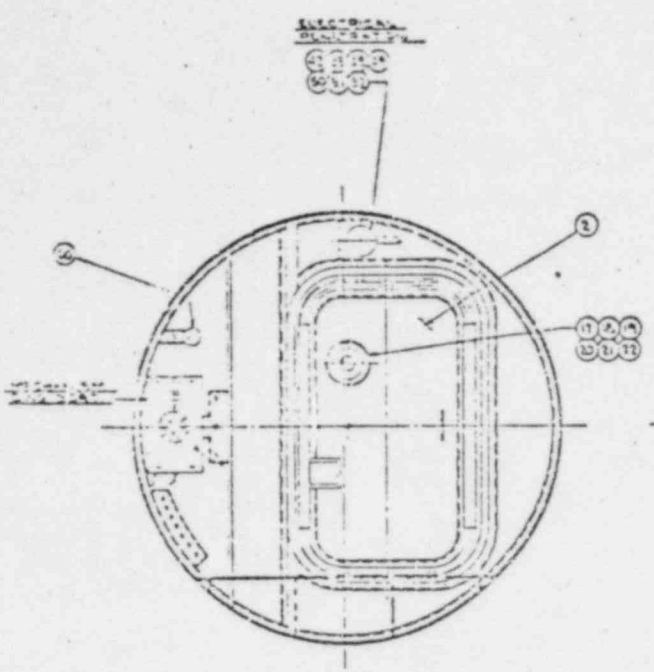
Approved By:

Concurrence By:

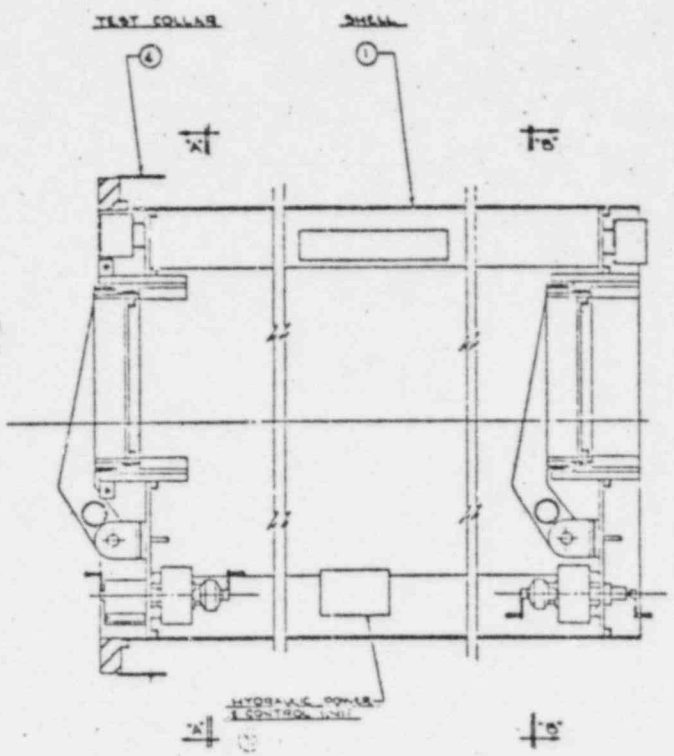
RB/cap

NOTE "A" - LEG OF FILLET WELD 1/16" SHORT

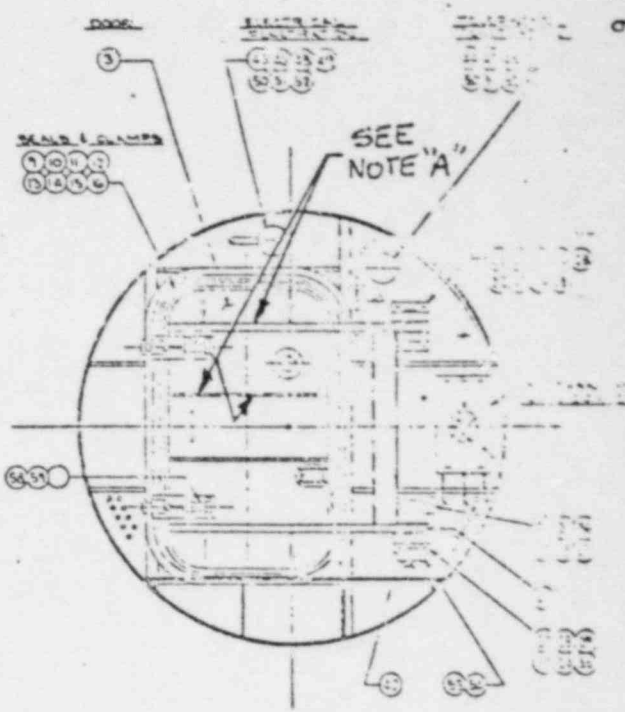
UNIT #1



SECTION "A-A"



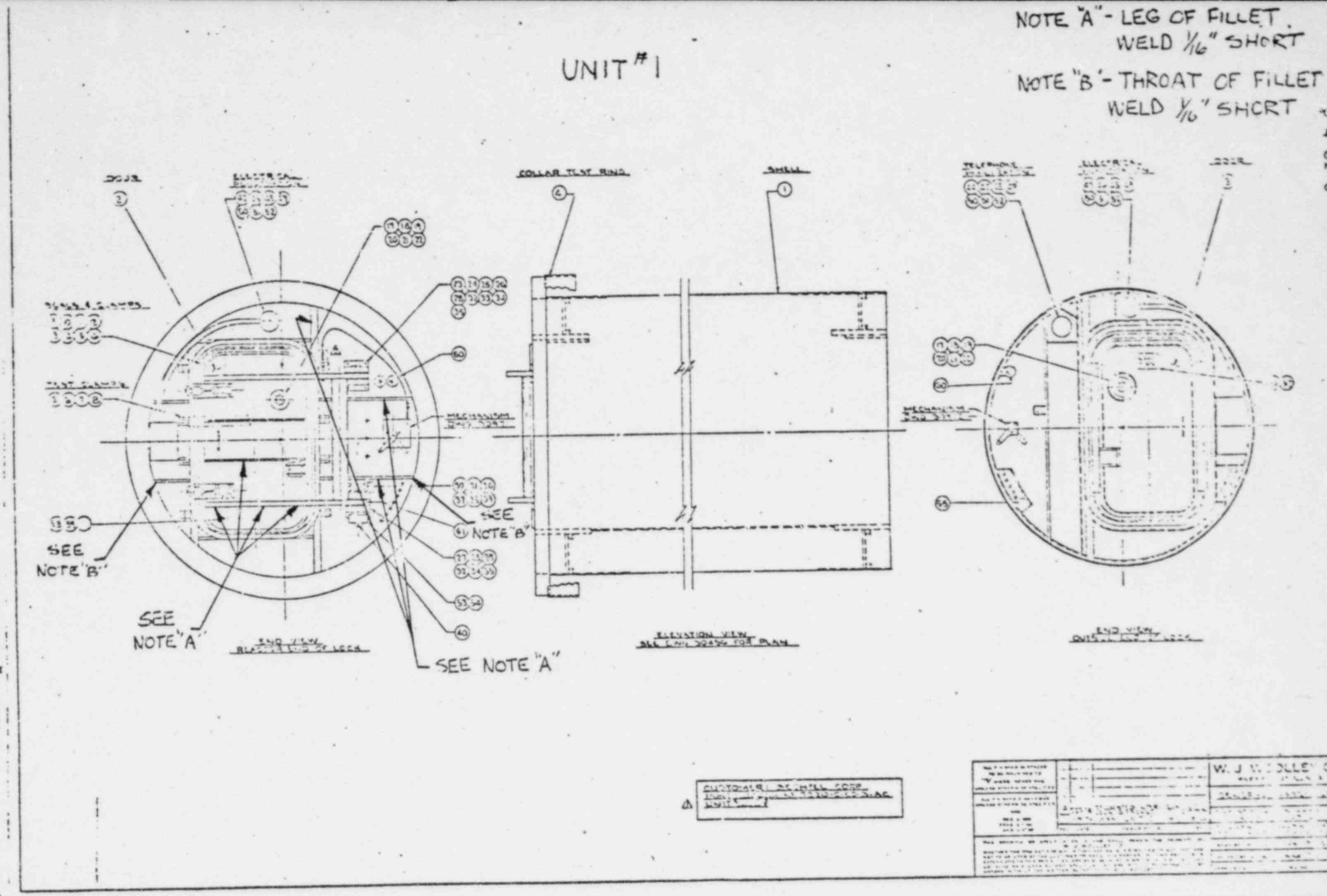
PLAN VIEW W/ ROTATION ELEVATION



SECTION "B-B"

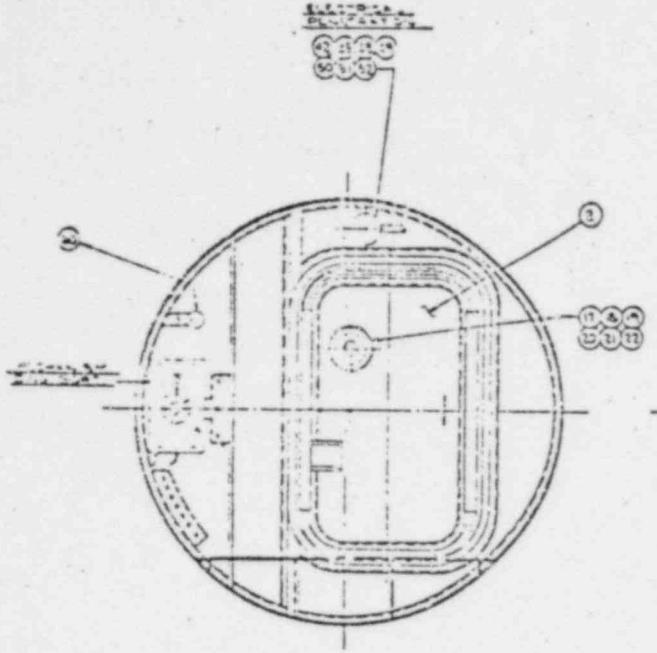
CUSTOMER: BECHTEL CORP
PURCHASER N° 7220-E-50-B-AE
UNIT

W. J. WOOLLEY CO.


NOTE "A" - LEG OF FILLET WELD 1/16" SHORT
NOTE "B" - THROAT OF FILLET WELD 1/16" SHORT
UNIT # 1
DOOR
ELECTRICAL
COLLAR TEST RING
SHELL
TELEPHONE
MECHANISM
TEST CLAMPS
SEE NOTE "B"
SEE NOTE "A"
SEE NOTE "A"
END VIEW
ELEVATION VIEW
END VIEW
W. J. WOOLLEY CO

NOTE "A" - LEG OF FILLET WELD 1/16" SHORT

UNIT #2



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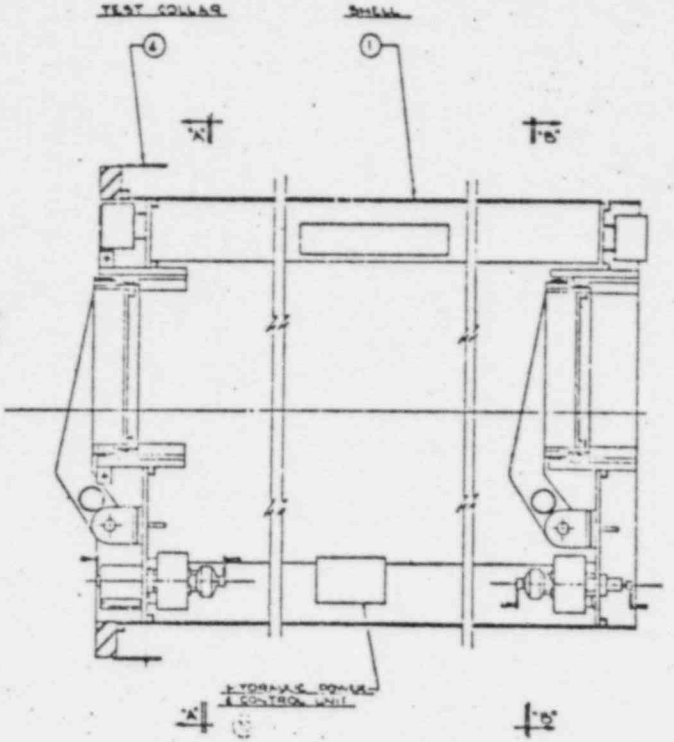
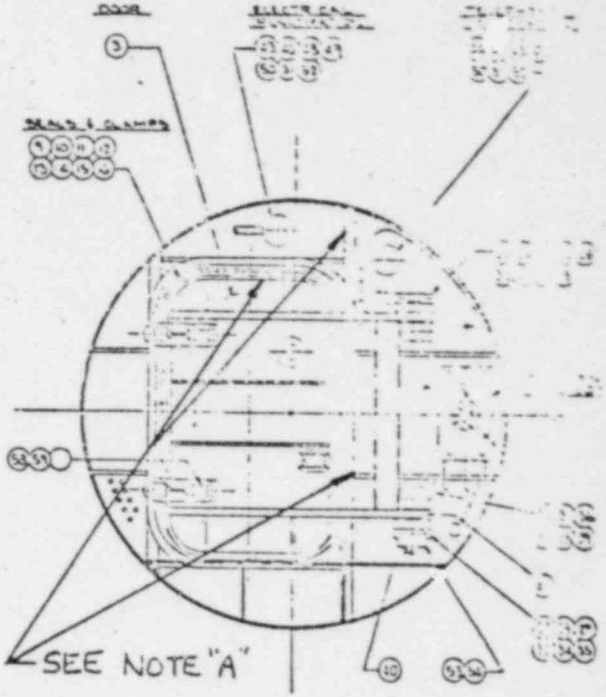


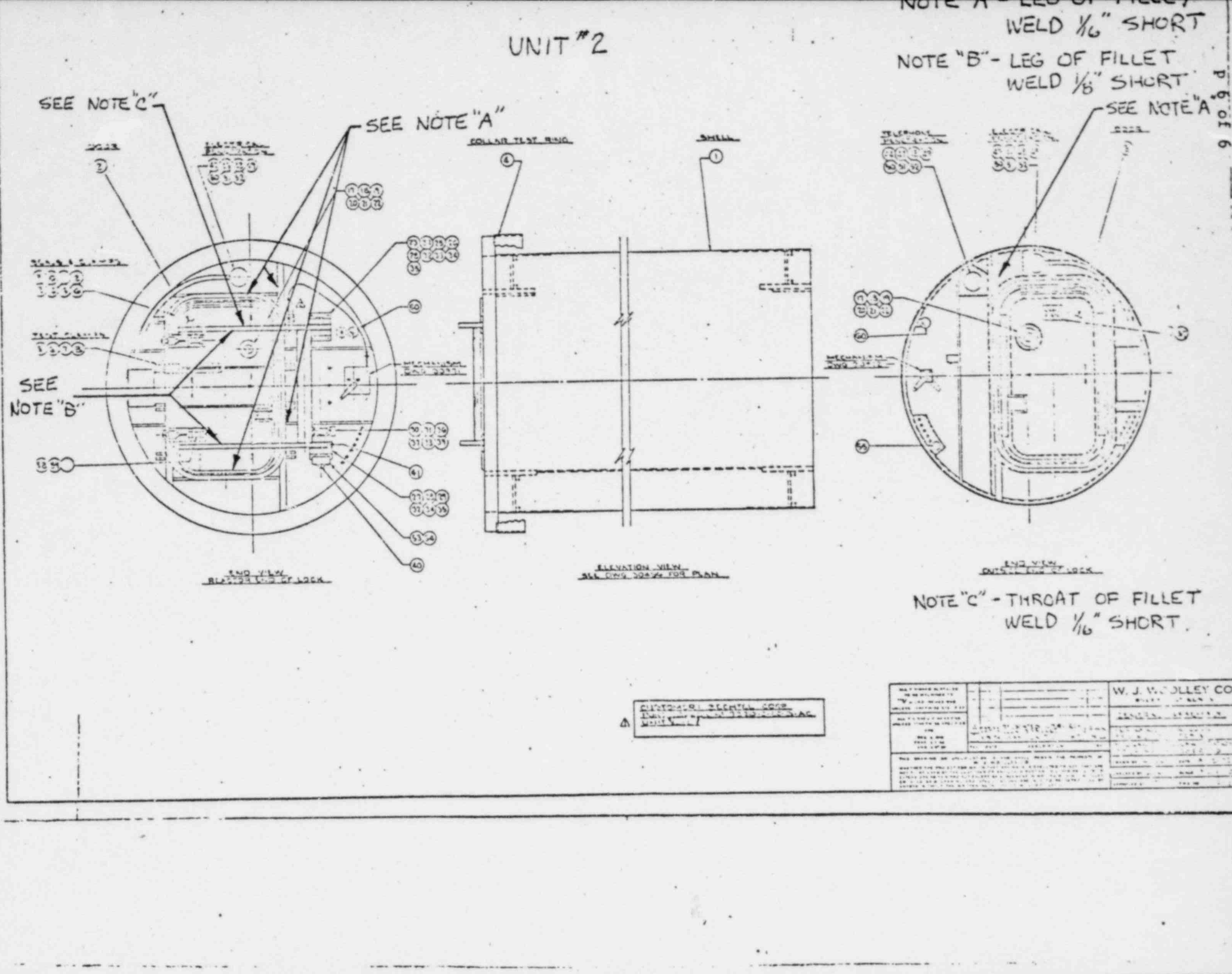
PLAN VIEW
W/ PORTION IN ELEVATION



SECTION "B-B"

CUSTOMER: BECHTEL CORP
UNIT

W. J. WOOLLEY CO


UNIT #2
NOTE "A" - LEG OF FILLET WELD 1/16" SHORT
NOTE "B" - LEG OF FILLET WELD 1/8" SHORT
NOTE "C" - THROAT OF FILLET WELD 1/16" SHORT
SEE NOTE "C"
SEE NOTE "A"
SEE NOTE "B"
COLLAR TEST RING
SHELL
END VIEW
ELEVATION VIEW
END VIEW
W. J. WOOLLEY CO