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PGE Portland General Electric Company

Charles Goodwin, Jr. Assistant Vice President

July 2, 1980

Trojan Nuclear Plant
Docket 50-344
License NPF-1

Mr. R. H. Engelken, Director
U. S. Nuclear Regulatory Commission
Region V
Suite 202, Walnut Creek Plaza
1990 N. California Blvd.
Walnut Creek, CA 94596

Dear Sir:

Attached is PGE's response to IE Bulletin 80-08 which was forwarded by your letter dated April 7, 1980. That bulletin requested information about the specifications for and examinations of Containment piping penetration welds. As the attached response indicates, the Containment penetration flued head to outer sleeve welds at Trojan were all subjected to 100-percent radiographic examination, and thus we do not consider the problem described in the bulletin to exist at Trojan. Some of the information requested by the bulletin must be obtained from construction records, some of which have not yet been retrieved from our files. That information should be available, if needed, by August 1, 1980.

If you have any questions regarding this response or if the unavailable information is needed to complete your review, please call me.

Sincerely,

C. Goodwin, Jr.

C. Goodwin, Jr.
Assistant Vice President
Thermal Plant Operation and
Maintenance

CG/LVE/4mg8A8
Attachment

c: Mr. Lynn Frank, Director
State of Oregon
Department of Energy

Director
Division of Reactor Construction Inspection
U. S. Nuclear Regulatory Commission

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TROJAN NUCLEAR PLANT
Response to IE Bulletin 80-08
Examination of Containment Liner Penetration Welds

Item 1

Determine if your facility contains the flued head design for penetration connections, or other designs with Containment boundary butt weld(s) between the penetration sleeve and process piping as illustrated in Figure NE 1120-1, Winter 1975 Addenda to the 1974 and later editions of the ASME B&PV Code.

Response:

Containment piping penetrations at Trojan are of the flued head design with Containment boundary butt welds as described above.

Item 2

If affirmative answer is reached for Item 1, determine the following:

(a) Applicability of the ASME Code including year and addenda and/or Regulatory Guide 1.19,

(b) Type of nondestructive examinations performed during construction,

(c) Type of weld joint (including pipe material and size) and whether or not backing bars were used,

(d) Results of construction nondestructive examinations, i.e., if repairs were required, this should be identified including extent of repairs and description of defects encountered during repair, if known.

Response:

The applicable code for the Containment piping penetrations is ASME B&PV Code Section III, 1971 Edition with Addenda through Winter 1971. Penetrations are also in accordance with Regulatory Guide 1.19. Nondestructive examinations performed during construction consisted of 100-percent radiography. Full penetration butt welds were used. The attached Table I provides identification of Containment piping penetrations and the line size, piping material, if backing rings were used and type of defect for any repair work for each penetration. The backing ring and repair records for the penetrations designated by an asterisk were not available at the time of preparation of this response.

Item 3

For those facilities committed during construction to perform volumetric examination of such penetration through SER commitments which have not performed radiography, justify not performing radiography or submit plans and schedules for performing radiographic examinations.

Response:

This item is not applicable since 100-percent radiography was performed on Containment piping penetration butt welds during construction at Trojan.

TABLE I

IE Bulletin 80-08
TROJAN NUCLEAR PLANT
CONTAINMENT PIPE PENETRATION

Penetration Number	Line Number and Size	Pipe Material	Backing Bars Used	Repair Work Done
1) P-1-1	3/4"-CCB-1-652	A-376TY304	*	*
2) P-2-1	2"-CS-601R-4	A-312TY304	*	*
3) P-3-3	2"-CS-2501R-28	A-376TY304	*	*
4) P-5-1	2"-CS-2501R-28	A-376TY304	*	*
5) P-7	4"-CS-151R-6-2	A-312TY304	NO	NO
6) P-8	3"-CS-2501R-5-5	A-312TY304	NO	NO
7) P-9	14"-RH-601R-5-1	A-312TY304	NO	Yes a) Incomplete fusion
8) P-10	4"-RC-151R-1-2	A-312TY304	NO	NO
9) P-11	12"-RH-2501R-19-2	A-358TY304	NO	NO
10) P-12	3/4"-RC-2501R-21	A-376TY304	NO	NO
11) P-13	3"-HCB-16-1	A-312TY304	YES	NO
12) P-14-1	3/4"-HCB-17-650	A-312TY304	*	*
13) P-17	3"-HCB-4-1	A-312TY304	YES	NO
14) P-20	3"-RC-151R-19-1	A-312TY304	YES	NO
15) P-21	3"-HBE-9-1	A-333 Gr6	YES	Yes a) Slag Inclusion b) Root Concavity
16) P-22	3"-HBE-8-1	A-333 Gr6	YES	NO
17) P-40-2	3/4"-RC-151R-32-51	A-312TY304	*	*
18) P-1-3	3/8"-RC-2505R-1	A-269TY316	NO	NO
19) P-25	8"-HCB-11-1	A-312TY304	YES	NO
20) P-26	10"-HCB-10-1	A-312TY304	NO	NO

TABLE I

Penetration Number	Line Number and Size	Pipe Material	Backing Bars Used	Repair Work Done
21) P-40-3	3/4"-SI-2501R-22	A-376TY304	*	*
22) P-28	14"-EBE-3-1	OUT A106B INL A333 Gr6	NO	NO
23) P-29	14"-EBE-3-1	OUT A106B INL A333 Gr6	NO	NO
24) P-30	14"-EBE-3-1	OUT A106B INL A333 Gr6	NO	NO
25) P-31	14"-EBE-3-1	OUT A106B INL A333 Gr6	NO	NO
26) P-32	28"-EBB-1-2	A-155 Gr KCF-70	NO	NO
27) P-33	28"-EBB-1-2	A-155 Gr KCF-70	NO	NO
28) P-34	28"-EBB-1-1	A-155 Gr KCF-70	NO	NO
29) P-35	28"-EBB-1	A-155 Gr KCF-70	NO	NO
30) P-36-1	2"-EBE-6-655	A-335 Gr6	NO	NO
31) P-37-1	2"-EBE-6-654	A-335 Gr6	NO	NO
32) P38-1	2"-EBE-6-650	A-335 Gr6	NO	NO
33) P39-1	2"-EBE-6-651	A-335 Gr6	NO	NO
34) P40-1	1"-SI-602N-1	A-106B	*	*
35) P14-2	3/4"-GBC-10	A-312TY304	*	*
36) P-42	14"-HBE-2-1	A-333 Gr6	NO	Yes a) Surface Defect
37) P-43	14"-HBE-3-1	A333 Gr6	NO	Yes a) Root Concavity

TABLE I

Penetration Number	Line Number and Size	Pipe Material	Backing Bars Used	Repair Work Done
38) P-44	3"-SI-2501R-3-3	A-376TY304	NO	NO
39) P-45	4"-SI-2501R-1-1	A-376TY304	YES	NO
40) P46	8"-SI-2501R-31-2	A-376TY304	YES	NO
41) P-47	8"-SI-2501R-31-1	A-376TY304	YES	Yes a) Hole in backing ring
42) P-48	10"-HCB-9-1	A-358TY304	YES	NO
43) P-49	10"-HCB-9-2	A-358TY304	NO	NO
44) P-50	18'-GCB-5-1	A-358TY304	NO	Yes a) Slag Inclusion
45) P-51	18"-GCB-5-1	A-358TY304	YES	NO
46) P-16-3	3/4"-CCB-1-651	A-376TY304	*	*
47) P-14-3	3/4"-CCB-2-652	A-376TY304	*	*
48) P-54	3"-HCB-15-1	A-312TY304	NO	Yes a) Slag inclusion b) Incomplete fusion
49) P55	3"-HCB-12-1	A-312TY304	NO	NO
50) P56-1	1"-HCC-19	A-312TY304	*	*
51) P57-1	4"-HBE-11-1	A335Gr6	*	*
52) P58	3"-HCB-3-1	A312TY304	YES	Yes a) Slag inclusion
53) P62	1"-HCB-20-54	A312TY304	*	*
54) P63	4"-SI-2501R-1-8	A376TY304	NO	NO
55) P65	1"-HCB-20-54	A312TY304	*	*
56) P68	8"-HBE-14-1	A335 Gr6	NO	NO
57) P69	1"-HCB-20-54	A312TY340	*	*
58) P70	4"-SI-2501R-1-9	A376TY304	NO	NO
59) P71	1"-HCB-20-54	A312TY304	*	*
60) P72	8"-HBE-14-1	A333 Gr6	NO	NO

TABLE I

Penetration Number	Line Number and Size	Pipe Material	Backing Bars Used	Repair Work Done
61) P74	14"-HBE-7-1	A333 Gr6	NO	Yes a) Root Concavity
62) P76	14"-HBE-5-2	A333 Gr6	NO	Yes a) Root Concavity
63) P101-1	8"-HBE-16-1	A333 Gr6	YES	Yes a) Slag inclusion
64) V18	54"-HBE-15-1	A333 Gr6	NO	Yes a) Slag inclusion b) Porosity
65) V19	54"-HBE-15-1	A333 Gr6	NO	Yes a) Slag inclusion b) Incomplete fusion
66) P3-2	2"-CS-2501R-28-55	A376TY304	*	*
67) P5-3	2"-CS-2501R-28-651	A376TY304	*	*
68) P5-1	1"-GBB-1-50	A333 Gr6	*	*
69) P36-2	3/4"-EBE-6-657	A333 Gr6	NO	NO
70) P37-2	3/4"-EBE-6-656	A333 Gr6	NO	NO
71) P38-2	3/4"-EBE-6-653	A333 Gr6	NO	NO
72) P39-2	3/4"-EBE-6-652	A333 Gr6	NO	NO
73) P37-3	2"-HBE-17-50	A333 Gr6	NO	NO
74) P39-3	2"-HBE-17-50	A333 Gr6	*	*
75) P101-2	8"-HBE-16-1	A333 Gr6	YES	Yes a) Slag inclusion
76) P57-2	4"-HBE-10-1-2	A333 Gr6	NO	NO
77) P56-2	1"-HCB-19-52	A312TY304	*	*

* Information not available at time of report.

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