

80A0482

012

SHOREHAM NUCLEAR  
POWER STATION  
UNIT I  
PRESERVICE INSPECTION  
PROGRAM PLAN

PREPARED FOR  
LONG ISLAND LIGHTING COMPANY  
HICKSVILLE, NY

CONTROLLED  
COPY

BY

NUCLEAR ENERGY SERVICES, INC.,  
DANBURY, CT

REV. NO.	DATE
0	2-17-78
1	7-11-79
2	4-27-80
3	6/30/80

PREPARED BY *Albertuziel*  
Shoreham ISI Proj. Mgr

APPROVED BY *W. J. Mann for L. J.*  
ISI Program Manager

*J. S. Le Guardia*  
QA Manager



NUCLEAR ENERGY SERVICES, INC.

8008120404

## RECORD OF REVISION

Rev. No.	Date	Description	Reason	Prep'd by	App'd by
1	7-11-79	<p>Add Appendix P to Preservice Inspection Program Plan.</p> <p>Add on Table of Contents Page under 4 Appendices "Appendix P Controlled Documents".</p> <p>Add to page 3.3 new paragraph to read.            "Appendix P contains a list of Controlled Documents, denoting the current revision, that are contained within the Shoreham Preservice Inspection Program".            CRA 877</p>	LILCO request	SP.	Emf
2	4-21-80	<p>Remove CRD Return System. Implement full compliance of examination requirements of K-1 support members. Implement examination of CRD housing flange &amp; intermediate weld.            CRA 1117</p> <p>Revise Appendix A &amp; D and incorporate LILCO comments. (See CRA 1310) Revise Piping Isometrics (See CRA No. 1254)</p>	LILCO comment & request Incorporate as-built revisions.	CJE	AK
3	6/30/80	Standby Liquid Control System (C41) revised. (See CRA 1372)	Incorporate as-built information.	AK	AK



SYSTEM: Standby Liquid Control  
 REFERENCE DRAWING: No. 10-01  
 Preservice Inspection

# 1725

## PROGRAM PLAN AND SCHEDULE

Shoreham

BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
 APP: \_\_\_\_\_ DATE: \_\_\_\_\_  
 REV: \_\_\_\_\_ PAGE 1 OF \_\_\_\_\_

PROJECT

ITEM NO.	COMPONENT IDENTIFICATION	COMPONENT DESCRIPTION	PROCEDURE NUMBER	CALIBRATION BLOCK (If applicable)	CODE CATEGORY	CODE EXAM METHOD	ZONE NO.	REMARKS
		<b>PIPING WELDS</b>						
1	C41-P0955-L	Valve EV-010A to 1 1/2" Pipe	80A0472 80A0473		J-1	PT VT	II	
2	C41-P0955-J	1 1/2" Pipe to Tee	80A0472 80A0473		J-1	PT VT	II	
3	C41-P0955-K	Valve EV-010B to 1 1/2" Pipe	80A0472 80A0473		J-1	PT VT	II	
4	C41-P0955-I	1 1/2" Pipe to Tee	80A0472 80A0473		J-1	PT VT	II	
5	C41-P0955-H	1 1/2" Tee to Pipe	80A0472 80A0473		J-1	PT VT	II	
6	C41-P0949-T	1 1/2" Pipe to Flange	80A0472 80A0473		J-1	PT VT	II	
7	C41-P0949-U	Flange to 1 1/2" Pipe	80A0472 80A0473		J-1	PT VT	II	
8	C41-P0949-V	1 1/2" Pipe to Ell	80A0472 80A0473		J-1	PT VT	II	

SYSTEM: Sandy Liquid Control  
 REFERENCE DRAWING: No. 10-01  
Preservice Inspection



**PROGRAM PLAN AND SCHEDULE**  
 Shoreham

BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
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PROJECT

ITEM NO.	COMPONENT IDENTIFICATION	COMPONENT DESCRIPTION	PROCEDURE NUMBER	CALIBRATION BLOCK (If applicable)	CODE CATEGORY	CODE EXAM METHOD	ZONE NO.	REMARKS
		<b>PIPING WELDS</b>						
9	C41-P0949-W	1 1/2" Ell to Pipe	80A0472 80A0473		J-1	PT VT	II	
10	C41-P0949-X	1 1/2" Pipe to Tee	80A0472 80A0473		J-1	PT VT	II	
11	C41-P0949-Y	1 1/2" Tee to 1 1/2" x 3/4" Reducer	80A0472 80A0473		J-1	PT VT	II	
12	C41-P-0949-Z	1 1/2" Tee to Pipe	80A0472 80A0473		J-1	PT VT	II	
13	C41-P0949-DD	1 1/2" Pipe to Ell	80A0472 80A0473		J-1	PT VT	II	
14	C41-P0949-CC	1 1/2" Ell to Pipe	80A0472 80A0473		J-1	PT VT	II	
15	C41-P0949-BB	1 1/2" Pipe to Ell	80A0472 80A0473		J-1	PT VT	II	
16	C41-P0949-AA	1 1/2" Ell to Pipe	80A0472 80A0473		J-1	PT VT	II	



SYSTEM Standby Liquid Control  
 REFERENCE DRAWING: No. 10-01  
 Preservice Inspection

**PROGRAM PLAN AND SCHEDULE**  
 Shoreham

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PROJECT

ITEM NO.	COMPONENT IDENTIFICATION	COMPONENT DESCRIPTION	PROCEDURE NUMBER	CALIBRATION BLOCK (If applicable)	CODE CATEGORY	CODE EXAM METHOD	ZONE NO.	REMARKS
		<b>PIPING WELDS</b>						
17	C41-P0949-EE	1 1/2" Pipe to Ell	80A0472 80A0473		J-1	PT VT	II	
18	C41-P0949-FF	1 1/2" Ell to Pipe	80A0472 80A0473		J-1	PT VT	II	
19	C41-P0949-GG	1 1/2" Pipe to Ell	80A0472 80A0473		J-1	PT VT	II	
20	C41-P0949-HH	1 1/2" Ell to Pipe	80A0472 80A0473		J-1	PT VT	II	
21	C41-P0946-Q	1 1/2" Pipe to Ell	80A0472 80A0473		J-1	PT VT	II	
22	C41-P0946-P	1 1/2" Ell to Pipe	80A0472 80A0473		J-1	PT VT	II	
23	C41-P0946-O	1 1/2" Pipe to Ell	80A0472 80A0473		J-1	PT VT	II	
24	C41-P0946-N	1 1/2" Ell to Pipe	80A0472 80A0473		J-1	PT VT	II	



SYSTEM: Standby Liquid Control  
REFERENCE DRAWING: No. 10-01  
Preservice Inspection

**PROGRAM PLAN AND SCHEDULE**  
Shoreham

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PROJECT

ITEM NO.	COMPONENT IDENTIFICATION	COMPONENT DESCRIPTION	PROCEDURE NUMBER	CALIBRATION BLOCK (If applicable)	CODE CATEGORY	CODE EXAM METHOD	ZONE NO.	REMARKS
		<b>PIPING WELDS</b>						
25	C41-P0946-M	1 1/2" Pipe to Tee	80A0472 80A0473		J-1	PT VT	II	
26	C41-P0946-L	1 1/2" Tee to 1 1/2" x 3/4" Reducer	80A0472 80A0473		J-1	PT VT	II	
27	C41-P0946-K	1 1/2" Tee to Pipe	80A0472 80A0473		J-1	PT VT	II	
28	C41-P0946-J	1 1/2" Pipe to Valve 02V-0010	80A0472 80A0473		J-1	PT VT	II	
29	C41-P0946-I	Valve 02V-0010 to 1 1/2" Pipe	80A0472 80A0473		J-1	PT VT	II	
30	C41-P0946-H	1 1/2" Pipe to Tee	80A0472 80A0473		J-1	PT VT	II	
31	C41-P0946-G	1 1/2" Tee to 1 1/2" x 3/4" Reducer	80A0472 80A0473		J-1	PT VT	II	
32	C41-P0946-F	1 1/2" Tee to Pipe	80A0472 80A0473		J-1	PT VT	II	

SYSTEM: Standby Liquid Control  
 REFERENCE DRAWING: No. 10-01  
 Preservice Inspection



**PROGRAM PLAN AND SCHEDULE**  
 Shoreham

BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
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PROJECT

ITEM NO.	COMPONENT IDENTIFICATION	COMPONENT DESCRIPTION	PROCEDURE NUMBER	CALIBRATION BLOCK (If applicable)	CODE CATEGORY	CODE EXAM METHOD	ZONE NO.	REMARKS
		<b>PIPING WELDS</b>						
33	C41-P0946-E	1 1/2" Pipe to Tee	30A0472 80A0473		J-1	PT VT	II	
34	C41-P0946-D	1 1/2" Tee to 1 1/2" x 3/4" Reducer	80A0472 80A0473		J-1	PT VT	II	
35	C41-P0946-C	1 1/2" Tee to Pipe	80A0472 80A0473		J-1	PT VT	II	
36	C41-P0946-B	1 1/2" Pipe to Coupling	80A0472 80A0473		J-1	PT VT	II	
37	C41-P0946-A	1 1/2" Coupling to Pipe	80A0472 80A0473		J-1	PT VT	II	
38	C41-P0905-A	1 1/2" Pipe to Coupling	80A0472 80A0473		J-1	PT VT	II	
39	C41-P0905-B	1 1/2" Coupling to Pipe	80A0472 80A0473		J-1	PT VT	II	
40	C41-P0905-C	1 1/2" Pipe to Ell	80A0472 80A0473		J-1	PT VT	II	



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SYSTEM Standby Liquid Control  
REFERENCE DRAWING: No. 10-01  
Preservice Inspection

# PROGRAM PLAN AND SCHEDULE

Shoreham

BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
APP: \_\_\_\_\_ DATE: \_\_\_\_\_  
REV: \_\_\_\_\_ PAGE 6 OF \_\_\_\_\_

PROJECT

ITEM NO.	COMPONENT IDENTIFICATION	COMPONENT DESCRIPTION	PROCEDURE NUMBER	CALIBRATION BLOCK (If applicable)	CODE CATEGORY	CODE EXAM METHOD	ZONE NO.	REMARKS
		<b>PIPING WELDS</b>						
41	C41-P0905-D	1 1/2" Ell to Pipe	80A0472 80A0473		J-1	PT VT	II	
42	C41-P0905-E	1 1/2" Pipe to Coupling	80A0472 80A0473		J-1	PT VT	II	
43	C41-P0906-A	1 1/2" Coupling to Pipe	80A0472 80A0473		J-1	PT VT	II	
44	C41-P0906-B	1 1/2" Pipe to Ell	80A0472 80A0473		J-1	PT VT	II	
45	C41-P0906-H	1 1/2" Ell to Pipe	80A0472 80A0473		J-1	PT VT	II	
46	C41-P0906-I	1 1/2" Pipe to Ell	80A0472 80A0473		J-1	PT VT	II	
47	C41-P0906-E	1 1/2" Ell to Pipe	80A0472 80A0473		J-1	PT VT	II	
48	C41-P0906-F	1 1/2" Pipe to Coupling	80A0472 80A0473		J-1	PT VT	II	





SYSTEM Standby Liquid Control  
 REFERENCE DRAWING No. 10-01  
Preservice Inspection

**PROGRAM PLAN AND SCHEDULE**  
 Shoreham

BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
 APP: \_\_\_\_\_ DATE: \_\_\_\_\_  
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PROJECT

ITEM NO.	COMPONENT IDENTIFICATION	COMPONENT DESCRIPTION	PROCEDURE NUMBER	CALIBRATION BLOCK (If applicable)	CODE CATEGORY	CODE EXAM METHOD	ZONE NO.	REMARKS
		<b>PIPING WELDS</b>						
49	C41-P0907-A	1 1/2" Coupling to Pipe	80A0472 80A0473		J-1	PT VT	II	
50	C41-P0907-B	1 1/2" Pipe to Ell	80A0472 80A0473		J-1	PT VT	II	
51	C41-P0907-C	1 1/2" Ell to Pipe	80A0472 80A0473		J-1	PT VT	II	
52	C41-P0907-D	1 1/2" Pipe to Ell	80A0472 80A0473		J-1	PT VT	II	
53	C41-P0907-E	1 1/2" Ell to Pipe	80A0472 80A0473		J-1	PT VT	II	
54	C41-P0907-F	1 1/2" Pipe to Valve 02V-0008	80A0472 80A0473		J-1	PT VT	II	
55	C41-P0908-A	Valve 02V-0008 to 1 1/2" Pipe	80A0472 80A0473		J-1	PT VT	II	
56	C41-P0908-B	1 1/2" Pipe to Tee	80A0472 80A0473		J-1	PT VT	II	

SYSTEM Standby Liquid Control  
 REFERENCE DRAWING No. 10-01  
 Preservice Inspection



**PROGRAM PLAN AND SCHEDULE**

Shoreham

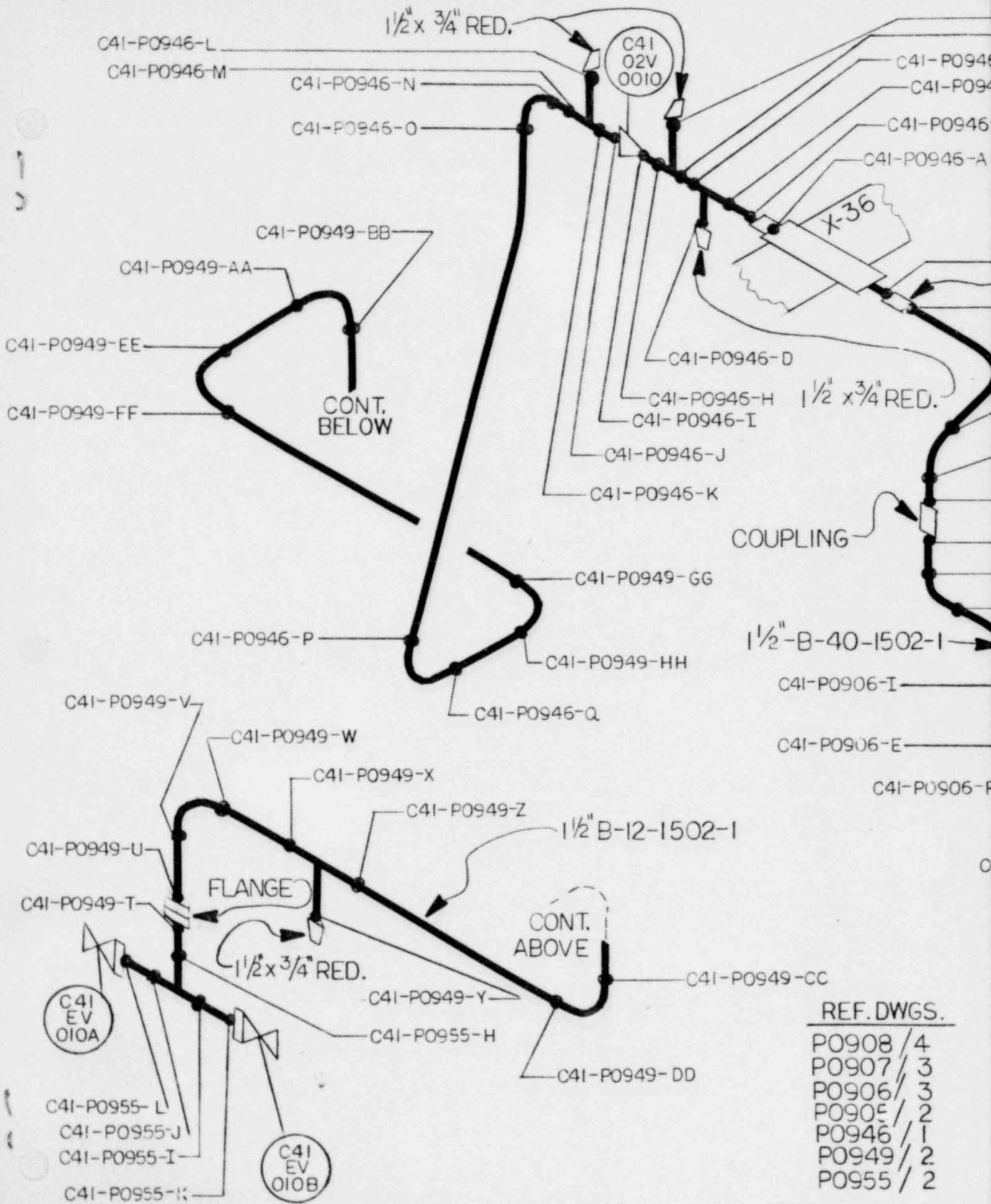
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 APP: \_\_\_\_\_ DATE: \_\_\_\_\_  
 REV: \_\_\_\_\_ PAGE 8 OF \_\_\_\_\_

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PROJECT

ITEM NO.	COMPONENT IDENTIFICATION	COMPONENT DESCRIPTION	PROCEDURE NUMBER	CALIBRATION BLOCK (if applicable)	CODE CATEGORY	CODE EXAM METHOD	ZONE NO.	REMARKS
		<b>PIPING WELDS</b>						
57	C41-P0908-K	1 1/2" Tee to 1 1/2" x 3/4" Reducer	80A0472 80A0473		J-1	PT VT	II	
58	C41-P0908-C	1 1/2" Tee to Pipe	80A0472 80A0473		J-1	PT VT	II	
59	C41-P0908-D	1 1/2" Pipe to Tee	80A0472 80A0473		J-1	PT VT	II	
60	C41-P0908-L	1 1/2" Tee to 1 1/2" x 3/4" Reducer	80A0472 80A0473		J-1	PT VT	II	
61	C41-P0908-E	1 1/2" Tee to Pipe	80A0472 80A0473		J-1	PT VT	II	
62	C41-P0908-O	1 1/2" Pipe to Valve HV-023	80A0472 80A0473		J-1	PT VT	II	
63	C41-P0908-N	Valve HV-023 to 1 1/2" Pipe	80A0472 80A0473		J-1	PT VT	II	
64	C41-P0908-H	1 1/2" Pipe to Tee	80A0472 80A0473		J-1	PT VT	II	





C41-P0946-L

C41-P0946-M

C41-P0946-N

C41-P0946-O

C41-P0949-BB

C41-P0949-AA

C41-P0949-EE

C41-P0949-FF

CONT.  
BELOW

1/2 x 3/4" RED.

C41  
02V  
0010

C41-P0946

C41-P0946

C41-P0946

C41-P0946-A

X-36

C41-P0946-D

C41-P0946-H

C41-P0946-I

C41-P0946-J

C41-P0946-K

1/2 x 3/4" RED.

COUPLING

C41-P0949-GG

C41-P0946-P

C41-P0949-HH

1/2"-B-40-1502-1

C41-P0906-I

C41-P0906-E

C41-P0906-F

C41-P0949-V

C41-P0949-W

C41-P0949-X

C41-P0949-Z

1/2" B-12-1502-1

C41-P0949-U

FLANGE

C41-P0949-T

1/2 x 3/4" RED.

CONT.  
ABOVE

C41-P0949-CC

C41  
EV  
010A

C41-P0949-Y

C41-P0955-H

C41-P0949-DD

C41-P0955-L

C41-P0955-J

C41-P0955-I

C41-P0955-K

C41  
EV  
010B

REF. DWGS.

P0908	/	4
P0907	/	3
P0906	/	3
P0905	/	2
P0946	/	1
P0949	/	2
P0955	/	2

C41-P0946-G  
 C41-P0946-F  
 -E  
 -6-C  
 -B

3

C41-P0905-A  
 COUPLING  
 C41-P0905-B

C41-P0905-C  
 C41-P0905-D  
 C41-P0905-E

C41-P0906-A  
 C41-P0906-B

C41-P0906-H

COUPLING

C41-P0907-B

C41-P0907-C  
 1/2" x 3/4" RED.

C41-P0908-D  
 C41-P0908-C

C41-P0908-K

C41-P0908-B

C41-P0908-A

C41 HV 023

C41-P0908-H

1/2" x 3/4" RED.

C41-P0908-I

C41-P0908-M

C41-P0908-N

C41-P0908-O

C41-P0908-E

C41-P0907-A

C41-P0907-F

C41-P0907-E

C41-P0907-D

C41 02V 0008

C41-P0908-L  
 1/2" x 3/4" RED.



NUCLEAR ENERGY SERVICES, INC.  
 NES DIVISION

SYSTEM NO. C41	TITLE STANDBY LIQUID CONTROL
REV: 0	FIG. NO. 10-01
BY: JS	DATE: 5/12/80
APP: A. Koch	DATE: 5/12/80
PROJECT:	5536 SNPS-1
NOT TO SCALE	



ITEM NO.	DOCUMENT NO.	APPROVAL DATE	LATEST REV. NO.	LATEST REV. DATE	LATEST CRA NO.	TITLE	REMARKS	
1	80A2941	7-9-79	6	5-14-80	1328	MASTER DOCUMENT LIST	CONTROLLED	
2	80A0448	5-16-77	7	5-9-80	1324	QUALITY ASSURANCE PLAN FOR INSERVICE INSPECTION PROGRAM		
3	80A0462	6-10-75	1	12-8-75	99	MANUAL ULTRASONIC EXAM. PROC. FOR REACTOR PRESSURE VESSEL, CIRCUM. & LONG. WELDS		
4	80A0467	9-23-77	4	10-30-78	559	UT EXAM PROC FOR CLOSURE HEAD & FLANGE WELDS		
5	80A0468	10-31-77	0			UT EXAM. PROC FOR REACTOR VESSEL TO FLANGE WELD & STUD LIGAMENTS		
6	80A0469	10-20-77	3	6-28-79	930	MANUAL UT EXAM. PROC. FOR CLOSURE HEAD & VESSEL NOZZLE WELDS		
7	80A0470	2-1-76	1	11-3-78	567	AUTO. UT EXAM. PROC FOR VESSEL NOZZLE WELDS		
8	80A0471	11-18-77	0			MANUAL UT EXAM. PROC. FOR VESSEL WELDS & STABILIZER BRACKET WELDS		
9	80A0472	9-23-77	1	10-14-77	317	LIQUID PENETRANT EXAM. PROC.		
10	80A0473	9-23-77	3	7-8-80	1373	VISUAL EXAM. PROC.		LILCO APPROVAL REQ PRIOR TO ISSURANCE & USE
11	80A0474	2-15-78	1	11-3-78	568	REMOTE UT EXAM. FOR NOZZLE SAFE END WELDS		
12	80A0475	2-15-78	1	7-27-79	972	MANUAL UT EXAM PROC. FOR VESSEL NOZZLE SAFE ENDS & CLOSURE HEAD NOZZLE FLANGE WELDS		
13	80A0476	10-19-77	0			UT EXAM PROC. FOR CLOSURE HEAD STUDS & NUTS & RECIRC. PUMP STUDS & NUTS		
14	80A0478					AUTO. UT EXAM PROC. FOR NOZZLE INNER RADII		
15	80A0479					MANUAL UT EXAM PROC. FOR NOZZLE INNER RADII		



NUCLEAR ENERGY SERVICES, INC.

MASTER DOCUMENT LIST NO. 80A2941 REV. 6

DATE 7-10-79 SHEET 2 OF 2

Project Title SHOREHAM - PRESERVICE INSPECTION

PROJECT NO. 5536 TASK NO. 010

Block Size: 80X2941 To 80X2951

PROGRAM PLAN

PROJECT ENGINEER APPROVAL [Signature]

ITEM NO.	DOCUMENT NO.	APPROVAL DATE	LATEST REV. NO.	LATEST REV. DATE	LATEST CRA NO.	TITLE	REMARKS
16	80A0480	2-15-78	1	11-3-78	569	AUTO. UT EXAM. PROC. FOR VESSEL WELDS	
17	80A0481	9-23-77	3	9-5-79	515	UT EXAM. PROC. FOR PIPING BUTT & LONG. WELDS	
18	80A0482	2-17-78	3	6-30-80	1372	SHOREHAM NUCLEAR POWER STATION UNIT PSI PLAN	
19	80A0485	5-31-79	0			ULTRASONIC EXAM. PROC. FOR CRD HOUSING WELDS	LITCO APPROVAL REQ. PRIOR TO ISSURANCE & USE
20	80A0486	5-22-79	1	7-3-79	910	UT PROC. FOR JET PUMP INSTRUMENTATION NOZZLE SAFE-END TO MANIFOLD WELD	
21	80A0487	5-31-79	2	10-12-79	1078	GENERAL MAGNETIC PARTICLE EXAM.	
22	80A2942	9-7-79	1	11-30-79	1128	UT EXAM. PROC. FOR INTEGRALLY WELDED PIPE SUPPORTS AND ATTACHMENTS	△ △ △