C-E Newington Site

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POWER SYSTEMS

August 4, 1980

Mr. Uldis Potapovs, Chief
Vendor Inspection Branch
United States
Nuclear Regulatory Commission
Region IV
611 Ryan Plaza Drive, Suite 1000
Arlington, Texas 76012

Reference: Docket No. 99900259/80-01

Dear Mr. Potapovs:

In response to your letter dated July 16, 1980, the following information is submitted as a supplement to our audit reply of July 3, 1980:

Item E.

The Foreman responsible for supervising the welding processes utilized for both the base metal repair and Inconel Cladding has provided the following information. It has been documented on the applicable Detailed Welding Procedures:

1) The base metal repair was started and completed on the same shift by one qualified Welder. The Temper Bead Technique was verified by both the Manufacturing Foreman and the Authorized Nuclear Inspector, who had imposed an A.N.I. "Hold" point on the repair.

2) A review of sheet 2 of WMC-10-11, Rev. 01 (attached) used for the Inconel Cladding, revealed that the foreman had initialed each sequence of the repair upon its completion. The pictorial presentation in the top right corner has omitted the words "Zone 1" following the lower arrow. Consequently, the foreman interpreted the unidentified area to be the base material and Zone 2 to be the cladding. When circling the area for the Inconel Cladding on sheet 1 of the D.W.P. , he circled only Zone 2. The master copy of D.W.P. WMC-10-11 has been corrected to reflect Zone 1.

If you require additional information, please advise.

Prepared by: D. C. Almeda
D. C. Almeda
Quality Systems Supervisor

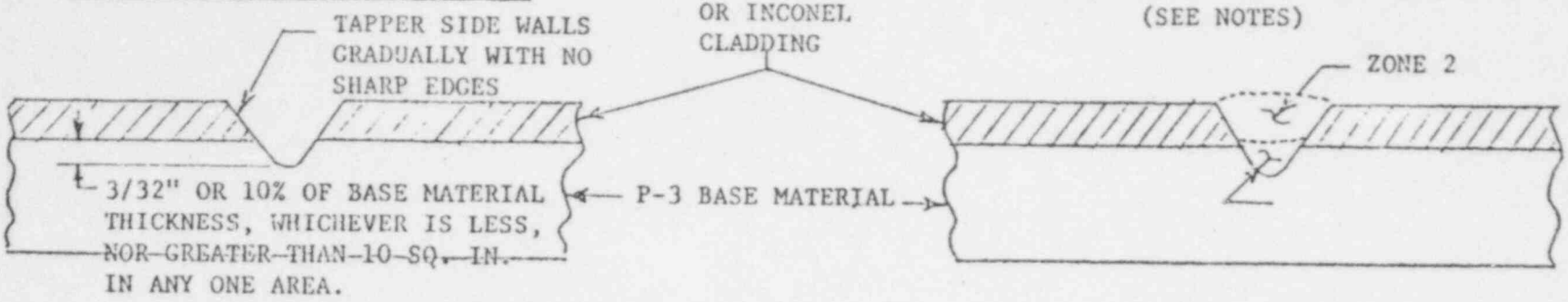
Approved by: C. E. White
C. E. White
Quality Assurance Manager

Attachment
ACA/pk

8009190017

COMBUSTION ENGINEERING, INC., C-E AVERY DIVISION
DETAILED WELDING PROCEDURE

EXCAVATED AREA LIMITATIONS



WELD REPAIR SEQUENCE

(SEE NOTES)

NOTES: 1. If base material is exposed within the excavated area, repair weld using the following sequence:

A. Ensure that the area of exposed base material does not exceed the limits specified in the above sketch.

B. Preheat and maintain the repair area at a minimum temperature of 350°F during all welding. Interpass temperature shall not exceed 450°F. RLR

C. Cover all exposed base material (Zone 1) by depositing a single layer of weld deposit using 3/32" dia. electrode. RLR

D. Remove by grinding, part of the first layer (Zone 1) prior to depositing additional layers (Zone 2). RLR

E. Deposit a minimum of one additional layer (Zone 2) using 3/32" or 1/8" dia. electrode. RLR

F. At the completion of welding, maintain the weld area at a temperature of 400-500°F for a minimum of one hr. RLR

G. Blend repaired areas into the surrounding weld metal.

2. If base material is not exposed within the excavated area, repair weld using the following sequence:

A. Maintain a minimum preheat temperature of 65°F. Interpass temperature shall not exceed 450°F. RLR

B. Weld the repair area complete using 3/32" or 1/8" dia. electrode. RLR

C. Blend repaired areas into the surrounding weld metal. RLR