



UNITED STATES
ATOMIC ENERGY COMMISSION
DIRECTORATE OF REGULATORY OPERATIONS
REGION III
799 ROOSEVELT ROAD
GLEN ELLYN, ILLINOIS 60137

TELEPHONE
(312) 858-2660

June 29, 1972

Commonwealth Edison Company
ATTN: Mr. Byron Lee, Jr.
Assistant to the President
P. O. Box 767
Chicago, Illinois 60690

Docket No. 50-10
Docket No. 50-237
Docket No. 50-249
Docket No. 50-254
Docket No. 50-265
Docket No. 50-295
Docket No. 50-304

Gentlemen:

Information obtained during inspections conducted by the Directorate of Regulatory Operations, has disclosed that a number of facilities have been equipped with valves with wall thicknesses below the minimum requirements specified by the applicable codes, standards and procurement specifications. In other instances, licensees have not been able to document whether or not their valves met minimum wall thickness requirements. Our survey of this subject has disclosed that the matter is not limited to any class of licensee or valve supplier.

In light of the above information, you are requested to verify, through manufacturing records or other suitable means, that valves important to nuclear safety installed or to be installed at your facilities meet the minimum wall thickness requirements of the specified codes or standards. To the extent that verification records are currently available, you are requested to promptly accumulate those records at the plant site, and to advise this office within thirty (30) days of the date of this letter, of what records are available and when our inspector may examine them at the plant site.

In the event that records are not currently available, you are requested to advise this office within thirty (30) days, of your plans and schedules for demonstrating by suitable alternate means, that valves important to nuclear safety installed or to be installed at your facilities are acceptable with respect to wall thickness. Records of conformance shall be maintained current with inspections performed.

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The valves which require demonstration of acceptable wall thickness are the following:

Each valve within the reactor coolant pressure boundary, as defined in subsection 50.55(a) (Codes and Standards) of 10 CFR 50, where the valve is:

- (a) over 1-inch nominal pipe size for pressurized water reactors;
- (b) over 1½-inch nominal pipe size in water lines for boiling water reactors;
- (c) over 2½-inch nominal pipe size in steam lines for boiling water reactors.

The following techniques are considered to be a sufficient demonstration of acceptable wall thickness. Alternate techniques may be offered, but there is no assurance that they will be found acceptable:

- (1) Documented direct physical measurement of actual wall thickness, with comparison to specified minimum wall thickness.
- (2) Documented results of ultrasonic measurement of wall thickness, with comparison to specified minimum wall thickness, and documentation that the ultrasonic measurement technique is demonstrated to have a maximum error in repeatability and accuracy, of not more than 2% of the wall thickness.
- (3) Wall thicknesses, verified by either of the above techniques, to be not less than 90% of specified minimum wall thickness will be acceptable, provided that the documented mechanical characteristics of the material exceed the specification minimum by an amount sufficient to compensate for the measured reduction in wall thickness.
- (4) "Specified Minimum Wall Thickness" as used above, means the wall thickness required by the relevant codes and standards (e.g., ASA B31.1 (1955); USAS B31.1.0 (1967); USAS B16.5; MSS-SP-66) in effect on the date of the purchase order.

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- (5) Certain of your valves may have, for procurement convenience, been ordered to ratings higher than actually required by service conditions. In such instances, you may, if you wish, provide for our review, an engineering justification for accepting valves which do not conform to procurement specifications, but do in your opinion, satisfy service requirements. Such justification should be promptly transmitted to this office, in ten (10) copies.
- (6) In certain instances, you may wish to repair valves found to have wall thickness below the specified minimum. In such instances you are requested to provide this office for our review, the proposed repair procedure, including a description of techniques to be used to verify the acceptability of the repaired components. Such a proposed procedure should also be submitted in ten (10) copies.

Acceptable documentation of conformance with the above requirements must be completed within three (3) years of the date of this letter.

Very truly yours,

Boyce H. Grier
Regional Director

bcc: RO Files
DR Central Files
PDR
Local PDR

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