



THE ELECTRIC COMPANY

KANSAS GAS AND ELECTRIC COMPANY

TIC

GLENN L. KOESTER
VICE PRESIDENT-OPERATIONS

July 1, 1980

Mr. Karl V. Seyfrit, Director
U.S. Nuclear Regulatory Commission
Region IV
611 Ryan Plaza Drive, Suite 1000
Arlington, Texas 76012

KMLNRC-010

Re: RIV Docket No. STN 50-482/IE Bulletin No. 80-08
Ref: Letter of 4/7/80 from Office of Inspection and
Enforcement, NRC to KG&E

Dear Mr. Seyfrit:

The referenced letter required action by Kansas Gas and Electric Company in regard to IE Bulletin 80-08 concerning examination of containment liner penetration welds. Our response is as follows:

Response to Item 1

The Wolf Creek Generating Station, Unit No. 1, (WCGS) design uses a flued head design for penetration connections. The design utilizes a full penetration butt weld between penetration sleeve and process pipe as illustrated in Figure NE 1120-1, Winter 1975 Addenda to the 1974 edition of the ASME Boiler and Pressure Vessel Code.

Response to Item 2

- a) The erection of WCGS is being conducted in accordance with the 1974 edition of the ASME Boiler and Pressure Vessel Code including Addenda through Summer 1975.
- b) Radiographic examination of penetration sleeve to process pipe welds is required by the Code. Field installation at WCGS of the subject flued heads has only begun and non-destructive examination (NDE) results are as yet unavailable.
- d) Once installation is complete, the NDE information will be forwarded to you.
- c) The type of weld joint and other details regarding pipe material, size and thickness, etc., for all flued head

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penetration assemblies are shown on the attached four sheets. Backing bars or rings are precluded for use with this type of weld.

Response to Item 3

Not applicable.

Yours very truly,

Glenn L. Kaestle

GLK:bb
Attach

cc: Director, Division of Reactor
Construction Inspection
Washington, D.C. 20555
Attachment

APPENDIX E FLUED HEAD DATA

PENE NO	SYS *	PROCESS PIPE DATA										SLEEVE DATA					FLUED HEAD DATA				
		DIA (IN)		MATERIAL	THICK. (IN) t _p (NOM)	CBORE (IN) C _p - .005	WELD END PREP TYPE (MS-8)	DESIGN CONDITIONS		SHT NO & FW NO (SEE NOTE NO 2)		DIA (IN) OD _s	THICK (IN) t _s	CBORE (IN) C _s - .005	WELD END PREP TYPE (MS-8)	MAT'L	L3	FIELD WELD NO. (SEE NOTE NO 21)	LENGTHS		MATERIAL
		OD _p	ID _p					PRESSURE (psig)	TEMP (°F)	OUTSIDE	INSIDE								OVER-ALL L ₁	SLEEVE TO PIPE L ₂	
P-1	AB	28.000	25.000	SA-155 KC 70 CL1	0.934 MIN INSIDE	NOTE NO1	C ^Δ	1185	650	01-F074	01-F075	44.312	1.942	40.056	C	SA 516	15"	01-F056	10'-6"	2'-0"	SA 516 CL1
P-2				INSIDE	INSIDE					01-F007	01-F057					GR 70	12"	01-F058	8'-1 ³ / ₁₆ "		
P-3				SA-106 GR C OUTSIDE	1.500 MIN OUTSIDE					01-F026	01-F108						12"	01-F100	8'-1 ³ / ₁₆ "		
P-4										01-F050	01-F101						15"	01-F102	10'-6"		
P-5	*	14.000	12.500	SA-333	750	12.646			450	05-F006	05-F009	30.375	942	28.056			12"	05-F039	10'-1 ¹ / ₂ "	1'-6"	
P-6				GR. 6						04-F008	04-F009							04-F037	8'-0 5/16"		
P-7										04-F023	04-F024							04-F038	8'-0 5/16"		
P-8										05-F023	05-F024							05-F040	10'-1 ¹ / ₂ "		
P-9	BM	4.500	3.438	SA-508	531	3.529			575	01-F001	01-F003	18.000	741	16.456		SA333	9"	01-F002	11'-3 ³ / ₈ "	2'-0"	
P-10				CL 1						01-F004	01-F005					GR 6		01-F005	8'-7 ¹ / ₈ "		
P-11										02-F001	02-F003							02-F002	8'-0 3/8"		
P-12							C ^Δ	1185		02-F004	02-F005							02-F005	9'-5 ⁵ / ₈ "		
P-22	BB	2.375	1.687	SA-312	344	NA	B	2485	650	11-F001	11-F002						6"	27-F003	6'-6 ¹ / ₁₆ "	1'-3"	SA-1 F 30 OR F 31
P-39				TP 304						09-F001	09-F002							26-F003			
P-40										07-F001	07-F002							07-F003			
P-41										08-F001	08-F002							08-F003			
P-23	BG	3.500	2.900		SEE NOTE 4		B	700	600	03-F001	22-F023	20.000	806	18.326				22-F024	6'-4 ¹ / ₁₆ "	1'-3 ¹ / ₂ "	
P-80		3.500	2.624		.438	2.692	C ^Δ	2800	200	01-F026	23-F002							23-F001	6'-4 ³ / ₈ "	1'-2 ¹ / ₁₆ "	
P-27	EJ	10.750	8.750		1.000	8.959		2485	120	02-F041	04-F002							04-F001	7'-9 ⁵ / ₁₆ "	2'-0 1/4"	
P-82		10.750	8.750		1.000	8.959				01-F046	04-F042							04-F041	7'-3 ¹ / ₄ "	1'-5 ¹ / ₄ "	
P-52		12.750	11.750		.500	SEE		600	400	01-F001	04-F019	24.000	.971	21.996				04-F018	7'-9 ¹ / ₄ "	2'-3 ¹ / ₄ "	
P-79		12.750	11.750		.500	NOTE 3	C ^Δ			01-F007	04-F037	24.000	.971	21.996	C			04-F038	7'-9 ⁵ / ₁₆ "	2'-5 ¹ / ₄ "	

NOTES:

- 26.091 INSIDE & 24.959 OUTSIDE REACTOR BUILDING
- TYPICAL FIELD WELD NO. (REFER TO 10466 MS-8)

1- AB-01-F074
 UNIT NO. | SYSTEM | SEQUENCE NO. | FIELD WELD

BECHTEL DWG. SHEET NO.

- 11834 INSIDE AND 12.052 OUTSIDE REACTOR BUILDING.

E-1
REV. 8

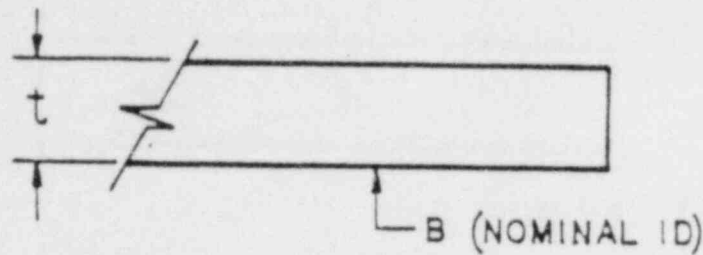
* SYSTEM DESIGNATORS
 AB MAIN STEAM
 AE MAIN FEEDWATER
 BM STEAM GENERATOR BLOWDOWN
 BG CHEMICAL AND VOLUME CONTROL
 EJ RESIDUAL HEAT REMOVAL
 BB REACTOR COOLANT

Δ USE COUNTERBORE DEPTH, X₁

4. WELD PREP TO MATCH SCH. 40S ON THE OUTSIDE AND SCH. 80S ON THE INSIDE OF THE REACTOR BUILDING.

TYPE "A"

APPLICATION: FOR NOMINAL WALL THICKNESSES $\frac{1}{8}$ " AND BELOW IN ASME SECTION III CLASS 1, 2, & 3 AND ANSI B31.1 CRITICAL AND NONCRITICAL SYSTEMS.



NOTE:

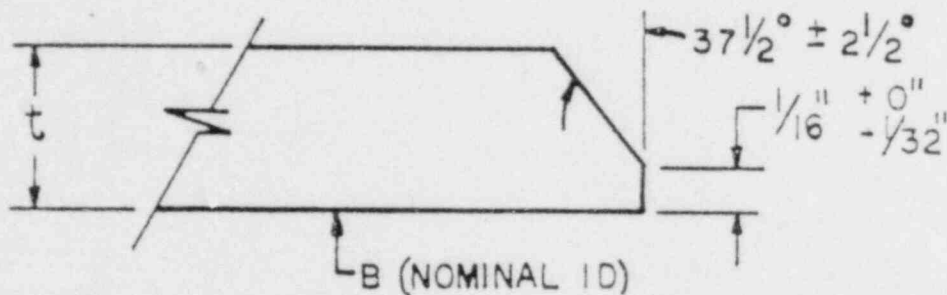
1. FITTINGS NORMALLY SUPPLIED WITH $37\frac{1}{2}$ DEGREE BEVEL ARE PERMISSIBLE AT FIELD WELDS.


TYPE "B"

APPLICATIONS: 1. FOR NOMINAL WALL THICKNESSES ABOVE $\frac{1}{8}$ " TO $\frac{3}{8}$ " INCLUSIVE IN ASME SECTION III CLASS 1, 2, & 3 AND ANSI B31.1 CRITICAL SYSTEMS.

2. FOR NOMINAL WALL THICKNESSES ABOVE $\frac{1}{8}$ " TO $\frac{3}{4}$ " INCLUSIVE IN ANSI B31.1 NONCRITICAL SYSTEMS.

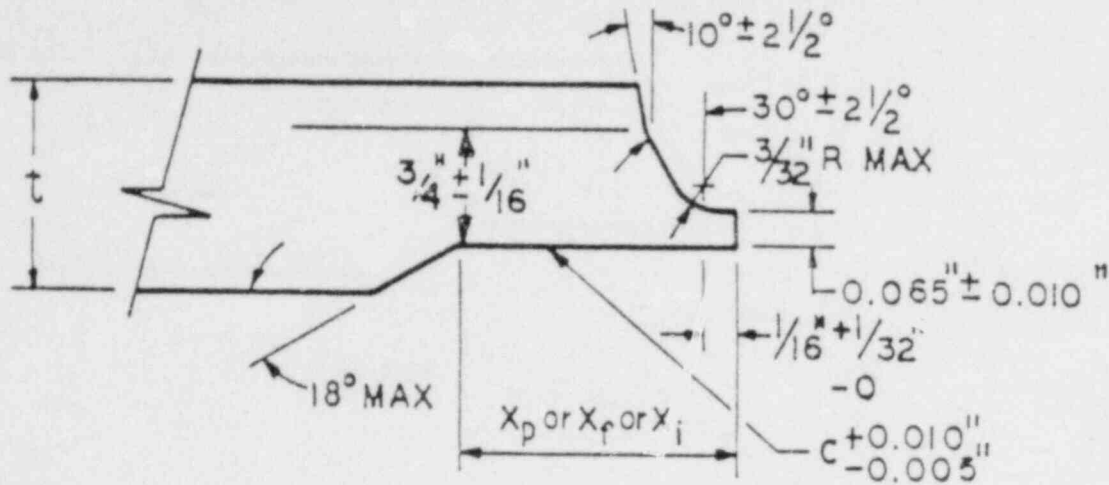
3. FOR NOMINAL WALL THICKNESS ABOVE $\frac{1}{8}$ " TO $\frac{3}{8}$ " INCLUSIVE IN ANSI B31.1 SYSTEM FOR FIELD WELD ENDS JOINING BECHTEL PIPING TO WESTINGHOUSE VALVE OR EQUIPMENT.



SCALE NTS	DESIGNED AB	DRAWN TCB	CHIEF ENGR	JOB NO 10466	BECHTEL DWG NO	REV
SNUPPS		END PREPARATION DATA		MS-6	5	
SHEET 5 OF 7				DWG APPLICABLE TO UNITS		
				1	2	3
				4	5	6
				7	8	

TYPE "C"

APPLICATION: FOR NOMINAL WALL THICKNESSES ABOVE $\frac{3}{8}$ " IN ASME SECTION III CLASS 1, 2, 3 AND ANSI B31.1 CRITICAL SYSTEMS. SEE NOTE 4



NOTES:

1. FOR PIPING, PUMPS, VALVES, NOZZLES AND FITTINGS NOT REQUIRING INSERVICE INSPECTION:

$$X_p = t + \frac{1}{8} - \frac{1}{16} \text{ (WHERE } t \text{ IS THE NOMINAL PIPE WALL THICKNESS)}$$

2. FOR ALL CLASS 1 AND THOSE CLASS 2 PIPES IDENTIFIED ON ISOMETRIC DRAWINGS AS REQUIRING INSERVICE INSPECTION:


$$X_i = 2t + \frac{1}{8} - \frac{1}{16}$$

3. FOR VALVES AND FITTINGS WHERE CONFORMANCE WITH NOTE 1 ABOVE IS NOT FEASIBLE:

$$X_f = \frac{1}{4} + \frac{1}{8} - \frac{1}{16}$$

SEE MS-7 FOR TRANSITION ANGLE ON VALVES

4. THIS WELD END PREPARATION IS COMPATIBLE WITH WESTINGHOUSE VALVES AND EQUIPMENT WHOSE NOMINAL WALL THICKNESS IS ABOVE $\frac{3}{8}$ ".

SCALE NTS	DESIGNED AB	DRAWN TCB	CHIEF ENGR	JOB NO 10466	
				BECHTEL DWG NO.	REV
SNUPPS		END PREPARATION DATA		MS-6	5
		SHEET 6 OF 7		DWG APPLICABLE TO UNITS	
				1	2 3 4 5 6 7 8

APPENDIX "D"

SPECIFICATION NO. 10466-M-203

