U.S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT

REGION III

Reports No. 50-373/81-03; 50-374/81-03

Docket Nos. 50-374; 50-374 Licenses No. CPPR-99; CPPR-100

Licensee: Commonwealth Edison Company
Post Office Box 767
Chicago, IL 60690

Facility Name: La Salle County Station, Units 1 and 2

Inspection At: La Salle Site, Marseilles, IL

Inspection Conducted: January 27 and 28, 1981

Inspector: for C. M. Erb — 2/24/81

Approved By: D. H. Danielson, Chief — 2/24/81
Materials and Processes Section

Inspection Summary

Inspection on January 27 and 28, 1981 (Reports No. 50-373/81-03; 50-374/81-03)
Areas Inspected: Procedures and welding of supports; SRV piping in the suppression pool, Unit 2; rework activity caused by replacement of 24 inch spool on discharge side of Loop "B", Unit 2; Welding Procedure Specification for stub tubes to CRD housings. This inspection involved 11 inspector-hours onsite by one NRC inspector.
Results: No items of noncompliance or deviations were identified.

DETAILS

Persons Contacted

Licensee Employees

*L. J. Burke, Site Project Superintendent
*T. E. Quaka, Site Quality Assurance Superintendent
*R. A. Braun, Quality Assurance Supervisor
*E. R. Wendorf, Project Construction Engineer
*G. E. Groth, Project Construction Engineer
*W. L. Hartig, Quality Assurance Inspector
*R. E. Hetzendorfe, Quality Assurance Welding Engineer

Other Personnel

J. Courtney, Site Manager, Reactor Controls, Inc. (RCI)
L. Bartlett, Supervisor Quality Control (RCI)
M. Wherry, Quality Control Supervisor MOrrison Construction (MCCO)
D. Donath, Production Supervisor (RCI)

*Denotes those present at the exit meeting on January 28, 1981.

Functional or Program Areas Examined

1. Welding in the Suppression Pool, Unit 2

Welding of the bracket to the suppression pool wall was observed. The SRV pipe is 12 inch schedule 80 made to ASME Specification SA106B. There are four shear lugs 6 x 2½ x 1½ welded to the pipe just below the clamp and four lugs welded just above the clamp. These welds are fillet type and are welded with E7018 electrode to procedure P1-18LS. The inspection is visual to NDE VE2, Revision 1.

The bracket welded to the wall is to ASME Specification SA588GrB. This weld is made to MCCO Specification J-2530 and requires a preheat. Procedure DS 22LS is used for the bracket weld and is given a visual and Penetrant Test.

The sway struts which connect the SRV pipe clamp to the wall bracket are furnished by ITT Grinnel. These are adjustable and are set cold. ASME Section IX, 1974 Edition governs this welding.

No items of noncompliance or deviations were identified.

2. Welding in Recirculation System, Unit 2

The welding of the riser elbow spools from the header to the vessel nozzle was held up until a 24 inch diameter spool piece below the circular header had been welded in. This replacement spool was

required because the original spool exhibited a lamination during the ISI UT examination. This work was covered by GE FDI 73/57435.

The welding is to be performed to WP.P8-19LS, Revision 3 for the 12 inch x .604 riser elbow and to P8-18L or P8-19L for the 24 inch x 1.265 replacement spool welds.

Radiography of these welds will be performed to RT-1-NP-R5 by CONAM. Penetrant Test and Visual Examination will be performed by Morrison Construction Company.

No items of noncompliance or deviations were identified.

3. Current Range on Weld Procedure Specifications from RCI

Several weld procedure specifications indicate rather wide ranges for amperage. An example is WIS-052 which was used by RCI to weld the stub tubes to the CRD housings at La Salle. The weld is a combination GTAW and SMAW process and the amperes and volts are as shown below:

Process	Amps	Volts
GTAW	60-180 amps	10-16
SMAW	70-170	16-24

Three filler wire sizes 1/16 inch, 3/32 inch, and 1/8 inch may be used so rather wide heat range can be expected particularly when two or more PQR's support the WPS.

An interpretation was issued on August 9, 1977, by the ASME Code as follows:

> Question: With respect to the 1971 Edition of Section IX, Q-11(b)(5), is it intended that the ranges for amperage, voltage, and speed of travel may be different in the Welding Procedure Specifications from that recorded in the PQR test?
>
> Reply: It is the intent of Section IX (1971 Edition), Q-11(b)(5) that the procedure qualification record shall record the ranges actually used with the filler metal used in the procedure qualification test, but that the Welding Procedure Specification may specify ranges in amperage, voltage, and speed of travel that will procedure acceptable welds and yet might be quite different than the actual values used in the procedure qualification record. For example, the procedure qualification record may have recorded data on a 5/32in. electrode actually used, whereas the Welding Procedure Specification written as supported by the welding procedure record, gives the ranges to be used for 1/8 inch through 1/4 inch diameter electrodes. The Electrode manufacturers ranges when available are an acceptable guide. In the case of shielded metal-arc welding and

gas tungsten-arc welding even wider ranges are possible. The size of the electrode or filler metal is not an essential variable.

This item which was open is now closed.

No items of noncompliance or deviations were identified.

Exit Interview

The inspector met with licensee representatives (see Persons Contacted) at the conclusion of the inspection on January 28, 1981. The inspector summarized the scope and findings of the inspection, which were acknowledged by the licensee.