

DUKE POWER COMPANY

POWER BUILDING  
ATLANTA, GEORGIA

422 SOUTH CHURCH STREET, CHARLOTTE, N. C. 28242

81 JUN 8 P 2: 03

WILLIAM O. PARKER, JR.  
VICE PRESIDENT  
STEAM PRODUCTION

June 1, 1981

TELEPHONE: AREA 704  
373-4083

Mr. James P. O'Reilly, Director  
U. S. Nuclear Regulatory Commission  
Region II  
101 Marietta Street, Suite 3100  
Atlanta, Georgia 30303

Re: RII: EHG  
50-413/80-17  
50-414/80-17

Dear Mr. O'Reilly:

Please find attached final response to Infraction No. 413-414/80-17-01  
which was identified in the above referenced Inspection Report.

I declare under penalty of perjury that the statements set forth herein  
are true and correct to the best of my knowledge.

Very truly yours,

*William O. Parker, Jr.*

William O. Parker, Jr.

*by RHO*

RWO/djs  
Attachment

cc: NRC - Catawba Resident Inspector

1. During inspection conducted July 21 - 25, 1980, five welds on socket welded flanges were identified as being undersized. These welds were identified to DPC personnel, and it was confirmed that they were undersized due to slight concavity and local irregularities.
2. The socket welded flanges had been previously accepted by QC welding inspectors. It is significant to note that Duke Power Company chooses to fabricate all socket welded flanges per L-200 which meets the ASME Code and is more stringent than ANSI B31.1. ANSI requires a fillet weld leg length of 1.09t as opposed to the 1.4t required by ASME. The size weld is a function of pipe wall thickness and often results in odd sizes (i.e., 0.186", 0.305"). This makes measurement difficult considering the geometry involved and resulted in estimations of weld leg size being made by the inspectors.

3. A) All welding inspectors have been retrained in accordance with Welding Program Process Specification L-200 "Gas Tungsten Arc Welding" and Quality Assurance Procedure L-80 "Visual Workmanship Standards for Welds".

Construction Procedure #427 "Hold Points and Process Control Requirements for ASME Class A, B, and C Welds" was issued on July 25, 1980, which provides additional information to the welding inspector to aid in determining weld leg length for socket welded flanges.

- B) A program was developed whereby all socket welded flanges for ASME (Duke Class A, B, and C) and ANSI B31.1 (Duke Class E and F) welded prior to August 27, 1980, were identified. Upon review of the program printout, which listed socket welded flanges by weld number, Duke Class, size and schedule, the decision was made to reinspect all welds listed with repairs to be made as necessary.

Results of reinspection found that 301 (approx. 17% of the total welds reinspected) welds were undersized. Repair process control forms were issued for all welds found to be undersized.

4. To prevent further violations, welding inspectors have been retrained in the requirements of L-200 and L-80. Construction Procedure #427 was developed and implemented.
5. Reinspection is complete and all repairs have been made. Full compliance was achieved by June 1, 1981.