



Commonwealth Edison
One First National Plaza, Chicago, Illinois
Address Reply to: Post Office Box 767
Chicago, Illinois 60690

August 3, 1981



Mr. A. Schwencer, Chief
Licensing Branch No. 2
Division of Licensing
U.S. Nuclear Regulatory Commission
Washington, DC 20555

Subject: LaSalle County Station Unit 1
Update of Baseline Inspection Report
NRC Docket No. 50-373

Reference (1): L. O. DelGeorge letter to B. J. Youngblood
dated December 12, 1980

Dear Mr. Schwencer:

Enclosed for your review are two (2) copies of the subject information. These materials should be consolidated with the report submitted by Reference (1). This update includes changeout pages dated April 17 and April 22, 1981.

If you have any questions in this regard, please direct them to this office.

Very truly yours,

L. O. DelGeorge
Director of Nuclear Licensing

Enclosures

cc: NRC Resident Inspector - LSCS (w/o Enc.)

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Distribution*

GENERAL  ELECTRIC

INSTALLATION AND
SERVICE ENGINEERING
DIVISION

GENERAL ELECTRIC COMPANY, 814 COMMERCE DR., OAK BROOK, ILL. 60521

April 22, 1981

Mr. George R. Crane
Station Nuclear Engineering Department
Commonwealth Edison Company
1 First National Plaza
P. O. Box 767
Chicago, Illinois 60690

SUBJECT: LaSalle Unit 1 PSI Report Update
April 22, 1981

Dear Mr. Crane:

The update package is issued in the form of replacement pages. Revisions, additions or deletions are incorporated directly into the affected pages. Attached is a table containing the necessary changes.

If you have any questions, please do not hesitate to call or write.

Sincerely yours,



R. C. Hooper
NDE Specialist-Technical Support
Central Nuclear Plant Services

RCH:ck
attachment

INSTALLATION & SERVICE ENGINEERING DIVISION

TABLE OF CONTENTS

LSCS Unit 1 - PSI Report

April 22, 1981

Update Package

<u>Section</u>	<u>Volume</u>	<u>Description</u>	<u>Status</u>
10.2.1	4	Inspection Checklist 1 - NIR, Page 4, Rev. 4 Inspection Checklist 1 - NIR, Page 5, Rev. 4	R/R R/R
10.4.5	4	Inspection Checklist IMS-1053, Page 2, Rev. 5	R/R
12.1.1	6	PSI Ref. No. RPV-11, Pages 1 thru 8 PSI Ref. No. RPV-12, Pages 1 thru 25	A A
12.2.1	7	Examination Data Sheets (EDS) 10005E EDS 13001	R/R R/R
12.2.1	8	EDS 55096 EDS 62028 EDS 62031 EDS 62035 EDS 62036 EDS 65066	R/R R/R R/R R/R R/R R/R
12.2.1	9	EDS 70014 EDS 77012 EDS 77028 Evaluation Sheet for EDS 77497 EDS 77597 thru 77614	R/R R/R R/R A A
12.2.1	10	EDS 83035 EDS 85100 CDS 85101 CDS 85133 EDS 85134 CDS 85135 CDS 88015 CDS 88023 EDS 88024 Page 1	R/R R/R R/R R/R R/R R/R R/R R/R R/R
12.2.1	11	EDS 92278 thru 92282 CDS 94124 EDS 94125	A R/R R/R
12.2.1	12	EDS 96000A EDS 96001 EDS 96004 EDS 97005	R/R R/R R/R R/R

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. 1-NIR REV. 4

PAGE 4 of 7

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whalley DATE 4/13/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	O.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-3D	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	97023 45526 73012 73012	99019 45522 73008 73008	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	<u>L.D. Whalley 4/13/81</u>	<u>ref 4/13/81</u>
N/A	1-NIR-4A* (30°)	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	16023 16023 16029 16029	16021 16021 16022 16022	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	<u>L.D. Whalley 4/13/81</u>	<u>ref 4/13/81</u>
N/A	1-NIR-4B* (90°)	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	16024 16024 16030 16030	16021 16021 16022 16022	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	<u>L.D. Whalley 4/13/81</u>	<u>ref 4/13/81</u>
N/A	1-NIR-4C* (150°)	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	16025 16025 16031 16031	16021 16021 16022 16022	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	<u>L.D. Whalley 4/13/81</u>	<u>ref 4/13/81</u>
N/A	1-NIR-4D* (210°)	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	16026 16026 16032 16032	16021 16021 16022 16022	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	<u>L.D. Whalley 4/13/81</u>	<u>ref 4/13/81</u>
*	<p>NIR For PT examinations: See PSI Ref. No. RPV-11. For additional UT examinations: See PSI Ref. Nos. RPV-5 and RPV-12 Nozzle Bore For PT examinations: See PSI Ref. No. RPV-11 For UT examinations: See PSI Ref. No. RPV-6</p>												

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. 1-NIR REV. 4

PAGE 5 of 7

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR R.D. Whately DATE 4/13/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-4E* (270°)	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	16027 16027 16033 16033	16021 16021 16022 16022	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	R.D. Whately 4/13/81	conf. 4/13/81
N/A	1-NIR-4F* (330°)	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	16028 16028 73014 73014	16021 16021 73013 73013	MP-1 MP-1 MP-1 MP-1	N/A N/A 73013 73013	R.D. Whately 4/13/81	conf. 4-13-81
N/A	1-NIR-5	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99002 45501 73006 73006	99000 45500 73005 73005	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	R.D. Whately 4/13/81	conf. 4-13-81
N/A	1-NIR-6A	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	45505 45505 16018 16018	45504 45504 16017 16017	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	R.D. Whately 4/13/81	conf. 4-13-81
N/A	1-NIR-6B	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	45506 45506 16019 16019	45504 45504 16017 16017	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	R.D. Whately 4/13/81	conf. 4-13-81
*	NIR For PT examinations: See PSI Ref. No. RPV-11. For additional UT examinations: See PSI Ref. Nos. RPV-5 and RPV-12. Nozzle Bore For PT examinations: See PSI Ref. No. RPV-11. For UT examinations: See PSI Ref. No. RPV-6.												

INSPECTION CHECKLIST
 LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1053 REV. 5

PAGE 2 of 3

REVIEWED AND APPROVED BY:

O.C. SUPERVISOR L.W. Wheatley DATE 6/23/80

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
26"	IMS-1053-12LD	0	B-J	L.S.	1 1 2	2 0 2	UT-0 ⁰ UT-45 ⁰ PT	20096 70017	20093 70016	01-26-01 01-26-01	20052 10040	L.W. Wheatley 6/23/80	W. J. Caldwell 6-24-80
26"	IMS-1053-13LU	0	B-J	L.S.	1 1 2	3 0 2	UT-0 ⁰ UT-45 ⁰ PT	25110 70022 60010	25109 70020	01-26-01 01-26-01	25103 10040	L.W. Wheatley 6/23/80	W. J. Caldwell 6-24-80
26"	IMS-1053-13	0	B-J	P-V	1 1 2	2 0 2	UT-0 ⁰ UT-45 ⁰ PT	80052 70022 60010	80051 70020	01-26-01 01-26-01	10035 10040	L.W. Wheatley 6/23/80 also 72225, 792231	W. J. Caldwell 6-24-80
26"	IMS-1053-8	0	B-J	P-P	1 1 2	2 2 2	UT-0 ⁰ UT-45 ⁰ PT	80066 20183 60015	80065 20182	01-26-01 01-26-01	10035 10035	L.W. Wheatley 6/23/80 INCR-37 (10505)	W. J. Caldwell 6-24-80
26"	IMS-1053-8LU	0	B-J	L.S.	1 1 2	2 2 2	UT-0 ⁰ UT-45 ⁰ PT	80066 20183 40021	80065 20182	01-26-01 01-26-01	10035 10035	L.W. Wheatley 6/23/80	W. J. Caldwell 6-24-80
26"	IMS-1053-15	0	B-J	V-P	1 1 2	2 2 2	UT-0 ⁰ UT-45 ⁰ PT	20096 10080 60012	20093 10079	01-26-01 01-26-01	20052 10035	L.W. Wheatley 6/23/80	W. J. Caldwell 6-24-80
26"	IMS-1053-15LD	0	B-J	L.S.	1 1 2	2 2 2	UT-0 ⁰ UT-45 ⁰ PT	20096 80055 60012	20093 80054	01-26-01 01-26-01	20052 10035	L.W. Wheatley 6/23/80	W. J. Caldwell 6-24-80
26"	IMS-1053-18	0	B-J	P-PH	1 1 2	0 0 2	UT-0 ⁰ UT-45 ⁰ PT	20030 10008 60014	20029 10007	01-26-02 01-26-02	20001 10001	L.W. Wheatley 6/23/80	W. J. Caldwell 6-24-80

FINAL BORE PT INSPECTION

NOZZLE	INDICATIONS: APPROXIMATE AZIMUTH, DISTANCE FROM FACE, DESCRIPTION	EXAMINER, LEVEL, DATE
30	<p>No relevant indications</p> <p>Note: Re-PT'd grind out area, no relevant indications noted. B.W. Seal II 4/27/78</p>	<p>WLL Level II 7/14/78 Eg Brogan HSB ANI-</p>
90	<p>No relevant indications</p>	<p>WLL Level II 7/14/78 Eg Brogan HSB-ANI</p>
150	<p>No relevant indications</p>	<p>WLL Level II 7/14/78 Eg Brogan - HSB 4-14-78 ANI</p>
210	<p>No relevant indications</p>	<p>WLL Level II 7/14/78 Eg Brogan HSB ANI</p>
270	<p>No relevant indications</p>	<p>WLL 4/12/78 Level II Eg Brogan HSB ANI-</p>
330	<p>No relevant indications</p>	<p>WLL 7/17/78 Level II Eg Brogan HSB ANI</p>

Proj. No. 391N0185

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
(Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 30° FEEDWATER NOZZLE
COMPONENT FEEDWATER NOZZLE BORE MATERIAL CARBON STEEL
PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED
SUMMER 76 ADDENDA

Penetrant Materials

Penetrant Materials Manufacture		MAGNAFLUX SPOT CHECK	
Pre-cleaning Solvent	Type <u>SKC-NF</u>	Batch No.	<u>78A167</u>
Penetrant	Type <u>SKL-HF/S</u>	Batch No.	<u>78A052</u>
Penetrant Remover	Type <u>SKC-NF</u>	Batch No.	<u>78A167</u>
Developer	Type <u>SKD-NF</u>	Batch No.	<u>7K107</u>
Post-Examination Cleaner	Type <u>SKC-NF</u>	Batch No.	<u>78A167</u>

Penetrant Process

A. Pre-Examination Clearing

Grinding Flapper Wheels Other _____
 Normal Evaporation Drying (5 minutes minimum) 5 Minutes
 Forced Hot Air Drying (5 minutes minimum) _____ Minutes
Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? Yes No
Penetrant Temperature Between 60°F and 125°F? Yes No
 Dipping Brushing Spraying
Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal

The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.

Type of Penetrant Cleaner Used SKC-NF
Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application

Type of Solvent Suspension Wet Developer Used SKD-NF
Development Time (7-30 minutes) 7-15 Minutes

E. Post-Examination Cleaning

Type of solvent used for penetrant materials removal SKC-NF
PSI Ref. No. RPV-11
Page 2 of 8.

NDE EXAMINER'S NAME & LEVEL W. J. [Signature] Level II DATE 4/14/78

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
(Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 30° FEEDWATER NOZZLE
COMPONENT FEEDWATER NOZZLE BORE GRINDOUT MATERIAL CARBON STEEL
PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED
SUMMER 76 ADDENDA

Penetrant Materials

Penetrant Materials Manufacturer		<u>MAGNAFLUX SPOT CHECK</u>	
Pre-cleaning Solvent	Type	<u>SKC-NF</u>	Batch No. <u>78A167</u>
Penetrant	Type	<u>SKL-HF/S</u>	Batch No. <u>78A052</u>
Penetrant Remover	Type	<u>SKC-NF</u>	Batch No. <u>78A167</u>
Developer	Type	<u>SKD-NF</u>	Batch No. <u>7K107</u>
Post-Examination Cleaner	Type	<u>SKC-NF</u>	Batch No. <u>78A167</u>

Penetrant Process

A. Pre-Examination Cleaning

Grinding Flapper Wheels Other _____
 Normal Evaporation Drying (5 minutes minimum) 5 Minutes
 Forced Hot Air Drying (5 minutes minimum) _____ Minutes
 Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? Yes No
 Penetrant Temperature Between 60°F and 125°F? Yes No
 Dipping Brushing Spraying
 Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal

The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.
 Type of Penetrant Cleaner Used SKC-NF
 Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application

Type of Solvent Suspension Wet Developer Used SKD-NF
 Development Time (7-30 minutes) 10 Minutes

PSI Ref. No. RPV-11
Page 3 of 8

E. Post-Examination Cleaning

Type of solvent used for penetrant materials removal SKC-NF

NDE EXAMINER'S NAME & LEVEL Bill Waincott DATE 4/27/78

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
(Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 90° FEEDWATER NOZZLE
COMPONENT FEEDWATER NOZZLE BORE MATERIAL CARBON STEEL
PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED
SUMMER 76 ADDENDA

Penetrant Materials

Penetrant Materials Manufacturer		MAGNAFLUX - SPOT CHECK	
Pre-cleaning Solvent	Type	SKC-NF	Batch No. <u>78A167</u>
Penetrant	Type	SKL-HF/S	Batch No. <u>78A052</u>
Penetrant Remover	Type	SKC-NF	Batch No. <u>78A167</u>
Developer	Type	SKD-NF	Batch No. <u>7K107</u>
Post-Examination Cleaner	Type	SKC-NF	Batch No. <u>78A167</u>

Penetrant Process

A. Pre-Examination Cleaning

Grinding Flapper Wheels Other _____
 Normal Evaporation Drying (5 minutes minimum) 5 Minutes
 Forced Hot Air Drying (5 minutes minimum) _____ Minutes
 Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? Yes No
 Penetrant Temperature Between 60°F and 120°F? Yes No
 Dipping Brushing Spraying
 Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal

The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.
 Type of Penetrant Cleaner Used SKC-NF
 Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application

Type of Solvent Suspension Wet Developer Used SKD-NF
 Development Time (7-30 minutes) 7-15 Minutes

E. Post-Examination Cleaning

Type of solvent used for penetrant materials removal SKC-NF PSI Ref. No. RPV-11
Page 4 of 8

NDE EXAMINER'S NAME & LEVEL W. J. Smith Lead II DATE 4/14/78

EXHIBIT I ANI - EG Bogan 4-14-78

RELATIONSHIP SERVICE ENGINEERING DIVISION

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
(Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 210° FEEDWATER NOZZLE
COMPONENT FEEDWATER NOZZLE BORE MATERIAL CARBON STEEL
PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED
JUNNER 76 ADDENDA

Penetrant Materials

Penetrant Materials Manufacturer		MAGNAFLUX- SPOT CHECK	
Pre-cleaning Solvent	Type	SKC-NF	Batch No. <u>78A167</u>
Penetrant	Type	SKL-HF/S	Batch No. <u>78A052</u>
Penetrant Remover	Type	SKC-NF	Batch No. <u>78A167</u>
Developer	Type	SKD-NF	Batch No. <u>7K107</u>
Post-Examination Cleaner	Type	SKC-NF	Batch No. <u>78A167</u>

Penetrant Process

A. Pre-Examination Cleaning

Grinding Flapper Wheels Other _____
 Normal Evaporation Drying (5 minutes minimum) 5 Minutes
 Forced Hot Air Drying (5 minutes minimum) _____ Minutes
 Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? Yes No
 Penetrant Temperature Between 60°F and 125°F? Yes No
 Dipping Brushing Spraying
 Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal

The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.
 Type of Penetrant Cleaner Used SKC-NF
 Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application

Type of Solvent Suspension Wet Developer Used SKD-NF
 Development Time (7-30 minutes) 7-15 Minutes

E. Post-Examination Cleaning

Type of solvent used for penetrant materials removal SKC-NF

PSI Ref. No. RPV-11
Page 6 of 8

NDE EXAMINER'S NAME & LEVEL W. Donath Level II DATE 4/14/78
 EXHIBIT I AV/E J. B. Began 4-14-78

INSTALLATION SERVICE ENGINEERING DIVISION

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
 (Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 270° FEEDWATER NOZZLE
 COMPONENT FEEDWATER NOZZLE BORE MATERIAL CARBON STEEL
 PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED
 SUMMER 76 ADDENDA

Penetrant Materials

Penetrant Materials Manufacturer MAGNAFLUX - SPOT CHECK
 Pre-cleaning Solvent Type SKC-NF Batch No. 78A167
 Penetrant Type SKL-HF/S Batch No. 78A052
 Penetrant Remover Type SKC-NF Batch No. 78A167
 Developer Type SKD-NF Batch No. 7K107
 Post-Examination Cleaner Type SKC-NF Batch No. 78A167

Penetrant Process

A. Pre-Examination Cleaning

Grinding Flapper Wheels Other _____
 Normal Evaporation Drying (5 minutes minimum) 5 Minutes
 Forced Hot Air Drying (5 minutes minimum) _____ Minutes
 Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? Yes No
 Penetrant Temperature Between 60°F and 125°F? Yes No
 Dipping Brushing Spraying
 Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal

The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.
 Type of Penetrant Cleaner Used SKC-NF
 Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application

Type of Solvent Suspension Wet Developer Used SKD-NF
 Development Time (7-30 minutes) 7-15 Minutes

PSI Ref. No. RPV-11
 Page 7 of 8

E. Post-Examination Cleaning

Type of solvent used for penetrant materials removal SKC-NF

NDE EXAMINER'S NAME & LEVEL Whitcomb Level II DATE 4/12/78

INSTALLATION MATERIALS ENGINEERING DIVISION

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
(Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 330° FEEDWATER NOZZLE
COMPONENT FEEDWATER NOZZLE BORE MATERIAL CARBON STEEL
PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED
SUMMER 76 ADDENDA

Penetrant Materials

	MAGNAFLUX-SPOT CHECK	
Penetrant Materials Manufacturer	Type	Batch No.
Pre-cleaning Solvent	SKC-NF	78A167
Penetrant	SKL-HF/S	78A052
Penetrant Remover	SKC-NF	78A167
Developer	SKB-NF	7K107
Post-Examination Cleaner	SKC-NF	78A167

Penetrant Process

A. Pre-Examination Cleaning

Grinding Flapper Wheels Other _____
 Normal Evaporation Drying (5 minutes minimum) 5 Minutes
 Forced Hot Air Drying (5 minutes minimum) _____ Minutes
Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? Yes No
Penetrant Temperature Between 60°F and 125°F? Yes No
 Dipping Brushing Spraying
Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal

The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.

Type of Penetrant Cleaner Used SKC-NF
Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application

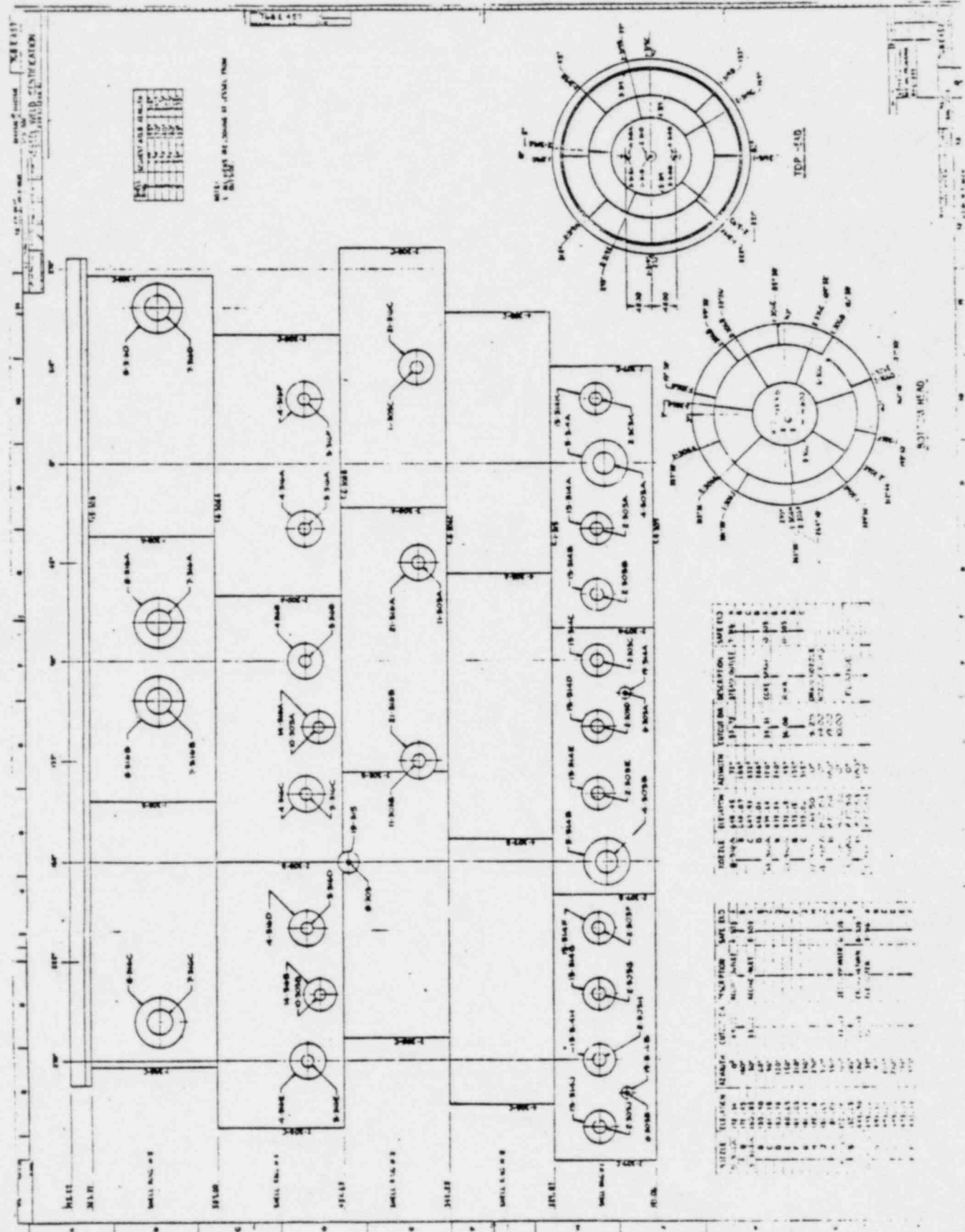
Type of Solvent Suspension Wet Developer Used SKD-NF
Development Time (7-30 minutes) 7-15 Minutes

PSI Ref. No. RPV-11
Page 8 of 8

E. Post-Examination Cleaning

Type of solvent used for penetrant materials removal SKC-NF

NDE EXAMINER'S NAME & LEVEL W. J. [Signature] Level II DATE 4/14/78



SEE EAST SIDE OF DRAWING FOR DIMENSIONS AND WEIGHTS

ITEM	QTY	DESCRIPTION
1	1	REACTOR CORE
2	1	TOP END
3	1	BOTTOM END

NOTE: 1. ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.

ITEM	QTY	DESCRIPTION	UNIT
1	1	REACTOR CORE	EA
2	1	TOP END	EA
3	1	BOTTOM END	EA

ITEM	QTY	DESCRIPTION	UNIT
1	1	REACTOR CORE	EA
2	1	TOP END	EA
3	1	BOTTOM END	EA

ULTRASONIC INSPECT. REPORT

INFORMATION
 REPORTABLE
 Yes No

ACCEPTABLE
 Satisfactory
 Unsatisfactory

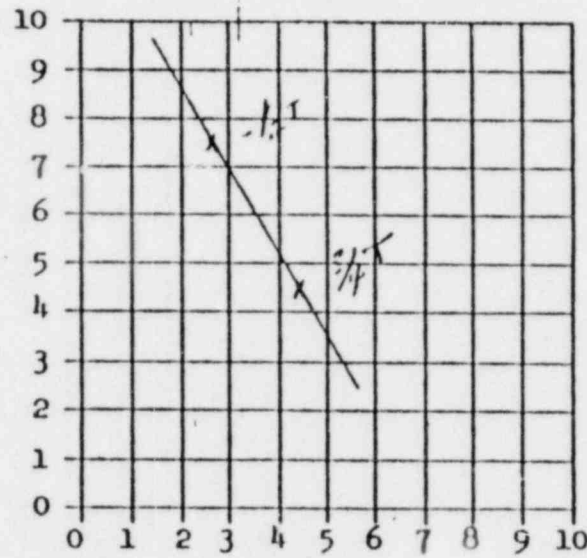
CONTRACT 2867 JOB & CONTROL NO.: V-20777-053 SEQ. 50 OPERATION 4278 DATE 12/1/76
 COMPONENT: Final Vessel Assy QTY 1 SEAM PART OR CODE NO.: 316-02-1
 TYPE SEAM: GIRTH LONG NOZZLE OTHER _____ REPAIR
 M&P SPECIFICATION 2.4.4.11 (a) RECEIVING IN-PROCESS FINAL
 COMPLETE INCOMPLETE NDE EVALUATE _____ REJ. NO. _____ RECORD
 INSPECTOR(S) R. Wille II S. Wells II CUSTOMER _____

*Reviewed
 w/ Caldwell AMEF HSB
 4-8-81*

TEST

BM 0° - HAZ 45° 60°
 B.R. _____ % I.D. O.D.
 IIW BLOCK ANGLE 45°
 CALIBRATION BLOCK NO. 2867-8'
 TRANSDUCER S/N 564 #7-CWShal
 CABLE S/N n/a
 EQUIPMENT S/N 740916
 CE S/N 9445

DAC



LINEARITY CHECKS

DB @ 10X _____
13 DB @ 5X _____
 _____ DB @ 2X _____
 _____ DB @ 1/2X _____
 _____ DB @ 1/4X _____

TIME (MILITARY)

0830 _____
0930 _____

INCHES/DIV.

2

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
n/a DB DIAL
 FREQUENCY 1.0 2.25 5.0
 OTHER
 JACK (R) T
 REP RATE 1K
 FILTER Hi
 DAMPING Med
 VIDEO (NORMAL)/DIFFERENTIAL
 REJECT (OFF)
 SWEEP DELAY n/a COARSE
140 FINE
 RANGE 10
 MATERIAL CALIBRATION 8.50
 SWEEP DIAL n/a
 SWEEP RATIO n/a
 CALIBRATION SHEET 13-1
 N-2.4.4.111(a)
 Figure D

COUPLANT: WATER GLYCERINE
 SILICONE GREASE

TEST TEMPERATURE:
 AMBIENT ELEVATED _____ °F

1304 PSI Ref. No.

INFORMATION
 REPORTABLE
 Yes No

ACCEPTANCE
 Satisfactory
 Unsatisfactory

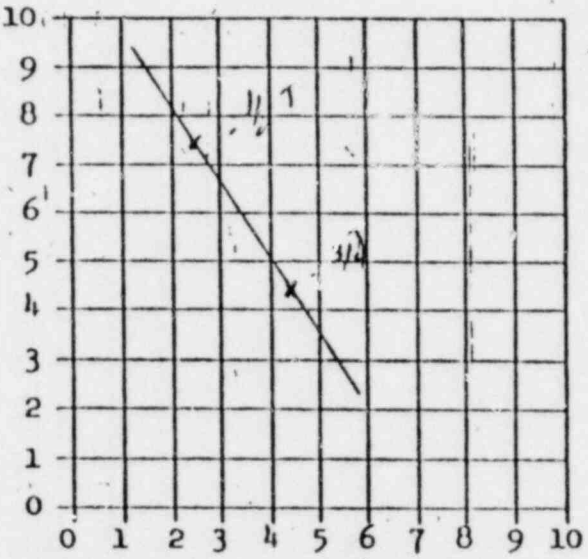
CONTRACT 2867 JOB & CONTROL NO. 70777-053 SEQ. 50 OPERATION 4278 DATE 1/21/76
 COMPONENT: Final Vessel Assy QTY 1 SEAM/PART OR CODE NO.: 316-02-1
 TYPE SEAM: GIRTH LONG NOZZLE OTHER _____ REPAIR
 M&P SPECIFICATION 2.4.4.111 (a) RECEIVING IN-PROCESS FINAL
 COMPLETE INCOMPLETE NDE EVALUATE _____ REJ. NO. _____ RECORD
 INSPECTOR(S) R. Wille IT S. Wells IT CUSTOMER _____

*Received
 w/ Calibration ANFF 1158
 1-4-85*

TEST

DAC

BM 0°-HAZ 45° 60°
 B.R. _____ % I.D. O.D.
 IIW BLOCK ANGLE 45.0°
 CALIBRATION BLOCK NO. 2867-8"
 TRANSDUCER S/N S-64 #800w shoe
 CABLE S/N n/a
 EQUIPMENT S/N 740916
 C.E S/N 9445
 PULSER/RECEIVER S/N FIS/NIKI
 COUPLANT: WATER GLYCERINE
 SILICONE GREASE



LINEARITY CHECKS
 _____ DB @ 10X
13 DB @ 5X
 _____ DB @ 2X
 _____ DB @ 1/2X
 _____ DB @ 1/4X

TIME (MILITARY)
0830
0930

INCHES/DIV. 2

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
n/a DB DIAL
 FREQUENCY 1.0 2.25 5.0
 OTHER
 JACK (R) T
 REP RATE 1K
 FILTER Hi
 DAMPING Med
 VIDEO (NORMAL)/DIFFERENTIAL
 REJECT OFF
 SWEEP DELAY n/a COARSE
140 FINE
 RANGE 10
 MATERIAL CALIBRATION 8.52
 SWEEP DIAL n/a
 SWEEP RATIO n/a
 CALIBRATION SHEET 142
 N-2.4.4.111(a)
 Figure D U Wear

1305 PSI Ref. No. RPV-12
 Page 4 of 25

INFORMATION
REPORTABLE
Yes No

ACCEPTABLE
 Satisfactory
 Unsatisfactory

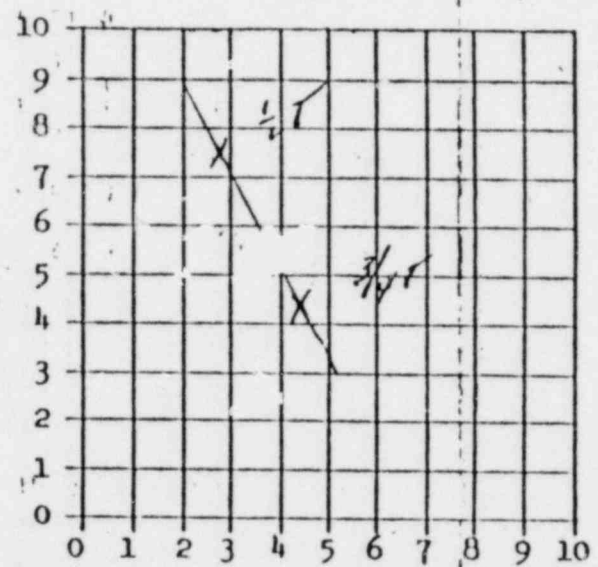
CONTRACT 2867 JOB & CONTROL NO.: V-7077-053 SEQ. 50 OPERATION 4278 DATE 1/2/76
 COMPONENT: Final Road Assy QTY 1 SEAM POINT OR CODE NO.: 316-02-2
 TYPE SEAM: GIRTH LONG NOZZLE OTHER Rollins REPAIR
 M&P SPECIFICATION 2.4.4.111(h) RECEIVING IN-PROCESS FINAL
 COMPLETE INCOMPLETE NDE EVALUATE _____ REJ. NO. _____ RECORD
 INSPECTOR(S) G. Phillips & R. Harton II CUSTOMER _____

*Revised
by Callahan NAFS HSB
4-8-81*

TEST

DAC

BM 0°-HAZ 45° 60°
 B.R. _____ % I.D. O.D.
 11W BLOCK ANGLE 45°
 CALIBRATION BLOCK NO. 2867-8"
 TRANSDUCER S/N S-64 #7 CW shoe
 CABLE S/N 144
 EQUIPMENT S/N 940916
 C/E S/N 9445



SET-UP
 SENSITIVITY -1 DB FINE
+30 DB COARSE
N/A DB DIAL
 FREQUENCY 1.0 2.25 5.0
 OTHER

JACK (R) T
 REP RATE 1K
 FILTER Hi
 DAMPING med
 VIDEO (NORMAL) DIFFERENTIAL
 REJECT (OFF)
 SWEEP DELAY N/A COARSE
1.40 FINE
 RANGE 10
 MATERIAL CALIBRATION 8.52
 SWEEP DIAL N/A
 SWEEP RATIO N/A
 CALIBRATION SHEET NO. 3
 N-2.4.4.111(h)
 Figure D

LINEARITY CHECKS

13 DB @ 10X
 _____ DB @ 5X
 _____ DB @ 2X
 _____ DB @ 1/2X
 _____ DB @ 1/4X

TIME (MILITARY)
06:00
16:30

INCHES/DIV.

PULSER/RECEIVER S/N F51 MK I
 COUPLANT: WATER GLYCERINE
 SILICONE GREASE
 TEST TEMPERATURE:
 AMBIENT ELEVATED _____ OF

1306

PSI Ref. No.

RPV-12
Page 6 of 25

INFORMATION
 REPORTABLE
 Yes No

ACCEPTABLE
 Satisfactory
 Unsatisfactory

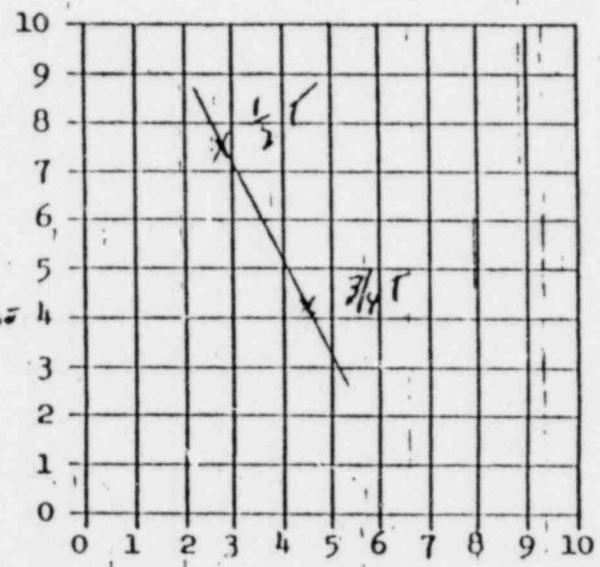
CONTRACT 2867 JOB & CONTROL NO.: V-76777-053 SEQ. 50 OPERATION 4278 DATE 12/1/76
 COMPONENT: Final vessel assy QTY 1 SEAM, PART OR CODE NO.: 316-02-2
 TYPE SEAM: GIRTH LONG NOZZLE OTHER Seams REPAIR
 M&P SPECIFICATION 2.4.4.11(A) RECEIVING IN-PROCESS FINAL
 COMPLETE INCOMPLETE NDE EVALUATE _____ REJ. NO. _____ RECORD
 INSPECTOR(S) G. Phillips II R. Horton II CUSTOMER _____

Reviewed
 w/ Caldwell AMEF-MSB
 4-8-81

TEST

DAC

BM 0° HAZ 45° 60° _____
 B.R. _____ % I.D. O.D.
 IIW BLOCK ANGLE 45°
 CALIBRATION BLOCK NO. 2867-8"
 TRANSDUCER S/N S-64 #8 ccw slot
 CABLE S/N 1/A
 EQUIPMENT S/N 140916
 C-E S/N 9445
 PULSER/RECEIVER S/N FTS-111K I



LINEARITY CHECKS
 _____ DB @ 10X
13 DB @ 5X
 _____ DB @ 2X
 _____ DB @ 1/2X
 _____ DB @ 1/4X

TIME (MILITARY)
05:30
06:00

INCHES/DIV.
 1/A

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
1/A DB DIAL
 FREQUENCY 1.0 2.25 5.0
 OTHER
 JACK (R) T
 REP RATE 1K
 FILTER Eli
 DAMPING med
 VIDEO (NORMAL) DIFFERENTIAL
 REJECT (OFF)
 SWEEP DELAY 1/A COARSE
1.40 FINE
 RANGE 10
 MATERIAL CALIBRATION 8.52
 SWEEP DIAL 1/A
 SWEEP RATIO 1/A
 CALIBRATION SHEET 4
 N-2.4.4.11(a)
 Figure D

1307 PSI Ref. No. RPV-12 Page 8 of 25

TEST TEMPERATURE:
 AMBIENT ELEVATED _____ °F

INFORMATION
 REPORTABLE
 Yes No

ACCEPTANCE
 Satisfactory
 Unsatisfactory

CONTRACT 2867 JOB & CONTROL NO.: V-70777-053 SEQ. 50 OPERATION 4278 DATE 1/21/76
 COMPONENT: Final Vessel Body QTY 1 SEAM, PART OR CODE NO.: 316-02-3
 TYPE SEAM: GIRTH LONG NOZZLE OTHER Radius REPAIR
 M&P SPECIFICATION 2.4.4.111(A) RECEIVING IN-PROCESS FINAL
 COMPLETE INCOMPLETE NDE EVALUATE _____ REF. NO. _____ RECORD
 INSPECTOR(S) G. Phillips & R. H. Stewart CUSTOMER _____

Reviewed by Caldwell NDE- HSB
 4-8-81

TEST

DAC

BM 0° - HAZ 45° 60°

B.R. _____ % I.D. O.D.

11W BLOCK ANGLE 45°

CALIBRATION BLOCK NO. 2867-8

TRANSDUCER S/N S-64 #7 show cw

CABLE S/N N/A

EQUIPMENT S/N 740916

C-E S/N 9445

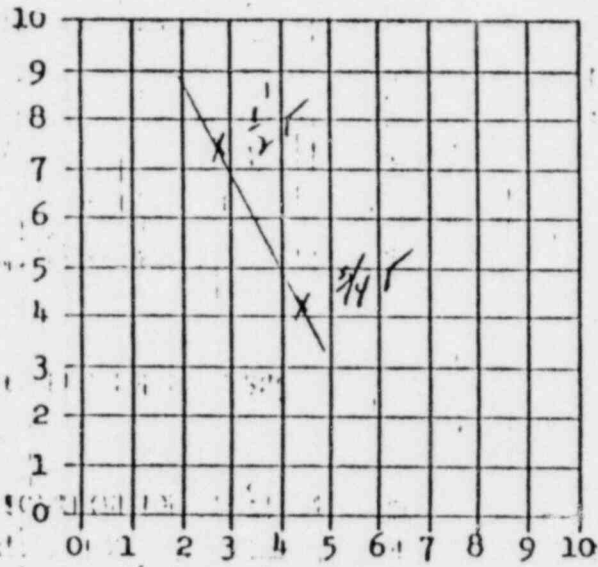
PULSER/RECEIVER S/N FYS-MKT

COUPLANT: WATER GLYCERINE

SILICONE GREASE

TEST TEMPERATURE:

AMBIENT ELEVATED _____ °F



LINEARITY CHECKS

_____ DB @ 10X
1.3 DB @ 5X
 _____ DB @ 2X
 _____ DB @ 1/2X
 _____ DB @ 1/4X

TIME (MILITARY)

04:30
05:30

INCHES/DIV.

2"

SET-UP

SENSITIVITY 1 DB FINE
+30 DB COARSE
N/A DB DIAL

FREQUENCY 1.0 2.25 5.0
 OTHER

JACK (R) T

REP RATE 1K

FILTER Hi

DAMPING Med

VIDEO (NORMAL) DIFFERENTIAL

REJECT (OFF)

SWEEP DELAY N/A COARSE
6.40 FINE

RANGE 10

MATERIAL CALIBRATION 8.52

SWEEP DIAL N/A

SWEEP RATIO N/A

CALIBRATION SHEET 5
 N-2.4.4.111(a)
 Figure D

1305
 PSI Ref. No.
 RPV-12
 Page 10 of 25

ULTRASONIC INSPECTION REPORT

INFORMATION
 REPORTABLE
 Yes No

ACCEPTANCE
 Satisfactory
 Unsatisfactory

CONTRACT 2867 JOB & CONTROL NO: U-70777-053 SEQ. 50 OPERATION 4278 DATE 1/21/76
 COMPONENT: Front Vessel ASS'y QTY 1 SEAM, PART OR CODE NO.: 316-02-3
 TYPE SEAM: GIRTH LONG NOZZLE OTHER Radius REPAIR
 M&P SPECIFICATION 2.4.4.11 A RECEIVING IN-PROCESS FINAL
 COMPLETE INCOMPLETE NDE EVALUATE _____ REJ. NO. _____ RECORD
 INSPECTOR(S) G. Phillips & R. Harrison CUSTOMER _____

*Revised
 w/ Caldwell ASET - HSB
 4-8-81*

TEST

EAC

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
n/a DB DIAL

FREQUENCY 1.0 2.25 5.0
 OTHER

JACK (R) T
 REP RATE 1K
 FILTER H
 DAMPING med
 VIDEO (NORMAL) DIFFERENTIAL

REJECT (OFF)
 SWEEP DELAY n/a COARSE
1.40 FINE

RANGE 10
 MATERIAL CALIBRATION 8.52
 SWEEP DIAL n/a
 SWEEP RATIO n/a

CALIBRATION SHEET 6
 N-2.4.4.11(a)
 Figure D

BM 0° HAZ 45° 60°

B.R. _____ % I.D. O.D.

11W BLOCK ANGLE 45°

CALIBRATION BLOCK NO. 2867-8

TRANSDUCER S/N S-64 # 8 skew ccw

CABLE S/N n/a

EQUIPMENT S/N 740916

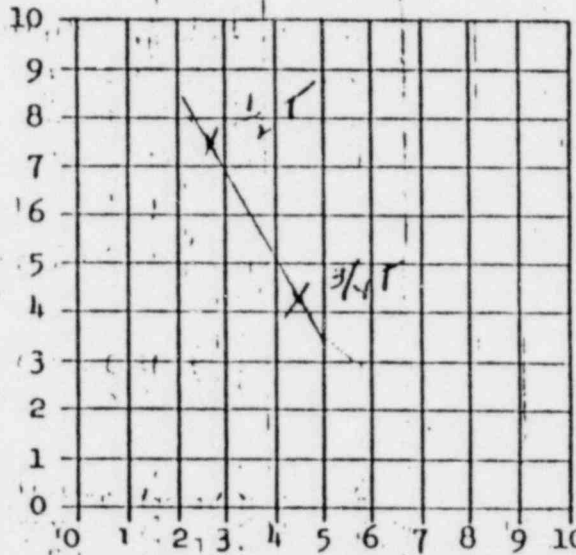
C.E. S/N 9045

PULSER/RECEIVER S/N ATS-DIKT

COUPLANT: WATER GLYCERINE

SILICONE GREASE

TEST TEMPERATURE:
 AMBIENT ELEVATED _____ °F



LINEARITY CHECKS

_____ DB @ 10X
13 DB @ 5X
 _____ DB @ 2X
 _____ DB @ 1/2X
 _____ DB @ 1/4X

TIME (MILITARY)

09:00
09:30

INCHES/DIV.

1"

<input type="checkbox"/> INFORMATION	<input type="checkbox"/> ACCEPTABLE
REPORTABLE Yes <input type="checkbox"/> No <input type="checkbox"/>	<input type="checkbox"/> Satisfactory <input type="checkbox"/> Unsatisfactory

CONTRACT 2867 JOB & CONTROL NO.: V-70777-053 SEQ. 50 OPERATION 4278 DATE 11/21
 COMPONENT: FINAL VESSEL ASSY QTY 1 SEAM, PART OR CODE NO.: 316-02-4
 TYPE SEAM: GIRTH LONG NOZZLE OTHER _____ REPAIR
 M&P SPECIFICATION 2.4.4.111(a) RECEIVING IN-PROCESS FINAL
 COMPLETE INCOMPLETE NDE EVALUATE _____ REJ. NO. _____ RECORD
 INSPECTOR(S) R. WILLE II S. WELLS II CUSTOMER _____

*Revised
 w/ Caltech AMET-MSB
 4-8-81*

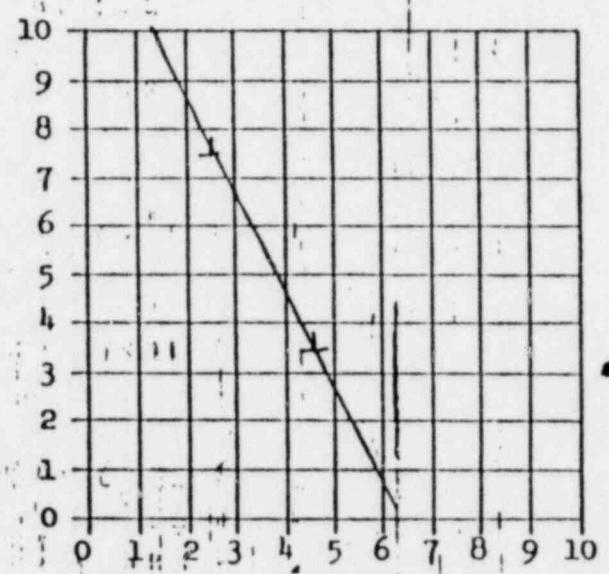
SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
N/A DB DIAL
 FREQUENCY 1.0 2.25 5
 OTHER
 JACK T
 REP RATE 1K
 FILTER H1
 DAMPING MED
 VIDEO NORMAL DIFFERENTIAL
 REJECT OFF
 SWEEP DELAY N/A COAR
1.40 FINE
 RANGE 10
 MATERIAL CALIBRATION 8.52
 SWEEP DIAL N/A
 SWEEP RATIO N/A
 CALIBRATION: TNO. 7
 N-2.4.4.111(a),
 Figure B ()

TEST

BM 0° - HAZ 45° 60° _____
 B.R. _____ % I.D. O.D.
 11W BLOCK ANGLE 45°
 CALIBRATION BLOCK NO. 2867-8
 TRANSDUCER S/N 5-64 #7cw
 CABLE S/N N/A
 EQUIPMENT S/N FTS 740916
 C-E S/N 9445
 PULSER/RECEIVER S/N FTS MARK I
 COUPLANT: WATER GLYCERINE
 SILICONE GREASE

DAC



LINEARITY CHECKS

13 DB @ 10X
 _____ DB @ 5X
 _____ DB @ 2X
 _____ DB @ 1/2X
 _____ DB @ 1/4X

TIME (MILITARY)
1300
1330

INCHES/DIV. 2

TEST TEMPERATURE:

AMBIENT ELEVATED _____ OF

1311

PS-1 Ref. No. RPV-12

Page 14 of 25

ULTRASONIC INSPECT, N REPORT

<input type="checkbox"/> INFORMATION	<input type="checkbox"/> ACCI
REPORTABLE Yes <input type="checkbox"/> No <input type="checkbox"/>	<input type="checkbox"/> Satisfact <input type="checkbox"/> Unsatisf

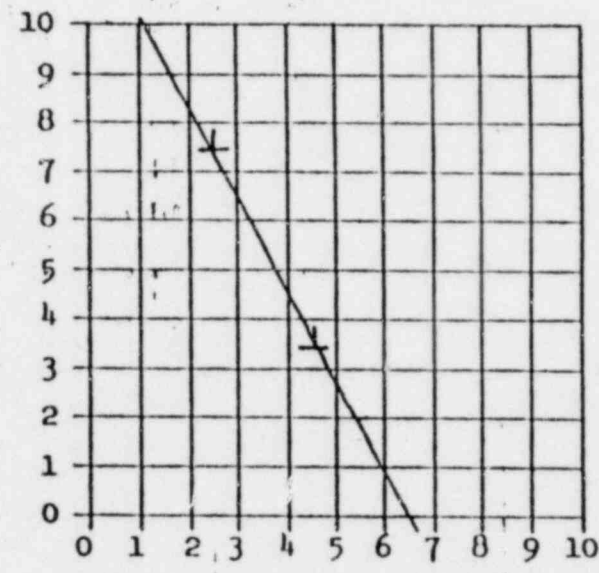
CONTRACT 2867 JOB & CONTROL NO.: V-70777-053 SEQ. 50 OPERATION 4278 DATE 112
 COMPONENT: FINAL VESSEL Assy QTY 1 SEAM, PART OR CODE NO.: 316-02-4
 TYPE SEAM: GIRTH LONG NOZZLE OTHER _____ REPAIR
 M&P SPECIFICATION 2.4.4.111(a) RECEIVING IN-PROCESS FINAL
 COMPLETE INCOMPLETE NDE EVALUATE _____ REJ. NO. _____ RECORD
 INSPECTOR(S) R. WILLE II S. WELLS II CUSTOMER _____

*Removal
 w/ Caldwell ART HSB
 4-8-81*

TEST

BM 0°-HAZ 45° 60°
 B.R. _____ % I.D. O.D.
 11W BLOCK ANGLE 45°
 CALIBRATION BLOCK NO. 2867-8"
 TRANSDUCER S/N 5-64 #8cew
 CABLE S/N n/a
 EQUIPMENT S/N 740916
 CE S/N 9445
 PULSER/RECEIVER S/N FIS MARK³
 COUPLANT: WATER GLYCERINE
 SILICONE GREASE

DAC



LINEARITY CHECKS
 _____ DB @ 10X
13 DB @ 5X
 _____ DB @ 2X
 _____ DB @ 1/2X
 _____ DB @ 1/4X

TIME (MILITARY)
1300 _____
1330 _____

INCHES/DIV. 2"

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
n/a DB DIAL
 FREQUENCY 1.0 2.25 5
 OTHER
 JACK (R) T
 REP RATE 1K
 FILTER Hi
 DAMPING MED
 VIDEO (NORMAL) DIFFERENTIAL
 REJECT (DEF)
 SWEEP DELAY: n/a COAR
1.40 FINE
 RANGE 10
 MATERIAL CALIBRATION 2.5
 SWEEP DIAL n/a
 SWEEP RATIO n/a
 CALIBRATION IT NO. 8
 N-2.4.4.111(a), (.)
 Figure D

TEST TEMPERATURE:
 AMBIENT ELEVATED _____ °F

1310

PSI Ref. No. RPV-12
 Page 16 of 25

INFORMATION
 REPORTABLE
 Yes No

ACCEPTANCE
 Satisfactory
 Unsatisfactory

CONTRACT: 2867 JOB & CONTROL NO.: V-70777-053 SEQ. 50 OPERATION 4278 DATE 1/21/76
 COMPONENT: FINAL VESSEL Assy QTY 1 SEAM, PART OR CODE NO.: 316-02-5
 TYPE SEAM: GIRTH LONG NOZZLE OTHER _____ REPAIR
 M&P SPECIFICATION 2.4.4.111(a) RECEIVING IN-PROCESS FINAL
 COMPLETE INCOMPLETE NDE EVALUATE _____ REJ. NO. _____ RECORD
 INSPECTOR(S) R. WILLE II S. WELLS II CUSTOMER _____

*u of Calhoun ARII-115B
 4-8-81*

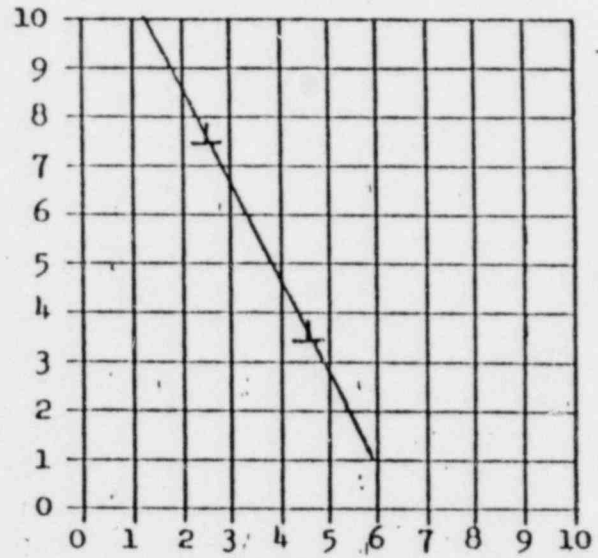
TEST

BM 0°-HAZ 45° 60° _____
 B.R. _____ % I.D. O.D.
 TIW BLOCK ANGLE 45.0°
 CALIBRATION BLOCK NO. 2867-8
 TRANSDUCER S/N 5-64 #8 CCW SHOE
 CABLE S/N n/a
 EQUIPMENT S/N 740916
 C-E S/N 9445

PULSER/RECEIVER S/N FIS MARK I
 COUPLANT: WATER GLYCERINE
 SILICONE GREASE

TEST TEMPERATURE:
 AMBIENT ELEVATED _____ °F

DAC



LINEARITY CHECKS
13 DB @ 10X
 _____ DB @ 5X
 _____ DB @ 2X
 _____ DB @ 1/2X
 _____ DB @ 1/4X

TIME (MILITARY)
1100
1130

INCHES/DIV. 2

SET-UP

SENSITIVITY -1 DB FINE
150 DB COARSE
n/a DB DIAL
 FREQUENCY 1.0 2.25 5.0
 OTHER
 JACK (R) T
 REP RATE 1K
 FILTER Hi
 DAMPING MED
 VIDEO (NORMAL) DIFFERENTIAL
 REJECT (OFF)
 SWEEP DELAY n/a COARSE
1.40 FINE
 RANGE 10
 MATERIAL CALIBRATION 8.52
 SWEEP DIAL n/a
 SWEEP RATIO n/a
 CALIBRATION SHEET NO. 9
 N-2.4.4.111(a)
 Figure D

1312 PSI Ref. No. RPV-12 Page 18 of 25

<input type="checkbox"/> INFORMATION
REPORTABLE
Yes <input type="checkbox"/> No <input type="checkbox"/>

<input type="checkbox"/> ACCEPTED
<input type="checkbox"/> Satisfactory
<input type="checkbox"/> Unsatisfactory

CONTRACT 2867 JOB & CONTROL NO.: V-70777-053 SEQ. 50 OPERATION 4278 DATE 12/1/76
 COMPONENT: FINAL VESSEL ASSY QTY 1 SEAM, PART OR CODE NO.: 316-02-5
 TYPE SEAM: GIRTH LONG NOZZLE OTHER _____ REPAIR
 M&P SPECIFICATION 2:4.4:111(a) RECEIVING IN-PROCESS FINAL
 COMPLETE INCOMPLETE NDE EVALUATE _____ REJ. NO. _____ RECORD
 INSPECTOR(S) R. WILLE II S. WELLS II CUSTOMER _____

*Removal
w/ Caldwell AREF-453
4-8-81*

TEST

DAC

BM 0° - HAZ 45° 60°

B.R. _____ % I.D.

11W BLOCK ANGLE 45°

CALIBRATION BLOCK NO. 2867-18

TRANSDUCER S/N 5-64 #7 Curshaw

CABLE S/N n/a

EQUIPMENT S/N 740916

C-E S/N 9445

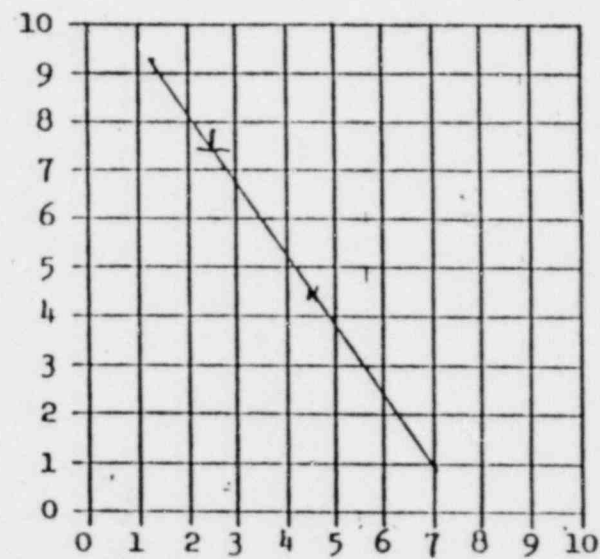
PULSER/RECEIVER S/N F15 MARK I

COUPLANT: WATER GLYCERINE

SILICONÉ GRÉASE

TEST TEMPERATURE:

AMBIENT ELEVATED _____ °F



LINEARITY CHECKS

13 DB @ 10X
 _____ DB @ 5X
 _____ DB @ 2X
 _____ DB @ 1/2X
 _____ DB @ 1/4X

TIME (MILITARY)

1100
1130

INCHES/DIV.

2

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
NA DB DIAL

FREQUENCY 1.0 2.25 5.0
 OTHER

JACK T

REP RATE 1K

FILTER Hi

DAMPING MED

VIDEO NORMAL DIFFERENTIAL

REJECT OFF

SWEEP DELAY n/a COARSE
1.40 FINE

RANGE 10

MATERIAL CALIBRATION 8.57

SWEEP DIAL n/a

SWEEP RATIO n/a

CALIBRATION SHEET 10

1313 PSI Ref. No.
 RPV-12
 Page 20 of 25

ULTRASONIC INSPECTION REPORT

<input type="checkbox"/> INFORMATION	<input type="checkbox"/> ACCEPTABLE
REPORTABLE	<input type="checkbox"/> Satisfactory
Yes <input type="checkbox"/> No <input type="checkbox"/>	<input type="checkbox"/> Unsatisfactory

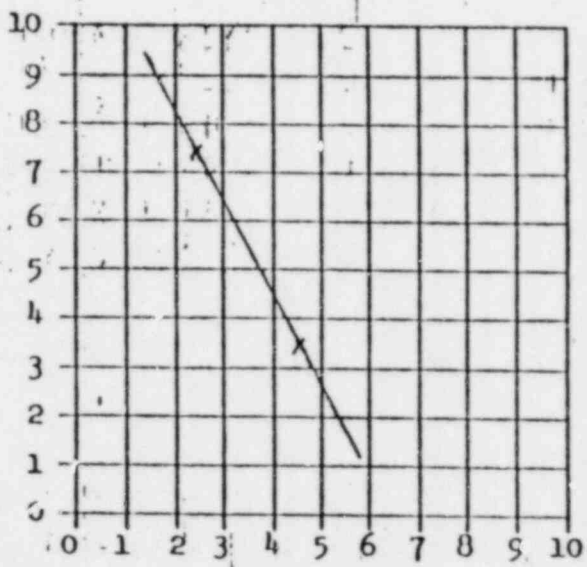
CONTRACT 2867 JOB & CONTROL NO.: V-70777-053 SEQ. 50 OPERATION 4228 DATE 11/21/76
 COMPONENT: Final Vessel Assy QTY 1 SEAM PART OR CODE NO.: 316-02-6
 TYPE SEAM: GIRTH LONG NOZZLE OTHER _____ REPAIR
 M&P SPECIFICATION 2.4.4.111(a) RECEIVING IN-PROCESS FINAL
 COMPLETE INCOMPLETE NDE EVALUATE _____ REJ. NO. _____ RECORD
 INSPECTOR(S) R. W. Wille II S. Walls II CUSTOMER _____

removed
 w/ Calibration with HSB
 4-8-81
SET-UP
 SENSITIVITY -1 DB FINE
+30 DB COARSE
N/A DB DIAL
 FREQUENCY 1.0 2.25 5.0
 OTHER
 JACK (R) T
 REP RATE 1K
 FILTER 4i
 DAMPING Med
 VIDEO (NORMAL)/DIFFERENTIAL
 REJECT (OFF)
 SWEEP DELAY n/a COARSE
1.40 FINE
 RANGE 10
 MATERIAL CALIBRATION 8.52
 SWEEP DIAL n/a
 SWEEP RATIO n/a
 CALIBRATION SHEET 11
 N-2.4.4.111(a)
 Figure D

TEST

DAC

BM 0° HAZ 45° 60° _____
 B.R. _____ % I.D. O.D.
 11W BLOCK ANGLE 45°
 CALIBRATION BLOCK NO. 2867-8"
 TRANSDUCER S/N 5-64 #7-CW Shoe
 CABLE S/N n/a
 EQUIPMENT S/N 740916
 C-E S/N 9445
 PULSER/RECEIVER S/N FIS/MKI
 COUPLANT: WATER GLYCERINE
 SILICONE GREASE



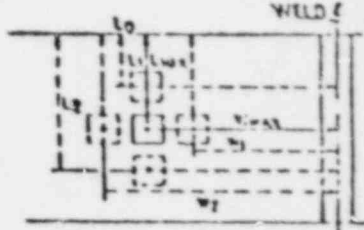
LINEARITY CHECKS
 _____ DB @ 10X
13 DB @ 5X
 _____ DB @ 2X
 _____ DB @ 1/2X
 _____ DB @ 1/4X
 TIME (MILITARY)
1030
1130
 INCHES/DIV.
2

TEST TEMPERATURE:
 AMBIENT ELEVATED _____ °F

1814 PSJ Ref. No. RPV-12 Page 22 of 25

WELD SCAN DATA SHEET

CONTRACT NO. 2867 SEAM, PIECE OR CODE NO. 316-026 I.D. O.D. DATE 1/21/76
 CALIBRATION SHEET NO. 11 SHEET NO. 11 OF 1 TIME 1:30
 SEAM LENGTH 360°
 TEST PARAMETER: START 0° END 360° INSPECTORS R. Willett & S. Welby II
 START _____ END _____ # 7 CW Shop



* (L) measured from: Top of No. 2 Flg. TYPE OF TEST HAZ 45° 60°

L1				L2				W1				W2				MP				MP				MP				DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW
10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max		

INFORMATION
REPORTABLE
Yes No

ACCEPTABLE
Satisfactory
Unsatisfactory

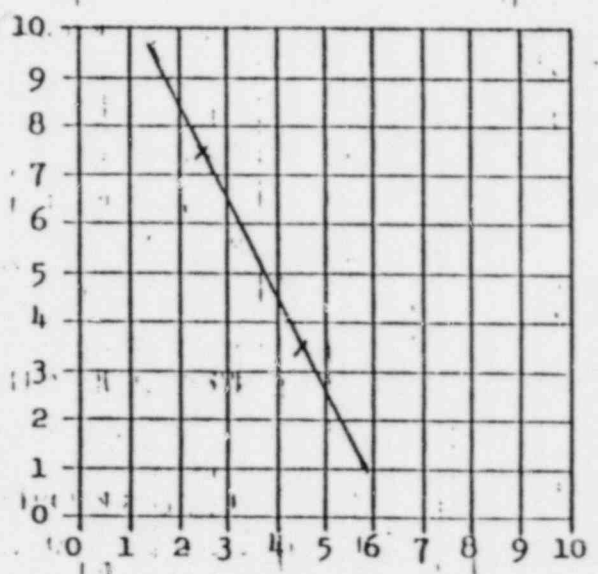
CONTRACT: 2867 JOB & CONTROL NO.: V-70777-053 SEQ. 50 OPERATION 4278 DATE 1/12/76
 COMPONENT: Final Vessel Assy QTY 1 SEAM PART OR CODE NO.: 316-02-6
 TYPE SEAM: GIRTH LONG NOZZLE OTHER _____ REPAIR
 M&P SPECIFICATION 2.4.4.11 (a) RECEIVING IN-PROCESS FINAL
 COMPLETE INCOMPLETE NDE EVALUATE _____ REJ. NO. _____ RECORD
 INSPECTOR(S) R. Wells II S. Wells II CUSTOMER _____

*Revised
w/ing Caldwell ARES-HSB
4-8-81*

TEST

DAC

BM 0° HAZ 45° 60° _____
 B.R. _____ % I.D. O.D.
 IIW BLOCK ANGLE 45°
 CALIBRATION BLOCK NO. 2867-8"
 TRANSDUCER S/N S-60 #800w shoe
 CABLE S/N n.a.
 EQUIPMENT S/N 740916
 C.E. S/N 9445
 PULSER/RECEIVER S/N ETS/n/a



LINEARITY CHECKS N _____
 DB @ 10X _____
13 DB @ 5X _____
 DB @ 2X _____
 DB @ 1/2X _____
 DB @ 1/4X _____

TIME (MILITARY) 1030
1130
 INCHES/DIV. 2

SET-UP

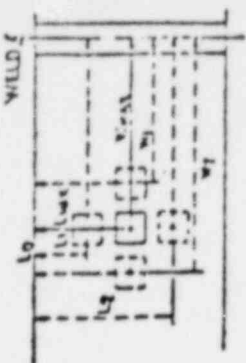
SENSITIVITY -1 DB FINE
+30 DB COARSE
n/a DB DIAL
 FREQUENCY 1.0 2.25 5.0
 OTHER
 JACK (B) T
 REF RATE 1K
 FILTER H1
 DAMPING Med
 VIDEO (NORMAL) DIFFERENTIAL
 REJECT (OFF)
 SWEEP DELAY n/a COARSE
1.40 FINE
 RANGE 10
 MATERIAL CALIBRATION 8.52
 SWEEP DIAL n/a
 SWEEP RATIO n/a
 CALIBRATION SHEET 12
 N-2.4.4.11(a)
 Figure D

COUPLANT: WATER GLYCERINE
 SILICONE GREASE
 TEST TEMPERATURE:
 AMBIENT ELEVATED _____ °F

1315 PSI Ref. No.

WELD SCAN DATA SHEET

CONTRACT NO. 2867 SEAM, PIECE OR CODE NO. 316-02-6 I.D. O.D. DATE 12/1/76
 CALIBRATION SHEET NO. 12 SHEET NO. 1 OF 1 TIME 1030
 SEAM LENGTH 360° END 360° INSPECTORS R. Wells II & S. Wells II
 TEST PARAMETER: START 0° END 360° #8 CCW Shot



(L) measured from: Top of No. 7 Rod

L1	L2	TYPE OF TEST			W2	MP			NIP	DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW		
		W1	W	MP		MP	MP	MP				MP	
10	20	50	100	Max	100	50	20	10	100	50	20	10	
20	50	100	Max		50	20	10	10	Max				
50	100	Max			20	10	10	100					
100	Max				10	10	100						
Max					50	20	50						
					20	10	20						
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					20	10	20						
					10	10	10						

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT I

E.D.S. NO. 10005F

A. Procedure No. PP-S751 REV. 5

Examination Personnel:

NAME Steven Trigo LEVEL II
 NAME N/A LEVEL N/A

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 78D056
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO Temp. _____
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO Temp. _____

b. SURFACE PREPARATION:

*1. Grinding *2. Flapping *3. None *4. Other _____

E. Date: Note: All Exam. Components are ASME Section XI Category _____

LINE NO. 00	DATE 01	PRE-CLEAN EVAP. TIME (MIN) 02	PEN. DWELL TIME (MIN) 03	PEN. REM. EVAP. TIME (MIN) 04	DEV. TIME (MIN) 05	EXAMINATION COMPONENT I.D. NO. 06	MAT'L 07	SURF. PREP. 08	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION LOCATION/SIZE OR COMMENTS 13
									YES 09	NO 10	YES 11	NO 12	
1	6-7-79	5	20	5	15	IRH 1011-41	CS	1,2	✓		✓		
2													
3													
4													
5													
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By: _____
 NDE SUPERVISOR S. Blamelly DATE 6/12/79
 QC SUPERVISOR Salehuddin DATE 6/13/79
 AUTHORIZED INSPECTOR w. J. Caldwell DATE 3-23-81

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT I

E.D.S. NO. 13001

Procedure No. PP-S751 REV. 5

Examination Personnel:

NAME E. J. ... LEVEL II
 NAME ... LEVEL N/A

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 78D056
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO Temp. _____
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO Temp. _____

b. SURFACE PREPARATION:

*1. Grinding *2. Flapping *3. None *4. Other _____

E. Data: Note: All Exam. Components are ASME Section XI Category B1

LINE NO.	DATE	PRE-CLEAN EVAP. TIME (MIN)	PEN. DWELL TIME (MIN)	PEN. REM. EVAP. TIME (MIN)	DEV. TIME (MIN)	EXAMINATION COMPONENT I.D. NO.	MAT'L	SURF. PREP.	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES	NO	YES	NO	
01	02	03	04	05	06	07	08	09	10	11	12	13	
1	6-15-79	5	10	5	15	I-MS-1053-1ALU	C/S	2		✓	✓		
2													
3													
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14													
15													

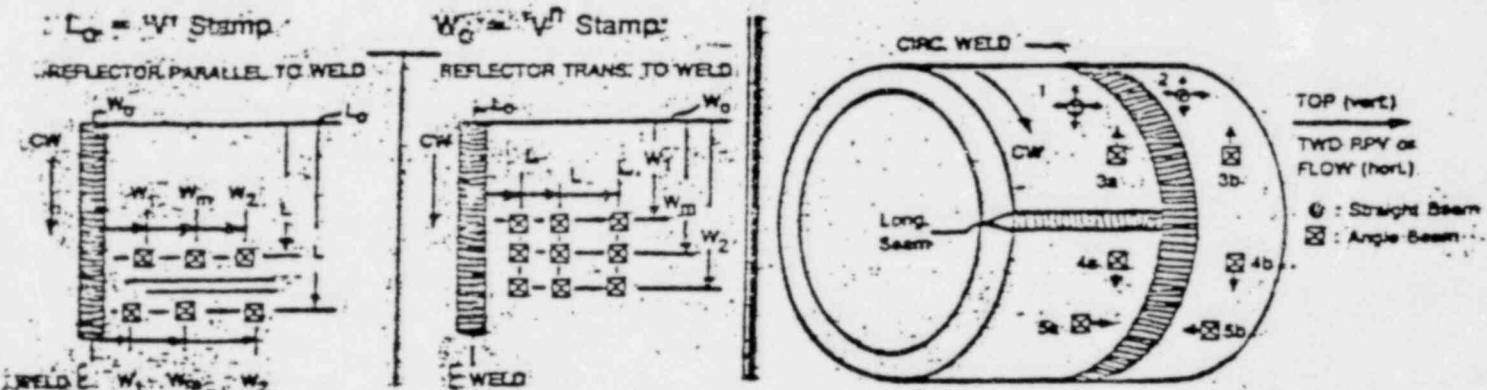
* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By:

NDE SUPERVISOR [Signature] DATE 6/18/79
 QC SUPERVISOR [Signature] DATE 6/18/79
 AUTHORIZED INSPECTOR [Signature] DATE 3-23-81

ULTRASONIC EXAMINATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

A. Procedure No. MPUP 5751 REV. 3
 B. Examination Personnel:
 NAME Walter Montross LEVEL II NAME Charles E. Mills LEVEL II
 C. Search Unit Beam Angle ($\pm 2^\circ$): 0° 45° 60° Other _____
 D. Couplant: Glycerine Ultragel II Other _____
 E. Scan Sensitivity: (+) 8 dB
 F. Reference System _____ G. Scan Orientation _____



H. Data:

00 DATE	01 LINE NO.	02 EXAM/COMP. I.D. NO.	03 COMP. FIG.	04 REC. IND. YES/NO	05 MAX. DAC @ Wm	06 L0 / W0	07 L	08 W1	09 Wm	10 W2	11 SRP1 or MP1	12 SRPm or MPm	13 SRP2 or MP2	14 SCAN	15 Comments (Thickness Meas.)
1979															
4/3	1	IRR1007-3ALU	LS	YES	100%	2.5	6		2.5			48	4A	Q.D. FINGER DAMP LENGTH OF LONG SEAM INTERMITTENT	
4/3	2	IRR1007-3ALU	LS	YES	80%	5.5			1.6			22	4A	LENGTH OF LONG SEAM: INTERMITTENT	
4/3	3	IRR1007-3ALU	LS	YES	100%	6.5			4.4			76	4A	LENGTH OF LONG SEAM: INTERMITTENT	
4/3	4	IRR1007-3ALU	LS	YES	70%	8.0			1.0			18	4A	LENGTH OF LONG SEAM INTERMITTENT	
4/3	5	IRR1007-3ALU	LS	YES	66%	6.0			2.0			26	3A	LENGTH OF LONG SEAM INTERMITTENT	
4/3	6	IRR1007-3ALU	LS	YES	100%	4.5			3.2			58	3A	Q.D. FINGER DAMP LENGTH OF LONG SEAM INTERMITTENT	
4/3	7	IRR1007-3ALU	LS	YES	100% +2	5.0			3.8			74	3A	LENGTH OF LONG SEAM INTERMITTENT	
	8	* L0	IS MEASURED												FROM E OF WELD IRR1007-3
	9														

I. Reviewed By: SA Connelly DATE 4/4/79
 NDE SUPERVISOR _____
 QC SUPERVISOR: Salahuddin DATE 7/12/79
W J Caldwell DATE 3-26-81

LIQUID PENETRANT EXAMINATION DATA SHEET
LASALLE COUNTY STATION UNIT

E.D.S. NO. 62028

A. Procedure No. PP-5751 REV. 5

Examination Personnel:

NAME David W. Fryer LEVEL II
 NAME Gordon Craig LEVEL I

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 78D056
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:
 1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO Temp. _____
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO Temp. _____
 b. SURFACE PREPARATION:
 *1. Grinding *2. Flapping *3. None *4. Other _____

E. Data: Note: All Exam. Components are ASME Section XI C-F Category

E NO.	DATE	PRE-CLEAN EVAP. TIME (MIN)	PEN. DWELL TIME (MIN)	PEN. REM. EVAP. TIME (MIN)	DEV. TIME (MIN)	EXAMINATION COMPONENT I.D. NO.	MAT'L	SURF. PREP.	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES	NO	YES	NO	
00	01	02	03	04	05	06	07	08	09	10	11	12	13
1	5-17	Spin	90min	Spin	15min	IRH 1077 718	CS	8	✓			✓	
2	NOTE Linear indications 4" CW of STAMP 1-10" FROM												
3	WELD CENTERLINE - UPSTREAM.												
4	NOTE - AREA ABOVE WILL NEED A POSITIVE METAL THICKNESS CHECK												
5													
6	REF. EDS 65049												
7													
8													
9													
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO. place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By: [Signature]
 NDE SUPERVISOR [Signature] DATE 5-18-79
 QC SUPERVISOR [Signature] DATE 5/21/79
 AUTHORIZED INSPECTOR [Signature] DATE 3-26-81

LIQUID PENETRANT EXAMINATION DATA SHEET
LASALLE COUNTY STATION UNIT

E.D.S. NO. 62034

A. Procedure No. PP-S751 REV. 5

Examination Personnel:

NAME David W. F. [unclear] LEVEL II
 NAME NA LEVEL NA

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 78D056
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:
 1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO Temp. _____
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO Temp. _____
 b. SURFACE PREPARATION:
 *1. Grinding *2. Flapping *3. None *4. Other _____

E. Date: Note: All Exam. Components are ASME Section XI C-1 Category

LINE NO.	DATE	PRE-CLEAN EVAP. TIME (MIN)	PEN. DWELL TIME (MIN)	PEN. REM. EVAP. TIME (MIN)	DEV. TIME (MIN)	EXAMINATION COMPONENT I.D. NO.	MAT'L	SURF. PREP.	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES	NO	YES	NO	
00	01	02	03	04	05	06	07	08	09	10	11	12	13
1	6-1	5min	15min	5min	15min	IRH1007 #28	CS	2		✓	✓		*
2	NOTE - T.D. CONDITIONS NOTED - ON EDGET 90 LB WERE												
3	REMOVED BY FLAPPING, WELD REPAIR AREA ONLY												
4	+ 1" EACH SIDE WAS DETECTED BY PT AND D												
5	FOUND ACCEPTABLE												
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO. place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By: R. Hooper DATE 6-1-79
 NDE SUPERVISOR _____ DATE 6-6-79
 QC SUPERVISOR Salahuddin DATE 3-26-81
 AUTHORIZED INSPECTOR w J Caldwell

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT

E.D.S. NO. 62035

A. Procedure No. PP-S751 REV. 3

Examination Personnel:

NAME Robert E. Hooper LEVEL FD
 NAME NA LEVEL NA

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 78D056
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:
 1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO Temp. _____
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO Temp. _____

b. SURFACE PREPARATION:

*1. Grinding *2. Flapping *3. None *4. Other _____

E. Data: Note: All Exam. Components are ASME Section XI C-F Category

LINE NO. 00	DATE 01	PRE-CLEAN EVAP. TIME (MIN) 02	PEN. DWELL TIME (MIN) 03	PEN. REM. EVAP. TIME (MIN) 04	DEV. TIME (MIN) 05	EXAMINATION COMPONENT I.D. NO. 06	MAT'L 07	SURF. PREP. 08	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION LOCATION/SIZE OR COMMENTS 13
									YES 09	NO 10	YES 11	NO 12	
1	K-1	5min	5min	5min	5min	TRM1007 #41 CS	g		✓	✓			✓
2													
3													
4													
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* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By: Robert E. Hooper
 NDE SUPERVISOR _____ DATE 6-1-79
 QC SUPERVISOR Selchmaldimane DATE 6-6-79
 AUTHORIZED INSPECTOR w J Cottrell DATE 3-26-81

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT

E.D.S. NO. 69036

A. Procedure No. PP-S751 REV. 5

Examination Personnel:

NAME L. [unclear] LEVEL II
 NAME [unclear] LEVEL NA

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 78D056
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:
 1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO Temp. _____
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO Temp. _____

b. SURFACE PREPARATION:
 *1. Grinding *2. Flapping *3. None *4. Other _____

E. Date: Note: All Exam. Components are ASME Section XI C-F Category.

LINE NO.	DATE	PRE-CLEAN EVAP. TIME (MIN)	PEN. DWELL TIME (MIN)	PEN. REM. EVAP. TIME (MIN)	DEV. TIME (MIN)	EXAMINATION COMPONENT I.D. NO.	MATL	SURF. PREP.	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES	NO	YES	NO	
00	01	02	03	04	05	06	07	08	09	10	11	12	13
1	6-1	5min	5min	15min		TRH1007 #46	CS	2					*
2	*AFTER INSPECTION NOTED ON EDS # 90127 WERE												
3	*REMOVED BY FLAPPING LEAD REPAIR ONLY												
4	*1" EACH SIDE WAS RETESTED BY MT												
5	FOUND ACCEPTABLE												
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By: RS. Hooper DATE 6-1-79
 NDE SUPERVISOR _____ DATE _____
 QC SUPERVISOR Salahuddin DATE 6-6-79
 AUTHORIZED INSPECTOR wj Caldwell DATE 3-26-81

LIQUID PENETRANT EXAMINATION DATA SHEET
LASALLE COUNTY STATION UNIT

E.D.S. NO. 65066

A. Procedure No. PP-S751 REV. 5

Examination Personnel:
 NAME David Styles LEVEL II
 NAME N/A LEVEL N/A

C. Penetrant Materials:
 a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 78D056
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:
 a. TEMPERATURE:
 1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO Temp. _____
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO Temp. _____
 b. SURFACE PREPARATION:
 *1. Grinding *2. Flapping *3. None *4. Other _____

E. Date: Note: All Exam. Components are ASME Section XI Category CF

EXAM NO.	DATE	PRE-CLEAN EVAP. TIME (MIN)	PEN. DWELL TIME (MIN)	PEN. REM. EVAP. TIME (MIN)	DEV. TIME (MIN)	EXAMINATION COMPONENT I.D. NO.	MAT'L	SURF. PREP.	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION, LOCATION/SIZE OR COMMENTS
									YES	NO	YES	NO	
01	02	03	04	05	06	07	08	09	10	11	12	13	
1	5-18-79	8	20	8	25	IRH-1077-1B	CS	2		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		SEE NOTE 1
2													
3													
4													
5													
6	NOTE 1: See "T" EDS 94098 for thickness measurement.											SKB 7/23/80	
7													
8													
9													
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By: _____
 NDE SUPERVISOR _____ DATE 5-20-79
 QC SUPERVISOR Selamuddin DATE 6-6-79
 AUTHORIZED INSPECTOR wj Caldwell DATE 3-26-81

EDS# 70014

CDS# 70016

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT

A. PROCEDURE NO. MPUP-5751 REV. 0

B. EXAMINATION PERSONNEL:
NAME B. DUMMCA LEVEL II; NAME G. Fry LEVEL I

C. SEARCH UNIT BEAM ANGLE: 0°; 15°; 60°; OTHER 47°

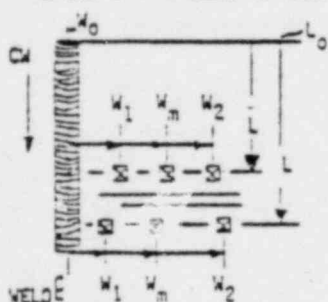
D. COUPLANT: GLYCERINE; ULTRAGEL II; OTHER N/A

E. SCAN SENSITIVITY: (+) 8 dB

F. REFERENCE SYSTEM

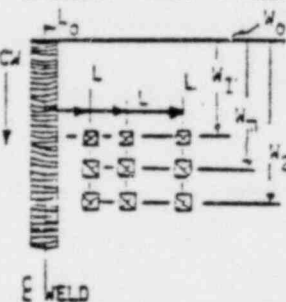
L_0 = 'V' STAMP

REFLECTOR PARALLEL TO WELD

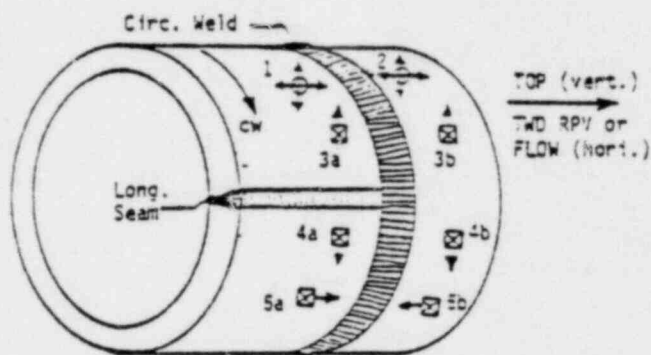


W_0 = 'V' STAMP

REFLECTOR TRANS. TO WELD



G. SCAN ORIENTATION



H. DATA

DATE	LINE NO.	EXAM/COMP. I.D. NO.	COMP. FIG.	REC. IND. YES/NO	MAX % DAC	L_0	L	W_1 (50% DAC)	W_m	W_2 (50% DAC)	SRP ₁ (50% DAC)	SRP ₂	SRP ₂ (50% DAC)	SCAN	Comments (Thickness Meas.)
8/25/78	1	I-MS-1051 15	P	✓	YES	80%	V	0	1.4			30		5b	INTERMITTENT 360°
8/25	2	I-MS-1051 15	P	✓	YES	60%	V	39.7	1.7			41		5b	LINES 2, 3, 4
8/25	3	I-MS-1051 15	P	✓	YES	50%	V	39.6	1.7			41		5b	SAME INDICATION
8/25	4	I-MS-1051 15	P	✓	YES	50%	V	39.8	1.7			41		5b	LENGTH 0.2"
	5														SCAN PIPE SIDE ONLY DUE TO GEOMETRY ON VALUE
	6														
	7														
	8														
	9														

I. REVIEWED BY: NDE SUPERVISOR John Fisher DATE 9-26-78
QC SUPERVISOR Mike Hart DATE 9-26-78
AUTHORIZED INSPECTOR W J Caldwell DATE 3-26-81

A. PROCEDURE NO. PP-5751 REV. 6

B. EXAMINATION PERSONNEL:

NAME Ed Homler LEVEL II
 NAME William J. Keane LEVEL IT

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 79E033
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO

b. SURFACE PREPARATION:

*1. GRINDING *2. FLAPPING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

06 LINE	01 DATE	02 PRE-CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. *	RELEVANT INDICATION		ACCEPTABLE		13 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES 09	NO 10	YES 11	NO 12	
1	11-23-79	5	10	5	15	1-RH-1040-9	CS	2	X			X	LINEAR INDICATION, 3 9/16"
2													FROM V STAMP
3													(CW), LOCATED
4	NOTE 1: See "T" EDS 77036 for thickness measurement.												IN SURFACE ONE
5													.300 IN LENGTH
6							GRUB	7/23/80					1.3" FROM E OF
7													1-RH-1040-9.
8													GRINDER HAS GAGE
9													APRX. .075" IN
10													DEPTH. No Channel
11													Depth OR DIRECTION.
12													IND. IS PARALLEL
13													TO CIRCLE SEAM.
14													(SEE NOTE 1)
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(S) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR S. Homler DATE 11/28/79
 QC SUPERVISOR Salabuddin DATE _____
 AUTHORIZED INSPECTOR W.J. Caldwell DATE 3-26-81

A. PROCEDURE NO. PP-S751 REV. 6

B. EXAMINATION PERSONNEL:

NAME CA Homler LEVEL II
 NAME Edward Hale LEVEL IT

C. PENETRANT MATERIALS:

- a. MANUFACTURER MAGNAFLUX-SPOTCHECK
- b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
- c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073
- d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
- e. DEVELOPER TYPE SKD-S BATCH NO. 79E033
- f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

- 1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO
- 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO

b. SURFACE PREPARATION:

- *1. GRINDING *2. FLAPPING *3. NONE *4. OTHER _____

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

00 LINE NO.	01 DATE	02 PRE-CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. #	09 RELEVANT INDICATION		10 ACCEPTABLE		11 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES 09	NO 10	YES 11	NO 12	
1	11-19-79	5	10	5	15	1-RH-1041 13	CS	2	X			X	24" FROM 'V' STAMP. CLUSTER POROSITY CONNECTED BY LINEAR INDICATION DIRECTLY IN CENTER OF WELD. (GROUND) JUST BELOW BASE METAL LONGEST LINEAR INDICATION IS 1/2"
2													
3													
4													
5													
6													See Note 1
7													
8	Note 1: See "T" EDS 76001 for thickness measurement.												JMB 7/23/80
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(S) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR A. Donnelly DATE 11/28/79
 OC SUPERVISOR L. J. Whitley DATE 11/28/79
 AUTHORIZED INSPECTOR w. j. Caldwell DATE 3-28-81

LASALLE UNIT I

$T_p =$ 0.52

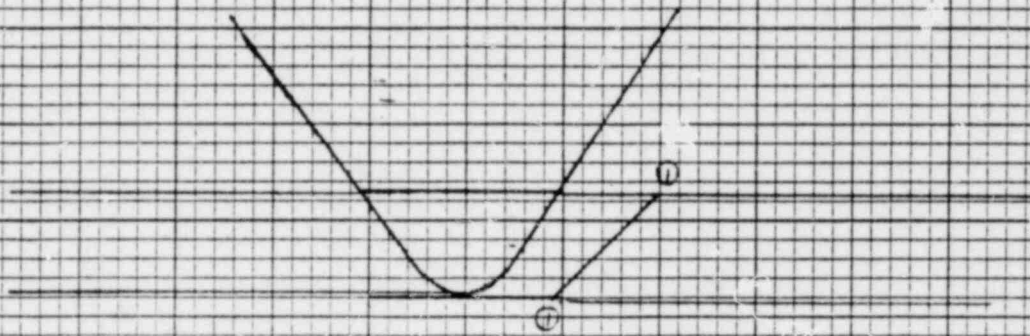
WELD IRH-1048-20

$T_w =$ 0.58

EDS 77497

$T_e =$ 0.55

GENERAL  ELECTRIC



LINE	EVALUATION
1	ID geometry from counterbore
2	OD geometry from face toe of weld
3-8	Made conversion
9	ID geometry from weld root
10	OD geometry & subsequent made conversion

EVALUATED BY L. D. Whately
Level III

DATE 9/8/60

REVIEWED BY n. J. Colwell
ANII

DATE 9.9.60

INSTALLATION & SERVICE ENGINEERING DIVISION

LASALLE COUNTY NUCLEAR STATION UNIT 1

A. PROCEDURE NO. PP-S751 REV. 7

B. EXAMINATION PERSONNEL:

NAME CA Hamler LEVEL II
 NAME NA LEVEL NA

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 79B109
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 79E033
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO

b. SURFACE PREPARATION:

*1. GRINDING *2. FLAPPING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

LINE NO.	DATE	PRE-CLEAN EVAP. TIME	PEN. DWELL TIME	PEN. REM. EVAP. TIME	DEV. TIME	EXAMINATION COMPONENT I.D. NO.	MAT'L	SURF. PREP. #	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES 09	NO 10	YES 11	NO 12	
1	2-27	5	15	5	15	1R1-1015-1	CS	2		X	X		
2	2-27	5	15	5	15	1R1-1015-1B	CS	2		X	X		
3	2-27	5	15	5	15	1R1-1015-1A	CS	2		X	X		
4	2-27	5	15	5	15	1R1-1015-2	CS	2		X	X		
5	2-27	5	15	5	15	1R1-1014-4	CS	2		X	X		
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(S) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR SD Connelly DATE 3/2/81
 QC SUPERVISOR L D White DATE 3/4/81
 AUTHORIZED INSPECTOR W J Caldwell DATE 3-13-81

INSTALLATION & SERVICE ENGINEERING DIVISION

A. Procedure No. MPUP-5751 REV. 6

Examination Personnel: NAME Robert LEVEL I NAME Al Connolly LEVEL I

Instrument: SERIAL NO. 1348 MAKE/MODEL: - BRANSON/303: SONIC/MK I; KK/USL32; OTHER

D. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
 TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
 SERIAL NO.: A22016; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
 TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT; CERAMIC DUAL ELEMENT; OTHER
 WEDGE TYPE: STANDARD WEDGE; SPECIAL WEDGE/TYPE
 CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 = \underline{0^\circ}$

E. Cable: LENGTH: 6 FT. TYPE: RG-58; RG-59; RG-57; RG-174; OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL; TRANSVERSE TO PIPE AXIS
 FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE PARALLEL; TRANSVERSE to hole centerline

G. Calibration Standard: LSCS CAL STD. NO. 01-10-01 THICKNESS .75" DIAMETER 10"
 MATERIAL: CARBON; STAINLESS; INCONEL; OTHER

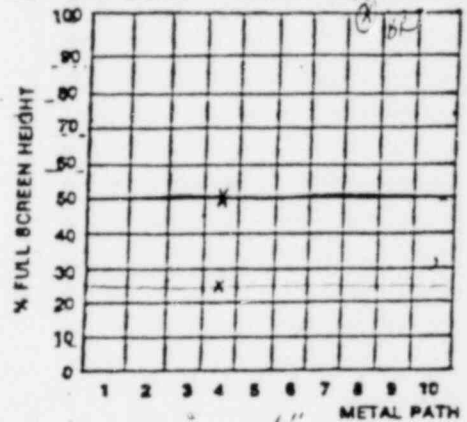
H. Couplant: GLYCERINE; ULTRAGEL II; OTHER

L. Comments: +4 dB = BR To 100% FSH

J. Dac Curve — Data

CONTOR	PEAK AMP	W1	Wm	W2	MP1	MPm	MP2	HOLE DEPTH
01	02	03	04	05	06	07	08	09
WT of /8 Vee								
WT of /8 Vee	50%				.35			.35
WT of /8 Vee								
EP of /8 Vee	100%				.75			

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS	SET	CHECK BOXES							
		02	03	04	05	06	07	08	09
GAIN	34 dB	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>						
SCAN GAIN	42 dB	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>						
SWEEP	5/675	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>						
DELAY	749	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>						
FILTER	Auto	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>						
REP RATE	MED	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>						
DAMPENING	OFF	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>						
RE...	OFF	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>						
OTHER	NA	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>						

M. Calibration Time — Records

DATE	01 ORIG. CAL. TIME	02 CAL. CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
1981					
2-27	1135	NA	NA	NA	YES
2-27	NA	1240	NA	NA	YES
2-27	NA	1525	77599	7	YES

N. Reviewed By: NDE SUPERVISOR Al Connolly DATE 3/2/81
 Q.C. SUPERVISOR [Signature] DATE 3/13/81
 AUTHORIZED INSPECTOR [Signature] DATE 3-13-81

EDS # 77599

CDS # 77598

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

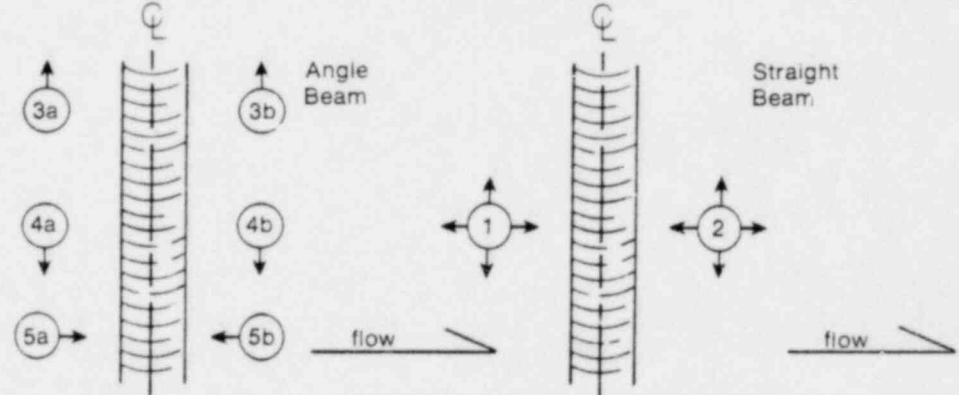
EXAMINATION PERSONNEL:
 NAME LA Homer LEVEL II; NAME JD Connelly LEVEL IT

SEARCH UNIT BEAM ANGLE: 0°: X 45°: _____ 60°: _____ OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/W1	Lm/Wm	L2/W2	MP1	MPm	MP2	SCAN	STAT.	COMMENTS
2-27	1	1R11014 4	PE		P	CL	E					A	
2-27	2	1R11014 4	PE		EXCAVATION		.64					A	PT INDICATION REMOVAL EXCAVATION LOCATED 2° CCW FROM V' IN SURFACE 2 WELD TOE.
2-27	3	1R11014 7	EP		E	CL	P					A	
2-27	4	1R11015 1A	EP		E	CL	P					A	
2-27	5	1R11015 1B	EE		E	CL	E					A	
2-27	6	1R11015 1	TE		T	CL	E					A	NO SCAN (I) 4" EA. SIDE OF TDC DUE TO TEE CONFIGURATION.
2-27	7	1R11015 2	TP		T	CL	P					A	NO SCAN (I) 4" EA. SIDE OF TDC DUE TO TEE CONFIGURATION.

REVIEWED BY: JD Connelly DATE 3/2/81
 NDE SUPERVISOR _____
 QC SUPERVISOR RJD Wheatley DATE 3/13/81
 AUTHORIZED INSPECTOR wj Cahill DATE 3-13-81

A. PROCEDURE NO. PP-5751 REV. 7

EXAMINATION PERSONNEL:

NAME CA Bomler LEVEL II
 NAME NA LEVEL NA

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 79B109
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 79E033
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:
 1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO
 b. SURFACE PREPARATION:
 *1. GRINDING *2. FLAPPING *3. NONE *4. OTHER _____

E. DATA: NOTE: All Exam components are ASME Sect. XI _____ Category. CF

00 LINE NO.	01 DATE	02 PRE- CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. #	09 RELEVANT INDICATION		10 ACCEPTABLE		11 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES	NO	YES	NO	
1	3-5 1981	5	15	5	15	1MS-1044-46	CS	2	X		X		16.5" CCW FROM V 1/8" RD. IND. WELD CL
2													
3													
4													
5													
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(S) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

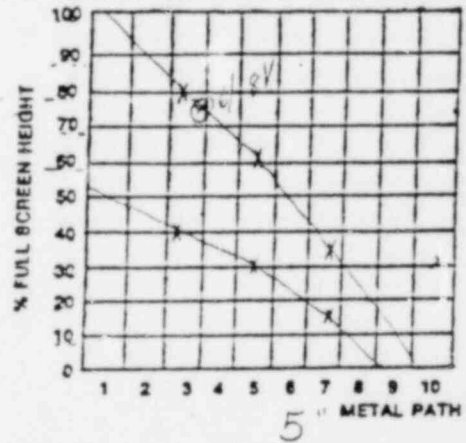
REVIEWED BY: NDE SUPERVISOR AD Connelly DATE 3/6/81
 QC SUPERVISOR LD Weather DATE 3/13/81
 AUTHORIZED INSPECTOR w g Caldwell DATE 3-13-81

- A. Procedure No. MPUP-5751 REV. 6
- B. Examination Personnel: NAME C. J. Connelly LEVEL II NAME J. E. Williams LEVEL IT
- C. Instrument: SERIAL NO. 521 MAKE/MODEL: - BRANSON/303: SONIC/MK I; KK/USL32; OTHER _____
- D. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
 TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
 SERIAL NO.: L07944; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
 TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT; CERAMIC DUAL ELEMENT; OTHER _____
 WEDGE TYPE: STANDARD WEDGE; SPECIAL WEDGE/TYPE _____
 CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 = \underline{44.5^\circ}$
- E. Cable: LENGTH: 6 FT. TYPE: RG-58; RG-59; RG-57; RG-174; OTHER _____
- F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL; TRANSVERSE TO PIPE AXIS
 FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE: PARALLEL; TRANSVERSE to hole centerline
- G. Calibration Standard: LSCS CAL STD. NO. 01-10-01 THICKNESS .75 DIAMETER 10"
 MATERIAL: CARBON; STAINLESS; INCONEL; OTHER _____
- H. Couplant: GLYCERINE; ULTRAGEL II; OTHER _____
- I. Comments: +10 dB = 6/8 V To 100% DAC

J. Dac Curve — Data

REFLECTOR	PEAK AMP	W1	Wm	W2	MP1	MPm	MP2	HOLE DEPTH
01	01	02	03	04	02	06	07	08
W-T or 4/8 Vee	80		.76			1.1		
W-T or 2/8 Vee	62		1.53			2.2		
W-T or 12/8 Vee	35		2.28			3.3		
B-R or 7/8 Vee	100 10		1.01			1.4		.36

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS	SET	CHECK BOXES							
		02	03	04	05	06	07	08	09
GAIN	52 dB	✓							
SCAN GAIN	60 dB	✓							
SWEEP	2.5/078	✓							
DELAY	753	✓							
FILTER	AUTO	✓							
REP RATE	Med	✓							
DAMPENING	OFF	✓							
TEST	OFF	✓							
OTHER	NA	✓							

M. Calibration Time — Records

DATE	01 ORIG. CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
1981					
3-5	0830	NA	NA	NA	Yes
3-5	NA	1135	77602	8	Yes
3-5	NA	1135	77602	9	Yes
3-5	NA	1135	77603	8	Yes

N. Reviewed By: NDE SUPERVISOR J. J. Connelly DATE 3/6/81
 Q.C. SUPERVISOR J. E. Williams DATE 3/16/81
 AUTHORIZED INSPECTOR C. J. Connelly DATE 3-18-81

EDS# 77602

CDS# 77601

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

EXAMINATION PERSONNEL:
 NAME Calomela LEVEL II; NAME M E Williams LEVEL IT

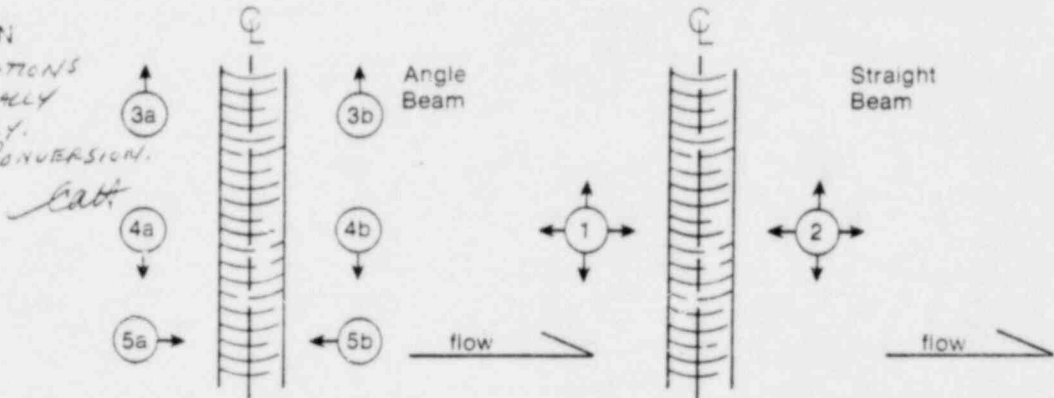
SEARCH UNIT BEAM ANGLE: 0°; 45°; X 60°; OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION

* STARRED INDICATIONS
 APPEAR INDIVIDUALLY
 & SIMULTANEOUSLY.
 POSSIBLE MODE CONVERSION.



DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/ W1	Lm/ Wm	L2/ W2	MP1	MPm	MP2	SCAN	STAT.	COMMENTS
3-5	1	1A1 1015 2	TP		No SCAN SA-4'E 4. SIDE OF TDC DUE TO Tee Configuration.								
3-5	2	2	TP	75	360	1.15			3.05		5B	E	FDFS
3-5	3	2	TP	100	360	.9			2.2		5A	A	FDFS *
3-5	4	2	TP	50	360	.9			2.3		5A	E	FDFS *
3-5	5	2	TP	60	360	.9			2.5		5A	E	FDFS *
3-5	6	2	TP	75	360	.9			2.7		5A	E	FDFS *
3-5	7	2	TP	100 -2	360	.38			1.1		5A	E	
3-5	8	1A1 1015 2	TP	50	360	.38			1.5		5A	E	FDFS *

REVIEWED BY: NDE SUPERVISOR AJ Connelly DATE 3/6/81
 QC SUPERVISOR L J Wheatle DATE 3/16/81
 AUTHORIZED INSPECTOR w j Calmell DATE 3-18-81

EDS # 77602
 CDS # 77601

EXHIBIT 3
ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

EXAMINATION PERSONNEL:
 NAME EA Rosen LEVEL II; NAME ME Williams LEVEL IT

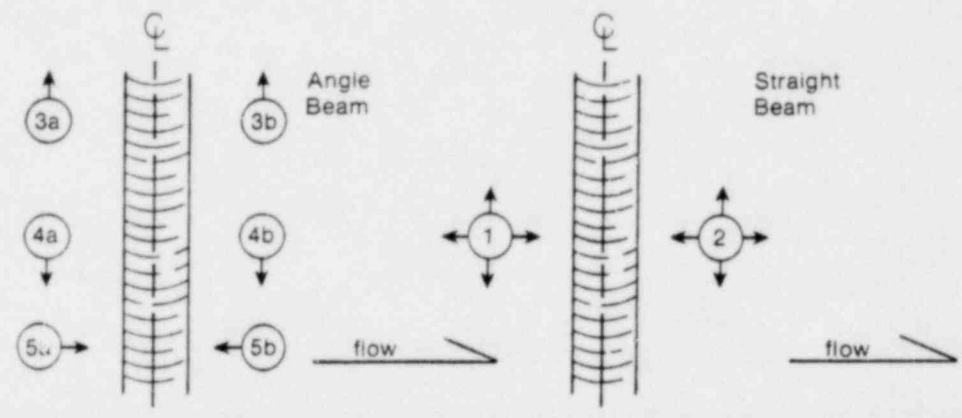
SEARCH UNIT BEAM ANGLE: 0°; 45° X 60°; OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION

★ See Note
 Page 1
 cat



DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/W1	Lm/Wm	L2/W2	MP1	MPm	MP2	SCAN	STAT.	COMMENTS
1981	9	IRI-1015 2	TP	50		360/NT -38			2.0		5A	E	* FDFS

REVIEWED BY: SD Connelly DATE 3/6/81
 NDE SUPERVISOR _____ DATE 3/16/81
 QC SUPERVISOR LD Wheatley DATE 3-18-81
 AUTHORIZED INSPECTOR W J Caldwell DATE _____

LASALLE UNIT 1

$T_r =$.98

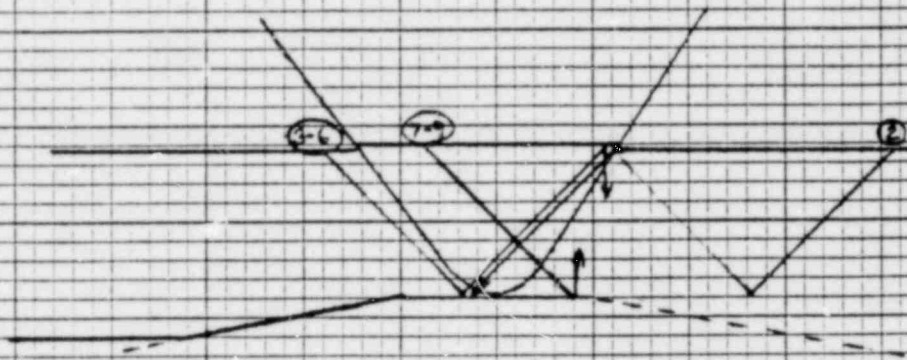
WELD IRI-1015-2

$T_w =$.79

EDS 77602

$T_p =$.67

GENERAL  ELECTRIC



LINE	EVALUATION
2	ID geometry from weld root
3-6	OD geometry from weld cap & subsequent mode conversion
7-9	ID geometry from weld root & subsequent mode conversion

EVALUATED BY L D Wheatley
Level III

DATE 3/16/81

REVIEWED BY w J Caldwell
ANII

DATE 3-18-81

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

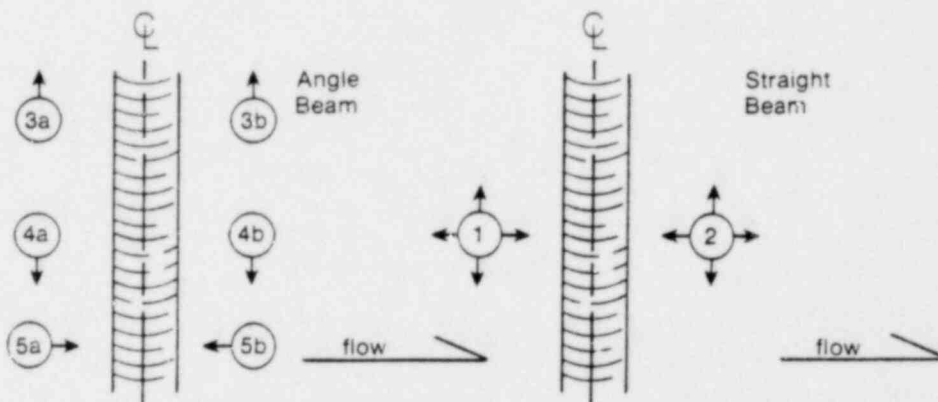
EXAMINATION PERSONNEL:
 NAME CA Hamler LEVEL II; NAME ME Williams LEVEL IT

SEARCH UNIT BEAM ANGLE: 0°: _____ 45°: X 60°: _____ OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/W1	Lm/Wm	L2/W2	MP1	MPm	MP2	SCAN	STAT.	COMMENTS
1981		IR1 1015											
3-5	1	1	TP		NO SCAN SA-4" EA. SIDE OF TDC DUE TO TEE CONFIGURATION.								
3-5	2	1	TP	75	360 INT	1.6			1.1		5B	E	
3-5	3	1	TP	100 +2	360 INT	1.8			2.0		5B	A	* Fdns
3-5	4	1	TP	90	360 INT	1.8			3.6		5B	E	* Fdns
3-5	5	1	TP	100	360 INT	1.15			2.6		5A	A	* Fdfs
3-5	6	1	TP	75	360 INT	1.15			2.9		5A	E	* Fdfs
3-5	7	1	TP	75	360 INT	1.15			3.3		5A	E	* Fdfs
3-5	8	IR1 1015 1	TP		* STAPPED INDICATIONS APPEAR SIMULTANEOUSLY POSSIBLE MODE CONVERSION.								

REVIEWED BY: NDE SUPERVISOR AD Connelly DATE 3/6/81

QC SUPERVISOR LW Wheatley DATE 3/16/81

AUTHORIZED INSPECTOR wj Calvert DATE 3-18-81

LASALLE UNIT 2

$T_T =$.92

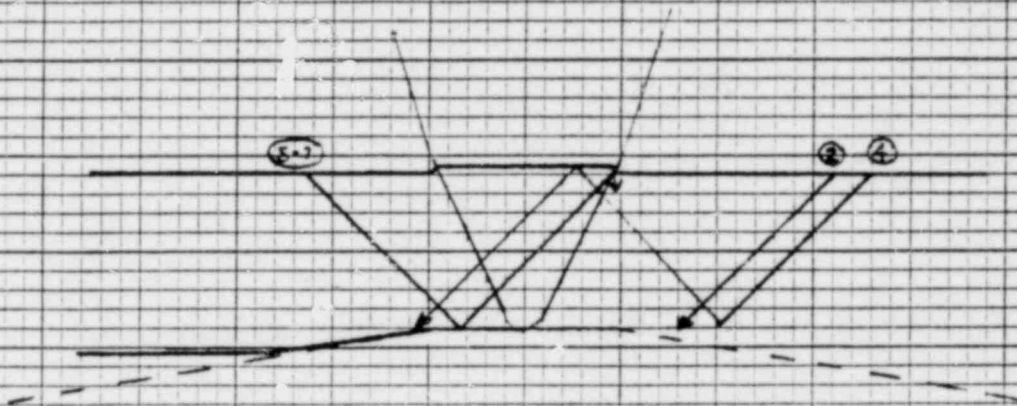
WELD IRI-1015-1

$T_W =$.83

EDS 77603

$T_E =$.75

GENERAL  ELECTRIC



LINE	EVALUATION
2,4	ID geometry from counter bore
5-7	OD geometry from weld cap & subsequent mode conversion

EVALUATED BY L.D. Wheatley DATE 3/16/81
 Level III

REVIEWED BY W.J. Caldwell DATE 3-18-81
 ANII

A. PROCEDURE NO. PP-S751 REV. 7

B. EXAMINATION PERSONNEL:

NAME [Signature] LEVEL II
 NAME NA LEVEL NA

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 79B109
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 79E033
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO

b. SURFACE PREPARATION:

*1. GRINDING *2. FLAPPERING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

00 LINE NO.	01 DATE	02 PRE- CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. *	09 RELEVANT INDICATION		10 ACCEPTABLE		11 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES 09	NO 10	YES 11	NO 12	
1	3-6	5	15	5	15	IMS1044-31	CS	2	X		X		1/8" RDIND - 0" FROM V-weld CL
2	3-6	5	15	5	15	IMS1044-16	CS	2	X		X		3/32" RDIND - 14" CCW FROM V. SURF 2 TUE
3	3-6	5	15	5	15	IMS1044-1	CS	2		X	X		
4													
5													
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(S) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

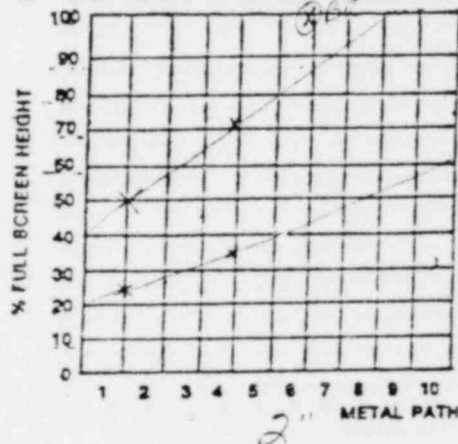
REVIEWED BY: NDE SUPERVISOR [Signature] DATE 3/9/81
 QC SUPERVISOR [Signature] DATE 3/12/81
 AUTHORIZED INSPECTOR [Signature] DATE 3-13-81

- A. Procedure No. MPUP-5751 REV. 6
- B. Examination Personnel: NAME J. Connelly LEVEL I NAME J. Connelly LEVEL IT
- C. Instrument: SERIAL NO. 521 MAKE/MODEL: - BRANSON/303: SONIC/MK I; KK/USL32; OTHER
- D. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
 TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
 SERIAL NO.: K25806; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
 TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT; CERAMIC DUAL ELEMENT; OTHER
 WEDGE TYPE: STANDARD WEDGE; SPECIAL WEDGE/TYPE
 CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 =$ 0°
- E. Cable: LENGTH: 6 FT. TYPE: RG-58; RG-59; RG-57; RG-174; OTHER
- F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL; TRANSVERSE TO PIPE AXIS
 FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE PARALLEL; TRANSVERSE to hole centerline
- G. Calibration Standard: LSCS CAL STD. NO. 01-26-02 THICKNESS 1.06 DIAMETER 26"
 MATERIAL: CARBON; STAINLESS; INCONEL; OTHER
- H. Couplant: GLYCERINE; ULTRAGEL II; OTHER
- L. Comments: +6 dB = BR to 100% FSH

J. Dec Curve - Data

UTDR OR	PEAK AMP dB	W1 dB	Wm dB	W2 dB	MP1 dB	MPm dB	MP2 dB	HOLE DEPTH dB
W T or /B Year	50					.20		.20
W T or /B Year								
W T or /B Year	72					.78		.78
B R. or /B Year	+6					1.06		

K. Dec Curve - Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES							
		02	03	04	05	06	07	08	09
GAIN	44 dB	✓							
SCAN GAIN	52 dB	✓							
SWEEP	5/142	✓							
DELAY	758	✓							
FILTER	402	✓							
REP RATE	Mod	✓							
DAMPENING	off	✓							
TEST	off	✓							
OTHER	na	✓							

M. Calibration Time - Records

DATE	01 ORIG CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
1781					
3-6	1255	na	na	na	yes
3-6	NA	1535	77605	6	yes
3-6	NA	1535	77606	8	yes

N. Reviewed By: NDE SUPERVISOR J. Connelly
 O.C. SUPERVISOR J. Connelly
 AUTHORIZED INSPECTOR W. J. Connelly

DATE 3/9/81
 DATE 3/16/81
 DATE 3-18-81

EDS # 77605

CDS # 77604

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPJP 5751 REV. 6

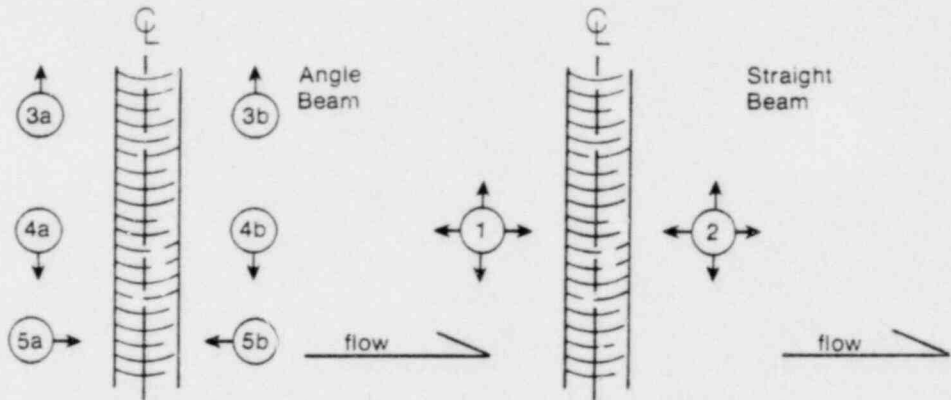
EXAMINATION PERSONNEL:
 NAME EA Ambr LEVEL II; NAME SD Connelly LEVEL IT

SEARCH UNIT BEAM ANGLE: 0°; X 45°; _____ 60°; _____ OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L 1/ W 1	L m/ W m	L 2/ W 2	MP ₁	MP _m	MP ₂	SCAN	STAT.	COMMENTS
3-6	1	1MS1044 31	P-P		P	Z	P						
3-6	2	1MS1044 31	P-P	100%	1.00	1.12	1.00						
3-6	3	1MS1044 31	P-P	50%	16.20	16.00	15.30		.84		2	E	BL 100% -4db
3-6	4	1MS1044 31	P-P	60%	1.25	1.50	1.80		.86		1	A	SPOT ONLY
3-6	5	1MS1044 31	P-P	100%	9.3	2.75			.54		2	A	SPOT ONLY
3-6	6	1MS1044 31	P-P	75%	42.2	42.5	42.6		.5		2	E	B.R. 100%
					2.5	2.25	2.41		.4				
					48.3	15							

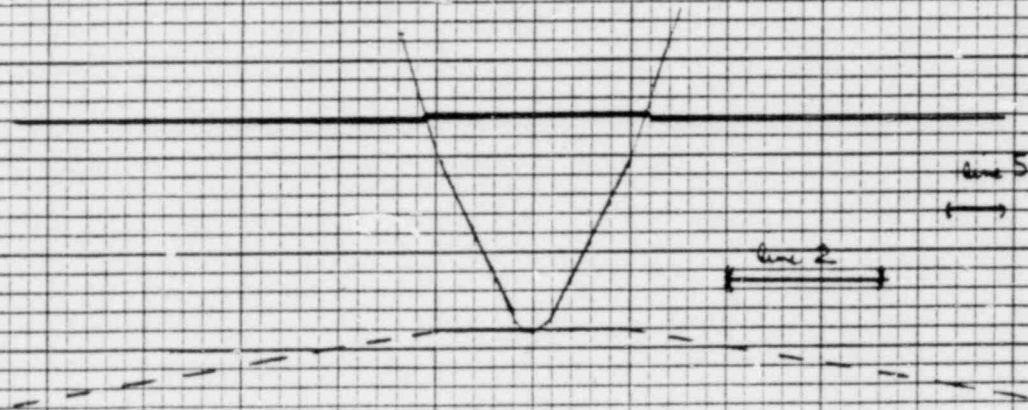
REVIEWED BY: NDE SUPERVISOR SD Connelly DATE 3/9/81
 QC SUPERVISOR W J Whately DATE 3/16/81
 AUTHORIZED INSPECTOR W J Connelly DATE 3-18-81

LASALLE UNIT 1 $T_P =$ 1.0

WELD IMS-1049-31 $T_W =$ 1.12

EDS 77605 $T_P =$ 1.02

GENERAL  ELECTRIC



LINE	EVALUATION
2,5	There are laminations in the base metal. They are acceptable per Section XI Figure 14B-3514.2 as area does not exceed 8 in ² .

EVALUATED BY R. J. Wheatley
Level III

DATE 3/16/81

REVIEWED BY W. J. Caldwell
ANII

DATE 3-18-81

EDS# 77006

CDS# 77604

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

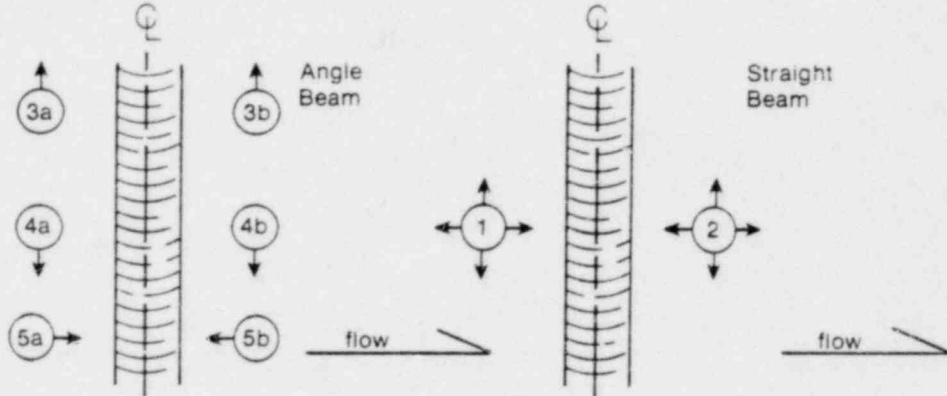
EXAMINATION PERSONNEL:
 NAME Ed Homer LEVEL II; NAME AD Connelly LEVEL IT

SEARCH UNIT BEAM ANGLE: 0°: X 45°: _____ 60°: _____ OTHER: _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER: _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION




DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/W1	Lm/Wm	L2/W2	MP1	MPm	MP2	SCAN	STAT.	COMMENTS
3-6	1	IMS1044 46	PP		P	CL	P						
					1.04	1.08	1.04					11A	
3-6	2	IMS1044 46	PP	100 +2	71.55	71.7	71.8		.52		2	E	BR=100%+2 100-100 Length
					2.80	2.85	3.15						
3-6	3	IMS1044 46	PP	100 +2	71.4	71.7	71.9		.52		2	E	BR=100%+2 50-50 Length
					2.70	2.85	3.30						
3-6	4	IMS1044 46	PP	60		15.4			.48		2	A	SPOT ONLY
						1.9							
3-6	5	IMS1044 46	PP	100 +6	16.2	16.0	15.8		.54		2	E	BR=100%-6dB 100-100 Length
					2.6	2.75	3.1						
3-6	6	IMS1044 46	PP	100 +6	16.4	16.0	15.75		.54		2	E	BR=100%-6dB 50-50 Length
					2.5	2.75	3.2						
3-6	7	IMS1044 46	PP	60		32.75			.6		2	A	SPOT ONLY
						1.30							
3-6	8	IMS1044 46	PP	50		39.2			.44		2	A	SPOT ONLY
						3.25							

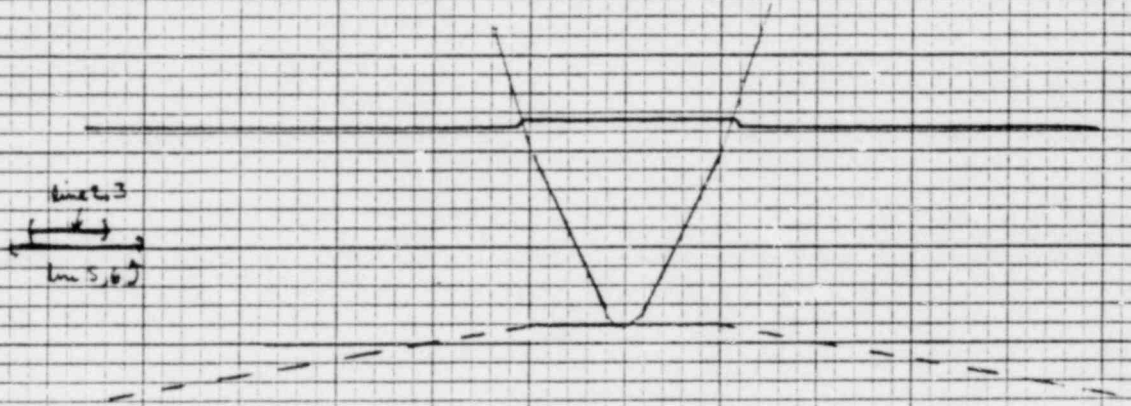
REVIEWED BY: NDE SUPERVISOR AD Connelly DATE 3/9/81

QC SUPERVISOR LW Wheatley DATE 3/17/81

AUTHORIZED INSPECTOR W J Caldwell DATE 3-18-81

LASALLE UNIT J T = _____
 WELD 1ms-1044-46 T_w = _____
 EDS 77606 T = _____

GENERAL  ELECTRIC



LINE	EVALUATION
2,3,5,6	These are base metal lamination well outside the IT
	area from the weld toe, thus do not require evaluation

EVALUATED BY L D Whentley DATE 3/17/81
 Level III

REVIEWED BY W J Caldwell DATE 3-18-81
 ANII

INSTALLATION & SERVICE ENGINEERING DIVISION

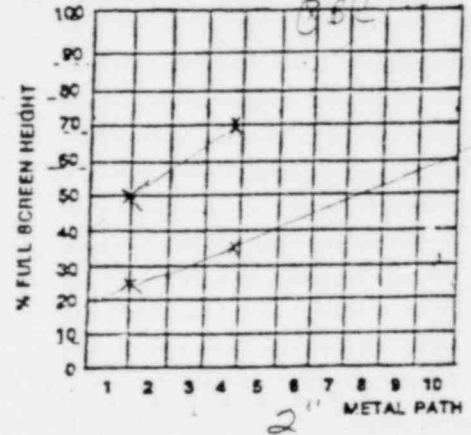
A. Procedure No. MPUP-5751 REV. 6
 Examination Personnel: NAME W. Connelly LEVEL II NAME M.E. Williams LEVEL IT
 Instrument: SERIAL NO. 521 MAKE/MODEL: - BRANSON/3003: SONIC/MK I; KK/USL32; OTHER
 D. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
 TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
 SERIAL NO.: A27016; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
 TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT; CERAMIC DUAL ELEMENT; OTHER
 WEDGE TYPE: STANDARD WEDGE; SPECIAL WEDGE/TYPE
 CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 =$ 0°

E. Cable LENGTH: 6 FT. TYPE: RG-58; RG-59; RG-57; RG-174; OTHER
 F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL; TRANSVERSE TO PIPE AXIS
 FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE PARALLEL; TRANSVERSE to hole centerline
 G. Calibration Standard: LSCS CAL STD. NO. 01-26-02 THICKNESS 1.06 DIAMETER 26"
 MATERIAL: CARBON; STAINLESS; INCONEL; OTHER
 H. Couplant: GLYCERINE; ULTRAGEL II; OTHER
 I. Comments: +6db - BR = 100% FSH

J. Dac Curve - Data

W T or /8 Yaw	PEAK AMP	W1	Wm	W2	MP1	MPm	MP2	HOLE DEPTH
50%						.20		.20
70%						.76		.76
100%						1.06		

K. Dac Curve - Screen Representation



L. Instrument Settings/Checks

CONTROLS	SET	CHECK BOXES								
		02	03	04	05	06	07	08	09	
GAIN	46 dB	✓								
SCAN GAIN	54 dB	✓								
SWEEP	5/143	✓								
DELAY	759	✓								
FILTER	Auto	✓								
REP RATE	Med	✓								
DAMPENING	Off	✓								
OTHER	na	✓								

M. Calibration Time - Records

DATE	01 ORIG CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
1981					
3-9	0830	na	na	na	yes
3-9	na	1131	77608	6	yes
3-9	na	1131	77609	4	yes

N. Reviewed By: NDE SUPERVISOR S. Connelly
 Q.C. SUPERVISOR W. Connelly
 AUTHORIZED INSPECTOR W. J. Connelly

DATE 3/10/81
 DATE 3/13/81
 DATE 3-18-81

EDS # 77608

CDS # 77607

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

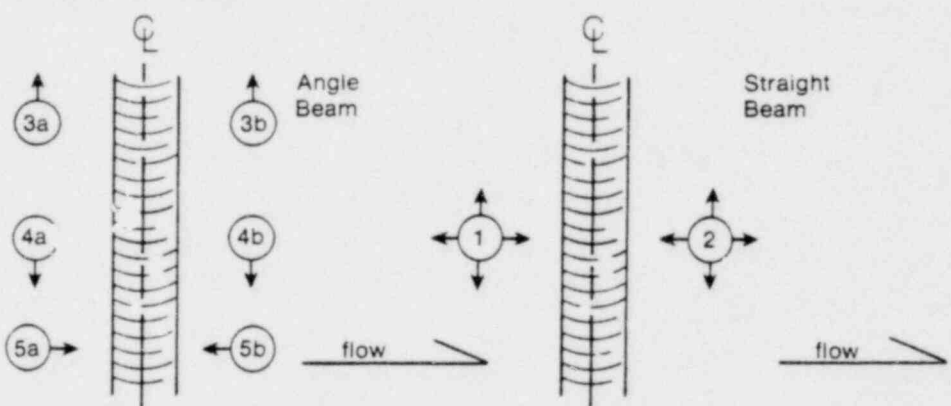
EXAMINATION PERSONNEL:
 NAME Castro LEVEL II; NAME McWilliams LEVEL IT

SEARCH UNIT BEAM ANGLE: 0°; X 45°; _____ 60°; _____ OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE	L'NE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/W1	Lm/Wm	L2/W2	MP1	MPm	MP2	SCAN	STAT.	COMMENTS
1981		IMS1044			P	CL	P						
3-9	1	16	PP		1.04	1.08	1.02					INA	
3-9	2	16	PP	60		19.5			.44		2	A	SPOT ONLY
3-9	3	16	PP	75		39.4			.42		2	A	SPOT ONLY
3-9	4	16	PP	75		50.95			.52		2	A	SPOT ONLY
3-9	5	16	PP	100	15.8	15.6	15.4		.74		2	E	BR=100%+2
3-9	6	IMS1044 16	PP	50	1.4	1.6	2.0		.58		1	A	SPOT ONLY
						4.5CCW							
						CL							

REVIEWED BY: AD Connelly DATE 3/10/81
 NDE SUPERVISOR
 QC SUPERVISOR: L J O'Heath DATE 3/13/81
 AUTHORIZED INSPECTOR: w j Colwell DATE 3-18-81

EDS # 77609

CDS # 77607

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

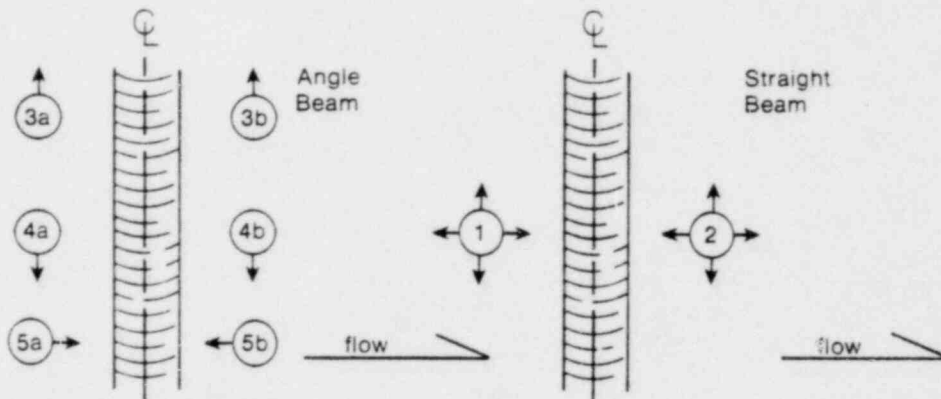
EXAMINATION PERSONNEL:
 NAME Cl Humber LEVEL II; NAME M Williams LEVEL IT

SEARCH UNIT BEAM ANGLE: 0°: X 45°: _____ 60°: _____ OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB


SCAN ORIENTATION

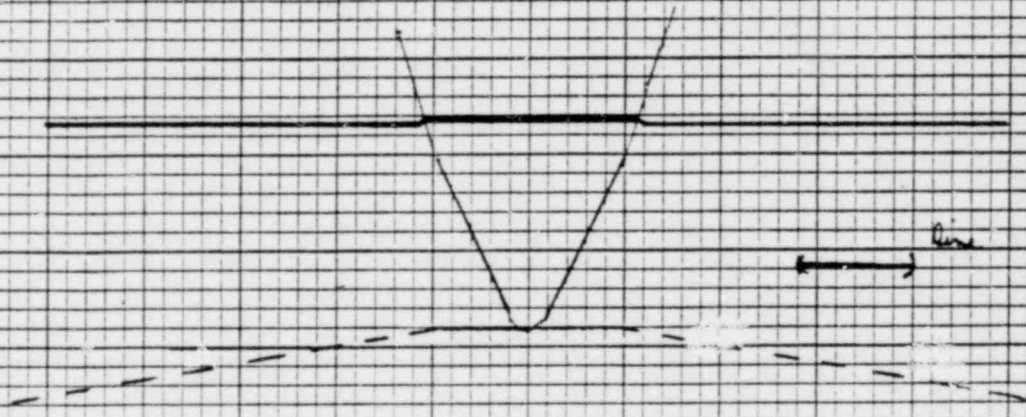


DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/W1	Lm/Wm	L2/W2	MP1	MPm	MP2	SCAN	STAT.	COMMENTS
1981		1MS1044			P	CL	P						
3-9	1	1	PP		1.02	1.10	1.04					A	
3-9	2	1	PP	75		154			.88		2	A	SPOT ONLY
3-9	3	1	PP	50		21.52			.46		2	A	SPOT ONLY
3-9	4	1MS1044	PP	50		52.25			.40		1	A	SPOT ONLY

REVIEWED BY: NDE SUPERVISOR SO Connelly DATE 3/10/81
 QC SUPERVISOR LD D Whalley DATE 3/13/81
 AUTHORIZED INSPECTOR w J Caldwell DATE 3-18-81

LASALLE UNIT 2 T = _____
 WELD 1ms-1044-16 T_w = _____
 EDS 77608 T = _____

GENERAL  ELECTRIC



LINE	EVALUATION
5	This is a base metal lamination. This is acceptable per Section XI Figure 1WB-3360 as there is no total loss of back reflection & size does not exceed criteria per Paragraph 1WB-3514.2

EVALUATED BY L O Whalley DATE 3/13/81
 Level III

REVIEWED BY w g Caldwell DATE 3-18-81
 ANII

INSTALLATION & SERVICE ENGINEERING DIVISION

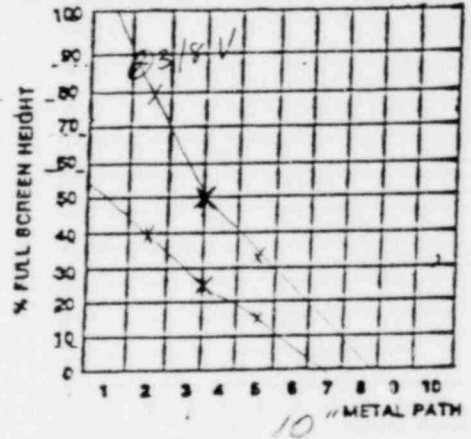
A. Procedure No. MPUP-5751 REV. 6
 Examination Personnel: NAME Ch. Bonita LEVEL II NAME M.E. Williams LEVEL IT
 Instrument SERIAL NO. 521 MAKE/MODEL: - BRANSON/303: SONIC/MK I; KK/USL32 OTHER
 B. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
 TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
 SERIAL NO.: L07944; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
 TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT CERAMIC DUAL ELEMENT OTHER
 WEDGE TYPE: STANDARD WEDGE SPECIAL WEDGE/TYPE
 CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 = 44.5^\circ$

E. Cable LENGTH: 6 FT. TYPE: RG-58 RG-59 RG-57 RG-174 OTHER
 F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL TRANSVERSE TO PIPE AXIS
 FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE PARALLEL TRANSVERSE to hole center
 G. Calibration Standard: LSCS CAL STD. NO. 01-26-02 THICKNESS 1.06" DIAMETER 26"
 MATERIAL: CARBON STAINLESS INCONEL OTHER
 H. Couplant: GLYCERINE ULTRAGEL II OTHER
 L. Comments: +10 dB = 3/8 V To 100% DAC

J. Dac Curve - Data

REFLECTOR	PEAK AMP	W1	Wm	W2	MP1	MPm	MP2	HOLE DEPTH
or	or	or	or	or	or	or	or	or
W-Top 4/8 V	80		1.05			1.5		
W-Top 2/8 V	50		2.13			3.0		
W-Top 1/8 V	32		3.20			4.5		
B.R.-or 3/8 V	100 +10		.82			1.1	.81	

K. Dac Curve - Screen Representation



L. Instrument Settings/Checks

CONTROLS	SET	CHECK BOXES							
		01	02	03	04	05	06	07	08
GAIN	48	✓							
SCAN GAIN	56	✓							
SWEEP	10/956	✓							
DELAY	764	✓							
FILTER	AUTO	✓							
REP RATE	MED	✓							
DAMPENING	OFF	✓							
ECT...	OFF	✓							
OTHER	NA	✓							

M. Calibration Time - Records

DATE	01 ORIG CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. ?	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
1981					
3-9	1252	NA	NA	NA	Yes
3-9	NA	1535	77611	6	Yes
3-9	NA	1535	77612	8	Yes

N. Reviewed By: NDE SUPERVISOR A. Bonnelly
 O.C. SUPERVISOR [Signature]
 AUTHORIZED INSPECTOR [Signature]

DATE 3/10/81
 DATE 3/16/81
 DATE 3-18-81

EDS # 77611

CDS # 77610

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

EXAMINATION PERSONNEL:
NAME Chomble LEVEL II; NAME McWilliams LEVEL IT

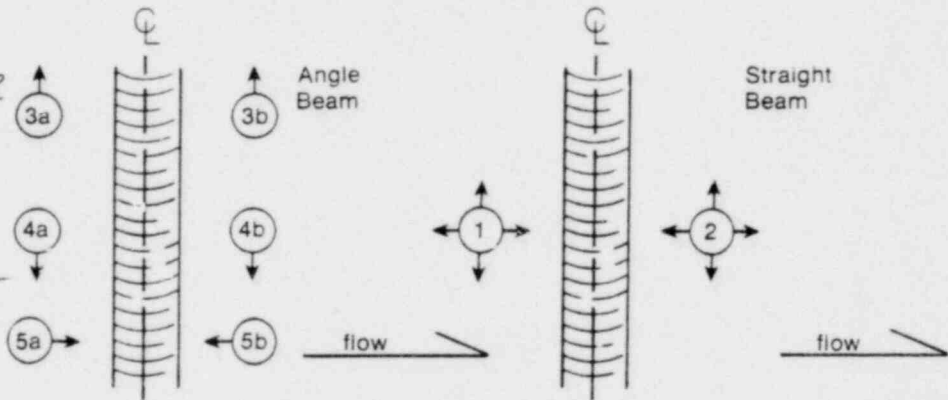
SEARCH UNIT BEAM ANGLE: 0°; 45°; X 60°; OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION

* INDICATIONS APPEAR INDIVIDUALLY & SIMULTANEOUSLY. POSSIBLE MODE CONVERSION. eat



DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/W1	Lm/Wm	L2/W2	MP1	MPm	MP2	SCAN	STAT.	COMMENTS
3-9	1	IMS1044	PP	75	360	1.15	INT		1.6		5A	E	
3-9	2		PP	100	360	1.55	INT		3.0		5A	A	* FDFS
3-9	3		PP	60	360	1.55	INT		4.1		5A	E	* FDFS
3-9	4		PP	50	360	1.55	INT		5.2		5A	E	* FDFS
3-9	5		PP	100 +2	360	1.5	INT		3.0		5B	A	FDFS
3-9	6	MS-1044	PP	75	360	3.0	INT		4.6		5B	E	FDNS

REVIEWED BY: AD Connelly DATE 3/10/81
 NDE SUPERVISOR
 QC SUPERVISOR L D Whately DATE 3/16/81
 AUTHORIZED INSPECTOR w g Caldwell DATE 3-18-81

LASALLE UNIT 1

$T_r = 1.02$

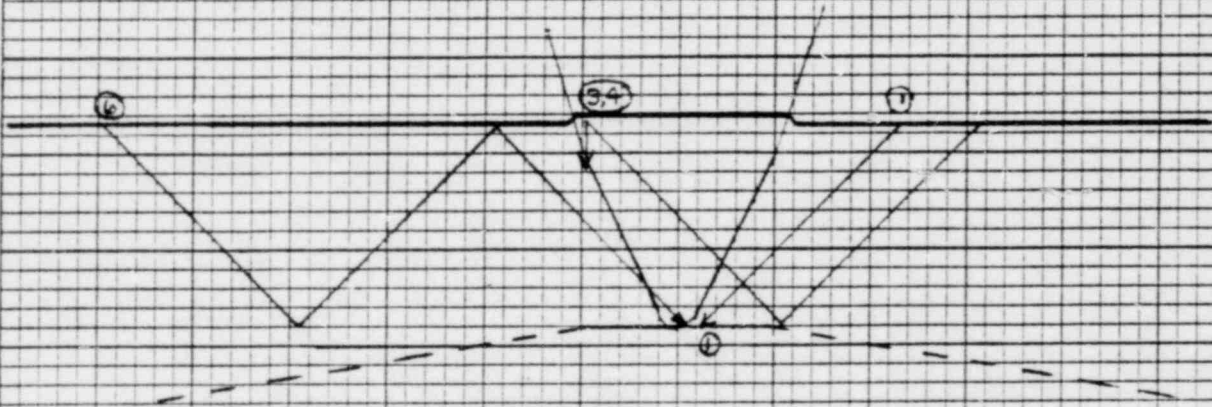
WELD 1MS-1044-1

$T_w = 1.1$

EDS 77611

$T_r = 1.04$

GENERAL  ELECTRIC



LINE	EVALUATION
3,4	Mode conversion from weld toe
1,6	ID geometry from weld root

EVALUATED BY L D Wheatley
Level III

DATE 3/16/81

REVIEWED BY w g Cahill
ANII

DATE 3-18-81

EDS # 77612

CDS # 77610

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

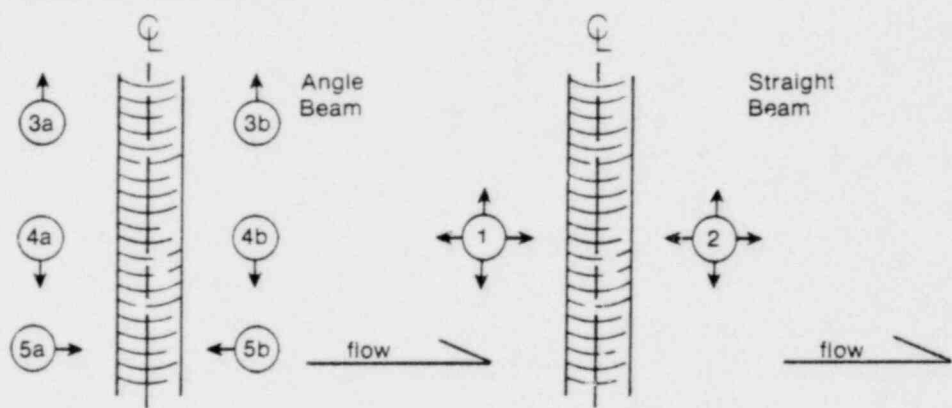
EXAMINATION PERSONNEL:
 NAME LA Hamler LEVEL II; NAME McWilliams LEVEL IT

SEARCH UNIT BEAM ANGLE: 0°; 45° X 60°; OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/ W1	Lm/ Wm	L2/ W2	MP ₁	MP _m	MP ₂	SCAN	STAT.	COMMENTS
1981		1MS1044											
3-9	1	16	PP	100 +2	360	1NT			3.0		5B	A	FDFS
3-9	2	16	PP	100 +4	360	1NT			2.9		5A	A	FDFS
3-9	3	16	PP	90	360	1NT			4.5		5A	E	FDNS
3-9	4	16	PP	60	360	1NT			1.5		5A	E	
3-9	5	1MS1044 31	PP	100 +2	360	1NT			3.1		5B	A	FDFS
3-9	6	31	PP	100	360	1NT			3.2		5A	A	FDFS
3-9	7	1MS1044 46	PP	60	360	1NT			3.0		5B	A	FDFS
3-9	8	46	PP	75	360	1NT			2.9		5A	A	FDFS

REVIEWED BY: AD Connelly DATE 3/10/81
 NDE SUPERVISOR
 QC SUPERVISOR: LD Whalley DATE 3/16/81
 AUTHORIZED INSPECTOR: wj Cabell DATE 3-18-81

INSTALLATION & SERVICE ENGINEERING DIVISION

LASALLE COUNTY NUCLEAR STATION UNIT 1

A. PROCEDURE NO. PP-S751 REV. 7

B. EXAMINATION PERSONNEL:

NAME CA Humber LEVEL II

NAME NA LEVEL NA

C. PENETRANT MATERIALS:

- a. MANUFACTURER MAGNAFLUX-SPOTCHECK
- b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
- c. PENETRANT TYPE SKL-HF /SKI-S BATCH NO. 79B109
- d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
- e. DEVELOPER TYPE SKD-S BATCH NO. 79E033
- f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

- 1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO
- 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO

b. SURFACE PREPARATION:

- *1. GRINDING *2. FLAPPING *3. NONE *4. OTHER _____

E. DATA: NOTE: All Exam components are ASME Sect. XI _____ Category. CF

01 LINE NO.	02 DATE	03 PRE-CLEAN EVAP. TIME	04 PEN. DWELL TIME	05 PEN. REM. EVAP. TIME	06 DEV. TIME	07 EXAMINATION COMPONENT I.D. NO.	08 MAT'L	09 SURF. PREP. *	10 RELEVANT INDICATION		11 ACCEPTABLE		12 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES 09	NO 10	YES 11	NO 12	
1	3-26	5	10	5	15	12H1023-16	CS	2	X		X		3/32" EDIND - IN WELD @ SURF 1.15.5" FROM V'
2	3-26	5	10	5	15	12H1024-4A	CS	2		X	X		
3	3-26	5	10	5	15	12H1024-4B	CS	2		X	X		
4	3-26	5	10	5	15	12H1023-14	CS	2	X		X		1/8" EDIND - SURF 1 TOE OF WELD 10.1" CCW FROM TDC
5													
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

* NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(S) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NCE SUPERVISOR W Connelly DATE 3/27/81
 QC SUPERVISOR L D Whately DATE 4/2/81
 AUTHORIZED INSPECTOR W J Caldwell DATE 4-2-81

A. PROCEDURE NO. PP-S751 REV. 7

B. EXAMINATION PERSONNEL:
 NAME [Signature] LEVEL II
 NAME NA LEVEL NA

C. PENETRANT MATERIALS:
 a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 79B109
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKU-S BATCH NO. 79E033
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO

b. SURFACE PREPARATION:

- *1. GRINDING *2. FLAPPING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

LINE NO	DATE	PRE-CLEAN EVAP. TIME	PEN. DWELL TIME	PEN. REM. EVAP. TIME	DEV. TIME	EXAMINATION COMPONENT I.D. NO.	MAT'L	SURF. PREP. #	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES 09	NO 10	YES 11	NO 12	
1	3-27	5	10	5	15	1R41023-9	CS	2		X	X		
2	3-27	5	10	5	15	1R41023-8	CS	2		X	X		
3	3-27	5	10	5	15	1R41023-7	CS	2		K	X		
4	3-27	5	10	5	15	1R41023-4A	CS	2		X	X		UNDER MIDWELL-TDC
5	3-27	NA	NA	NA	NA	1R41023-4A	CS	2	NA	NA	NA	NA	IN WELD C/ EXCAVATIONS
6						SEE INCR-106							
7													
8													
9													
10													
11													
12													
13													
14													
5													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(S) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NCE SUPERVISOR [Signature] DATE 3/30/81
 QC SUPERVISOR [Signature] DATE 4/2/81
 AUTHORIZED INSPECTOR [Signature] DATE 4-2-81

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT I

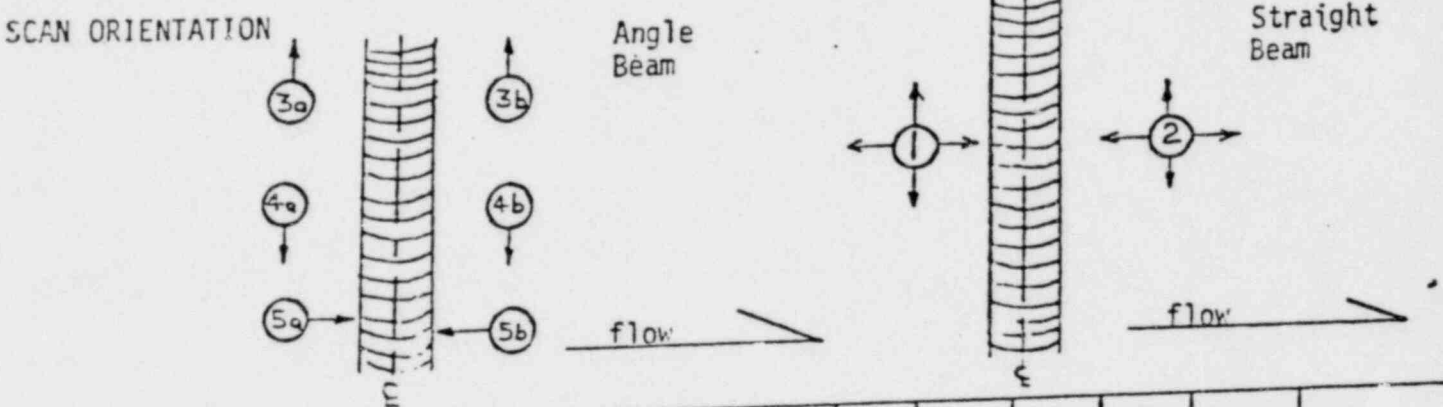
PROCEDURE NO. MPUP - 5751 REV. 6

EXAMINATION PERSONNEL:
 NAME F. Abuzo, Jr. LEVEL II; NAME NA LEVEL NA

SEARCH UNIT BEAM ANGLE: 0°; 45°; 60°; OTHER _____

COUPLANT: GLYCERINE: ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB



DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/W1	Lm/Wm	L2/W2	MP1	MPm	MP2	SCAN	STAT.	COMMENT
7/1/80	1	IRI-1022-11	P-E	70%		360° INT.			1.05		50	A	OD FO FAR TOE
7/1/80	2	IRI-1022-12	E-P									A	

REVIEWED BY: S.D. Connelly DATE 7/3/80
 NDE SUPERVISOR _____ DATE 7/9/80
 QC SUPERVISOR Solomon DATE 3-26-81
 AUTHORIZED INSPECTOR W.D. Caldwell

ULTRASONIC EXAMINATION DATA SHEET
LASALLE COUNTY STATION UNIT

A. Procedure No. MPUA 5751 REV. 3

B. Examination Personnel:
NAME [Signature] LEVEL III NAME Gary R. Cobble LEVEL IT

C. Search Unit Beam Angle ($\pm 2^\circ$): 0° 45° 60° Other _____

D. Couplant: Glycerine Ultragel II Other _____

E. Scan Sensitivity (+): 8 dB

F. Reference System

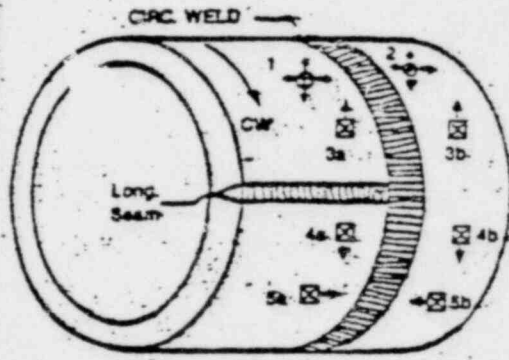
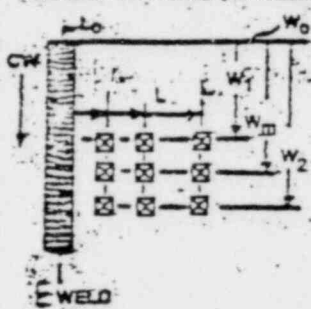
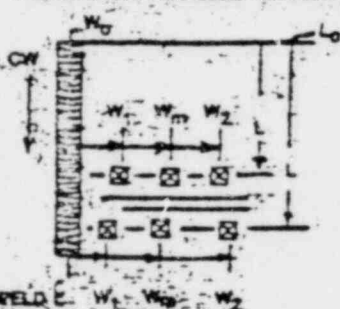
G. Scan Orientation

$L_0 = V^N$ Stamp

$W_0 = V^N$ Stamp

REFLECTOR PARALLEL TO WELD

REFLECTOR TRANS. TO WELD



TOP (vert)
TWO PPV or FLOW (horiz.)
⊙ : Straight Beam
⊗ : Angle Beam

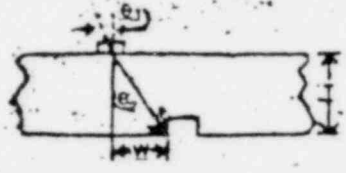
H. Data

00 DATE	01 LINE NO.	02 EXAM/COMP. I.D. NO.	03 COMP. FIG.	04 REC. IND. YES/NO	05 MAX. DAC W_m	06 L_0 / W_0	07 L	08 W_1	09 W_m	10 W_2	11 SRP ₁ or MP ₁	12 SRP _m or MP _m	13 SRP ₂ or MP ₂	14 SCAN	15 Comments (Thickness Meas.)
1979															
4/5	1	IMS-1044 13	P/E	Yes	50	$\frac{14}{E}$	14		17			60		5A	FINGER DAMP 360° INT.
4/5	2	IMS-1044 13	P/E	Yes	50	$\frac{19}{E}$	19		16			32		5A	360° INT.
4/5	3	IMS-1044 13	P/E	Yes	50	$\frac{7}{E}$	7		16			64		5B	FINGER DAMP 360° INT.
4/5	4	IMS-1044 13	P/E	Yes	50	$\frac{10}{E}$	10		17			30		5B	360° INT.
	5	* CENTER OF WELD STAMP													
	6														
	7														
	8														
	9														

L. Reviewed By: [Signature] DATE 4/6/79
NDE SUPERVISOR _____
QC SUPERVISOR: [Signature] DATE 4/17/79
AUTHORIZED INSPECTOR [Signature] DATE 3-26-81

INSTALLATION & SERVICE ENGINEERING DIVISION

A. Procedure No. MPUP-5751 REV. 3
 Examination Personnel: NAME R. J. [unclear] LEVEL 3 NAME [unclear] LEVEL I-T
 Instrument: SERIAL NO. 70403 MAKE/MODEL: - BRANSON/303: SONIC/MK1; KK/USL32; OTHER USA-2
 D. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
 TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
 SERIAL NO.: L20811; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
 TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT; CERAMIC DUAL ELEMENT; OTHER
 WEDGE TYPE: STANDARD WEDGE; SPECIAL WEDGE/TYPE
 CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 =$ N/A



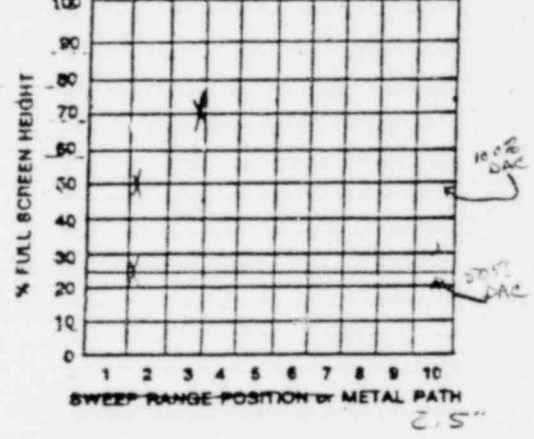
$\theta = \text{ARC TAN} \left(\frac{W}{T} \right)$
 T = CAL STD. THICKNESS

E. Cable: LENGTH: 6 FT. TYPE: RG-58; RG-59; RG-57; RG-174; OTHER
 F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL; TRANSVERSE TO PIPE AXIS
 FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE: PARALLEL; TRANSVERSE to hole centerline
 G. Calibration Standard: LSCS CAL STD. NO. 01-24-02 THICKNESS .7 DIAMETER 2.4
 MATERIAL: CARBON; STAINLESS; INCONEL; OTHER
 H. Couplant: GLYCERINE; ULTRAGEL II; OTHER
 I. Comments:

J. Dac Curve — Data SRP; MP in inches

ECTOR	PEAK AMP	W1	Wm	W2	SRP or 1 MP1	SRP or m MPm	SRP or 2 MP2	HOLE DEPTH
01	01	02	03	04	05	06	07	08
WT or 78 Vee								
WT or 78 Vee	50					.3		
WT or 78 Vee								
B.P. or 78 Vee	70					.7		.3

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS	SET	CHECK BOXES							
		02	03	04	05	06	07	08	09
GAIN	14	✓							
SCAN GAIN	22	✓							
SWEEP	25	✓							
DELAY	684	✓							
FILTER	Auto	✓							
REP RATE	Auto	✓							
DAMPENING	Auto	✓							
GT...	27F	✓							
NER	N/A	✓							

M. Calibration Time — Records

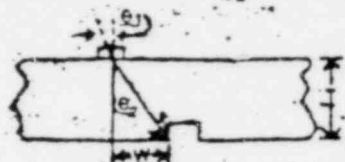
DATE	01 ORIG CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
1979					
4/6	0900	—	—	—	YES
4/6	—	1030	85/02	2	YES

N. Reviewed By: NDE SUPERVISOR S.D. Connelly DATE 4/9/79
 Q.C. SUPERVISOR [unclear] DATE 4/17/79
 AUTHORIZED INSPECTOR [unclear] DATE 3-26-81

INSTALLATION & SERVICE ENGINEERING DIVISION:

A. Procedure No. MPUP-5751 REV. 3
 Examination Personnel: NAME [Signature] LEVEL II NAME [Signature] LEVEL IT
 Instrument: SERIAL NO. 2680-1348 MAKE/MODEL: - BRANSON/303: SONIC/MK I; KK/USL32; OTHER

D. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
 TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
 SERIAL NO.: H 25833; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
 TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT; CERAMIC DUAL ELEMENT; OTHER
 WEDGE TYPE: STANDARD WEDGE; SPECIAL WEDGE/TYPE
 CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 = \frac{t}{R}$



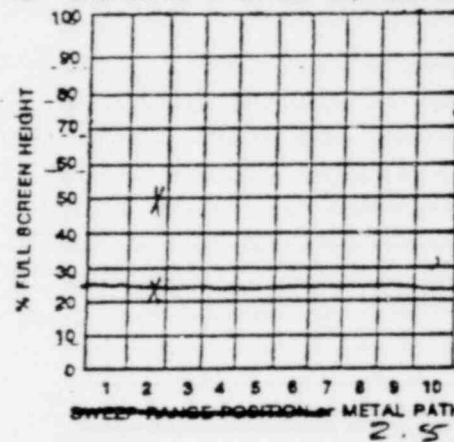
$\theta = \text{ARC TAN. } \left(\frac{W}{T}\right)$
 T = CAL STD. THICKNESS

E. Cable: LENGTH: 6 FT. TYPE: RG-58; RG-59; RG-57; RG-174; OTHER
 F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL; TRANSVERSE TO PIPE AXIS
 FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE PARALLEL; TRANSVERSE to hole centerline
 G. Calibration Standard: LSCS CAL STD. NO. 01-24-08 THICKNESS 1.0 DIAMETER 24
 MATERIAL: CARBON; STAINLESS; INCONEL; OTHER
 H. Couplant: GLYCERINE; ULTRAGEL II; OTHER
 I. Comments:

J. Dac Curve — Data SRP; MP in inches

ECTOR	PEAK AMP	W1	Wm	W2	SRP or 1 MP1	SRP or m MPm	SRP or 2 MPz	HOLE DEPTH
00	01	02	03	04	05	06	07	08
W T or /8 Vee								
W T or /8 Vee	50					.45		.45
W T or /8 Vee								
B.R. or /8 Vee						1.0		

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS	SET	CHECK BOXES							
		02	03	04	05	06	07	08	09
GAIN	36	<input checked="" type="checkbox"/>							
SCAN GAIN	44	<input checked="" type="checkbox"/>							
SWEEP	2.5/642	<input checked="" type="checkbox"/>							
DELAY	948	<input checked="" type="checkbox"/>							
FILTER	Auto	<input checked="" type="checkbox"/>							
REP RATE	Auto	<input checked="" type="checkbox"/>							
DAMPENING	Auto	<input checked="" type="checkbox"/>							
ECT	Auto	<input checked="" type="checkbox"/>							
OTHER	BFA	<input checked="" type="checkbox"/>							

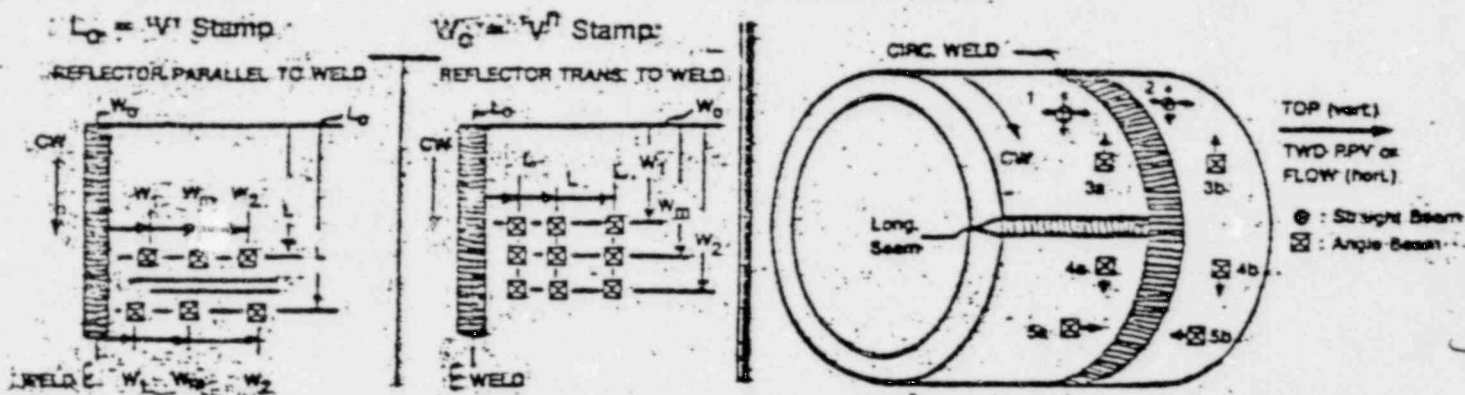
M. Calibration Time — Records

DATE	01 ORIG. CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
1979					
4/12	1530	—	—	—	Yes
4/12	—	1630	85134	2	Yes

N. Reviewed By: NDE SUPERVISOR [Signature] DATE 4/12/79
 Q.C. SUPERVISOR [Signature] DATE 4/17/79
 AUTHORIZED INSPECTOR [Signature] DATE 3-26-81

ULTRASONIC EXAMINATION DATA SHEET
 LASALLE COUNTY STATION UNIT 1

A. Procedure No. MP4P 5751 REV. 3
 B. Examination Personnel:
 NAME [Signature] LEVEL II NAME [Signature] LEVEL IT
 C. Search Unit Beam Angle ($\pm 2^\circ$): 0° 45° 60° Other _____
 D. Couplant: Glycerol Ultragel II Other _____
 E. Scan Sensitivity (+): 8 dB
 F. Reference System _____ G. Scan Orientation _____



H. Data:

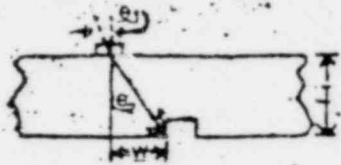
DATE	01 LINE NO.	02 EXAM/COMP. I.D. NO.	03 COMP. FIG.	04 REC. IND. YES/NO	05 MAX. DAC W_m	06 L_0 / W_0	07 L	08 W_1	09 W_m	10 W_2	11 SRP ₁ or MP ₁	12 SRP _m or MP _m	13 SRP ₂ or MP ₂	14 SCAN	15 Comments (Thickness Meas.)
1979															
4/12	1	100-1007	RSE	NO											1/2" T
	2														
	3														
	4														
	5														
	6														
	7														
	8														
	9														

L. Reviewed By: NDE SUPERVISOR [Signature] DATE 4/13/79
 QC SUPERVISOR: [Signature] DATE 4/17/79
 3. AUTHORIZED INSPECTOR [Signature] DATE 3-26-81

INSTALLATION & SERVICE ENGINEERING DIVISION

A. Procedure No. MPUP-5751 REV. 3
 Examination Personnel: NAME R. W. Wachuk LEVEL II NAME Gary K. Weber LEVEL IT
 Instrument: SERIAL NO. 26680-1348 MAKE/MODEL: - BRANSON/303: SONIC/MK1; KK/USL32; OTHER

D. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
 TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
 SERIAL NO.: D 05861; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
 TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT; CERAMIC DUAL ELEMENT; OTHER
 WEDGE TYPE: STANDARD WEDGE; SPECIAL WEDGE/TYPE
 CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 =$ 45°



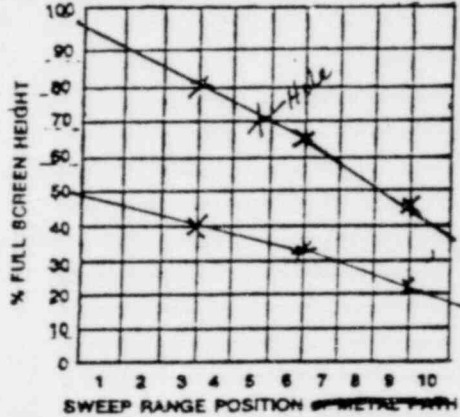
$\theta = \text{ARC TAN} \left(\frac{W}{T} \right)$
 T = CAL STD. THICKNESS

E. Cable: LENGTH: 6 FT. TYPE: RG-58; RG-59; RG-57; RG-174; OTHER
 F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL; TRANSVERSE TO PIPE AXIS
 FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE PARALLEL; TRANSVERSE to hole centerline
 G. Calibration Standard: LSCS CAL STD. NO. 01-18-01 THICKNESS .62 DIAMETER 18
 MATERIAL: CARBON; STAINLESS; INCONEL; OTHER
 H. Couplant: GLYCERINE; ULTRAGEL II; OTHER
 I. Comments: +10dB To bring Hole to 100% DAC
I.D. CORNER USED TO DETERMINE BEAM ANGLE

J. Dac Curve - Data SRP; MP in inches

LECTOR	PEAK AMP	W1	Wm	W2	SRP or 1 MP1	SRP or m MPm	SRP or 2 MP2	HOLE DEPTH
08	01	02	03	04	05	06	07	09
W T or /8 Vee	80		.62			30		
W T or /8 Vee	65		1.2			60		
W T or /8 Vee	45		1.75			90		
B.R. or /8 Vee	70		1.0			46	.2	

K. Dac Curve - Screen Representation



L. Instrument Settings/Checks

CONTROLS	SET	CHECK BOXES							
		02	03	04	05	06	07	08	09
GAIN	44	✓							
SCAN GAIN	52	✓							
SWEEP	2.5/616	✓							
DELAY	756	✓							
FILTER	Auto	✓							
REP RATE	Auto	✓							
DAMPENING	Auto	✓							
REFLECT	off	✓							
W/NER	N/A	✓							

M. Calibration Time - Records

DATE	01 ORIG CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
1979					
4/12	1400	-	-	-	YES
4/12	-	1530	85136	8	YES

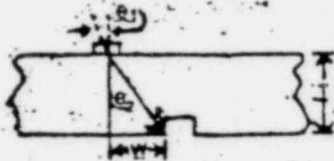
N. Reviewed By: NDE SUPERVISOR Stannally DATE 4/16/79
 O.C. SUPERVISOR Dave Halshaw DATE 4-20-79
 AUTHORIZED INSPECTOR w. J. Caldwell DATE 3-26-79

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. MPUP-5751 REV. 4

Examination Personnel: NAME RT Palmer LEVEL IV NAME Sam K. Wells LEVEL IT
Instrument: SERIAL NO. 522 MAKE/MODEL: - BRANSON/303: SONIC/MK1; KK/USL32; OTHER

D. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
SERIAL NO.: 005954; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT; CERAMIC DUAL ELEMENT; OTHER
WEDGE TYPE: STANDARD WEDGE; SPECIAL WEDGE/TYPE
CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 = \underline{45^\circ}$



$$\theta = \text{ARC TAN } \left(\frac{W}{T} \right)$$

T = CAL STD. THICKNESS

E. Cable: LENGTH: 6 FT. TYPE: RG-58; RG-59; RG-57; RG-174; OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL; TRANSVERSE TO PIPE AXIS
FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE PARALLEL; TRANSVERSE to hole centerline

G. Calibration Standards: LSCS CAL STD. NO. 01-12-01 THICKNESS .42 DIAMETER 12
MATERIAL: CARBON; STAINLESS; INCONEL; OTHER

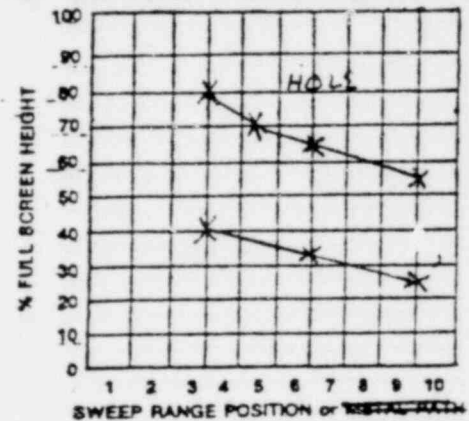
H. Couplant: GLYCERINE; ULTRAGEL II; OTHER

I. Comments: +9 dB To Acq Reference Hole To 100% Dac

J. Dac Curve — Data SRP; MP in inches

UTDR	PEAK AMP	W1	Wm	W2	SRP or 1	SRP or m	SRP or 2	HOLE DEPTH
01	01	02	03	04	05	06	07	08
WT of 4/8 Vee	80		.42			30		
WT of 5/8 Vee	65		1.0			60		
WT of 1 1/8 Vee	55		1.4			90		
B.R. of 6/8 Vee	70		.6			42		.59

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS	SET	CHECK BOXES							
		02	03	04	05	06	07	08	09
GAIN	42	✓	✓	✓					
SCAN GAIN	50	✓	✓	✓					
SWEEP	2.5/4.18	✓	✓	✓					
DELAY	3.56	✓	✓	✓					
FILTER	AUTO	✓	✓	✓					
REP RATE	AUTO	✓	✓	✓					
DAMPENING	AUTO	✓	✓	✓					
TEST	OFF	✓	✓	✓					
NUMBER	N/A	✓	✓	✓					

M. Calibration Time — Records

DATE	01 ORIG. CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S.	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
1979					
4/26	8:00am	12:00am	88016	5	Yes
4/26		12:30am			Yes
4/26		3:00am			Yes

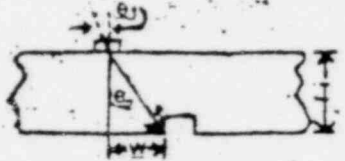
N. Reviewed By: NDE SUPERVISOR SJ Connelly
Q.C. SUPERVISOR Sahaduddeen
AUTHORIZED INSPECTOR H J Connelly

DATE 4/27/79
DATE 5/2/79
DATE 3-26-81

INSTALLATION & SERVICE ENGINEERING DIVISION

A. Procedure No. MPUP-5751 REV. 4
 Examination Personnel: NAME R. Palmer LEVEL II NAME Logan McChie LEVEL I
 Instrument: SERIAL NO. 522 MAKE/MODEL: - BRANSON/303: SONITAMK I; KK/USL32 OTHER

D. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
 TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
 SERIAL NO.: D05561; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
 TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT CERAMIC DUAL ELEMENT OTHER
 WEDGE TYPE: STANDARD WEDGE SPECIAL WEDGE/TYPE
 CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 = 45^\circ$



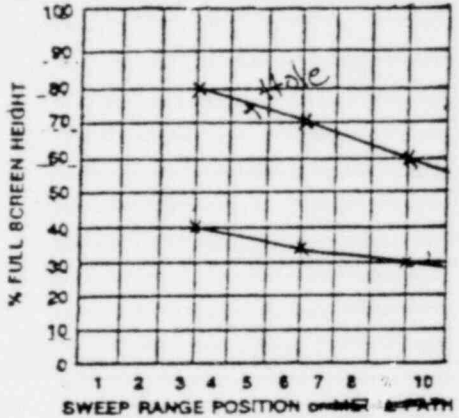
$\theta = \text{ARC TAN} \left(\frac{W}{T} \right)$
 T = CAL STD. THICKNESS

E. Cable: LENGTH: 6 FT. TYPE: RG-58 RG-59 RG-57 RG-174 OTHER
 F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL TRANSVERSE TO PIPE AXIS
 FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE PARALLEL TRANSVERSE to hole centerline
 G. Calibration Standard: LSCS CAL STD. NO. 01-18-01 THICKNESS .55 DIAMETER 18"
 MATERIAL: CARBON STAINLESS INCONEL OTHER
 H. Couplant: GLYCERINE ULTRAGEL II OTHER
 I. Comments: +8dB needed to bring reference hole to DAC

J. Dac Curve -- Data SRP; MP in Inches

ECTOR DE	PEAK AMP RT	W1 D1	Wm D1	W2 D1	SRP or 1 MP1 D1	SRP or m MPm D1	SRP or 2 MP2 D1	HOLE DEPTH D1
WT or 4/8 Yrs	80		.55			30		
WT or 8/8 Yrs	70		1.15			60		
WT or 12/8 Yrs	60		1.7			90		
B.R. or 6/8 Yrs	75		.8			46	.77	

K. Dac Curve -- Screen Representation



L. Instrument Settings/Checks

CONTROLS D1	SET D1	CHECK BOXES								
		D2	D3	D4	D5	D6	D7	D8	D9	
GAIN	40	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
SCAN GAIN	48	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
SWEEP	7.5/6.9	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
DELAY	7.56	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
FILTER	Auto	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
REP RATE	Auto	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
DAMPENING	OFF	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
GT	OFF	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
OTHER	N/A	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

M. Calibration Time -- Records

DATE	D1 ORIG. CAL TIME	D2 CAL CHECK TIME	D3 LAST E.D.S. #	D4 LAST E.D.S. LINE #	D5 VERIFICATION OF 25°F LIMIT (YES/NO)
5/2	8:00m	12:00m			Yes
5/2		12:30m			Yes
5/2		3:00m	88024	#6	Yes

N. Reviewed By: NDE SUPERVISOR J. Donnelly DATE 5/3/79
 Q.C. SUPERVISOR J. D. ... DATE 5/19/79
 AUTHORIZED INSPECTOR J. ... DATE 3-26-81

ULTRASONIC EXAMINATION DATA SHEET
LASALLE COUNTY STATION UNIT I

A. Procedure No. 77PUP-5751 REV. 4

B. Examination Personnel:
NAME R. Palmer LEVEL II NAME Raymond McLean LEVEL I

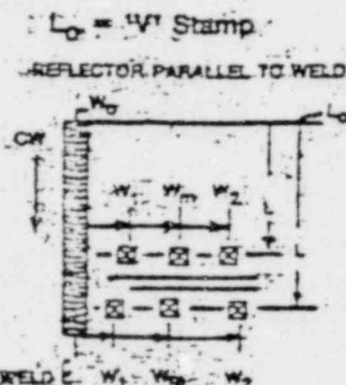
C. Search Unit Beam Angle ($\pm 2^\circ$): 0° 45° 60° Other _____

D. Couplant: Glycerine Ultragel II Other _____

E. Scan Sensitivity (+): 8 dB

F. Reference System

G. Scan Orientation



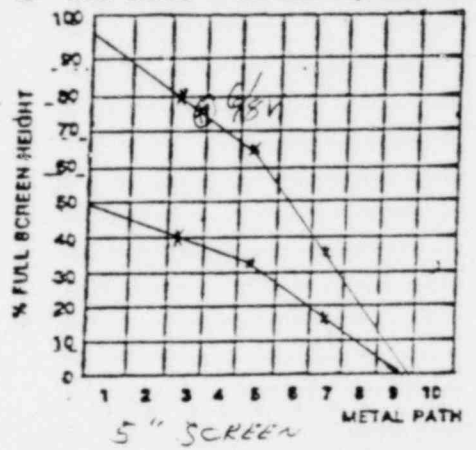
A. Procedure No. MPUP-5751 REV. 6
 Examination Personnel: NAME J. M. [unclear] LEVEL II NAME [unclear] LEVEL IV
 Instrument SERIAL NO. 1348 MAKE/MODEL: - BRANSON/3003: SONIC/MK I; KK/USL32 OTHER
 D. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
 TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
 SERIAL NO.: D05854; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
 TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT CERAMIC DUAL ELEMENT OTHER
 WEDGE TYPE: STANDARD WEDGE SPECIAL WEDGE/TYPE
 CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 =$ 45.7°

E. Cable LENGTH: 6 FT. TYPE: RG-58 RG-59 RG-57 RG-174 OTHER
 F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL TRANSVERSE TO PIPE AXIS
 FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE PARALLEL TRANSVERSE to hole center
 G. Calibration Standard: LSCS CAL STD. NO. 01-10-01 THICKNESS .75 DIAMETER 1.0"
 MATERIAL: CARBON STAINLESS INCONEL OTHER
 H. Couplant: GLYCERINE ULTRAGEL II OTHER
 I. Comments: + 12 db TO bring 6/8 v TO 100% DAC

J. Dac Curve - Data

REFLECTOR	PEAK AMP	W1	Wm	W2	MP1	MPm	MPz	HOLE DEPTH
WT of 4/8 Vee	80%		.81			1.1		
WT of 5/8 Vee	65%		1.58			2.2		
WT of 6/8 Vee	35%		2.27			3.25		
B.R. of 6/8 Vee	100%		1.05			1.4	37	

K. Dac Curve - Screen Representation



L. Instrument Settings/Checks

CONTROLS	SET	CHECK BOXES							
		01	02	03	04	05	06	07	08
GAIN	46	✓							
SCAN GAIN	54	✓							
SWEEP	867	✓							
DELAY	757	✓							
FILTER	AUTO	✓							
REP. RATE	MED	✓							
DAMPENING	OFF	✓							
REFLECT	OFF	✓							
OTHER	NA	✓							

M. Calibration Time - Records

DATE	01 ORIG. CAL. TIME	02 CAL. CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
1981					
3-9	1305	NA	NA	NA	YES
3-9	NA	1510	92279	6	YES

N. Reviewed By: NDE SUPERVISOR [Signature] DATE 3/11/81
 O.C. SUPERVISOR [Signature] DATE 3/14/81
 AUTHORIZED INSPECTOR [Signature] DATE 3-18-81

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP-5751 REV. 6

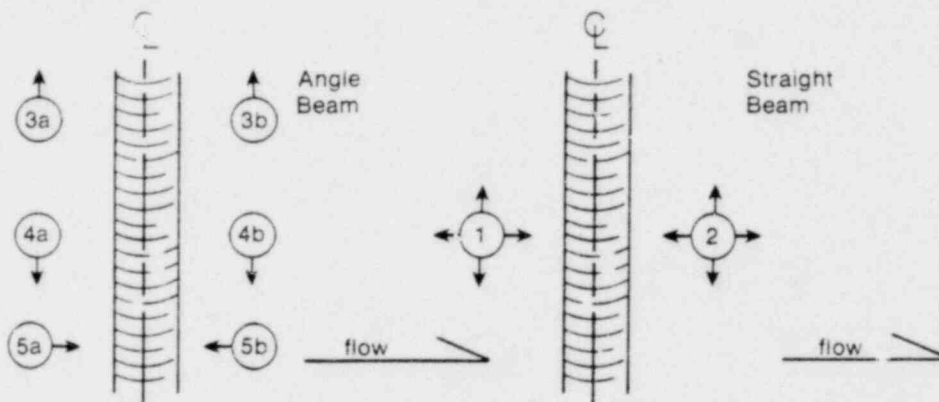
EXAMINATION PERSONNEL:
 NAME Jerry [Signature] LEVEL IV; NAME [Signature] LEVEL IT

SEARCH UNIT BEAM ANGLE: 0°; 45°; X 60°; OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



1981 DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/W1	Lm/Wm	L2/W2	MP1	MPm	MP2	SCAN	STAT.	COMMENTS
3-9	1	1A	E-P	100%							SB	A	NO SCAN (SB) FROM 4.5" TO 6" DUE TO WIRE ROPE U-BOLT
3-9	2	1A	E-P	100%							SB	A	SCAN (SB) LTD TO 1.5" FROM 6" CW TO 5" CCW FROM "V" DUE TO WIRE ROPE
3-9	3	1A	E-P	100%		360 INT .75			2.15		SB	A	FDFT
3-9	4	1A	E-P	60%		360 INT 1.7			1.0		SB	E	
3-9	5	1A	E-P	100% +2		360 INT .7			1.95		SA	A	FDFT
3-9	6	1A	E-P	75%		360 INT 1.75			1.15		SA	E	

REVIEWED BY: NDE SUPERVISOR [Signature] DATE 3/11/81
 QC SUPERVISOR [Signature] DATE 3/16/81
 AUTHORIZED INSPECTOR [Signature] DATE 3-18-81

LASALLE UNIT 1

T_E = .83

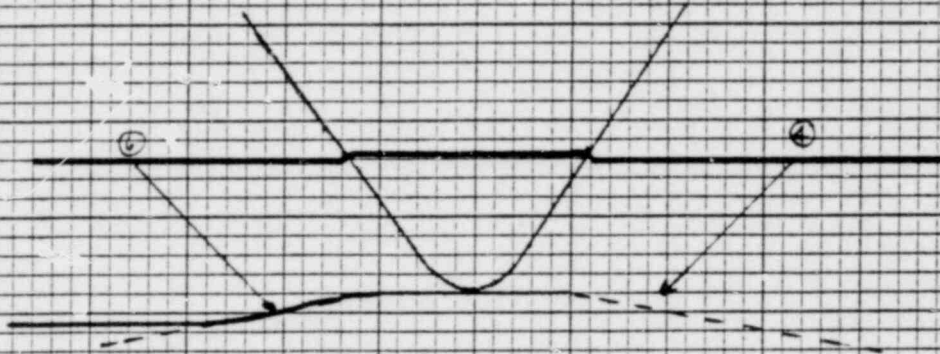
WELD IRI-1015-1A

T_w = .73

EDS 92279

T_f = .73

GENERAL  ELECTRIC



LINE	EVALUATION
4,6	ID geometry from centerline

EVALUATED BY W.D. Whitley
Level III O

DATE 3/16/81

REVIEWED BY W.D. Caldwell
ANII

DATE 3-18-81

INSTALLATION & SERVICE ENGINEERING DIVISION

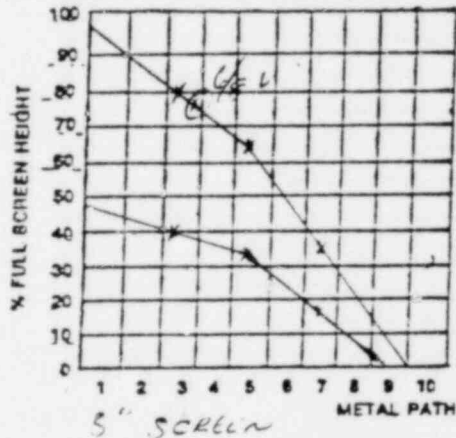
A. Procedure No. MPUP-5751 REV. 6
 Examination Personnel: NAME J. J. ... LEVEL II NAME ... LEVEL IV
 Instrument: SERIAL NO. 1398 MAKE/MODEL: - BRANSON/3003: SONIC/MK I; RK/USL32; OTHER
 D. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
 TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
 SERIAL NO.: DC5854; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
 TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT; CERAMIC DUAL ELEMENT; OTHER
 WEDGE TYPE: STANDARD WEDGE; SPECIAL WEDGE/TYPE
 CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 = \underline{45.7}^\circ$

E. Cable: LENGTH: 6 FT. TYPE: RG-58; RG-59; RG-57; RG-174; OTHER
 F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL; TRANSVERSE TO PIPE AXIS
 FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE: PARALLEL; TRANSVERSE to hole centerline
 G. Calibration Standard: LSCS CAL STD. NO. 01-10-01 THICKNESS .75 DIAMETER 1.0"
 MATERIAL: CARBON; STAINLESS; INCONEL; OTHER
 H. Couplant: GLYCERINE; ULTRAGEL II; OTHER
 I. Comments: +10db to bring 1/8" to 100% DAC

J. Dac Curve — Data

ECTOR	PEAK AMP	W1	Wm	W2	MP1	MPm	MP2	HOLE DEPTH
OR	RT	OR	OR	OR	OR	OR	OR	OR
WT or 1/8" Vee	80%		.81			1.1		
WT or 1/8" Vee	65%		1.58			2.2		
WT or 1/8" Vee	35%		2.27			3.25		
BR or 1/8" Vee	100%		1.05			1.4	.37	

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS	SET	CHECK BOXES							
		02	03	04	05	06	07	08	09
GAIN	44	/							
SCAN GAIN	52	/							
SWEEP	2.5/867	/							
DELAY	757	/							
FILTER	2070	/							
REP RATE	1000	/							
DAMPENING	OFF	/							
GT	OFF	/							
OTHER	NA	/							

M. Calibration Time — Records

DATE	01 ORIG. CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
1981					
3-10	0830	NA	NA	NA	YES
3-10	NA	1205	92281	4	YES
3-10	NA	1205	92282	8	YES
3-10	NA	205	92282	6	YES

N. Reviewed By: NDE SUPERVISOR A. J. Connelly DATE 3/11/81
 O.C. SUPERVISOR ... DATE 4/2/81
 AUTHORIZED INSPECTOR ... DATE 4-6-81

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP - 5751 REV. 6

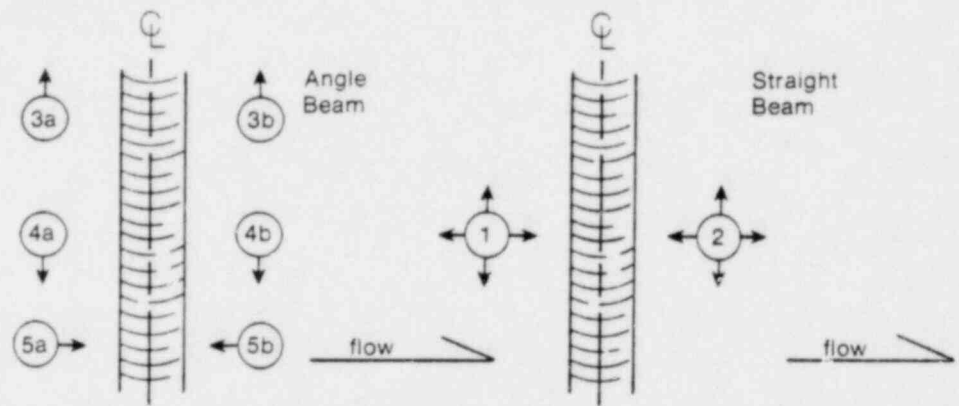
EXAMINATION PERSONNEL:
 NAME Jerry [Signature] LEVEL II; NAME [Signature] LEVEL IT

SEARCH UNIT BEAM ANGLE: 0°; 45°; X 60°; OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE	LINE NO.	EXAM I.D.	CC .1P FIG.	MAX AMP	L1/W1	Lm/Wm	L2/W2	MP1	MPm	MP2	SCAN	STAT.	COMMENTS
3-10	1	1R1-1014 7	E-P	75%		360° INT 1.3			2.3		5A	A	FDFT
3-10	2	7	E-P	70%		360° INT 2.2			3.6		5A	E	FDNS
3-10	3	7	E-P	55%		360° INT 1.2			1.05		5B	E	
3-10	4	7	E-P	80%		360° INT 1.1			2.25		5B	A	FDFT

REVIEWED BY: NDE SUPERVISOR [Signature] DATE 3/11/81
 QC SUPERVISOR [Signature] DATE 4/2/81
 AUTHORIZED INSPECTOR [Signature] DATE 4-6-81

LASALLE UNIT 2

T_P = .71

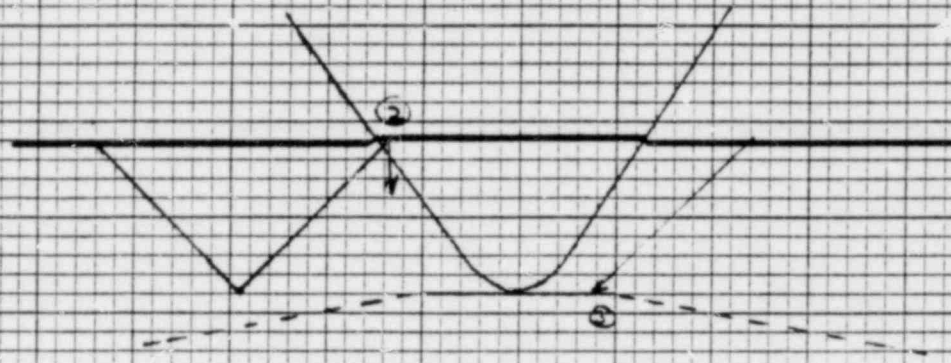
WELD IRI-1014-7

T_w = .82

EDS 92281

T_E = .81

GENERAL  ELECTRIC



LINE	EVALUATION
2	Mode conversion of d_{\perp} , weld cap
3	ID geometry

EVALUATED BY L. J. Whitley
Level III

DATE 4/2/81

REVIEWED BY W. J. Caldwell
ANI

DATE 4-6-81

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP-575-1 REV. 6

EXAMINATION PERSONNEL:
 NAME Jerry M. ... LEVEL II; NAME J. ... LEVEL IT

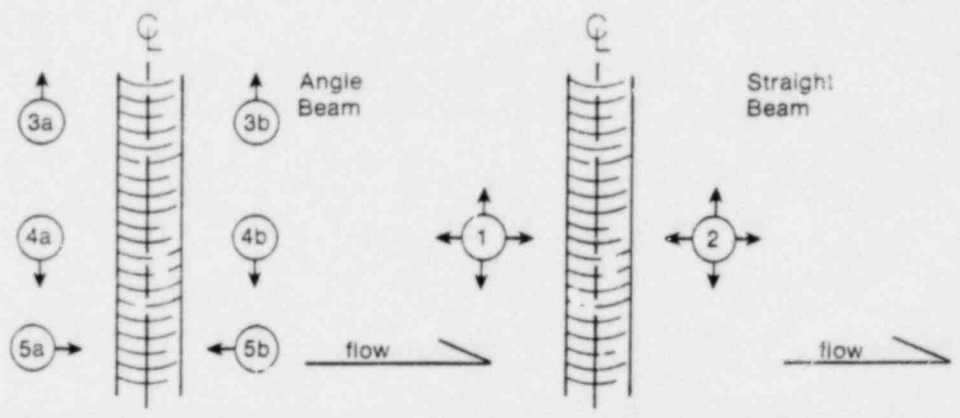
SEARCH UNIT BEAM ANGLE: 0°; 45°; X 60°; OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION

*: APPEAR SAME TIME ON CRT



1991 DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/W1	Lm/Wm	L2/W2	MP1	MPm	MP2	SCAN	STAT.	COMMENTS	
3-10	1	1A1-1015 1B	E-E	100%	360	INT	1.5		1.05		5A	E		
3-10	2	1B	E-E	100%	360	INT	1.7		2.7		5A	E	FDNS	
3-10	3	1B	E-E	90%	5.75	8.0	11.0	1.45	1.6	1.8	1.85	1.95	2.15	5A E
3-10	4	1B	E-E	90%	360	INT	1.9		2.2		5A	A	FDHT	
3-10	5	1B	E-E	60%	360	INT	2.0		2.1		5B	A	FDNT	
3-10	6	1B	E-E	75%	360	INT	1.4		2.65		5B	E	FDWC *	
3-10	7	1B	E-E	50%	360	INT	1.4		2.95		5B	E	FDWC *	
3-10	8	1B	E-E	100% +2	360	INT	1.4		3.3		5B	E	FDWC *	

REVIEWED BY: SD Connelly DATE 3/11/81
 NDE SUPERVISOR _____
 QC SUPERVISOR LW Dheatley DATE 4/2/81
 AUTHORIZED INSPECTOR w g Cathell DATE 4-6-81

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP-5751 REV. 6

EXAMINATION PERSONNEL:
NAME W. J. Caldwell LEVEL IT; NAME J. E. Cray LEVEL IT

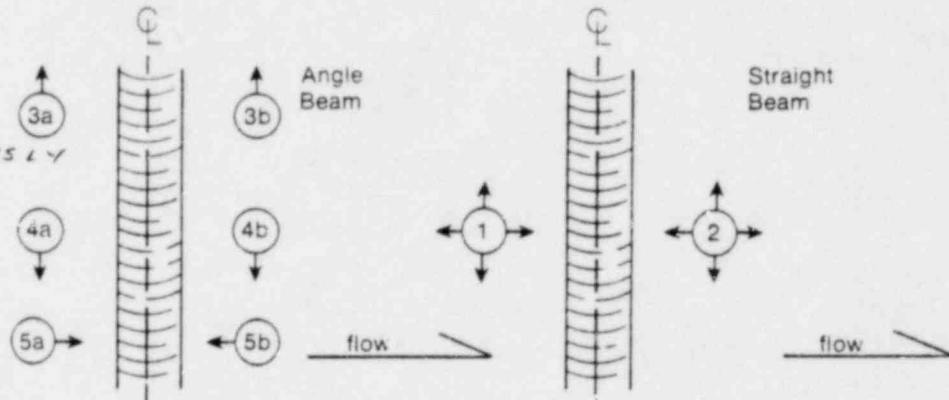
SEARCH UNIT BEAM ANGLE: 0°; 45°; X 60°; OTHER _____

COUPLANT: GLYCERINE: X ULTRAGEL II: _____ OTHER _____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION


*-INDICATIONS
APPEAR SIMULTANEOUSLY
ON CRT SCREEN

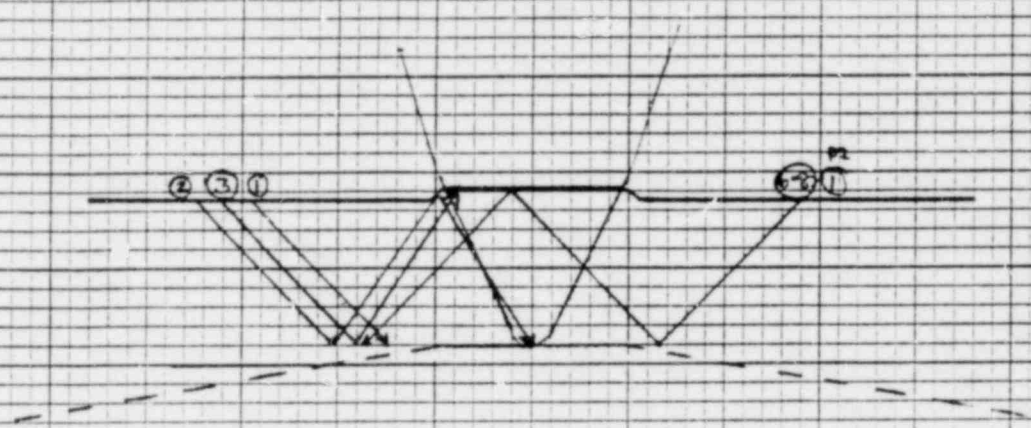


1981 DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L1/W1	Lm/Wm	L2/W2	MP1	MPm	MP2	SCAN	STAT.	COMMENTS
3-10	1	1R1-1015 1B	E-E	100% +2	360	INT	1.4		3.5		5B	E	FDWC *
3-10	2	1R1-1014 4	P-E	90%	360	INT	1.1		2.1		5A	A	FDFT
3-10	3	4	P-E	65%	360	INT	1.0		2.05		5B	A	FDFT
3-10	4	4	P-E	75%	360	INT	1.4		2.45		5B	E	FDWC *
3-10	5	4	P-E	75%	360	INT	1.4		2.7		5B	E	FDWC *
3-10	6	4	P-E	80%	360	INT	1.4		1.0		5B	E	

REVIEWED BY: NDE SUPERVISOR SD Counsel DATE 3/11/81
QC SUPERVISOR LD Wheatley DATE 4/2/81
AUTHORIZED INSPECTOR W J Caldwell DATE 4-6-81

LASALLE UNIT 1 $T_E = .74$
 WELD IRI-1015-1B $T_W = ~~98~~ .83$
 EDS 92282 $T_E = .76$

GENERAL  ELECTRIC



LINE	EVALUATION
1, 6-8, 1 ^{P2}	ID geometry & mode conversion from counterbore
2	ID geometry from weld root
3	OD geometry from weld cap

EVALUATED BY W J Wheatley DATE 4/2/81
 Level III

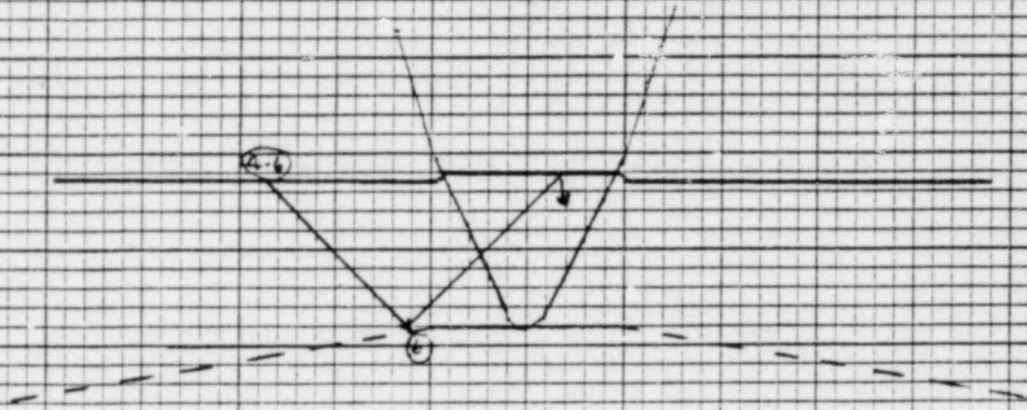
REVIEWED BY W J Caldwell DATE 4-6-81
 ANII

LASALLE UNIT 2 $T_p = \underline{.73}$

WELD IRI-1014-4 $T_w = \underline{.78}$

EDS 92282 $T_e = \underline{.79}$

GENERAL  ELECTRIC



LINE	EVALUATION
6	ID geometry off counterbore
4,5	Made conversion from weld cap

EVALUATED BY L D Wheatley
Level III

DATE 4/2/81

REVIEWED BY w J Caldwell
ANTI

DATE 4-6-81

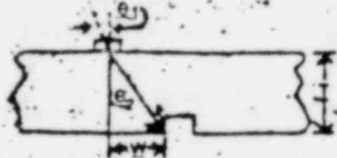
INSTALLATION & SERVICE ENGINEERING DIVISION

A. Procedure No. MPUP-5751 REV. 4

Examination Personnel: NAME John P. ... LEVEL II NAME J. Blonnelly LEVEL IT

Instrument: SERIAL NO. 736 MAKE/MODEL: - BRANSON/3003: SONIC/MK I; KX/USL32; OTHER 425733

D. Search Unit: BEAM ANGLE/MODE: STRAIGHT BEAM/LONG WAVE; 45°/TRANS WAVE; 60°/TRANS WAVE
 TRANSDUCER SIZE/FREQ: 0.25" DIA/2.25 MHz; 0.5" DIA/2.25 MHz; 1.0" DIA/2.25 MHz
 SERIAL NO.: H25733; 1.0" DIA/2.25 MHz; 0.5"x0.5"/2.25 MHz
 TRANSDUCER TYPE: CERAMIC SINGLE ELEMENT; CERAMIC DUAL ELEMENT; OTHER
 WEDGE TYPE: STANDARD WEDGE; SPECIAL WEDGE/TYPE
 CALCULATED BEAM ANGLE IN MATERIAL: $\theta_2 = \frac{W}{T}$



$\theta = \text{ARC TAN} \left(\frac{W}{T} \right)$
 T = CAL STD. THICKNESS

E. Cable: LENGTH: 6 FT. TYPE: RG-58; RG-59; RG-57; RG-174; OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: PARALLEL; TRANSVERSE TO PIPE AXIS
 FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE PARALLEL; TRANSVERSE to hole centerline

G. Calibration Standard: LSCS CAL STD. NO. 91-26-01 THICKNESS 1.25 DIAMETER 26
 MATERIAL: CARBON; STAINLESS; INCONEL; OTHER

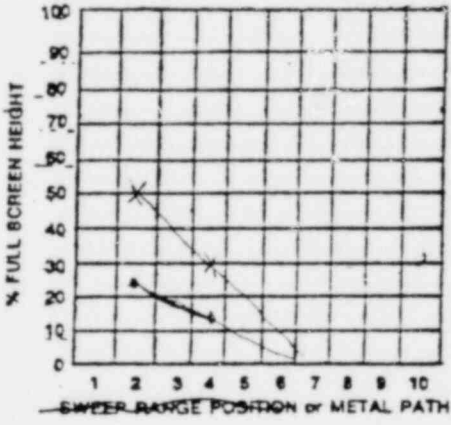
H. Couplant: GLYCERINE; ULTRAGEL II; OTHER

I. Comments: _____

J. Dac Curve — Data SRP; MP in-inches

CTDR	PEAK AMP	W1	Wm	W2	SRP or 1 MP1	SRP or m MPm	SRP or 2 MPz	HOLE DEPTH
01	02	03	04	05	06	07	08	09
WT or 1/8 Vee	50					250		250
WT or 1/8 Vee								
WT or 1/8 Vee	30					880		880
B.P. or 1/8 Vee	95					1.25		1.25

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS	SET	CHECK BOXES							
		02	03	04	05	06	07	08	09
GAIN	32	✓							
SCAN GAIN	40	✓							
SWEEP	25/46	✓							
DELAY	7.59	✓							
FILTER	Auto	✓							
REP RATE	Med	✓							
DAMPENING	OFF	✓							
CT	OFF	✓							
LR	N/A	✓							

M. Calibration Time — Records

DATE	01 ORIG. CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
1979					
6-15	1230	N/A	N/A	N/A	YES
6-15	N/A	1430	94125	2	YES

N. Reviewed By: NDE SUPERVISOR J. Blonnelly DATE 6/8/79
 Q.C. SUPERVISOR R. W. ... DATE 6/15/79
 AUTHORIZED INSPECTOR W. S. ... DATE 3-26-81

EDS# 94125

CDS# 94124

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

A. PROCEDURE NO. MPUPS751 REV. 4

B. EXAMINATION PERSONNEL:
NAME Tom Cully LEVEL II; NAME J. Connelly LEVEL IT

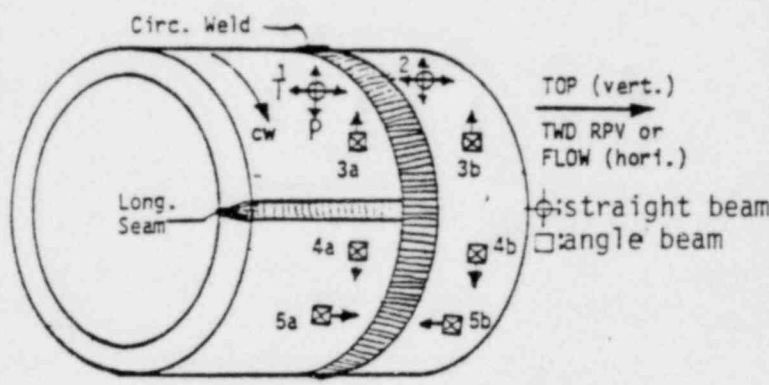
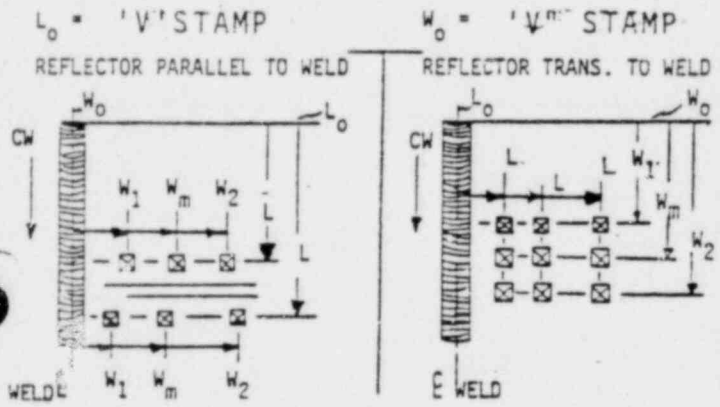
C. SEARCH UNIT BEAM ANGLE: 0°; 45°; 60°; OTHER _____

D. COUPLANT: GLYCERINE; ULTRAGEL II; OTHER _____

E. SCAN SENSITIVITY: (+) 8 dB

F. REFERENCE SYSTEM (CIRC. WELD)

G. SCAN ORIENTATION



H. DATA

DATE	LINE NO.	EXAM/COMP. I.D. NO.	COMP FIG.	REC. IND. YES/NO	MAX % DAC @ W _m	L ₀ / W ₀	L	W ₁	W _m	W ₂	SRP ₁ or MP ₁	SRP _m or MP _m	SRE ₂ or MP ₂	SCAN	Comments (Thickness Meas.)
6/5/79	1	IMS 1053 ALU	LS	YES	100% -4dB	0	0.76	5.5	5.7	6"	.70	.70	.70	1	P = 1.25 W = 1.35
6/5/79	2	IMS 1053 ALU	LS				O POINT TAKEN FROM JCT @ 1A & 1AL								
	3														
	4														
	5														
	6														
	7														

Line 1 See INCR-82

REVIEWED BY: NDE SUPERVISOR J. Connelly DATE 6/18/79

QC SUPERVISOR L. J. Whelan DATE 6/18/79

AUTHORIZED INSPECTOR W. J. Connelly DATE 3-26-81

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT I

E.D.S. NO. 96,000A

A. Procedure No. PP-S751 REV. 5

Examination Personnel:

NAME Mr. Mickelberg LEVEL II
 NAME _____ LEVEL _____

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 78D056

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO Temp. _____

2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO Temp. _____

b. SURFACE PREPARATION:

*1. Grinding *2. Flapping *3. None *4. Other _____

E. Data: Note: All Exam. Components are ASME Section XI Category B1

LINE NO.	DATE	PRE-CLEAN EVAP. TIME (MIN)	PEN. DWELL TIME (MIN)	PEN. REM. EVAP. TIME (MIN)	DEV. TIME (MIN)	EXAMINATION COMPONENT I.D. NO.	MAT'L	SURF. PREP.	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION LOCATION / SIZE OR COMMENTS
									YES	NO	YES	NO	
00	01	02	03	04	05	06	07	08	09	10	11	12	13
1	5/24/79	5	20	5	15	IFW 1001-65	C/S	2		✓	✓		SEE NOTE 1
2													
3													
4													
5													
6													
7													
8													
9	NOTE 1 - 0-11.5 AND 29-41.5 CW WERE NOT EXAMINED DUE TO PIPE SUPPORT RESTRICTION.												
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO. place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By: _____

NDE SUPERVISOR [Signature] DATE 5-29-79

QC SUPERVISOR [Signature] DATE 5/30/79

AUTHORIZED INSPECTOR [Signature] DATE 3-26-81

Procedure No. PP 5751 REV. 5

Examination Personnel:

NAME M.D. Neukirch LEVEL II
 NAME _____ LEVEL _____

C. Penetrant Materials:

a. MANUFACTURER: MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 78D056
 f. POST EXAMINATION CLEAKER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:
 1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO Temp. _____
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO Temp. _____

b. SURFACE PREPARATION:

*1. Grinding *2. Flapping *3. None *4. Other _____

E. Data: Note: All Exam. Components are ASME Section XI Category BJ

LINE NO.	DATE	PRE-CLEAN EVAP. TIME (MIN)	PEN. DWELL TIME (MIN)	PEN. REM. EVAP. TIME (MIN)	DEV. TIME (MIN)	EXAMINATION COMPONENT I.D. NO.	MATL.	SURF. PREP.	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES	NO	YES	NO	
00	01	02	03	04	05	06	07	08	09	10	11	12	13
1	7-25-79	5	30	5	15	I-MS-1002-4UD	CS	2		X	X		SEE NOTE 1
2													SEE NOTE 2
3													
4													
5													
6													
7													
8													
9													
10	NOTE 1 - TWO INDICATIONS REPORTED ON EDS 50003 WERE FLAPPED PRIOR TO PENETRANT EXAMINATION.												
11	AREAS WERE CHECKED FOR MINIMUM WALL THICKNESS												
12													
13													
14	NOTE 2:	See "T" EDS 96003 for thickness measurement. JXB 7/23/80											

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By: R. Hooper DATE 5-29-79
 NDE SUPERVISOR _____ DATE 5/30/79
 QC SUPERVISOR S. Caldwell DATE 3-26-81
 AUTHORIZED INSPECTOR _____

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT I

E.D.S. NO. 96004

Procedure No. PP-S751 REV. 5

Examination Personnel:

NAME Micklenberg LEVEL II
 NAME _____ LEVEL _____

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 78D056
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:
 1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO Temp. _____
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO Temp. _____

b. SURFACE PREPARATION:

*1. Grinding *2. Flapping *3. None *4. Other _____

E. Date: Note: All Exam. Components are ASME Section XI B-5 Category

LINE NO.	DATE	PRE-CLEAN EVAP. TIME (MIN)	PEN. DWELL TIME (MIN)	PEN. REM. EVAP. TIME (MIN)	DEV. TIME (MIN)	EXAMINATION COMPONENT I.D. NO.	MAT'L	SURF. PREP.	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES	NO	YES	NO	
00	01	02	03	04	05	06	07	08	09	10	11	12	13
1	5/29/79	5	25	5	15	IRR 1003-2	S/S	2		✓	✓		SEE NOTE 1
2													
3													
4													
5													
6													
7													
8													
9	NOTE: INDICATION REPORTED EDS 30012 OF 8-14-78 REMOVED BY FLAPPING AND AREA OF INTEREST RETESTED.												
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By: RC. Hagan DATE 5-29-79
 NDE SUPERVISOR _____ DATE _____
 QC SUPERVISOR Salahuddin DATE 5/30/79
 AUTHORIZED INSPECTOR W J Caldwell DATE 3-26-81

A. PROCEDURE NO. PP-5751 REV. 5

EXAMINATION PERSONNEL:

NAME Robert Austin LEVEL II
 NAME John Cutright LEVEL II

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF / CM-S BATCH NO. 78E073
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 79E033
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO

b. SURFACE PREPARATION:

*1. GRINDING *2. FLAPPING *3. NONE *4. OTHER _____

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. C-F

01 IN- NO	02 DATE	03 PRE- CLEAN EVAP. TIME	04 PEN. DWELL TIME	05 PEN. REM. EVAP. TIME	06 DEV. TIME	07 EXAMINATION COMPONENT I.D. NO. <i>etc</i>	08 MAT'L	09 SURF. PREP. *	10 RELEVANT INDICATION		11 ACCEPTABLE		12 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES 09	NO 10	YES 11	NO 12	
1	10-25-79	5	15	5	20	IRH-1023	C/S	2	NO	YES			
2	10-25-79	5	15	5	20	IRH-1024	C/S	2	NO	YES			
3	10-25-79	5	15	5	20	IRH-1047	C/S	2	NO	YES			
4	10-25-79	5	15	5	20	IRH-1047	C/S	2	NO	YES			
5	10-25-79	5	15	5	20	IRH-1047	C/S	2	NO	YES			
6	10-25-79	5	15	5	20	IRH-1047	C/S	2	NO	YES			
7													
8						* Data on line 1, voided per MCCA MRD		540	6343	540	6379		
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(S) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR SD Connelly DATE 10/29/79
 QC SUPERVISOR LW Wheatley DATE 11/6/79
 AUTHORIZED INSPECTOR W. J. Caldwell DATE 11-7-79

GENERAL  ELECTRIC

INSTALLATION AND
SERVICE ENGINEERING
DIVISION

GENERAL ELECTRIC COMPANY, 814 COMMERCE DR., OAK BROOK, ILL. 60521

April 17, 1981

Mr. George R. Crane
Station Nuclear Engineering Department
Commonwealth Edison Company
1 First National Plaza
P. O. Box 767
Chicago, Illinois 60690

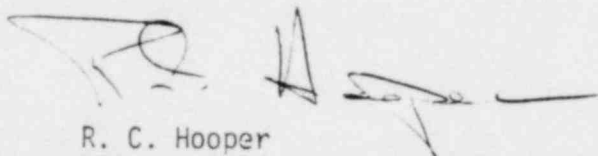
SUBJECT: LaSalle Unit 1 PSI Report Update
April 17, 1981

Dear Mr. Crane:

The update package is issued in the form of replacement pages. Revisions, additions or deletions are incorporated directly into the affected pages. Attached is a table containing the necessary changes.

If you have any questions, please do not hesitate to call or write.

Sincerely yours,



R. C. Hooper
NDE Specialist - Technical Support
Central Nuclear Plant Services

RCH:ck
attachment

INSTALLATION & SERVICE ENGINEERING DIVISION

TABLE OF CONTENTS

LSCS Unit 1 - PSI Report

April 17, 1981

Update Package

<u>Section</u>	<u>Volume</u>	<u>Description</u>
5.2	3	Calibration Transfer Data Sheet
9.0	4	Relief Request Tab Index RI-03, Page 1, Rev. 1 RI-07, Page 1, Rev. 1 RI-09, Page 1, Rev. 1
10.1	4	Format Legend and Notes, Pages 1 thru 4
10.2.1	4	1 - Internals, Page 1, Rev. 1 1 - NIR, Page 1, Rev. 1 1 - NIR, Page 2, Rev. 1 1 - NIR, Page 3, Rev. 1 1 - NIR, Page 4, Rev. 3 1 - NIR, Page 5, Rev. 3
10.3	4	Pump Tab Index
10.4.2	4	IHP-1001B, Page 1, Rev. 1
10.4.4	4	ILP-1001B, Page 1, Rev. 1 ILP-1011, Page 1, Rev. 1
10.4.5	4	IMS-1002B, Page 1, Rev. 1 IMS-1002B, Page 2, Rev. 1 IMS-1003B, Page 1, Rev. 1 IMS-1003B, Page 2, Rev. 1 IMS-1051B, Page 1, Rev. 2 IMS-1052B, Page 1, Rev. 2 IMS-1053B, Page 1, Rev. 2 IMS-1054B, Page 1, Rev. 2 IMS-1055B, Page 1, Rev. 1
10.4.8	4	IRH-1001, Page 1, Rev. 4 IRH-1001B, Page 1, Rev. 2 IRH-1002B, Page 1, Rev. 1 IRH-1003B, Page 1, Rev. 1 IRH-1004B, Page 1, Rev. 1 IRH-1005B, Page 1, Rev. 1 IRH-1013, Page 2, Rev. 1

INSTALLATION & SERVICE ENGINEERING DIVISION

April 17, 1981

<u>Section</u>	<u>Volume</u>	<u>Description</u>
10.4.8	5	IRH-1024B, Page 1, Rev. 0 IRH-1031B, Page 1, Rev. 1 IRH-1045, Page 1, Rev. 2 IRH-1047, Page 1, Rev. 1
10.4.9	5	IRI-1001B, Page 1, Rev. 1 IRI-1003B, Page 1, Rev. 1 IRI-1004, Page 3, Rev. 0 IRI-1004, Page 4, Rev. 1 IRI-1005, Page 1, Rev. 0 IRI-1013, Page 1, Rev. 2 IRI-1016, Page 1, Rev. 1 IRI-1018, Page 1, Rev. 1 IRI-1019, Page 2, Rev. 0 IRI-1020, Page 1, Rev. 2 IRI-1022, Page 1, Rev. 2 IRR-1009B, Page 1, Rev. 1 IRR-1010B, Page 1, Rev. 1 IRT-1001, Page 2, Rev. 1 IRT-1001, Page 3, Rev. 1
11.3	5	Nonconformity Report INCR-94 Nonconformity Report INCR-95 Nonconformity Report INCR-98 Nonconformity Report INCR-99 Nonconformity Report INCR-103 Nonconformity Report INCR-104 Nonconformity Report INCR-105
12.1.1	6	Data Sheets 16,000 thru 16,033 Data Sheets 73,005 thru 73,014 PSI Ref. No. RPV-3 PSI Ref. No. RPV-4, Pages 1 thru 4 PSI Ref. No. RPV-8, Pages 1 thru 55 PSI Ref. No. RPV-9, Pages 1 thru 6 PSI Ref. No. RPV-10, Pages 1 and 2
12.2	7	Piping, Pump and Valve Components Tab Index Pages 6 and 7
12.2.1		Examination Data Sheet No. 77596

INSTALLATION & SERVICE ENGINEERING DIVISION

April 17, 1981

<u>Section</u>	<u>Volume</u>	<u>Description</u>
12.2.6	12	PSI Ref. No. RH-2 PSI Ref. No. RI-1 PSI Ref. No. RI-2 PSI Ref. No. RI-3 PSI Ref. No. RI-4 PSI Ref. No. RI-5 PSI Ref. No. RI-6

CALIBRATION TRANSFER DATA - ZONE 1
FROM A 3/4 INCH DEEP NOTCH IN THE GE NOZZLE MOCK-UP

A dB GAIN INCREASE OF 22 HAS BEEN DETERMINED FOR THE WEDGES IDENTIFIED BY THE FOLLOWING NAME AND SERIAL NUMBERS

- LS-N5-Z1-CW & CCW
- LS-N5-Z1-CW & CCW
- 10 Scan
- 2-5-81

THESE WEDGES ARE INTENDED FOR USE ON THE _____ NOZZLES AT THE FOLLOWING REACTOR/S

- LaSalle 1
- _____
- _____

THIS DATA WAS OBTAINED USING TRANSDUCERS OF THE FOLLOWING DESCRIPTION AND APPLIES ONLY TO TRANSDUCERS OF THE SAME DESCRIPTION EXCEPTING SERIAL NUMBERS

- 1 INCHES DIAMETER • FREQUENCY 1 MHz
- MANUFACTURER KB AEROTECH • MODEL GAMMA
- SERIAL NO/S. K02612, B10716

A SIGNAL AMPLITUDE OF 80% FSH, 10% FSH, HAS BEEN OBTAINED FROM THE 3/4 INCH DEEP, ZONE 1 NOTCH IN THE GE NOZZLE MOCK-UP FOLLOWING THE ULTRASONIC SENSITIVITY CALIBRATION PROCEDURE DESCRIBED IN GE DOCUMENT

NUMBER NIRZ1-S751 REVISION 0

DATE OF CALIBRATION TRANSFER - 2 June 80

PERFORMED BY: [Signature]

*LS-N5-Z1 CW & CCW meets spec design for
 feedwater (N4) nozzles on
 Unit 1
 Steven M. Hanson
 2-30-81

FIGURE 9 CALIBRATION TRANSFER DATA FORM



9.0 RELIEF REQUESTS

<u>TAB</u>		<u>DESCRIPTION</u>
1	RI-01	ASME Category B-K-1, Support Fillet Welds
2	RI-02	ASME Category C-D, Class 2 Boltin.g
3	RI-03	ASME IWC-1220(a), Design Pressure and Temperature
4	RI-04	ASME Category B-F, B-J, C-F, C-G, Ultrasonic Sensitivity
5	RI-05	ASME Category B-J, C-F, Welds Inaccessible by Flued Heads
6	RI-06	Deleted
7	RI-07	ASME Category C-F, Saddle Welds
8	RI-08	ASME Category C-F, Underground Piping
9	RI-09	ASME Category B-D, RPV Top Head Nozzle Inner Radii
10	RI-10	ASME Category C-F, Ultrasonic Testing of Thin Wall Piping
11	RI-11	ASME Category B-J, Welds Inaccessible by Penetration Sleeves
12	RI-12	ASME Category C-F, Pressure Retaining Fillet Welds
13	RI-13	ASME Category B-M-2, Internal Surfaces of Pumps
14	RI-14	ASME Category B-M-2, Internal Surfaces of Valves
15	RI-15	ASME Category B-B, RPV Welds Inaccessible by CRD
16	RI-16	ASME Category B-J, C-F, Welds Inaccessible by Supports
17	RI-17	ASME Category C-F, Inaccessible Pump Welds
18	RI-18	ASME Category C-F, Welds Inaccessible by Penetration Seal



RELIEF REQUEST 00	SYSTEM OR COMPONENT 01	CLASS 02	CATEGORY AND JTEM NUMBER 03	EXEMPTED COMPONENT 04	SECTION XI TEST REQUIREMENT 05	BASIS FOR RELIEF 06	ALTERNATIVE TEST 07
RI-03	PC	2	ALL	All pressure retaining and support components.	IWC-1220 (a) Exempt components in systems where both the maximum design pressure and temperature are equal to or less than 275 Psig and 200° respectively.	Maximum design pressure and temperature conditions are much higher than actual conditions - which the components will see.	Exempt components in systems where both the maximum Operating Pressure and Temperature are equal to or less than 275 Psig and 200° F respectively.

GE-13



RELIEF REQUEST 00	SYSTEM OR COMPONENT 01	CLASS 02	CATEGORY AND ITEM NUMBER 03	EXEMPTED COMPONENT 04	SECTION XI TEST REQUIREMENT 05	BASIS FOR RELIEF 06	ALTERNATIVE TEST 07
RI-07	MS	2	C-F C2.3	Branch Pipe connection welds.	Volumetric	8 of the branch pipe connections on carbon steel piping are constructed with reinforcement saddles. These saddles are fillet welded over the actual branch pipe connection weld. (See Sketch attached). A volumetric examination consisting of a radiograph was performed on the actual branch pipe connection weld during fabrication. The fabrication documents are available on site for audit. A meaningful volumetric examination cannot be done on either the branch connection weld or the two saddle welds.	Surface examination of the two Saddle welds.

GE-118



RELIEF REQUESTS FOR COMPONENTS AND PIPING

RELIEF REQUEST 00	SYSTEM OR COMPONENT 01	CLASS 02	CATEGORY AND ITEM NUMBER 03	EXEMPTED COMPONENT 04	SECTION XI TEST REQUIREMENT 05	BASIS FOR RELIEF 06	ALTERNATIVE TEST 07
RI-09	N7-Head Spray Nozzle Inner Radius N8-Vent Nozzle Inner Radius N18-Spare Nozzle Inner Radius	1	B-D B1.4	N7 NIR N8 NIR N18 NIR	Volumetric examination of the nozzle inner radius is required.	An ultrasonic examination of the nozzle inner radius (NIR) was performed during the informational baseline at the vessel manufacturer. The UT exam data is available on site for audit. During refueling activities the RPV Closure Head is removed allowing access to the RPV Closure Head NIR. A surface examination is more sensitive in detecting surface defects at the NIR. Vessel Manufacturer: Unit 1-Combustion Engineering. Unit 2-CBI Nuclear	Surface Examination.

CE-118

10.1 FORMAT LEGEND AND NOTES CONT'd

<u>FIELD</u>	<u>DESCRIPTION</u>
12 QC REVIEW SIGNATURE/DATE	Quality Control Supervisor's Audit of Data, Signature of Inspection being complete, accepted and date signed.
13 AI INIT./DATE	Authorized Nuclear Inservice Inspector's initials and date of Data Review.

10.1 FORMAT LEGEND AND NOTES

<u>FIELD</u>	<u>DESCRIPTION</u>
00 SIZE	Nominal size in inches.
01 EXAM COMP. ID. NO.	Examination component identification number used to identify the component for examination. For bolting components, the "Dwg. No." refers to the ISI Bolting Detail Drawing.
02 DWG. REV. NO.	The Inspection Checklist Drawing Revision Number.
03 ASME CAT.	ASME Section XI Inspection Category as described by Tables IWB-2500 and IWC-2520 for ASME Class 1 and 2 components respectively.
04 COMP. FIG.	Component Figuration eg. P-E= pipe to elbow weld. See Note 1 for abbreviation listing.
05 PROCEDURE NO.	Nondestructive examination procedure used to perform the inspections eg. 1 = MPUP-S751. See Note 2 for inspection checklist procedure correlation.
06 REV. NO.	Nondestructive examination procedure revision number.
07 EXAM TYPE	Examination type that is used to inspect the component. UT-00 = Ultrasonic testing using a 0° straight beam technique. UT-450 = Ultrasonic testing using a 45° shear wave technique. UT-600 = Ultrasonic testing using a 60° shear wave technique. PT = Liquid penetrant technique. VT = Visual testing technique. MT = Magnetic particle technique. Z1CW/CCW = Ultrasonic testing of NIR Zone 1 using GE 3 Zone technique. Z2CW/CCW = Ultrasonic testing of NIR Zone 2 using GE 3 Zone technique. (CW-clockwise, CCW-counter-clockwise).
08 EDS NO.	Examination Data Sheet Number on which the specific examination is documented.
09 CDS NO.	Ultrasonic testing (UT) Calibration Data Sheet used to perform the specific examination.
10 LSCS CAL. STD. NO.	LaSalle County Station Ultrasonic Calibration Standard used to effect the UT calibration.
11 LDS NO.	Ultrasonic testing linearity data sheet number on which the particular UT instrument's screen height and amplitude linearity checks are documented.

10.1 Format Legend and Notes
Note 1COMPONENT FIGURATION ABBREVIATIONS
LSCS PSI

BH--Bottom Head
C--Cap
CHC--Closure Head Cladding
CR--Cross
E--Elbow
EX--Safe End Extension
F--Flange
FB--Flange Bolting
FL--Flange Ligament
H--Reactor Pressure Vessel Top Head
HD--Head (RHR Heat Exchanger or Pump)
IALS--Inside Arc Longitudinal Seam
IS--Instrumentation Seal
LS--Longitudinal Seam
N--Nozzle
NIR--Nozzle Inner Radius
OALS--Outside Arc Longitudinal Seam
P--Pipe
PB--Pump Bolting
PC--Pump Casing
PH--Penetration Head
PL--Plate
PU--Pump
PULS--Pump Longitudinal Seam
R--Reducer
RH--Rams Head
RHLS--Rams Head Longitudinal Seam
RPV--Reactor Pressure Vessel
S--Saddle
SE--Safe End
SH--Shell
SK--Reactor Pressure Vessel Skirt
SP--Spindle
ST--Stanchion
SUP--Support
SW--Sweepolet
T--Tee
TVH--Reactor Pressure Vessel Top Head
V--Valve
VB--Valve Bolting
VHLS--Reactor Pressure Vessel Top Head Longitudinal Seam
W--Weldolet

10.1 Format Legend and Notes
Note 2

INSPECTION CHECKLIST PROCEDURE CORRELATION

<u>IC Procedure No.</u>	<u>NDE Procedure</u>
1	MPUP-S751
2	PP-S751
3	MPUD-S751
4	PV1-S751
5	PV3-S751
6	MPURHX-S751
7	MPUV-S751
8	APUN-S751
9	APUV-S751
10	MPUSK-S751
11	MPUL-S751
12	NDT-C-14-L
13	NIRZ1-S751
14	MPSU1-S751
15	TP-508-0654
16	NIRZ2-S751

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. 1-Internals REV. 1

PAGE 1 of 4

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whalley DATE 12/9/80

SIZE	EXAM COMP ID NO	DMG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	01 1-Surveillance Sample Baskets	N/A	B-N-2	N/A	4	2	VT	84503A	N/A	N/A	N/A	<i>L.D. Whalley</i> 12/9/80	<i>WJC</i> 12-9-80
N/A	1-Core Plate Hold Down Bolts	N/A	B-N-1	N/A	5	2	VT	84003	N/A	N/A	N/A	<i>L.D. Whalley</i> 12/9/80	<i>WJC</i> 12-9-80
N/A	1-Steam Separator	N/A	B-N-1	N/A	5	2	VT		N/A	N/A	N/A		
N/A	1-Steam Dryer	N/A	B-N-1	N/A	5	2	VT		N/A	N/A	N/A		
N/A	1-Core Delta P and SBLC Piping Welds	N/A	B-N-1	N/A	5	2	VT		N/A	N/A	N/A	See PSI Ref. No. RPV-9	<i>WJC</i> 3-13-81
N/A	1-Shroud Support Welds	N/A	B-N-2	N/A	4	2	VT		N/A	N/A	N/A	See PSI Ref. No. RPV-10	<i>WJC</i> 3-13-81
N/A	1-Incore Housing to Incore Guide Tube Welds	N/A	B-N-2	N/A	4	2	VT		N/A	N/A	N/A	See PSI Ref. No. RPV-8	<i>WJC</i> 3-13-81

INSPECTION CHECKLIST

ASALLE COUNTY STATION UNIT 1

IC NO. 1-NIR REV. 1

PAGE 1 of 7

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L. D. Wheatley DATE 1/13/81

SIZE	EXAM. COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-1A	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	45528 45528 16013 16013	45527 45527 16012 16012	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	L. D. Wheatley 2/25/81	wjc 2-25-81
N/A	1-NIR-1B	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99016 45518 16014 16014	99015 45517 16012 16012	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	L. D. Wheatley 2/25/81	wjc 2-25-81
N/A	1-NIR-2A	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99025 99025 16006 16006	99024 99024 16001 16001	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	L. D. Wheatley 2/25/81	wjc 2-25-81
N/A	1-NIR-2B	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99005 45508 16005 16005	99004 45507 16001 16001	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	L. D. Wheatley 2/25/81	wjc 2-25-81
N/A	1-NIR-2C	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99006 45509 16004 16005	99004 45507 16001 16001	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	L. D. Wheatley 2/25/81	wjc 2-25-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. 1-NIR REV. 1

PAGE 2 of 7

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L. W. Wheatley DATE 1/13/81

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	O.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-2D	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99007 45510 16003 16003	99004 45507 16001 16001	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	<u>L. W. Wheatley</u> 2/25/81	<u>wjc</u> 2-25-81
N/A	1-NIR-2E	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99008 45511 16002 16002	99004 45507 16001 16001	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	<u>L. W. Wheatley</u> 2/25/81	<u>wjc</u> 2-25-81
N/A	1-NIR-2F	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99009 45512 16011 16011	99004 45507 16001 16001	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	<u>L. W. Wheatley</u> 2/25/81	<u>wjc</u> 2-25-81
N/A	1-NIR-2G	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99010 45513 16010 16010	99004 45507 16001 16001	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	<u>L. W. Wheatley</u> 2/25/81	<u>wjc</u> 2-25-81
N/A	1-NIR-2H	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99011 45514 16009 16009	99004 45507 16001 16001	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	<u>L. W. Wheatley</u> 2/25/81	<u>wjc</u> 2-25-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. 1-NIR REV. 1

PAGE 3 of 7

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whalley DATE 1/12/81

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-2J	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99013 45515 16008 16008	99004 45507 16001 16001	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	L.D. Whalley 2/25/81	w J. Caldwell 2-25-81
N/A	1-NIR-2K	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99014 45516 16007 16007	99004 45507 16001 16001	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	L.D. Whalley 2/25/81	w J.C. 2-25-81
N/A	1-NIR-3A	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99026 45523 73009 73009	99019 45522 73008 73008	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	L.D. Whalley 2/25/81	w J.C. 2-25-81
N/A	1-NIR-3B	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99021 45524 73010 73010	99019 45522 73008 73008	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	L.D. Whalley 2/25/81	w J.C. 2-25-81
N/A	1-NIR-3C	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99022 45525 73011 73011	99019 45522 73008 73008	MP-1 MP-1 MP-1 MP-1	NA NA NA NA	L.D. Whalley 2/25/81	w J.C. 2-25-81

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. 1-NIR REV. 3

PAGE 4 of 7

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L. D. Wheatley DATE 2/4/81

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-3D	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99023 45526 73012 73012	99019 45522 73008 73008	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	L. D. Wheatley 2/25/81	w g Caldwell 2-25-81
N/A	1-NIR-4A (30°)	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	16023 16023 16024 16024	16021 16021 16022 16022	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	L. D. Wheatley 2/25/81 Also done by CEC See PSI Ref Nos RPV-5,6	w g c 2-25-81
N/A	1-NIR-4B (90°)	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	16024 16024 16030 16030	16021 16021 16022 16022	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	L. D. Wheatley 2/25/81 Also done by CEC See PSI Ref Nos RPV-5,6	w g c 2-25-81
N/A	1-NIR-4C (150°)	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	16025 16025 16031 16031	16021 16021 16022 16022	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	L. D. Wheatley 2/25/81 Also done by CEC See PSI Ref Nos RPV-5,6	w g c 2-25-81
N/A	1-NIR-4D (210°)	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	16026 16026 16032 16032	16021 16021 16022 16022	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	L. D. Wheatley 2/25/81 Also done by CEC See PSI Ref Nos RPV-5,6	w g c 2-25-81

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. 1-NIR REV. 3

PAGE 5 of 7

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L D Wheatley DATE 2/4/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	EDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-4E (2700)	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	16027 16027 16033 16033	16021 16021 16022 16022	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	L D Wheatley 2/25/81 Also done by CECO See PSI Ref Nos RPV-5,6	w j Caldwell 2-25-81
N/A	1-NIR-4F (3300)	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	16028 16028 73014 73014	16021 16021 73013 73013	MP-1 MP-1 MP-1 MP-1	N/A N/A 73013 73013	L D Wheatley 2/25/81 Also done by CECO See PSI Ref Nos RPV-5,6	w j C 2-25-81
N/A	1-NIR-5	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	99002 45501 73006 73006	99000 45500 73005 73005	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	L D Wheatley 2/25/81	w j C 2-25-81
N/A	1-NIR-6A	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	45505 45505 16018 16018	45504 45504 16017 16017	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	L D Wheatley 2/25/81	w j C 2-25-81
N/A	1-NIR-6B	0	B-D	NIR	13 13 16 16	0 0 0 0	Z1CW Z1CCW Z2CW Z2CCW	45506 45506 16019 16019	45504 45504 16017 16017	MP-1 MP-1 MP-1 MP-1	N/A N/A N/A N/A	L D Wheatley 2/25/81	w j C 2-25-81

INSTALLATION & SERVICE ENGINEERING DIVISION

10.3 PUMPS

	<u>DESCRIPTION</u>	<u>TAB</u>	<u>INSPECTION CHECKLIST</u>
10.3.1	HP - High Pressure Core Spray Pump	1	IHP-PU
10.3.2	LP - Low Pressure Core Spray	2	ILP-PU
10.3.3	RH - Residual Heat Removal Pumps	3 4 5	IRH-PU1A IRH-PU1B IRH-PU1C
10.3.4	RI - Reactor Core Isolation Cooling Pump	6	IRI-PU
10.3.5	RR - Reactor Recirculation Pumps	7 8	IRR-PU1A IRR-PU1B

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. IHP-1001B REV. 1

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L. D. Wheatley DATE 12/4/80

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS. NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
7/8" Head (12)	1E22-F004 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L. D. Wheatley 2/5/81	w J Caldwell 2-18-81
1/2" (4)	1E22-F005-1 (See Dwg. 6, Part 19A.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L. D. Wheatley 2/5/81	w J C 2-18-81
3/4" (8)	1E22-F005-2 (See Dwg. 6, Part 19.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L. D. Wheatley 2/5/81	w J C 2-18-81
1-1/8" Head (8)	1E22-F005-3 (See Dwg. 6, Part 15.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L. D. Wheatley 2/5/81	w J C 2-18-81
1 1/2" (20)	1E22-F038 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L. D. Wheatley 2/5/81	w J C 2-18-81

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. IIP-1001B REV. 1

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whately DATE 12/15/80

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
7/8" Head (12)	1E21-FO05 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L.D. Whately 2/5/81	w g Calhoun 2-18-81
1/2" (4)	1E21-FO06-1 (See Dwg. 6, Part 19A.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L.D. Whately 2/5/81	w g c 2-18-81
3/4" (8)	1E21-FO06-2 (See Dwg. 6, Part 19.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L.D. Whately 2/5/81	w g c 2-18-81
1-1/8" (8)	1E21-FO06-3 (See Dwg. 6, Part 15.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L.D. Whately 2/5/81	w g c 2-18-81
7/8" Head (12)	1E21-FO51 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L.D. Whately 2/5/81	w g c 2-18-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. ILP-1011 REV. 1

PAGE 1 of 2

REVIEWED AND APPROVED BY:

O.C. SUPERVISOR L D Wheatley DATE 3/20/80

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS. NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
14"	ILP-1011-1	0	C-F	E-P	2 1 1	5 4 5	PT UT-0 ⁰ UT-45 ⁰	97040 7270 78159	78089 78158	01-14-01 01-14-01	0018 0024	L D Wheatley 3/21/80	w j c 3-21-80
14"	ILP-1011-2	0	C-F	P-E	2 1 1	6 4 5	PT UT-0 ⁰ UT-45 ⁰	78016 78023 78116	78022 78115	01-14-01 01-14-01	0015 0015	L D Wheatley 3/21/80	w j c 3-21-80
14"	ILP-1011-3	0	C-F	E-P	2 1 1	6 4 5	PT UT-0 ⁰ UT-45 ⁰	78016 78023 78116	78022 78115	01-14-01 01-14-01	0015 0015	L D Wheatley 3/21/80	w j c 3-21-80
14"	ILP-1011-4	0	C-F	P-E	2 1 1	5 4 5	PT UT-0 ⁰ UT-45 ⁰	78010 78023 78159	78022 78158	01-14-01 01-14-01	0015 0024	L D Wheatley 3/21/80	w j c 3-21-80
14"	ILP-1011-5	0	C-F	E-P	2 1 1	6 4 5	PT UT-0 ⁰ UT-45 ⁰	78005 78023 78116	78022 78115	01-14-01 01-14-01	0015 0015	L D Wheatley 3/21/80	w j c 3-21-80
14"	ILP-1011-6	0	C-F	P-E	2 1 1	6 4 5	PT UT-0 ⁰ UT-45 ⁰	91190 91189 78116	91188 78115	01-14-01 01-14-01	0009 0015	L D Wheatley 3/11/81 INCR-94	w j c 3-11-81
14"	ILP-1011-7	0	C-F	E-P	2 1 1	5 4 5	PT UT-0 ⁰ UT-45 ⁰	91178 91189 78116	91188 78115	01-14-01 01-14-01	0009 0015	L D Wheatley 5/30/80	w j c 7-22-80
14"	ILP-1011-8	0	C-F	P-E	2 1 1	5 4 5	PT UT-0 ⁰ UT-45 ⁰	91178 91189 78116	91188 78115	01-14-01 01-14-01	0009 0015	L D Wheatley 5/30/80	w j c 7-22-80

INSPECTION CHECKLIST
 LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1002B REV. 1

PAGE 1 of 2

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whately DATE 12/15/80

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
1" (12)	1B21-FO13D (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84507	N/A	N/A	N/A	L.D. Whately 2/15/81	wjc 2-18-81
1" (12)	1B21-FO13F (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84507	N/A	N/A	N/A	L.D. Whately 2/15/81	wjc 2-18-81
1" (12)	1B21-FO13K (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84510	N/A	N/A	N/A	L.D. Whately 2/15/81	wjc 2-18-81
1" (12)	1B21-FO13S (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84510	N/A	N/A	N/A	L.D. Whately 2/15/81	wjc 2-18-81
1" (12)	1B21-FO13M (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84507	N/A	N/A	N/A	L.D. Whately 2/15/81	wjc 2-18-81
1-3/8" (12)	IMS-1002B-15	1	B-G-2	FB	4	2	VT	84507	N/A	N/A	N/A	L.D. Whately 2/15/81	wjc 2-18-81
1-3/8" (12)	IMS-1002B-19	1	B-G-2	FB	4	2	VT	84507	N/A	N/A	N/A	L.D. Whately 2/15/81	wjc 2-18-81
1-3/8" (12)	IMS-1002B-23	1	B-G-2	FB	4	2	VT	84507	N/A	N/A	N/A	L.D. Whately 2/15/81	wjc 2-18-81

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1002B REV. 1
 PAGE 2 of 2

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Dineen DATE 12/15/81

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	I.D.S. NO.	Q.C. REVIEW SIGNATURE/DATE	AT INIT/DATE
00	01		03	04	05	06	07	08	09				
1-3/8" (12)	IMS-1002B-27	1	B-G-2	FB	4	2	VT	84507	N/A	N/A	N/A	L.D. Dineen 2/15/81	w.g. Caldwell 2-18-81
1-3/8" (12)	IMS-1002B-31	1	B-G-2	FB	4	2	VT	84507	N/A	N/A	N/A	L.D. Dineen 2/15/81	w.g. 2-18-81

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1003B REV. 1

PAGE 1 of 2

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L. D. Whalley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
1" (12)	1B21-FO13C (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84508	N/A	N/A	N/A	L. D. Whalley 2/5/81	wjc 2-18-81
1" (12)	1B21-FO13E (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84508	N/A	N/A	N/A	L. D. Whalley 2/5/81	wjc 2-18-81
1" (12)	1B21-FO13R (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84508	N/A	N/A	N/A	L. D. Whalley 2/5/81	wjc 2-18-81
1" (12)	1B21-FO13L (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84508	N/A	N/A	N/A	L. D. Whalley 2/5/81	wjc 2-18-81
1" (12)	1B21-FO13N (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84508	N/A	N/A	N/A	L. D. Whalley 2/5/81	wjc 2-18-81
1-3/8" (12)	IMS-1003B-13	1	B-G-2	FB	4	2	VT	84508	N/A	N/A	N/A	L. D. Whalley 2/5/81	wjc 2-18-81
1-3/8" (12)	IMS-1003B-17	1	B-G-2	FB	4	2	VT	84508	N/A	N/A	N/A	L. D. Whalley 2/5/81	wjc 2-18-81
1-3/8" (12)	IMS-1003B-21	1	B-G-2	FB	4	2	VT	84508	N/A	N/A	N/A	L. D. Whalley 2/5/81	wjc 2-18-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1003B REV. 1

PAGE 2 of 2

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L D Whalley

DATE 12/15/80

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01	02	03	04	05	06	07	08	09	10	11	12	13
3/8" (12)	IMS-1003B-25	1	B-C-2	FB	4	2	VT	84508	N/A	N/A	N/A	L D Whalley 2/5/81	w j C. L. L. 2-18-81
3/8" (12)	IMS-1003B-29	1	B-G-2	FB	4	2	VT	84503	N/A	N/A	N/A	L D Whalley 2/5/81	w j C. L. L. 2-18-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1051B REV. 2

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whalley DATE 12/23/80

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01	02	03	04	05	06	07	08	09	10	11	12	13
1-5/8" (24)	1B21-F022A (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L.D. Whalley 2/15/81	w J Caldwell 2-18-81
1-5/8" (24)	1B21-F028A (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L.D. Whalley 2/15/81	w J Caldwell 2-18-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1052B REV. 2

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whalley DATE 12/23/80

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01	02	03	04	05	06	07	08	09	10	11	12	13
1-5/8"	1B21-F022B (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	845H	N/A	N/A	N/A	L.D. Whalley 2/15/81	<i>w g Caldwell</i> 2-18-81
1-5/8"	1B21-F028B (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	845H	N/F.	N/A	N/A	L.D. Whalley 2/15/81	<i>w g c</i> 2-18-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1053B REV. 2

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whately DATE 12/23/80

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01	02	03	04	05	06	07	08	09	10	11	12	13
1-5/8" (24)	1B21-F022C (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L.D. Whately 2/5/81	w J Caldwell 2-18-81
1-5/8" (24)	1B21-F028C (Sec Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L.D. Whately 2/5/81	w J C 2-18-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1054B REV. 2

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whately DATE 12/23/80

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01	02	03	04	05	06	07	08	09	10	11	12	13
1-5/8" (24)	1B21-F022D (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L.D. Whately 2/15/81	wj 2-18-81
1-5/8" (24)	1B21-F028D (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L.D. Whately 2/15/81	wj 2-18-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1055B REV. 1

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whalley

DATE 12/15/86

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS. NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01	02	03	04	05	06	07	08	09	10	11	12	13
7/8" (10)	1E51-F063 (See Dwg. 1, Part 252-4.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L.D. Whalley 2/5/81	w J Calhoun 2-18-81

INSPECTION CHECKLIST
 LASALLE COUNTY STATION UNIT 1

IC NO. IRH-1001 REV. 4

PAGE 1 of 3

REVIEWED AND APPROVED BY:

O.C. SUPERVISOR L. J. Wheatley DATE 6/23/80

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01	02	03	04	05	06	07	08	09	10	11	12	13
12"	IRH-1001-1	0	C-F	P-V	1 1 2	2 2 3	UT-0 ⁰ UT-45 ⁰ PT	25002 25006 20227	25001 25004A	01-12-01 01-12-01	70165 20192	INCR-98 L. J. Wheatley 3/11/80 c.l.c. (97073)(97074)	w g c 3-27-80
12"	IRH-1001-2	0	B-J	P-V	1 1 2	2 3 3	UT-0 ⁰ UT-45 ⁰ PT	25004 25092 20228	25003 25091	01-12-03 01-12-03	70165 60099	L. J. Wheatley 6/23/80	w g Caldwell 6-23-80
12"	IRH-1001-4	0	B-K-1	P-PH	2	3	PT	20228				L. J. Wheatley 6/23/80 SEE RI-01	w g Caldwell 6-23-80
12"	IRH-1001-7	0	B-J	P-E	1 1 2	2 2 3	UT-0 ⁰ UT-45 ⁰ PT	25004 10167 (20228)	25003 10166	01-12-03 01-12-03	70165 20192	L. J. Wheatley 6/23/80 (05002)	w g Caldwell 6-23-80
12"	IRH-1001-10	0	B-J	P-E	1 1 2	2 2 3	UT-0 ⁰ UT-45 ⁰ PT	25004 10167 (20227)	25003 10166	01-12-03 01-12-03	70165 20192	L. J. Wheatley 6/23/80 (15003)	w g Caldwell 6-23-80
12"	IRH-1001-12	0	B-J	P-E	1 1 2	3 2 3	UT-0 ⁰ UT-45 ⁰ PT	25087 10183 80121	25086 10182	01-12-03 01-12-03	60099 20184	L. J. Wheatley 6/23/80	w g Caldwell 6-23-80
12"	IRH-1001-13	0	B-J	P-E	1 1 2	3 2 3	UT-0 ⁰ UT-45 ⁰ PT	25087 10184 (30040)	25086 10182	01-12-03 01-12-03	60099 20184	L. J. Wheatley 6/23/80 (45010)	w g Caldwell 6-23-80
12"	IRH-1001-14	0	B-J	P-E	1 1 2	2 3 3	UT-0 ⁰ UT-45 ⁰ PT	25038 25032 45007	25036 25051	01-12-03 01-12-03	20192 20192	L. J. Wheatley 6/23/80	w g Caldwell 6-23-80

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRH-1001B REV. 2

PAGE 1 of 1

REVIEWED AND APPROVED BY:

DATE 1/23/80

Q.C. SUPERVISOR *L.D. Whately*

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01	02	03	04	05	06	07	08	09	10	11	12	13
1/2" (6)	1E12-F050B-1 (See Dwg. 6, Part 19A)	1	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	<i>L.D. Whately 2/5/81</i>	<i>wjc 2-18-81</i>
3/4" (3)	1E12-F050B-2 (See Dwg. 6, Part 19)	1	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	<i>L.D. Whately 2/5/81</i>	<i>wjc 2-18-81</i>
1-1/8" Head (8)	1E12-F050B-3 (See Dwg. 6, Part 15)	1	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	<i>L.D. Whately 2/5/81</i>	<i>wjc 2-18-81</i>
3/4" (6)	1E12-F053B (See Dwg. 1, Part 232-4)	1	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	<i>L.D. Whately 2/5/81</i>	<i>wjc 2-18-81</i>
7/8" Head (12)	1E12-F090B (See Dwg. 1, Part 232-4)	1	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	<i>L.D. Whately 2/5/81</i>	<i>wjc 2-18-81</i>

INSPECTION CHECKLIST
 LASALLE COUNTY STATION UNIT 1

IC NO. IRH-1003B REV. 1

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR

R. D. Whalley

DATE 12/15/80

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE
00	01												
1/2"	1E12-FO41A-1 (See Dwg. 6, Part 19A.)	1	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	<i>R. D. Whalley</i> 2/5/81	wjc 2-18-81
3/4"	1E12-FO41A-2 (See Dwg. 6, Part 19.)	1	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	<i>R. D. Whalley</i> 2/5/81	wjc 2-18-81
1-1/8" Head	1E12-FO41A-3 (See Dwg. 6, Part 15.)	1	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	<i>R. D. Whalley</i> 2/5/81	wjc 2-18-81
7/8"	1E12-FO42A (See Dwg. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	<i>R. D. Whalley</i> 2/5/81	wjc 2-18-81
7/8"	1E12-FO92A (See Dwg. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	<i>R. D. Whalley</i> 2/5/81	wjc 2-18-81

Q.C. SUPERVISOR L.D. Whalley DATE 12/1/80

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01												
1/2" (4)	1E12-FO41C-1 (See Dwg. 6, Part 19A.)	1	B-G-2	VB	4	2	VT	84504	N/A	N/A	N/A	L.D. Whalley 2/15/81	wjc 2-18-81
3/4" (8)	1E12-FO41C-2 (See Dwg. 6, Part 19.)	1	B-G-2	VB	4	2	VT	84504	N/A	N/A	N/A	L.D. Whalley 2/15/81	wjc 2-18-81
1-1/8" Head (8)	1E12-FO41C-3 (See Dwg. 6, Part 15.)	1	B-G-2	VB	4	2	VT	84504	N/A	N/A	N/A	L.D. Whalley 2/15/81	wjc 2-18-81
7/8" (12)	1E12-FO42C (See Dwg. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L.D. Whalley 2/15/81	wjc 2-18-81
7/8" (12)	1E12-FO92C (See Dwg. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84504	N/A	N/A	N/A	L.D. Whalley 2/15/81	wjc 2-18-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRH-1013 REV. 1

PAGE 2 of 2

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.W. Wheatley DATE 1/22/80

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS. NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
18"	IRH-1013-6	1	C-F	P-T	1 1 2	4 4 5	UT-0° UT-45° PT	94034 91042 89004	94033 91041	01-18-01 01-18-01	0004 0005	L.W. Wheatley 5/24/79	1-24-80 FFR
18"	IRH-1013-7	1	C-F	P-T	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91030 0004	94022 91029	01-18-01 01-18-01	0004 0005	L.W. Wheatley 5/11/79	1-23-80 FFR
18"	IRH-1013-13	1	C-F	P-V	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91030 0004	94022 91029	01-18-01 01-18-01	0004 0005	L.W. Wheatley 5/11/79	1-23-80 FFR
18"	IRH-1013-14	1	C-F	E-V	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91030 0003	94022 91029	01-18-01 01-18-01	0004 0005	L.W. Wheatley 5/11/79	1-23-80 FFR
18"	IRH-1013-15	1	C-F	T-V	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91032 0005	94022 91031	01-18-01 01-18-01	0004 0005	L.W. Wheatley 5/11/79	1-23-80 FFR
18"	IRH-1013-16	1	C-F	P-V	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91030 0005	94022 91029	01-18-01 01-18-01	0004 0005	L.W. Wheatley 5/11/79	1-23-80 FFR
18"	IRH-1013-19	1	C-F	P-T	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91030 0003	94022 91029	01-18-01 01-18-01	0004 0005	L.W. Wheatley 5/11/79	1-23-80 FFR
18"	IRH-1013-20	1	C-F	P-T	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91030 0004	94022 91029	01-18-01 01-18-01	0004 0005	L.W. Wheatley 5/11/79	1-23-80 FFR

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRH-1031B REV. 1

PAGE 1 of 1

REVIEWED AND APPROVED BY:

DATE 12/15/80

Q.C. SUPERVISOR R.D. D'Arcy

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NC.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	I.D.S. NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01	02	03	04	05	06	07	08	09	10	11	12	13
1 1/2" Head (8)	1E12-FO08 (See Dwg. 1, Part 252-4.)	0	B-G-2	VB	4	2	VT	84S11	N/A	N/A	N/A	R.D. D'Arcy 2/15/81	wjc 2-18-81
1 1/2" Head (8)	1E12-FO09 (See Dwg. 1, Part 252-4.)	0	B-G-2	VB	4	2	VT	84S11	N/A	N/A	N/A	R.D. D'Arcy 2/15/81	wjc 2-18-81
1 1/2" Head (8)	1E12-FO20 (See Dwg. 1, Part 252-4.)	0	B-G-2	VB	4	2	VT	84S11	N/A	N/A	N/A	R.D. D'Arcy 2/15/81	wjc 2-18-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRH-1045 REV. 2

PAGE 1 of 3

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L. J. Wheatley DATE 6/17/80

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
8"	IRH-1045-1	0	C-F	E-P	2 1 1	6 4 5	PT UT-0 ⁰ UT-45 ⁰	78055 78057 77170	78056 77179	01-08-02 01-08-02	0015 0020	L. J. Wheatley 3/24/80	w g c 7-30-80
8"	IRH-1045-2	0	C-F	P-E	2 1 1	6 4 5	PT UT-0 ⁰ UT-45 ⁰	78055 78057 77170	78056 77179	01-08-02 01-08-02	0015 0020	L. J. Wheatley 3/24/80	w g c 7-30-80
8"	IRH-1045-3	0	C-F	E-P	2 1 1	6 5 5	PT UT-0 ⁰ UT-45 ⁰	97042 77212 77214	77211 77213	01-08-02 01-08-02	0020 0020	L. J. Wheatley 3/24/80	w g c 7-30-80
8"	IRH-1045-4	0	C-F	P-P	2 1 1	5 4 4	PT UT-0 ⁰ UT-45 ⁰			01-08-02 01-08-02		Examinations Not Required per Table IWC-2520 Category C-F	
8"	IRH-1045-5	0	C-F	P-E	2 1 1	6 5 5	PT UT-0 ⁰ UT-45 ⁰	97042 77212 77170	77211 77169	01-08-02 01-08-02	0020 0020	INCR-99 L. J. Wheatley 3/11/81	w g c 3-11-81
8"	IRH-1045-6	0	C-F	E-P	2 1 1	6 4 5	PT UT-0 ⁰ UT-45 ⁰	78055 78057 77214	78056 77213	01-08-02 01-08-02	0015 0020	L. J. Wheatley 10/22/80	w g c 10-27-80
8"	IRH-1045-7	0	C-F	P-E	2 1 1	6 4 4	PT UT-0 ⁰ UT-45 ⁰	78055 78057 78069	78056 78068	01-08-02 01-08-02	0015 0015	L. J. Wheatley 3/20/80	w g c 7-30-80
8"	IRH-1045-8	0	C-F	E P	2 1 1	6 4 4	PT UT-0 ⁰ UT-45 ⁰	78055 78057 78069	78056 78068	01-08-02 01-08-02	0015 0015	L. J. Wheatley 3/24/80	w g c 7-30-80

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. IRH-1047 REV. 1

PAGE 1 of 4

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L. J. Wheatley DATE 3/18/80

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS. NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
8"	IRH-1047-2	0	C-F	R-F	2 1 1	5 5 5	PT UT-0 ⁰ UT-45 ⁰	97005 93071 77164	93070 77163	01-08-02 01-08-02	0024 0020	L. J. Wheatley 3/25/80	X wgc 3-28-80
8"	IRH-1047-4	0	C-F	F-P	2 1 1	5 5 5	PT UT-0 ⁰ UT-45 ⁰	97005 93044 93058	93042 93057	01-08-02 01-08-02	0024 0024	L. J. Wheatley 3/25/80	wgc 3-26-80
8"	IRH-1047-7	0	C-F	P-V	2 1 1	5 5 5	PT UT-0 ⁰ UT-45 ⁰	97005 93043 93058	93042 93057	01-08-02 01-08-02	0024 0024	L. J. Wheatley 3/25/80	wgc 3-26-80
8"	IRH-1047-8	0	C-F	V-P	2 1 1	5 5 5	PT UT-0 ⁰ UT-45 ⁰	97005 93043 93058	93042 93057	01-08-02 01-08-02	0024 0024	L. J. Wheatley 3/25/80	wgc 3-26-80
8"	IRH-1047-11	0	C-F	P-E	2 1 1	6 5 5	PT UT-0 ⁰ UT-45 ⁰	97051 93071 77164	93070 77163	01-08-02 01-08-02	0024 0020	L. J. Wheatley 3/25/80	X wgc 3-28-80
8"	IRH-1047-15	0	C-F	E-V	2 1 1	5 5 5	PT UT-0 ⁰ UT-45 ⁰	97006 93043 93055	93042 93054	01-08-02 01-08-02	0024 0024	L. J. Wheatley 3/25/80	wgc 3-26-80
8"	IRH-1047-17	0	C-F	V-P	2 1 1	5 5 5	PT UT-0 ⁰ UT-45 ⁰	91177 93043 93055	93042 93054	01-08-02 01-08-02	0024 0024	INCR-95 L. J. Wheatley 3/11/81	wgc 3-11-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1001B REV. 1

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR *L.D. D...by*

DATE 12/15/50

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01		03	04	05	06	07	08	09	10	11	12	13
3/4" Head (6)	1E51-F008 (See Dwg. 1, Part 252-4.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	<i>L.D. D...by</i> 2/15/51	<i>W. J. Caldwell</i> 2-18-51
7/8" Head (10)	1E51-F064 (See Dwg. 1, Part 252-4.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	<i>L.D. D...by</i> 2/15/51	<i>W. J. Caldwell</i> 2-18-51

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1003B REV. 1

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whaley DATE 12/15/80

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01		03	04	05	06	07	08	09	10	11	12	13
3/4" Head (6)	1B51-FO13 (See DWG. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L.D. Whaley 2/15/81	wjc 2-18-81
5/8" (4)	1B12-FO19 (See DWG. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L.D. Whaley 2/15/81	wjc 2-18-81
1/2" (14)	1B51-FO65-1 (See DWG. 7, Parts 19 & 19A)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L.D. Whaley 2/15/81	wjc 2-18-81
1-1/8" Head (4)	1B51-FO65-2 (See DWG. 7, Part 15.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L.D. Whaley 2/15/81	wjc 2-18-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1004 REV. 0

PAGE 3 of 6

REVIEWED AND APPROVED BY:

O.C. SUPERVISOR L.W. Wheatley DATE 6/12/80

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
8"	IRI-1004-22	0	C-F	T-P	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	97088 77346 77348	77345 77347	01-08-02 01-08-02	0040 0040	L.W. Wheatley 5/1/80	wjc 8-1-80
8"	IRI-1004-24	0	C-F	P-V	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	77400 77408 77410	77407 77409	01-08-02 01-08-02	0040 0038	L.W. Wheatley 5/1/80	wjc 8-1-80
8"	IRI-1004-25	0	C-F	V-P	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	47087 77340 77342	77339 77341	01-08-02 01-08-02	0040 0040	L.W. Wheatley 8/1/80	wjc 8-1-80
8"	IRI-1004-30	0	C-F	P-F	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	97085 77340 77342	77339 77341	01-08-02 01-08-02	0040 0040	L.W. Wheatley 8/1/80	wjc 8-1-80
8"	IRI-1004-32	0	C-F	F-P	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	97085 77340 77342	77339 77341	01-08-02 01-08-02	0040 0040	L.W. Wheatley 8/1/80	wjc 8-1-80
8"	IRI-1004-33	0	C-F	P-F	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	97085 77340 77342	77339 77341	01-08-02 01-08-02	0040 0040	L.W. Wheatley 8/1/80	wjc 8-1-80
8"	IRI-1004-35	0	C-F	F-E	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	97085 77340 77342	77339 77341	01-08-02 01-08-02	0040 0040	L.W. Wheatley 8/1/80	wjc 8-1-80
6"	IRI-1004-37	0	C-F	E-P	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	(77352) 97085 77553 77561	77552 77560	01-06-01 01-06-01	0053 0057	(77463) INCR-103 L.W. Wheatley 3/1/81	wjc 3-11-81

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1004 REV. 1

PAGE 4 of 6

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whately DATE 2/17/81

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
6"	IRI-1004-37A	0	C-F	P-PU	2 1 1	6 6 6	PT UT-00 UT-450	77348 77553 77557	77554 77556	01-06-02 01-06-02	0053 0053	L.D. Whately 2/17/81	w. J. Caldwell 2-17-81
8"	IRI-1004-38B	0	C-F	F-F	2 1 1	6 6 6	PT UT-00 UT-450	83008 83014 83012	83013 83011	01-08-02 01-08-02	0038 0038	L.D. Whately 2/17/81	w. J. C 2-17-81
8"	IRI-1004-38C	0	C-F	E-P	2 1 1	6 6 6	PT UT-00 UT-450	83008 83014 83012	83013 83011	01-08-02 01-08-02	0038 0038	L.D. Whately 2/17/81	w. J. C 2-17-81
8"	IRI-1004-41	0	C-E-1	P-PH	NA	NA	MI	NA	NA	NA	NA	See PSI Ref. No. RI-1	w. J. C 2-18-81
8"	IRI-1004-43	0	C-F	P-V	2 1 1	6 6 6	PT UT-00 UT-450	78348 78352 78363	78350 78359	01-08-02 01-08-02	0036 0036	L.D. Whately 2/17/81	w. J. C 2-17-81
8"	IRI-1004-44	0	C-F	V-P	2 1 1	6 6 6	PT UT-00 UT-450	78348 78351 78363	78350 78359	01-08-02 01-08-02	0036 0036	L.D. Whately 2/17/81	w. J. C 2-17-81
3"	IRI-1004-46	0	C-F	P-V	2 1 1	6 6 6	PT UT-00 UT-450	78348 78351 78363	78350 78359	01-08-02 01-08-02	0036 0036	L.D. Whately 2/17/81	w. J. C 2-17-81
3"	IRI-1004-49	0	C-F	V-P	2 1 1	6 6 6	PT UT-00 UT-450	78348 78351 78363	78350 78359	01-08-02 01-08-02	0036 0036	L.D. Whately 2/17/81	w. J. C 2-17-81

INSPECTION CHECKLIST
 LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1005 REV. 0

PAGE 1 of 3

REVIEWED AND APPROVED BY:

O.C. SUPERVISOR L.W. Wheatley DATE 6/11/80

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
6"	IRI-1005-1	0	C-F	Pu-E	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	(77389) 77481 77483	77480 77482	01-06-02 01-06-02	0038 0047	(77463) WCR-104 L.W. Wheatley 3/11/81	w g c 3-11-81
6"	IRI-1005-3	0	C-F	E-V	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	77323 77326 77328	77325 77327	01-06-02 01-06-02	0040 0040	L.W. Wheatley 8/1/80	w g c 8-1-80
6"	IRI-1005-4	0	C-F	V-P	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	77323 77326 77328	77325 77327	01-06-02 01-06-02	0040 0040	L.W. Wheatley 8/1/80	w g c 8-1-80
6"	IRI-1005-6	0	C-F	P-E	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	77323 77326 77328	77325 77327	01-06-02 01-06-02	0040 0040	L.W. Wheatley 8/1/80	w g c 8-1-80
6"	IRI-1005-8	0	C-F	E-P	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	77323 77326 77328	77325 77327	01-06-02 01-06-02	0040 0040	L.W. Wheatley 8/1/80	w g c 8-1-80
6"	IRI-1005-7	0	C-E-1	E-ST	2	6	PT	77082				L.W. Wheatley 8/1/80	w g c 8-1-80
6"	IRI-1005-11	0	C-F	P-E	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	77323 77326 77328	77325 77327	01-06-02 01-06-02	0040 0040	L.W. Wheatley 8/1/80	w g c 8-1-80

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1013 REV. 2

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR LD D. Kelly DATE 2/10/81

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
00	01												
6"	IRI-1013-9	0	C-F	F-P	2 1 1	6 6 6	PT UT-00 UT-450	13020 13038 77455	13037 77454	01-06-01 01-06-01	0036 0046	LD D. Kelly 2/10/81 "T" EDS 77433	w g Caldwell 2-17-81
6"	IRI-1013-10	0	C-E-1	P-PH	NA	NA	MT	NA	NA	NA	NA	See PSI Ref. No. RI-2	w g c 2-18-81
6"	IRI-1013-13	0	C-F	P-E	2 1 1	6 6 6	PT UT-00 UT-450			01-06-01 01-06-01		See AZ-16	
6"	IRI-1013-14	0	C-F	E-P	2 1 1	6 6 6	PT UT-00 UT-450			01-06-01 01-06-01			

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1016 REV. 1
PAGE 1 of 2
REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whalley DATE 2/17/81

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
10"	IRI-1016-1	0	C-F	P-E	2 1 1	6 6 6	PT UT-0° UT-45°	93223 93232 93251	93231 93249	01-10-01 01-10-01	0038 0039	L.D. Whalley 2/17/81	w g c 2-17-81
10"	IRI-1016-2	0	C-F	E-P	2 1 1	6 6 6	PT UT-0° UT-45°	93223 93232 93251	93231 93249	01-10-01 01-10-01	0038 0039	L.D. Whalley 2/17/81	w g c 2-17-81
10"	IRI-1016-4	0	C-E-1	P-PH	NA	NA	MT	NA	NA	NA	NA	See PSI Ref. No. RI-3.	w g c 2-18-81
10"	IRI-1016-6	0	C-F	P-E	2 1 1	6 6 6	PT UT-0° UT-45°	93237 93023 93252	93022 93249	01-10-01 01-10-01	0036 0039	L.D. Whalley 2/17/81	w g c 2-17-81
10"	IRI-1016-7	0	C-F	E-E	2 1 1	6 6 6	PT UT-0° UT-45°	93237 93023 93251	93022 93249	01-10-01 01-10-01	0036 0039	L.D. Whalley 2/17/81	w g c 2-17-81
10"	IRI-1016-8	0	C-F	E-P	2 1 1	6 6 6	PT UT-0° UT-45°	93237 93023 93251	93022 93249	01-10-01 01-10-01	0036 0039	L.D. Whalley 2/17/81	w g c 2-17-81
10"	IRI-1016-12	0	C-F	P-E	2 1 1	6 6 6	PT UT-0° UT-45°	93239 93241 93252	93240 93249	01-10-01 01-10-01	0036 0039	L.D. Whalley 2/17/81	w g c 2-17-81
10"	IRI-1016-13	0	C-F	E-P	2 1 1	6 6 6	PT UT-0° UT-45°	93239 93241 93252	93240 93249	01-10-01 01-10-01	0036 0039	L.D. Whalley 2/17/81	w g c 2-17-81

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1018 REV. 1
PAGE 1 of 2
REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR J. D. Whitley DATE 2/17/81

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT C3	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
10"	IRI-1018-1	0	C-F	P-E	2 1 1	6 6 6	PT UT-00 UT-450	83025 93241 93250	93240 93249	01-10-01 01-10-01	0036 0039	J. D. Whitley 2/17/81	w. g. Caldwell 2-17-81
10"	IRI-1018-2	0	C-F	E-P	2 1 1	6 6 6	PT UT-00 UT-450	83026 93246 93250	93245 93249	01-10-01 01-10-01	0036 0039	J. D. Whitley 2/17/81	w g c 2-17-81
10"	IRI-1018-4	0	C-E-1	P-PH	NA	NA	MT	NA	NA	NA	NA	See PSI Ref. No. RI-4.	w g c 2-18-81
10"	IRI-1018-5	0	C-F	P-E	2 1 1	6 6 6	PT UT-00 UT-450	83021 83023 93256	83022 93255	01-10-01 01-10-01	0036 0039	J. D. Whitley 2/17/81	w g c 2-17-81
10"	IRI-1018-7	0	C-F	E-E	2 1 1	6 6 6	PT UT-00 UT-450	83021 83023 93257	830 2 93255	01-10-01 01-10-01	0036 0039	J. D. Whitley 2/17/81	w g c 2-17-81
10"	IRI-1018-8	0	C-F	E-P	2 1 1	6 6 6	PT UT-00 UT-450	83021 83023 93257	83022 93255	01-10-01 01-10-01	0036 0039	J. D. Whitley 2/17/81	w g c 2-17-81
10"	IRI-1018-9	0	C-F	P-E	2 1 1	6 6 6	PT UT-00 UT-450	93239 93246 83028	93240 83028	01-10-01 01-10-01	0036 0039	J. D. Whitley 2/17/81	w g c 2-17-81
10"	IRI-1018-11	0	C-F	E-P	2 1 1	6 6 6	PT UT-00 UT-450	93239 93246 83028	93245 83028	01-10-01 01-10-01	0036 0039	J. D. Whitley 2/17/81	w g c 2-17-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1019 REV. 0

PAGE 2 of 3

REVIEWED AND APPROVED BY:

O.C. SUPERVISOR L.W. Whately DATE 6/1/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
10"	IRI-1019-11	0	C-F	P-R	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	(97083) 77469 92213	77468 92212	01-10-02 01-10-02	0038 0050	(77463) L.W. Whately 3/4/80 INC-105	w g c 3-11-80
18"	IRI-1019-12	0	C-F	R-P	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	97081 77412 77415	77411 77413	01-14-01 01-14-01	0040 0038	L.W. Whately 10/22/80	w g. Calhoun 10-23-80
10"	IRI-1019-13	0	C-F	P-W	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	77400 77402 77405	77401 77403	01-10-02 01-10-02	0038 0038	L.W. Whately 8/1/80	w g c 8-1-80
18"	IRI-1019-14	0	C-F	P-C	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	77406 77412 77414	77411 77413	01-14-01 01-14-01	0040 0038	L.W. Whately 10/22/80	w g c 10-23-80
10"	IRI-1019-15	0	C-F	W-P	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	77400 77402 77405	77401 77403	01-10-02 01-10-02	0038 0038	L.W. Whately 8/1/80	w g c 8-1-80
10"	IRI-1019-16	0	C-F	P-E	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	77400 77402 77404	77401 77403	01-10-02 01-10-02	0038 0038	L.W. Whately 10/22/80	w g c 10-23-80
10"	IRI-1019-17	0	C-F	E-P	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	97087 77387 77381	77386 77375	01-10-02 01-10-02	0040 0043	L.W. Whately 8/1/80	w g c 8-1-80
10"	IRI-1019-18	0	C-F	P-E	2 1 1	6 6 6	PT UT-0 ⁰ UT-45 ⁰	97084 77330 77331	77329 77331	01-10-02 01-10-02	0040 0040	L.W. Whately 8/1/80	w g c 8-1-80

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1020 REV. 2

PAGE 1 of 2

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Whately DATE 2/17/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
10"	IRI-1020-1	0	C-F	E-P	2 1 1	6 6 6	PT UT-00 UT-45 ⁰	83017 93230 77378	93229 77375	01-10-02 01-10-02	0038 0043	L.D. Whately 2/17/81	w g c 2-17-81
10"	IRI-1020-3	0	C-F	P-V	2 1 1	6 6 6	PT UT-00 UT-45 ⁰	83020 93230 77376	93229 77375	01-10-02 01-10-02	0038 0043	L.D. Whately 2/17/81	w g c 2-17-81
10"	IRI-1020-4	0	C-F	V-E	2 1 1	6 6 6	PT UT-00 UT-45 ⁰	83020 93230 77377	93229 77375	01-10-02 01-10-02	0038 0043	L.D. Whately 2/17/81	w g c 2-17-81
10"	IRI-1020-5	0	C-F	E-P	2 1 1	6 6 6	PT UT-00 UT-45 ⁰	83020 93230 77376	93229 77375	01-10-02 01-10-02	0038 0043	L.D. Whately 2/17/81	w g c 2-17-81
10"	IRI-1020-9	0	C-F	P-V	2 1 1	6 6 6	PT UT-00 UT-45 ⁰	83020 93230 77378	93229 77375	01-10-02 01-10-02	0038 0043	L.D. Whately 2/17/81	w g c 2-17-81
10"	IRI-1020-10	0	C-F	V-P	2 1 1	6 6 6	PT UT-00 UT-45 ⁰	83020 93230 77378	93229 77375	01-10-02 01-10-02	0038 0043	L.D. Whately 2/17/81	w g c 2-17-81
10"	IRI-1020-13	0	C-E-1	P-PH	NA	NA	MT	NA	NA	NA	NA	See PSI Ref. No. RI-5.	w g c 2-18-81
10"	IRI-1020-16	0	C-F	P-E	2 1 1	6 6 6	PT UT-00 UT-45 ⁰	93212 93214 93216	93213 93215	01-10-02 01-10-02	0037 0028	L.D. Whately 2/17/81	w g c 2-17-81

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1022 REV. 2

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.D. Wheatley DATE 2/17/81

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
6"	IRI-1022 8	0	C-F	F-E	2 1 1	6 6 6	PT UT-0° UT-45°	R3027 R3033 R3040	R3032 R3039	01-06-01 01-06-01	0036 0039	L.D. Wheatley 2/17/81	w g c 2-17-81
6"	IRI-1022-9	0	C-F	E-E	2 1 1	6 6 6	PT UT-0° UT-45°	R3027 R3033 R3040	R3032 R3039	01-06-01 01-06-01	0036 0039	L.D. Wheatley 2/17/81	w g c 2-17-81
6"	IRI-1022-10	0	C-F	E-P	2 1 1	6 6 6	PT UT-0° UT-45°	R3027 R3033 R3040	R3032 R3039	01-06-01 01-06-01	0036 0039	L.D. Wheatley 2/17/81	w g c 2-17-81
6"	IRI-1022-11	0	C-F	P-E	2 1 1	6 6 6	PT UT-0° UT-45°	R3036 R3033 R3035	R3032 R3034	01-06-01 01-06-01	0036 0039	L.D. Wheatley 2/17/81	w g c 2-17-81
6"	IRI-1022-12	0	C-F	E-P	2 1 1	6 6 6	PT UT-0° UT-45°	R3027 R3033 R3035	R3032 R3034	01-06-01 01-06-01	0036 0039	L.D. Wheatley 2/17/81	w g c 2-17-81
6"	IRI-1022-13	0	C-E-1	P-PH	NA	NA	PT	NA	NA	NA	NA	See PSI Ref. No. RI-6	w g c 2-18-81
6"	IRI-1022-16	0	C-F	P-E	2 1 1	6 6 6	PT UT-0° UT-45°	R3007 4230 R3010	4229 R3009	01-06-01 01-06-01	0036 0039	L.D. Wheatley 2/17/81	w g c 2-17-81
6"	IRI-1022-17	0	C-F	E-P	2 1 1	6 6 6	PT UT-0° UT-45°			01-06-01 01-06-01			

INSPECTION CHECKLIST
 LASALLE COUNTY STATION UNIT 1

IC NO. IRR-1009B REV. 1

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR W. J. Kelly DATE 12/15/80

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01	02	03	04	05	06	07	08	09	10	11	12	13
3/4" Head (6)	1G33-F106 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	W. J. Kelly 2/15/81	W. J. Caldwell 2-18-81

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRR-1010B REV. 1

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR R. D. Whaley DATE 12/15/80

SIZE	EXAM COMP ID NO	DWG. REV. NO.	ASME CAT	COMP FIG	PROCEDURE NO.	REV. NO.	EXAM TYPE	EDS NO.	CDS NO.	LSCS CAL STD. NO.	LDS NO.	Q.C. REVIEW SIGNATURE/DATE	AI INIT/DATE
00	01	02	03	04	05	06	07	08	09	10	11	12	13
3/4" Head (6)	1G33-F100 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	R. D. Whaley 2/15/81	W. B. Caldwell 2-18-81

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. IRT-1001 REV. 1

PAGE 2 of 6

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L D Wheatley DATE 2/17/81

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
6"	IRT-1001-12	0	B-J	E-P	2 1 1	5 4 4	PT UT-00 UT-450	74168 74181 74184	74178 74187	01-06-03 01-06-03	0009 0009	L D Wheatley 2/17/81	w J Caldwell 2-17-81
6"	IRT-1001-12A	0	B-J	P-T	2 1 1	5 4 4	PT UT-00 UT-450	74169 74191 74188	74178 74187	01-06-03 01-06-03	0009 0009	L D Wheatley 2/17/81	w J C 2-17-81
6"	IRT-1001-12B	0	B-J	T-P	2 1 1	5 4 4	PT UT-00 UT-450	74169 74181 74188	74178 74187	01-06-03 01-06-03	0009 0009	L D Wheatley 2/17/81	w J C 2-17-81
4"	IRT-1001-13	0	B-J	T-P	2 1 1	5 4 4	PT UT-00 UT-450	74169 93013 74177	93012 74172	01-04-04 01-04-04	74134 0009	L D Wheatley 2/17/81	w J C 2-17-81
6"	IRT-1001-14	0	B-J	P-E	2 1 1	5 4 4	PT UT-00 UT-450	74169 74179 74188	74178 74187	01-06-03 01-06-03	0009 0009	L D Wheatley 2/17/81	w J C 2-17-81
4"	IRT-1001-15	0	B-J	P-E	2 1 1	5 4 4	PT UT-00 UT-450	74169 93013 74177	93012 74172	01-04-04 01-04-04	74134 0009	L D Wheatley 2/17/81	w J C 2-17-81
6"	IRT-1001-16	0	B-J	E-P	2 1 1	5 4 4	PT UT-00 UT-450	74169 74179 74188	74178 74187	01-06-03 01-06-03	0009 0009	L D Wheatley 2/17/81	w J C 2-17-81
6"	IRT-1001-18	0	B-J	P-F	2 1 1	7 6 6	PT UT-00 UT-450	73278 77577 77571	77578 77580	01-06-03 01-06-03	0057 0053	L D Wheatley 2/17/81	w J C 2-17-81

INSPECTION CHECKLIST
LASALLE COUNTY STATION UNIT 1

IC NO. IRT-1001 REV. 1

PAGE 3 of 6

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L.W. Wheatley DATE 2/17/81

SIZE	EXAM COMP ID NO	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
6"	IRT-1001-19	0	B-J	F-P	2 1 1	7 6 6	PT UT-00 UT-450	73278 77579 77578 77581 77580		01-06-03 01-06-03	0057 0053	L.W. Wheatley 2/17/81	w.g. Caldwell 2-17-81
6"	IRT-1001-20	0	B-J	P-E	2 1 1	5 4 4	PT UT-00 UT-450	94171 94177 94178 94188 94187		01-06-03 01-06-03	0009 0009	L.W. Wheatley 2/17/81	w.g.c 2-17-81
6"	IRT-1001-21	0	B-J	E-P	2 1 1	5 4 4	PT UT-00 UT-450	15029 94177 94178 94188 94187		01-06-03 01-06-03	0009 0009	L.W. Wheatley 2/17/81	w.g.c 2-17-81
6"	IRT-1001-22	0	B-J	P-E	2 1 1	5 4 4	PT UT-00 UT-450	15029 94177 94178 94188 94187		01-06-03 01-06-03	0009 0009	L.W. Wheatley 2/17/81	w.g.c 2-17-81
6"	IRT-1001-23	0	B-J	E-V	2 1 1	5 4 4	PT UT-00 UT-450	94171 94177 94178 94188 94187		01-06-03 01-06-03	0009 0009	L.W. Wheatley 2/17/81	w.g.c 2-17-81
6"	IRT-1001-24	0	B-J	V-P	2 1 1	5 4 4	PT UT-00 UT-450	15029 94177 94178 94188 94187		01-06-03 01-06-03	0009 0009	L.W. Wheatley 2/17/81	w.g.c 2-17-81
6"	IRT-1001-25	0	B-J	P-E	2 1 1	5 4 4	PT UT-00 UT-450	15029 94180 94178 94188 94187		01-06-03 01-06-03	0009 0009	L.W. Wheatley 2/17/81	w.g.c 2-17-81
6"	IRT-1001-26	0	B-J	E-P	2 1 1	5 4 4	PT UT-00 UT-450	94171 94180 94178 94188 94187		01-06-03 01-06-03	0009 0009	L.W. Wheatley 2/17/81	w.g.c 2-17-81



NONCONFORMITY REPORT

REVISION NO. 0

Project La Salle I PSI Report No. INCR-94

Initiated By L.W. Wheatley Date 2/20/80

Project No. LCS-PC173-1 Drawing No. ILP-1011

Item, Assembly Joint No. Weld ILP-1011-6

Heat & Lot, Serial No. (if applicable) NA

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. Exam Form 94487

Description of Nonconformity

During grinding out of indications found during penetrant examinations minimum wall has been violated. See enclosed drawing for details

Proposed Resolution

RESOLUTION PER CECO ENGINEERING

Signature [Signature] Date 2/28/80

Comments

Resolution Approved By <u>L.W. Wheatley</u>	Date <u>2/28/80</u>
Reviewed with AI By <u>[Signature]</u>	Date <u>3-11-81</u>
Completed <u>[Signature]</u>	Date <u>3/11/81</u>

EXAMINATION DATA FORM

EXAM FORM # 94487

CAL. FORM # 94486

DATE 2-27-80

EXAMINER [Signature] LEVEL II DATA TAKER Robert Austin LEVEL IT

	TOT	LEFT SIDE	BOT.	RIGHT SIDE	WELD
MATERIAL THICKNESS	.362	.363	.390	.370	.482
PIT GAUGE READINGS					
REMAINING WALL THK.	.309				

WELD NO. DLP1011-26 NOMINAL PIPE THICKNESS 0.375

NCR NO. INCR-94 MINIMUM WALL 0.328

MATERIAL THICKNESS				
PIT GAUGE READINGS				
REMAINING WALL THK.				

WELD NO. _____ NOMINAL PIPE THICKNESS _____

NCR NO. _____ MINIMUM WALL _____

MATERIAL THICKNESS				
PIT GAUGE READINGS				
REMAINING WALL THK.				

WELD NO. _____ NOMINAL PIPE THICKNESS _____

NCR NO. _____ MINIMUM WALL _____

MATERIAL THICKNESS				
PIT GAUGE READINGS				
REMAINING WALL THK.				

WELD NO. _____ NOMINAL PIPE THICKNESS _____

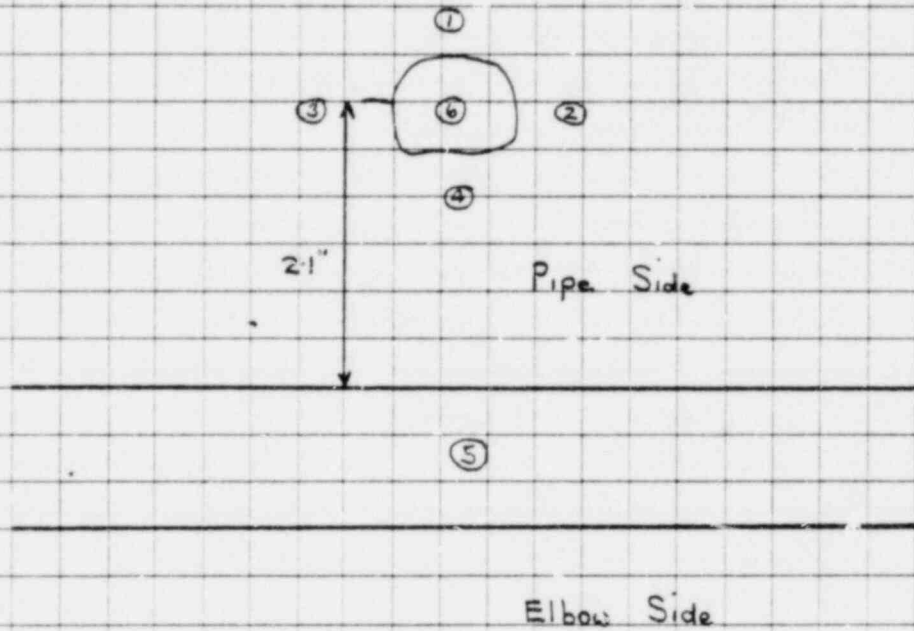
NCR. NO. _____ MINIMUM WALL _____

Dev./Station La Salle County Nuclear Station Unit I File No. _____

Subject INCR-94 on Weld ILP-1011-6

By _____ Date _____

Sheet No. _____ of _____ Problem No. _____ Checked By _____ Date _____



<u>Reading</u>	<u>Thickness</u>
1	.362"
2	.370"
3	.363"
4	.390"
5	.482"
6	.309"

The excavation is approximately 0.9" diameter. Nominal pipe thickness is 0.375" and minimum wall is 0.328".

INCR 94

FORM QP 15-1.1
12-13-78 (Rev. 2)

MINIMUM REQUIREMENTS FOR CONSTRUCTION AND TEST

LOT NO. 409

LP DE
LP UNIT

14" 14"
MORSE CONST CO

<input type="checkbox"/>	TEST	<input type="checkbox"/>	CONTRACTOR
<input type="checkbox"/>	TEST	<input type="checkbox"/>	TEST

<input type="checkbox"/>	CONTRACTOR
<input type="checkbox"/>	TEST

THERE IS AN AREA OF APPROXIMATELY
 1" IN DIAMETER BELOW THE ALL
 4 RINGS ON THE LEFT SIDE - 2
 RINGS OF THE FIELD WEEDS OF
 WHICH THE GROUND AREA IS 0.301
 2. APPROXIMATELY

15110	4892	N/A
SIGNATURE		
DATE	DATE	DATE
3-17-80	3-15-80	3-17-80
3-17-80	3-17-80	3-17-80

100% 50.5% Report
 Required

CONTRACTOR

ACCEPTABLE AS IS.

WINE REQUIRED

Rebuilt PCO 3-17-80

Handwritten signature and date 3/17/80

SARIBEL & LEINDY

ENGINEERS

FOUNDED BY ERICK PERJENT-89

55 EAST WARRLE STREET

CHICAGO ILLINOIS 60603

TELEPHONE 214 263 2000

CABLE ADDRESS SATLCHIC

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 394, 402, 408, 409,
419, 432, 433 & 420

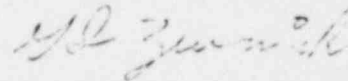
Mr. F. S. Watts
General System Engineer
Commonwealth Edison Company
1000 South Dearborn Street
Chicago, Illinois 60690

Re No. 4140:

The above NCR's all deal with potential minimum wall thicknesses due to planer edge wave counterboring or PT
indication removal. A minimum wall calculation has been
performed for each case under design conditions for
the areas involved. In all cases the remaining wall thickness
exceeds the required minimum wall thickness. Therefore, no
repair is necessary and all the above NCR's should be
accepted as is for the final disposition.

If you have any questions, please contact me.

Yours very truly,



G. I. Zvarich
Mechanical Engineer

GIZ:cb
In duplicate
Copies:

L. J. Burke	V. G. Schwartz	C. A. Richel
R. H. Pollock	E. S. Wavle	
P. E. Quinn	G. C. Jones	
B. J. Nade	J. R. Metz	



NONCONFORMITY REPORT

REVISION NO. C

Project LaSalle I PSI Report No. INCR-95

Initiated By L.W. Wheatley Date 3/7/80

Project No. LCS-P0173-1 Drawing No. IRH-1047

Item, Assembly Joint No. Weld IRH-1047-17

Heat & Lot, Serial No. (if applicable) NA

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. UT Reports LW-05, 06

Description of Nonconformity

Minimum wall violation caused by Flapping of liquid penetrant indications.
See enclosed drawing & data for further details

Proposed Resolution

RESOLUTION PER CECO ENGINEERING

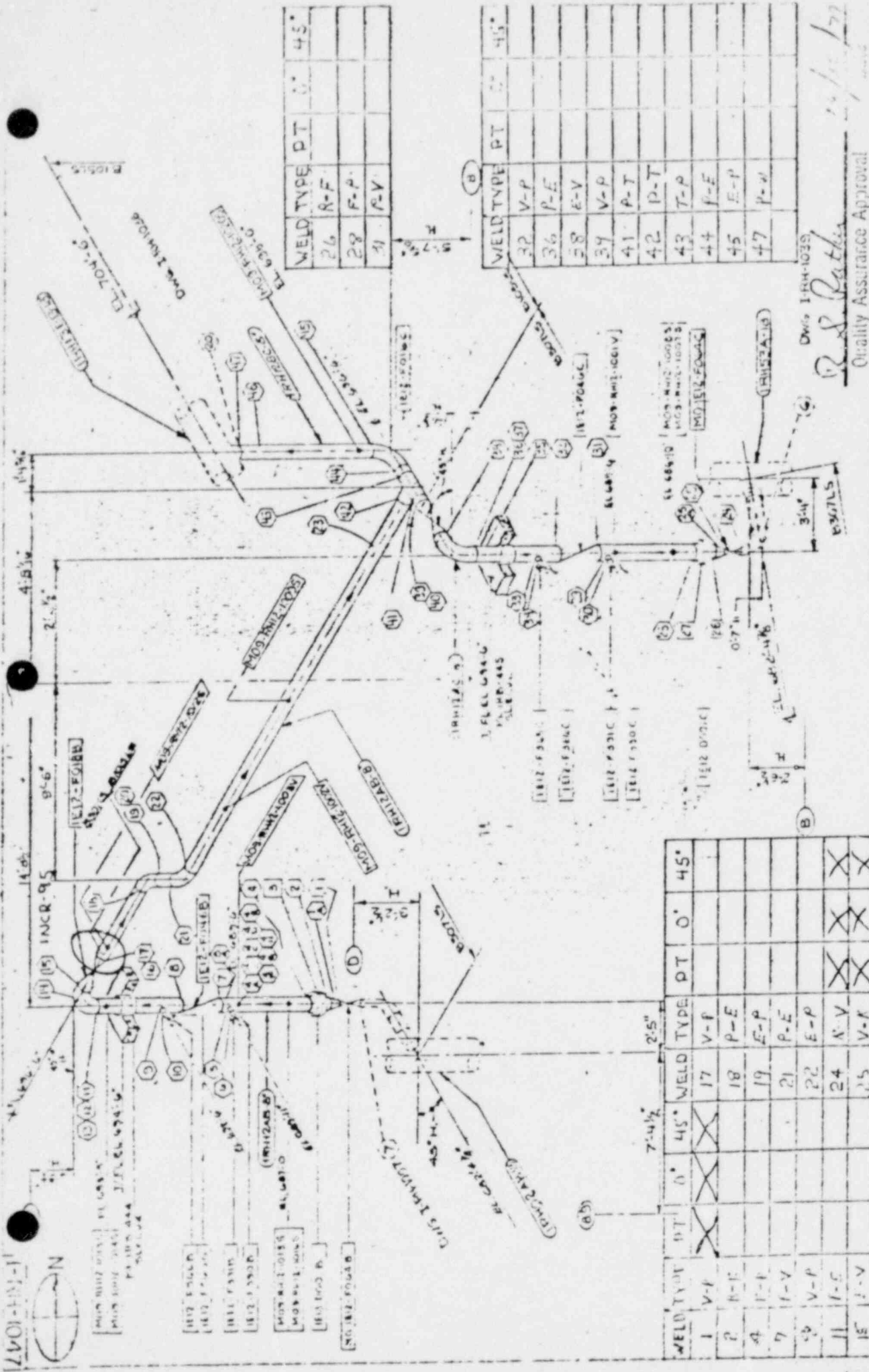
Signature *M. Connolly* Date 3/7/80

Comments

Resolution Approved By *L.W. Wheatley* Date 3/7/80

Reviewed with AI By *W.G. Caldwell* Date 3-11-80

Completed *L.W. Wheatley* Date 3/11/80



WELD TYPE	PT	O'	45°
26	R-F		
28	F-P		
31	F-V		

WELD TYPE	PT	O'	45°
32	V-P		
36	P-E		
38	E-V		
39	V-P		
41	P-T		
42	P-T		
43	T-P		
44	P-E		
45	E-P		
47	P-V		

WELD TYPE	PT	O'	45°	WELD TYPE	PT	O'	45°
1	V-P	X		17	V-P		
2	R-F	X		18	P-E		
4	F-P			19	E-P		
7	F-V			21	P-E		
9	V-P			22	E-P		
11	F-E			24	R-V	X	X
15	F-V			25	V-P		

MORRISON CONSTRUCTION CO.
 HAVILLAND, OHIO 44130
 INSURANCE DIVISION
 14000 W. STATE ST. SUITE 100
 CLEVELAND, OHIO 44115
 COMMERCIAL INSURANCE COMPANY OF OHIO
 INSURANCE DIVISION
 14000 W. STATE ST. SUITE 100
 CLEVELAND, OHIO 44115

DWG. I-14-1035
 R.S. Bates
 Quality Assurance Approval

G.E. P.S.I. Rev. 0 Changes
 ASME Cat.: C-F
 Procedures: UT #1 Rev. 4, PT #2 Rev. 5
 Cal. Std.: welds 01-08-02

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LASALLE COUNTY NUCLEAR STATION U.T. CALIBRATION FORM

FORM#: LW-05
DATE: 3/7/80

EXAMINER L. J. Wheatley LEVEL III DATA TAKER _____ LEVEL _____
INSTRUMENT MODEL KK USL-32 SERIAL NO. 26680-521
TRANSDUCER SIZE 0.25" x 0.25" DUAL FREQ. 5.0 MHZ SERIAL NO. I21611
CALIBRATION STD. 01-08-02 - Step Wedge MATERIAL Carbon Steel
COUPLANT Glycerine INITIAL CALIBRATION TIME 14:00

(CALIBRATION DATA)

STANDARD THICKNESS	INSTRUMENT READING
0.1	0.1
0.3	0.3
0.5	0.5
0.324	0.32 on block 01-08-02

Cal. Verification Times: 15:00

Final Cal. Check: 15:00

Gain
Sweep
Delay
Filter
Rep. Rate
Dampening
Reject
Digital Range
Calibrate
Velocity

INSTRUMENT START	SETTINGS: FINISH
64dB	64dB
756	756
170	170
NA	NA
AUTO	Auto
OFF	OFF
OFF	OFF
0.5"	0.5"
NA	NA
NA	NA

EXAMINATION DATA FORM

EXAM FORM # LW-06

CAL. FORM # LW-05

DATE 3/7/89

EXAMINER L W Wheatley LEVEL III DATA TAKER _____ LEVEL _____

MATERIAL THICKNESS	0.36	0.31	0.33	
PIT GAUGE READINGS	NA	NA	NA	NA
REMAINING WALL THK.				0.235

WELD NO. 1RH-1047-17 NOMINAL PIPE THICKNESS 0.322

NCR NO. INCR-95 MINIMUM WALL 0.282

MATERIAL THICKNESS				
PIT GAUGE READINGS				
REMAINING WALL THK.				

WELD NO. _____ NOMINAL PIPE THICKNESS _____

NCR NO. _____ MINIMUM WALL _____

MATERIAL THICKNESS				
PIT GAUGE READINGS				
REMAINING WALL THK.				

WELD NO. _____ NOMINAL PIPE THICKNESS _____

NCR NO. _____ MINIMUM WALL _____

MATERIAL THICKNESS				
PIT GAUGE READINGS				
REMAINING WALL THK.				

WELD NO. _____ NOMINAL PIPE THICKNESS _____

NCR. NO. _____ MINIMUM WALL _____

Dev./Station LaSalle County Nuclear Station

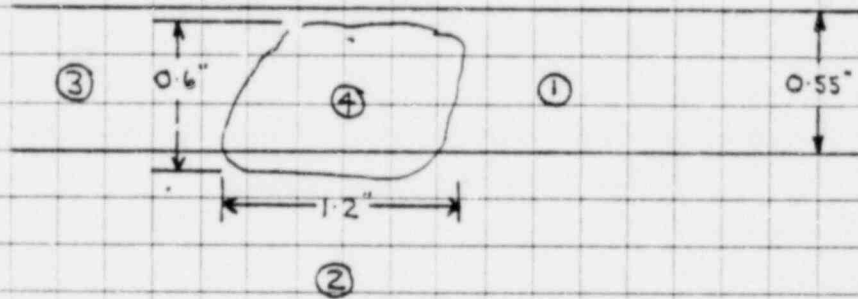
Unit I File No.

Subject INCR-95 on Weld IRH-1047-17

By _____ Date _____

Sheet No. _____ of _____ Problem No. _____ Checked By _____ Date _____

VALVE SIDE



PIPE SIDE

Area	Thickness
1	0.36
2	0.31
3	0.33
4	0.235

Minimum Wall = 0.282"

Nominal Pipe Thickness = 0.322"

"ORIGINAL"

INCR 95

FORM CP 15-1.1
12-15-78 (Rev.2)

NONCONFORMANCE REPORT FOR CONSTRUCTION AND TEST

NCR NO. 408

Edison

SHEET 1 OF 4

TYPE OF ITEM: PIPE PIPING

TEST NO. (EQUIP. NO.): IRHIC AB-8"

UNIT NO.: 1

CONTRACTOR: MORRISON CONST CO

CORRECT DAMAGED
 FAILURE DISCONTINUED
 REPAIR REWORK

FIELD INSPECTION CONTRACTOR
 TEST

THERE IS A AREA APPROXIMATELY
 1.2" O.D. BELOW MIN. WALL THICKNESS
 IN NCR'S FIELD WELD # KHESI ON
 LINE # IRHIC AB-8". WALL THICKNESS IN
 PROBLEM AREA IS 0.235". SEE ATTACH-1
 IN REPORT

18110	489'	WORK REQUEST NO.	211
DATE	DATE	DATE	DATE
3/12/80	3/14/80	3/14/80	3/14/80

10 CFR 50.55 Report
 Required Yes No

GROUND AREA CREATED. FENCING
 AROUND PERIMETER DURING EACH RE INSPECTION

ADVISE

2-5-80

ISOLATE, SECURE, MONITOR

4/3/81

B.R. H. 2381

ACCEPTABLE AS IS.

NONE REQUIRED

3/12/80 PCD 311

[Handwritten signature]

SANBORN & LINDV
MINERAL ENGINEERS

FOUNDED BY HENRIK SANBORN 1891
77 EAST MADISON STREET
CHICAGO, ILLINOIS 60603
TELEPHONE 312-269-2000
CABLE ADDRESS SANLUN-CHICAGO

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 384, 402, 403, 409,
429, 432, 453 & 480

Mr. P. E. Walts
General Design Engineer
Commonwealth Edison Company
P.O. Box 767 - 1584W
Chicago, Illinois 60690

Dear Mr. Walts:

The above NCR's all deal with potential minimum wall
violations due to either excessive counterboring or PT
improper removal. A minimum wall calculation has been
performed for each case based upon design conditions for
the area involved. In all cases the remaining wall thickness
exceeds the required minimum wall thickness. Therefore, no
repair is necessary and all the above NCR's should be
accepted as is for the final disposition.

If you have any questions, please contact me.

Yours very truly,

G. I. Kwarich

G. I. Kwarich
Mechanical Engineer

GIZ:cb

In duplicate

Copies:

L. J. Burke
R. H. H. Peak
T. E. Quaha
B. C. Mann

W. G. Schwab
E. R. Vost
G. C. Jones
E. R. Kurka

C. A. Riebel

NONCONFORMITY REPORT

REVISION NO. 0

Project La Salle I PSI Report No. INCR-98

Initiated By L W Wheatley Date 5/28/80

Project No. LCS-PO173-1 Drawing No. IRH-1001-1

Item, Assembly Joint No. Weld IRH-1001-1

Heat & Lot, Serial No. (if applicable) NA

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. UT Report LW-09 (84605)

Description of Nonconformity

In removing linear & clustered porosity indications during penetrant examinations, minimum wall has been violated. See enclosed UT Report for details.

Proposed Resolution

RESOLUTION PER CECO ENGINEERING

Signature SPennelly Date 5/28/80

Comments

Resolution Approved By	<u>L W Wheatley</u>	Date	<u>5/28/80</u>
Reviewed with ANI By	<u>W J Caldwell</u>	Date	<u>3-11-81</u>
Completed	<u>L W Wheatley</u>	Date	<u>3/11/81</u>

LASALLE COUNTY NUCLEAR STATION

U.T. CALIBRATION FORM

FORM # LW-08 (84604)

DATE 5/28/80

EXAMINER L W Wheatley LEVEL III DATA TAKER _____ LEVEL _____

INSTRUMENT MODEL CL-202 SERIAL NO. 801203

TRANSDUCER SIZE 0.25" DIA FREQ. 50 MHz SERIAL NO. 025810

CALIBRATION STD. CSC-1 a Step Wedge MATERIAL Carbon Steel

COUPLANT Glycerine INITIAL CALIBRATION TIME 13:40

(CALIBRATION DATA)

STANDARD THICKNESS	INSTRUMENT READING
.755	.756
1.253	1.257
.300	.299
.400	.399
.500	.500

CAL. VERIFICATION TIMES: NA

Final Cal. Check: 16:00

Gain
Sweep
Delay
Filter
Rep. Rate
Dampening
Reject
Digital Range
Calibrate
Velocity

INSTRUMENT START	SETTINGS: FINISH
NA	NA
↓	↓
↓	↓
↓	↓
↓	↓
↓	↓
↓	↓
2348	2349

EXAMINATION DATA FORM

EXAM FORM # LW-08 (34605)

CAL. FORM # LW-08 (34604)

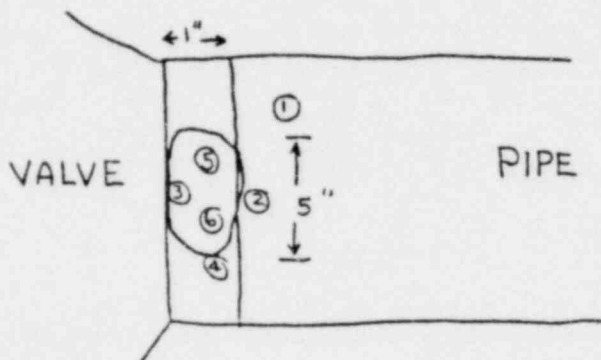
DATE 5/28/80

EXAMINER L. D. Wheatley LEVEL III DATA TAKER _____ LEVEL _____

MATERIAL THICKNESS	① 0.490	② 0.379	③ 0.330	④ 0.403
PIT GAUGE READINGS				
REMAINING WALL THK.	⑤ 0.330	⑥ 0.331		

WELD NO. IRH-1001 NOMINAL PIPE THICKNESS 0.406

NCR. NO. INCR-98 MINIMUM WALL 0.355

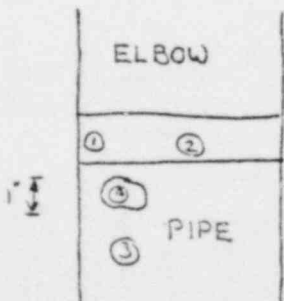


Area is 18" From top dead center

MATERIAL THICKNESS	① 0.404	② 0.396	③ 0.385	
PIT GAUGE READINGS				
REMAINING WALL THK.				④ 0.359

WELD NO. IHP-1005-68 NOMINAL PIPE THICKNESS 0.375

NCR. NO. NA MINIMUM WALL 0.328



INCR-98

FORM 15-1.1
12-10-72 (Rev. 2)

429

PERFORMANCE REPORT FOR CONSTRUCTION AND TEST

1 of 4

DESCRIPTION OF ITEM (EQUIPMENT, MATERIAL, COMPONENT, PART)
PIPES

ITEM NO. (AT 100, 1000, 10000, EQUIP. NO.)
1RHO3BB-12
MANUFACTURER/UTL
B.F. SHAW

RESIDUAL VALUE
REMOVAL UNIT
DAMAGE
DWG NONCONFORMANCE
REC NONCONFORMANCE

BASED ON
CONSTRUCTION
CONTRACTOR TEST
WORK REQUEST NO.

P.O. NO. & P.O. ITEM NO.
172801

NA NA

DESCRIPTION OF NONCONFORMANCE
THERE IS AN AREA APPROX 1'x5' ON THE
BETWEEN THE 1RHO3BB AND
1RHO3BB-12 WITH A WALL
KINDS OF O.B.E.O. THIS IS BEING
WALL

SIGNATURE NAME DESIGNATION DATE
NONCONFORMANCE OBSERVED BY [Signature] SPT 5-29-80
NONCONFORMANCE REPAIRED BY [Signature] SPT 5/29/80
CHECKED BY [Signature] SPT 7/30/80
APPROVED BY [Signature] SPT 5/29/80

10CFR 150.55 Report Required

ALL THE... WHEN...
AT THE... OF THE WELL.

ACCEPTABLE AS IS.

NONE REQUIRED

APPROVED BY [Signature]
DATE [Signature]

3-11-81
AD

SARGENT & LUNDY
ENGINEERS

FOUNDED BY FREDERICK SARGENT-1891
55 EAST MONROE STREET
CHICAGO, ILLINOIS 60603
TELEPHONE 312-269-2000
CABLE ADDRESS - SARGLUN-CHICAGO

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 394, 402, 408, 409,
429, 432, 453 & 480

Mr. T. E. [unclear]
General [unclear] Engineer
Commonwealth Edison Company
E. O. [unclear] - 3501W
Chicago, Illinois 60690

Dear Mr. [unclear]:

The above NCR's all deal with potential minimum wall
violations due to either excessive counterboring or PT
indications on wall. A minimum wall calculation has been
performed for each case based upon design conditions for
the area involved. In all cases the remaining wall thickness
exceeds the specified minimum wall thickness. Therefore, no
repair is necessary and all the above NCR's should be
accepted as is for the final disposition.

If you have any questions, please contact me.

Yours very truly,

G. I. Swarich

G. I. Swarich
Mechanical Engineer

GIZ:cb

In duplicate

Copies:

L. J. Burke

R. H. Pollock

T. E. Quinn

D. C. Haas

V. G. Schwartz

A. R. Weaver

G. C. Jones

A. R. Lertz

C. A. Riebel

NONCONFORMITY REPORT

REVISION NO. 0

Project La Salle PSI Report No. INCR-99

Initiated By L W Wheatley Date 5/29/80

Project No. LCS-PO173-1 Drawing No. IRH-1045

Item, Assembly Joint No. Weld IRH-1045-5

Heat & Lot, Serial No. (if applicable) _____

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. UT Report LW-11

Description of Nonconformity

Minimum wall violation on weld IRH-1045-5 caused during grind-out of penetrant indications. See UT Report LW-11 for details

Proposed Resolution

RESOLUTION PER CECO ENGINEERING

Signature L W Wheatley Date 5/30/80

Comments

Resolution Approved By	<u>L W Wheatley</u>	Date	<u>5/30/80</u>
Reviewed with ANI By	<u>W J Caldwell</u>	Date	<u>3-11-81</u>
Completed	<u>L W Wheatley</u>	Date	<u>3/11/81</u>

LASALLE COUNTY NUCLEAR STATION

U.T. CALIBRATION FORM

FORM # LW-10

DATE 5/29/80

EXAMINER L. W. Heasley LEVEL III DATA TAKER _____ LEVEL _____

INSTRUMENT MODEL Nortec 131D SERIAL NO. 339

TRANSDUCER SIZE 0.25" DIA FREQ. 5.0 MHz SERIAL NO. 025810

CALIBRATION STD. CSC-1 - Step Wedge MATERIAL Carbon Steel

COUPLANT Glycerine INITIAL CALIBRATION TIME 1420

(CALIBRATION DATA)

STANDARD THICKNESS	INSTRUMENT READING
0.755	0.758
1.255	1.258
1.300	1.302
1.400	1.404
1.500	1.504

CAL. VERIFICATION TIMES: NA

Final Cal. Check: 1600

	INSTRUMENT START	SETTINGS: FINISH
Gain	70dB	70dB
Sweep	880	880
Delay	468	468
Filter	OFF	OFF
Rep. Rate	3k	3k
Dampening	OFF	OFF
Reject	OFF	OFF
Digital Range	2"	2"
Calibrate	236	236
Velocity	596	596

EXAMINATION DATA FORM

EXAM FORM # LW-11

CAL. FORM # LW-10

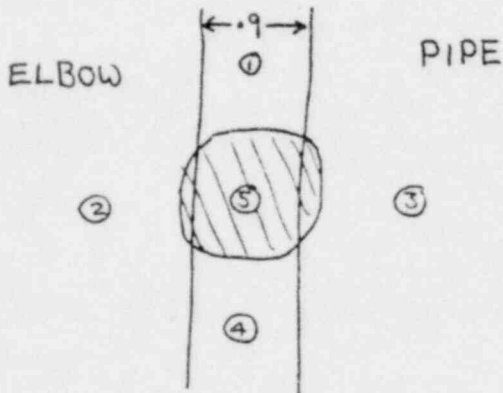
DATE 5/29/80

EXAMINER L. J. Healey LEVEL III DATA TAKER _____ LEVEL _____

MATERIAL THICKNESS	① .347	② .339	③ .313	④ .330
PIT GAUGE READINGS				
REMAINING WALL THK.	⑤ .256			

WELD NO. IRH-1045-5 NOMINAL PIPE THICKNESS 0.322

NCR. NO. INCR-99 MINIMUM WALL 0.282

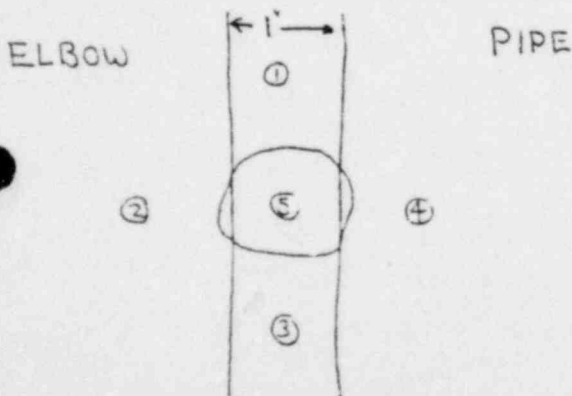


Ground out area is approximately 1.0" diameter and located 180° from Top Dead Center.

MATERIAL THICKNESS	① 1.029	② 1.091	③ 1.048	④ .985
PIT GAUGE READINGS				
REMAINING WALL THK.	⑤ .875			

WELD NO. IRH-1001-13 NOMINAL PIPE THICKNESS 1.00

NCR. NO. NA MINIMUM WALL 0.875



Ground out area is approximately 1.0" diameter and located 180° from Top Dead Center.

"ORIGINAL" INCR-99

FORM OF 15-1.1
12-15-78 (Rev.2)

NONCONFORMANCE REPORT FOR CONSTRUCTION AND TEST

ITEM NO. 432
PAGE 1 OF 4

Commonwealth Edison

DESCRIPTION OF ITEM (EQUIPMENT, MATERIAL, COMPONENT, PART)

RHR PIPING

ITEM NO. (PART NO., SER. NO., EQUIP. NO.)

1RH23AB-8"

MANUFACTURER/SUPPLIER

MERRISON CONST CO.

SYSTEM AND UNIT

RESIDUAL HEAT REMOVAL UNIT #1

CATEGORY

- DEFECT
- DAMAGE
- DWG NONCONFORMANCE
- SPEC NONCONFORMANCE
- FAILURE
- CORROSION
- MISIDENTIFICATION

INSPECTED

- SUPPLIER INSPECTION
- CONTRACTOR TEST

CONTRACTOR

TEST

DESCRIPTION OF NONCONFORMANCE

THERE IS AN AREA APPROX 1" DIA ON
END WELL WITH SCAB ON LINE
23AB-8" WITH A WALL THICKNESS
0.256" SEE ATTACHED UT REPORT

P.O. NO. / P.O. ITEM NO.

18110

FIELD TAG NO.

WORK REQUEST NO.

N/A

SIGNATURE

NAME

DEPARTMENT

DATE

NONCONFORMANCE OBSERVED BY

J. H. Smith

SEC

6-2-80

NONCONFORMANCE VERIFIED BY

J. H. Smith

Station

6/2/80

QA SUPV OR COORDINATOR

P. J. Smith

QA

6/2/80

DATE OF FIELD REPORT

6/2/80

10CFR 50.55a Report Required

Yes No

ALL ARE CREATED WHEN REMOVING
INDICATIONS ON THE SURFACE OF THE WELD DURING ISI
ASSEMBLY

ACCEPTABLE AS IS

ISOLATED OCCURRENCE - NONE REQUIRED

ACCEPTABLE AS IS

NONE REQUIRED

DATE

PC

3-11

[Handwritten signature]

[Handwritten signature]

SARGENT & LUNDY
ENGINEERS

FOUNDED BY FREDERICK SARGENT-1891
55 EAST MONROE STREET
CHICAGO, ILLINOIS 60603
TELEPHONE - 312-269-2000
CABLE ADDRESS - SARGLUN-CHICAGO

February 5, 1961
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 394, 402, 403, 409,
429, 432, 453 & 480

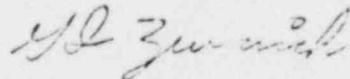
Mr. T. E. Watts
General Design Engineer
Commonwealth Edison Company
P. O. Box 767 - 3504W
Chicago, Illinois 60690

Dear Mr. Watts:

The above NCR's all deal with potential minimum wall thickness due to either excessive counterboring or PT (identical) removal. A minimum wall calculation has been performed for each case based upon design conditions for the areas involved. In all cases the remaining wall thickness exceeds the required minimum wall thickness. Therefore, no repair is necessary and all of the above NCR's should be accepted as is for the final disposition.

If you have any questions, please contact me.

Yours very truly,



G. I. Zvarich
Mechanical Engineer

GIZ:cb
In duplicate
Copies:

L. J. Burke	W. G. Schwartz	C. A. Riebel
R. H. Holjak	E. R. Kaver	
T. E. Quake	G. C. Jones	
D. C. Mann	E. R. Fortz	

NONCONFORMITY REPORT

REVISION NO. 0

Project LaSalle I PSI Report No. INCR-103

Initiated By L W Wheatley Date 8/14/80

Project No. LCS-P0173-1 Drawing No. IRI-1004

Item, Assembly Joint No. Weld IRI-1004-37

Heat & Lot, Serial No. (if applicable) NA

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. EDS 77465

Description of Nonconformity

During removal of penetrant indications, minimum wall has been violated. Remaining wall thickness is 0.258 in the excavation area whereas minimum wall is 0.273.

Proposed Resolution

RESOLUTION PER CECO ENGINEERING

Signature S. Stenely Date 8/14/80

Comments

Resolution Approved By	<u>L W Wheatley</u>	Date	<u>8/14/80</u>
Reviewed with ANI By	<u>W J Caldwell</u>	Date	<u>3-11-81</u>
Completed	<u>L W Wheatley</u>	Date	<u>3/11/81</u>

LASALLE COUNTY NUCLEAR STATION
U.T. CALIBRATION FORM

FORM # 77464
 DATE 8-6-80

EXAMINER Callender LEVEL I DATA TAKER al Green LEVEL II
 INSTRUMENT MODEL CL 202 SERIAL NO. 801203
 TRANSDUCER SIZE .25 FREQ. N/A MHZ SERIAL NO. A-28031
 CALIBRATION STD. CSC-1 MATERIAL C.S.
 COUPLANT GLYCERINE INITIAL CALIBRATION TIME 0819

(CALIBRATION DATA)

STANDARD THICKNESS	INSTRUMENT READING
<u>1.486</u>	<u>1.486</u>
<u>1.253</u>	<u>1.254</u>
<u>.755</u>	<u>.756</u>

CAL. VERIFICATION TIMES: 1109
1233
 Final Cal. Check: 1515

Gain
 Sweep
 Delay
 Filter
 Rep. Rate
 Dampening
 Reject
 Digital Range
 Calibrate
 Velocity

INSTRUMENT START	SETTINGS: FINISH
<u>2324</u>	<u>2324</u>

NDE Sup.
S. O'Malley 8/7/80

NDE Sup.
Strommally 8/7/80

EXAMINATION DATA FORM

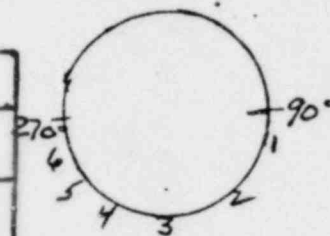
EXAM FORM # 77465

CAL. FORM # 77464

DATE 8-6-80

EXAMINER CA Homer LEVEL II DATA TAKER al Green LEVEL II

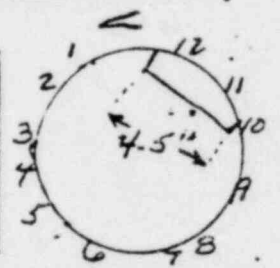
	1	2	3	4	5	6
MATERIAL THICKNESS	.317	.263	.257	.257	.256	.311
PIT GAUGE READINGS	.333	.295	.265	.294	.297	.334
REMAINING WALL THK.	.349	.257	.313	.311	.258	.271



WELD NO. 1R1-1004-37 NOMINAL PIPE THICKNESS _____
 NCR NO. INCR-103 MINIMUM WALL .273

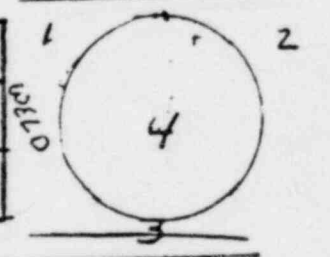
ELBOW

	1	2	3	4
MATERIAL THICKNESS	.499	.492	.522	.545
PIT GAUGE READINGS	.674	.673	.670	.654
REMAINING WALL THK.	.494	.463	.481	.468



WELD NO. 1R1 1005-1 NOMINAL PIPE THICKNESS _____
 NCR NO. 4.5" CCW; AND 1/2" FROM EDGE OF WELD MINIMUM WALL .490

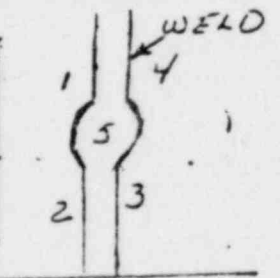
	1	2	3	4
MATERIAL THICKNESS	.434	.472	.379	.308
PIT GAUGE READINGS				
REMAINING WALL THK.	EXCAVATION 1.5" by 1"			



WELD NO. 1R1-1019-11 NOMINAL PIPE THICKNESS _____
 NCR NO. INCR-105 MINIMUM WALL .310

12" From V

	1	2	3	4
MATERIAL THICKNESS	.307	.306	.426	.397
PIT GAUGE READINGS	.285			
REMAINING WALL THK.				



WELD NO. 1R1-1004-57 NOMINAL PIPE THICKNESS _____
 NCR. NO. _____ MINIMUM WALL _____

INCR103, INCR104, INCK105

FORM 15-1.1
12-1-78 (Rev. 2)

NONCONFORMANCE REPORT FOR CONSTRUCTION AND TEST

453
1 of 10

3. DESCRIPTION OF ITEM (EQUIPMENT, MATERIAL, COMPONENT, PART)

PIPE WELD

5. SYSTEM AND UNIT

UNIT #

6. CATEGORY

DEFECT
 FAILURE

7. DAMAGE

ONE NONCONFORMANCE
 TWO NONCONFORMANCE

8. OPERATIONAL CONDITION

OPERATION
 MAINTENANCE

9. OBSERVED DURING

SAMPLE INSPECTION
 CONSTRUCTION

CONTRACTOR
 TEST

10. DESCRIPTION OF NONCONFORMANCE

THERE IS AN AREA OF 12 IN. WELD
IN THE 12 IN. BELL WELD = PI 103-7
RI 218 1/2 IN. WELD = RI 218 3/4 IN.
RI 203. SEE REPAIRS 103-7
THE SIZE OF THE WELD AREA

11. P.O. NO. & P.O. ITEM NO.
18110 / 172801

12. INSPECTION TAG NO.
6333-6335

13. WORK REQUEST NO.
N/A

14. SIGNATURE	NAME	EMPLOYMENT	DATE
<i>[Signature]</i>	is [unclear]	STA CONST	8/25/80
<i>[Signature]</i>	Maury E. Johnson	STA CONST.	8/25/80
<i>[Signature]</i>	John [unclear]	QA	8/26/80
<i>[Signature]</i>	John [unclear]	STA CONST	8/25/80

15. CAUSE OF NONCONFORMANCE

MIN WELD AREA CREATED REMAINING
PI INDICATION DURING ISI PIPELINE INSPECTION.

10 CFR 250.555 Reports Required Yes

16. IS THE NONCONFORMANCE ACCEPTABLE AS IS?

ACCEPTABLE AS IS

17. IS THERE A REQUIREMENT TO CORRECT THE NONCONFORMANCE?

NONE REQUIRED

18. IF NOT KNOWN, STATE THE OCCURRENCE

19. DETERMINATION OF ACTION TAKEN TO CORRECT THE NONCONFORMANCE

ACCEPTABLE AS IS.

20. IS THERE A REQUIREMENT TO CORRECT THE NONCONFORMANCE?

NONE REQUIRED

21. SIGNATURE OF PROJECT ENGINEER

[Signature]

PCD

3-11-81

2/23/81 APPROVED BY *[Signature]* 2-23-81
ENGINEERING DEPARTMENT

[Signature]
SUPERVISOR

SARGENT & LUNDY
ENGINEERS

FOUNDED BY FREDERICK SARGENT-1891
55 EAST MONROE STREET
CHICAGO, ILLINOIS 60603
TELEPHONE - 312-269-2000
CABLE ADDRESS - SARLUN-CHICAGO

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 394, 402, 408, 409,
429, 432, 453 & 480

Mr. T. E. Watts
General Design Engineer
Commonwealth Edison Company
P. O. Box 767 - 35FNW
Chicago, Illinois 60690

Dear Mr. Watts:

The above NCR's all deal with potential minimum wall violation due to either excessive counterboring or PT indication removal. A minimum wall calculation has been performed for each case based upon design conditions for the areas involved. In all cases the remaining wall thickness exceeds the required minimum wall thickness. Therefore, no repair is necessary and all the above NCR's should be accepted as is for the final disposition.

If you have any questions, please contact me.

Yours very truly,

G. I. Zwarich

G. I. Zwarich
Mechanical Engineer

GIZ:cb
In duplicate

Copies:

L. J. Burke
R. H. Holyoak
T. E. Quaka
D. C. Haan

W. G. Schwartz
E. R. Weaver
G. C. Jones
E. R. Kartz

C. A. Riebel

NONCONFORMITY REPORT

REVISION NO. 0

Project LaSalle I PSI Report No. INCR-104

Initiated By L.W. Wheatley Date 8/14/80

Project No. LCS-PO173-1 Drawing No. IRI-1005

Item, Assembly Joint No. Weld IRI-1005-1

Heat & Lot, Serial No. (if applicable) NA

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. EDS 77465

Description of Nonconformity

During removal of penetrant indications, minimum wall has been violated. Remaining wall thickness in the excavation is 0.463" whereas minimum wall is 0.490".

Proposed Resolution

RESOLUTION PER CECO ENGINEERING

Signature A. J. Donnelly Date 8/14/80

Comments

Resolution Approved By L.W. Wheatley Date 8/14/80
 Reviewed with ANI By W.G. Caldwell Date 3-11-81
 Completed L.W. Wheatley Date 3/11/81

LASALLE COUNTY NUCLEAR STATION
 U.T. CALIBRATION FORM

FORM # 77464
 DATE 8-6-80

EXAMINER CA Hombler LEVEL II DATA TAKER al Green LEVEL II
 INSTRUMENT MODEL CL 202 SERIAL NO. 801203
 TRANSDUCER SIZE .25 FREQ. N/A MHZ SERIAL NO. A-28031
 CALIBRATION STD. CSC-1 MATERIAL C.S.
 COUPLANT GLYCERINE INITIAL CALIBRATION TIME 0819

(CALIBRATION DATA)

STANDARD THICKNESS	INSTRUMENT READING
1.486	1.486
1.253	1.254
.755	.756

CAL. VERIFICATION TIMES: 1109
1233
 Final Cal. Check: 1515

- Gain
- Sweep
- Delay
- Filter
- Rep. Rate
- Dampening
- Reject
- Digital Range
- Calibrate
- Velocity

INSTRUMENT START	SETTINGS: FINISH
<u>2324</u>	<u>2324</u>

NDE Sup.
S. Lamelly 8/7/80

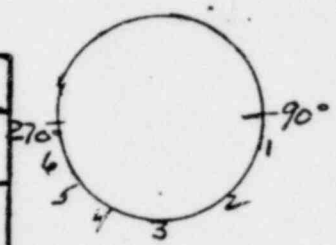
*NDE Sup.
Mormally 8/7/80*

EXAMINATION DATA FORM

EXAM FORM # 77465
CAL. FORM # 77464
DATE 8-6-80

EXAMINER CA Homer LEVEL II DATA TAKER al Duen LEVEL II

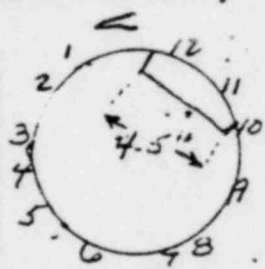
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MATERIAL THICKNESS	.317	.263	.264	.257	.256	.311
PIT GAUGE READINGS	.333	.295	.265	.294	.297	.334
REMAINING WALL THK.	.349	.257	.313	.311	.258	.271



WELD NO. IRI-1004-37 NOMINAL PIPE THICKNESS _____
NCR NO. INCR-103 MINIMUM WALL .273

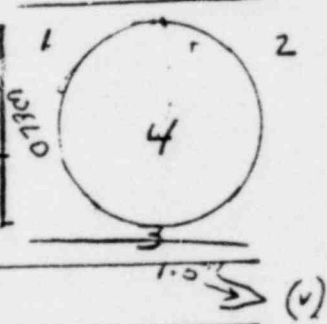
ELBOW

	1	2	3	4
MATERIAL THICKNESS	.499	.492	.522	.545
PIT GAUGE READINGS	.674	.673	.670	.654
REMAINING WALL THK.	.494	.463	.481	.468



WELD NO. IRI 1005-1 NOMINAL PIPE THICKNESS _____
NCR NO. 4.5" CCW; AND 1/2" FROM EDGE of WELD MINIMUM WALL .490

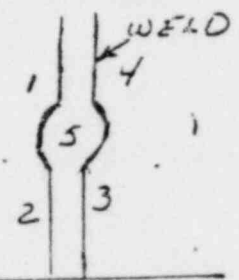
	1	2	3	4
MATERIAL THICKNESS	.434	.472	.379	.308
PIT GAUGE READINGS				
REMAINING WALL THK.	EXCAVATION 1.5" by 1"			



WELD NO. IRI-1019-11 NOMINAL PIPE THICKNESS _____
NCR NO. INCR-105 MINIMUM WALL .310

12" From V

	1	2	3	4
MATERIAL THICKNESS	.307	.306	.426	.397
PIT GAUGE READINGS	.285			
REMAINING WALL THK.				



WELD NO. IRI-1004-57 NOMINAL PIPE THICKNESS _____
NCR. NO. _____ MINIMUM WALL _____

SARGENT & LUNDY
ENGINEERS

FOUNDED BY FREDERICK SARGENT-1891
55 EAST MONROE STREET
CHICAGO, ILLINOIS 60603
TELEPHONE - 312-269-2000
CABLE ADDRESS - SARLUN-CHICAGO

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 394, 402, 408, 409,
429, 432, 453 & 480

Mr. T. E. Watts
General Design Engineer
Commonwealth Edison Company
P. O. Box 767 - 35FWW
Chicago, Illinois 60690

Dear Mr. Watts:

The above NCR's all deal with potential minimum wall violation due to either excessive counterboring or PT indication removal. A minimum wall calculation has been performed for each case based upon design conditions for the areas involved. In all cases the remaining wall thickness exceeds the required minimum wall thickness. Therefore, no repair is necessary and all the above NCR's should be accepted as is for the final disposition.

If you have any questions, please contact me.

Yours very truly,

G. I. Zwarich

G. I. Zwarich
Mechanical Engineer

GIZ:cb
In duplicate
Copies:

L. J. Burke
R. H. Holyoak
T. E. Quaka
D. C. Haan

W. G. Schwartz
E. R. Weaver
G. C. Jones
E. R. Hartz

C. A. Richel

NONCONFORMITY REPORT

REVISION NO. 0

Project La Salle I PSI Report No. INCR-105

Initiated By L W Wheatley Date 8/14/80

Project No. LCS-PC173-1 Drawing No. IRI-1019

Item, Assembly Joint No. Weld IRI-1019-11

Heat & Lot, Serial No. (if applicable) NA

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. EDS 77465

Description of Nonconformity

During removal of penetrant indications, minimum wall has been violated. Remaining wall thickness . . . the excavation is 0.308" whereas minimum wall is 0.310".

Proposed Resolution

~~RESOL~~
RESOLUTION PER RECO ENGINEERING

Signature A. Stoney Date 8/14/80

Comments

Resolution Approved By	<u>L W Wheatley</u>	Date	<u>8/14/80</u>
Reviewed with ANI By	<u>w j Calvert</u>	Date	<u>3-11-81</u>
Completed	<u>L W Wheatley</u>	Date	<u>3/11/81</u>

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

NDE Sup
Monnelly 8/1/80

EXAMINATION DATA FORM

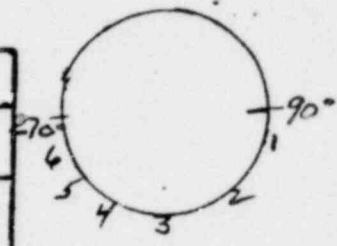
EXAM FORM # 77465

CAL FORM # 77464

DATE 8-6-80

EXAMINER CA Homer LEVEL II DATA TAKER al Green LEVEL II

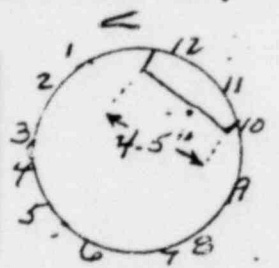
	1	2	3	4	5	6
MATERIAL THICKNESS	.317	.263	.264	.257	.256	.311
PIT GAUGE READINGS	.333	.295	.265	.294	.297	.334
REMAINING WALL THK.	.349	.257	.313	.311	.258	.271



WELD NO. IRI-1004-37 NOMINAL PIPE THICKNESS _____
 NCR NO. INCR-103 MINIMUM WALL .273

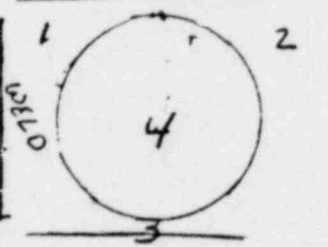
ELBOW

	1	2	3	4
MATERIAL THICKNESS	.499	.492	.522	.545
PIT GAUGE READINGS	.674	.673	.670	.654
REMAINING WALL THK.	.494	.463	.481	.468



WELD NO. IRI 1005-1 NOMINAL PIPE THICKNESS _____
 NCR NO. 4.5" CCW; AND 1/2" FROM EDGE OF WELD MINIMUM WALL .490

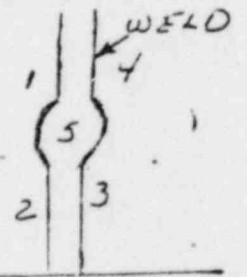
	1	2	3	4
MATERIAL THICKNESS	.434	.472	.379	.308
PIT GAUGE READINGS				
REMAINING WALL THK.	EXCAVATION 1.5' by 1"			



WELD NO. IRI-1019-11 NOMINAL PIPE THICKNESS _____
 NCR NO. INCR-105 MINIMUM WALL .310

12" From V

	1	2	3	4
MATERIAL THICKNESS	.307	.306	.426	.397
PIT GAUGE READINGS	.285			
REMAINING WALL THK.				



WELD NO. IRI-1004-57 NOMINAL PIPE THICKNESS _____
 NCR. NO. _____ MINIMUM WALL _____

SARGENT & LUNDY
ENGINEERS

FOUNDED BY FREDERICK SARGENT-1891
55 EAST MONROE STREET
CHICAGO, ILLINOIS 60603
TELEPHONE - 312-269-2000
CABLE ADDRESS - SARGUN-CHICAGO

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 394, 402, 408, 409,
429, 432, 453 & 480

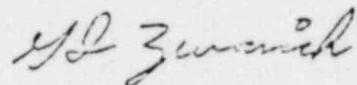
Mr. T. E. Watts
General Design Engineer
Commonwealth Edison Company
P. O. Box 767 - 35FNW
Chicago, Illinois 60690

Dear Mr. Watts:

The above NCR's all deal with potential minimum wall violation due to either excessive counterboring or PT indication removal. A minimum wall calculation has been performed for each case based upon design conditions for the areas involved. In all cases the remaining wall thickness exceeds the required minimum wall thickness. Therefore, no repair is necessary and all the above NCR's should be accepted as is for the final disposition.

If you have any questions, please contact me.

Yours very truly,



G. I. Zwarich
Mechanical Engineer

GIZ:cb
In duplicate
Copies:

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R. H. Holyoak
T. E. Quaka
D. C. Haan

W. G. Schwartz
E. R. Weaver
G. C. Jones
E. R. Kartz

C. A. Riebel

No. 16001

Date 1/31/81

Nozzle Inner Radius UT Calibration
SITE La Salle I

ZONE 1 (2)

PROCEDURE NO. NIRZ2-S751 EXAMINER A.W. Clay ASNT II

REV. 0 RECORDER Thaymit A. ASNT II

CAL. BLOCK NO. MP-1 COUPLANT Glycerine

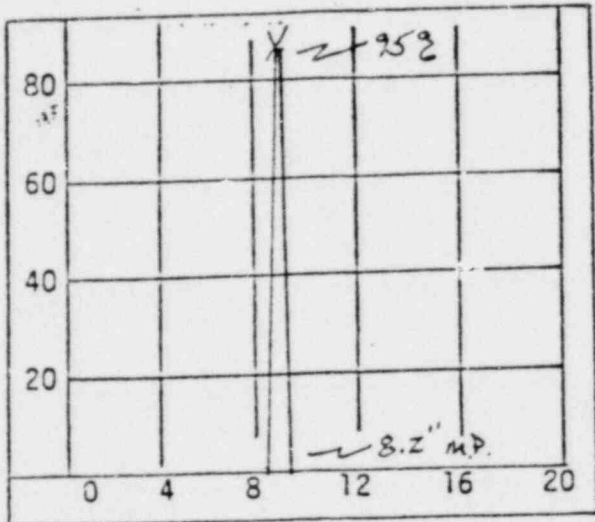
EQUIPMENT DATA: INSTRUMENT MODEL NO. KK USM2 SERIAL NO. 811368

Transducer CALIBRATION EXP. DATE 7/21/81

S/N B10716 TRANSDUCER TYPE AeroTech; SIZE 1.0" Ø FREQ. 1.0 MHz

WEDGE ID NO. LS-NZ-ZZ-CW/CCW

CABLE TYPE RG-174; LENGTH 10'



VERT LIN	
A	B
100	50
90	45
80	40
70	35
60	30
50	25
40	20
30	15
20	10

CONT. LIN.			
SET	dBA		LIMITS
80	-6	40	32-48
80	-12	21	16-24
40	+6	79	64-96
20	+12	80	64-96

B = 50% A
±5% FSH

* Scanning level reduced by 6db to make clad noise acceptable. (10)

INSTRUMENT SETTINGS:

GAIN @ CTB	38	38
dB INCREASE	28	22
GAIN @ 1 X	66	60
GAIN @ 2 X	72	66
SWEEP COURSE	10	10
SWEEP FINE	N/A	N/A
DELAY COURSE	796	796
DELAY FINE	N/A	N/A
FREQ.	N/A	N/A
PULSE REP.	Auto	Auto
PULSE LEVEL	N/A	N/A
PULSE DAMPING	off	off
REJECT	OFF	OFF

* See Note

NA = NOT APPLICABLE TO THIS INSTRUMENT
INITIAL CALIBRATION TIME 1000 0-24 HR.

B-NOTCH AMP.	METAL PATH	TIME
95%	8.2"	1205
95%	8.2"	1500
95%	8.2"	1745 Final

LAST PHOTO NO.

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: James C. Mackinnon DATE: 2-2-81
GENERAL ELECTRIC CO. LEVEL II
2/2/81
S.A. Felton 2/4/81 ANFD

A.W. Clayton
Chief

SHEET NO. 16005 DATE 1/31/81 NOZZLE ID NZ-B

CAL. NO. 16001

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCM	COMMENTS
					<i>ccw/ccw</i>	<i>No Recordable Indications</i>

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: *Shannon C. Moore* DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: 11

2/14/81 GE QC
S.P. TELBO 2/14/81 ANCO

H.W. Chan II
Chan and Co.

SHEET NO. 16007 DATE 1/31/81 NOZZLE ID NZ-K

CAL. NO. 16001

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR Ccw	COMMENTS
					<i>ccw</i>	<i>No Recordable Indications</i>

REVIEWED BY: *Shun C. Mak* DATE: 2-2-81
 GENERAL ELECTRIC CO. LEVEL: #
2/9/81
2/4/81
517010 2/4/81 ANIC

FIGURE 10 DATA RECORD SHEET

No. 16012

Date 1/31/81

ZONE 1 (2)

SITE Nozzle Inner Radius UT Calibration
La Salle I

PROCEDURE NO. NIRZZ-S751 EXAMINER A.W. Clay ASNT II

REV. 0 RECORDER Thompson ASNT II

CAL. BLOCK NO. MP-1 COUPLANT Glycerine

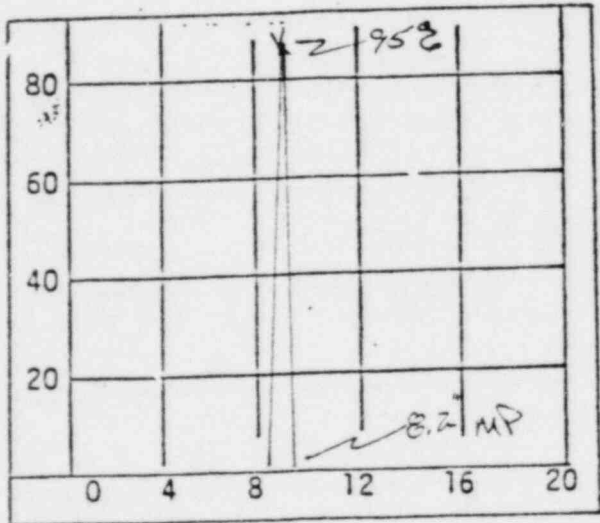
EQUIPMENT DATA: INSTRUMENT MODEL NO. KK USM2 SERIAL NO. 81368

Transducer CALIBRATION EXP. DATE 7/21/81

S/N B10716 TRANSDUCER TYPE Aerotech; SIZE 1.0" Ø FREQ. 1.0 MHz

WEDGE ID NO. Ls-NI-ZZ-Clw & CCW

CABLE TYPE RG-174; LENGTH 10'



VERT LIN	
A	B
100	50
90	45
80	40
70	35
60	30
50	25
40	20
30	15
20	10

CONT. LIN.			
SET	dBΔ		LIMITS
80	-6	40	32-48
80	-12	21	16-24
40	+6	79	64-96
20	+12	80	64-96

B = 50% A
±5% FSH

* Scanning level reduced by 6db to make Clad noise acceptable.

INSTRUMENT SETTINGS:

GAIN @ CTB	38	38
dB INCREASE	32	26
GAIN @ 1 X	70	64
GAIN @ 2 X	76	70
SWEEP COURSE	10	10
SWEEP FINE	N/A	N/A
DELAY COURSE	796	796
DELAY FINE	N/A	N/A
FREQ.	N/A	N/A
PULSE REP.	Auto	Auto
PULSE LEVEL	N/A	N/A
PULSE DAMPING	OFF	OFF
REJECT	OFF	OFF

* see note

NA = NOT APPLICABLE TO THIS INSTRUMENT
INITIAL CALIBRATION TIME 1500 0-24 HR.

B-NOTCH AMP. 95% METAL PATH 8.2" TIME 1745 Final

LAST PHOTO NO.

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: Simon C. MacFerson DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL II

W. Whately 2/4/81 GE-8C

S.A. Felton 2/4/81 ANFF

A.W. Clair IV
Clair with B.U.

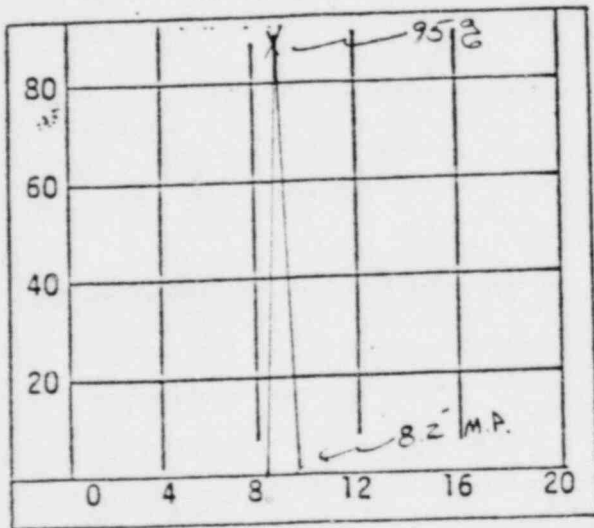
SHEET NO. 16014 DATE 1/31/81 NOZZLE ID N1-B
CAL. NO. 16012

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR Ccw	COMMENTS
45°	75° + 4"	2 1/2"	80	1/2"	Ccw	*
					Cw	No Recordable Indications
						* The "dist" was outside of the prescribed examination area per procedure NIRZ 2-571. The indication revealed very little "walking" which resembled that of "clad noise" as the transducer traversed up the radius towards the inside plate part the examination. (and) the clad noise scan exhibited an increase in amplitude on clad noise regions.
						James C. Sturman

REVIEWED BY: James C. Sturman DATE: 2-2-81
GENERAL ELECTRIC CO. LEVEL: II
2002 Building 2/14/81 GE-QC
S.P. 7660 2/11/81 ANSC

FIGURE 10 DATA RECORD SHEET

No. 16015
Date 2/2/81
SITE La Salle I ZONE 1 (2)
PROCEDURE NO. NIR22-5751 EXAMINER A. W. Clay ASNT II
REV. 0 RECORDER Thomson ASNT II
CAL. BLOCK NO. MP COUPLANT Glycerine
EQUIPMENT DATA: INSTRUMENT MODEL NO. KK-USM2 SERIAL NO. 811368
Transducer S/N 310716 CALIBRATION EXP. DATE 7/21/81
TRANSDUCER TYPE Aerotech; SIZE 1.0" Ø FREQ. 1.0 MHz
WEDGE ID NO. LS-129-22-CW & CW
CABLE TYPE RG-174; LENGTH 10'



VERT LIN	
A	B
100	50
90	45
80	40
70	35
60	30
50	25
40	20
30	15
20	10

B = 50% A
±5% FSH

CONT. LIN.			
SET	dBΔ		LIMITS
80	-6	41	32-48
80	-12	22	16-24
40	+6	78	64-96
20	+12	76	64-96

Final

INSTRUMENT SETTINGS:

GAIN @ CTB	40	40
dB INCREASE	22	22
GAIN @ 1 X	62	62
GAIN @ 2 X	68	68
SWEEP COURSE	10	10
SWEEP FINE	N/A	N/A
DELAY COURSE	790	790
DELAY FINE	N/A	N/A
FREQ.	N/A	N/A
PULSE REP.	Auto	Auto
PULSE LEVEL	N/A	N/A
PULSE DAMPING	OFF	OFF
REJECT	OFF	OFF

NA = NOT APPLICABLE TO THIS INSTRUMENT
INITIAL CALIBRATION TIME 0909 0-24 HR.

B-NOTCH AMP. 95% METAL PATH 8.2" TIME 1155
LAST PHOTO NO. _____

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: Sharon C. MacLennan DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL II

2/3/81 2/4/81 GE-60

SA T. P. 2/4/81 ANIE

No. 16017

Nozzle Inner Radius UT Calibration

Date 2/2/81

SITE LA SALLE I

ZONE 1 2

PROCEDURE NO. NIRZ2-S751 EXAMINER A. H. Clay ASNT II

REV. 0 RECORDER [Signature] ASNT TC

CAL. BLOCK NO. MP.1 COUPLANT GLYCERINE

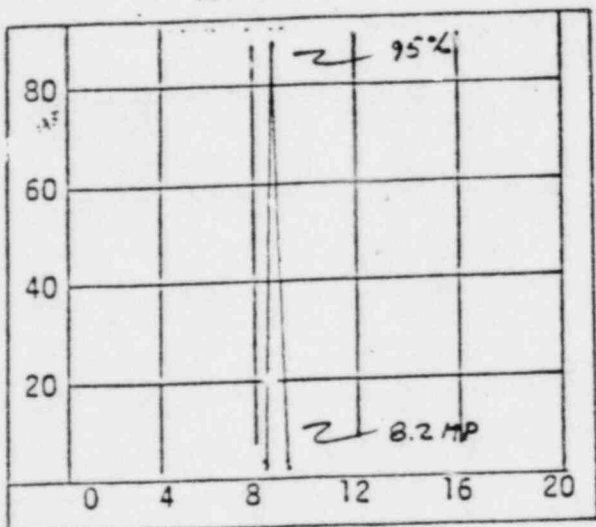
EQUIPMENT DATA: INSTRUMENT MODEL NO. KK 45M2 SERIAL NO. 811368

TRANS DUCER CALIBRATION EXP. DATE 7/21/81

TRANS DUCER TYPE AEROTECH; SIZE 1.0" ϕ FREQ. 1.0 MHz

WEDGE ID NO. LS-N4-22-CW & CCW

CABLE TYPE RG-174; LENGTH 10'



VERT LIN	
A	B
100	50
90	20
80	40
70	35
60	30
50	25
40	20
30	15
20	10

CONT. LIN.			
SET	dB Δ		LIMITS
80	-6	41	32-48
80	-12	22	16-24
40	+6	78	64-96
20	+12	76	64-96

B = 50% A
 $\pm 5\%$ FSH

* 2 dB WAS ADDED FINAL FOR SCANNING TO BRING UP CLADDING REFLECTIONS

INSTRUMENT SETTINGS:

GAIN @ CTB	40	40
dB INCREASE	26	28
GAIN @ 1 X	66	68
GAIN @ 2 X	72	74
SWEEP COURSE	10	10
SWEEP FINE	N/A	N/A
DELAY COURSE	790	790
DELAY FINE	N/A	N/A
FREQ.	N/A	N/A
PULSE REP.	Auto	AUTO
PULSE LEVEL	N/A	N/A
PULSE DAMPING	OFF	OFF
REJECT	OFF	OFF

* See Note

NA = NOT APPLICABLE TO THIS INSTRUMENT
INITIAL CALIBRATION TIME 0909 0-24 HR.

B-NOTCH AMP. Final 95% METAL PATH: 8.2" TIME: 1155

LAST PHOTO NO. _____

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: [Signature] DATE: 2-3-81
GENERAL ELECTRIC CO. LEVEL II
[Signature] 2/4/81 GE-QL
S. J. Felton 2/4/81 ANEE

A.W. Clay II
Checked with [Signature]

NOZZLE ID W6-B

DATE 2/2/81

SHEET NO. 16019

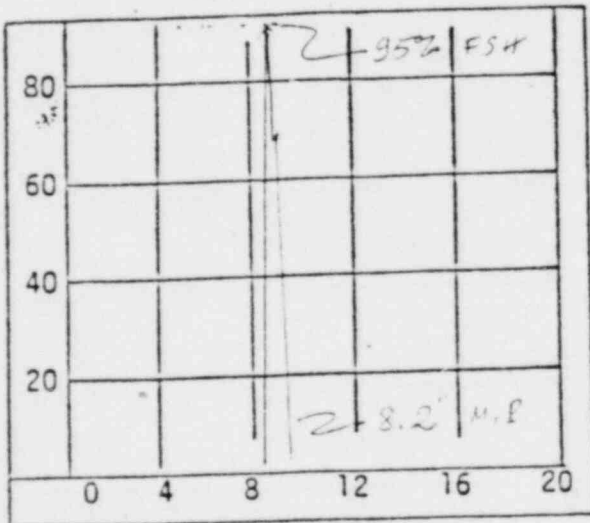
CAL. NO. 16017

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCH	COMMENTS
					<u>CW</u> <u>CCW</u>	<u>No Recordable Indications</u>

REVIEWED BY: Shane C. Markham DATE: 2-3-81
GENERAL ELECTRIC CO. LEVEL " "
S.I. [Signature] 2/4/81 ANDE

FIGURE 10 DATA RECORD SHEET

No. 16021
 Date 2/13/81
 SITE LA SALLE I ZONE ① 2
 PROCEDURE NO. NIRZ1-5751 EXAMINER A. J. Clay ASNT II
 REV. 0 RECORDER Thompson ASNT II
 CAL. BLOCK NO. MP-1 COUPLANT Glycerine
 EQUIPMENT DATA: INSTRUMENT MODEL NO. KK USA-2 SERIAL NO. 81136R
 TRANSDUCER S/N: B10716 CALIBRATION EXP. DATE 7/21/81
 TRANSDUCER TYPE Adoptech; SIZE 1.0" Ø FREQ. 1.0 MHz
 WEDGE ID NO. LS-N5-Z1 CW & CCW
 CABLE TYPE RG 174; LENGTH 10'



VERT LIN	
A	B
100	50
90	45
80	40
70	35
60	30
50	25
40	20
30	15
20	10

CONT. LIN.			
SET	dBΔ	LIMITS	
80	-6	42	32-48
80	-12	22	16-24
40	+6	78	64-96
20	+12	75	64-96

B = 50% A
 ±5% FSH

INSTRUMENT SETTINGS:

GAIN @ CTB	38	38
dB INCREASE	22	22
GAIN @ 1 X	60	60
GAIN @ 2 X	65	66
SWEEP COURSE	10	10
SWEEP FINE	N/A	N/A
DELAY COURSE	8.02	8.02
DELAY FINE	N/A	N/A
FREQ.	N/A	N/A
PULSE REP.	Auto	Auto
PULSE LEVEL	N/A	N/A
PULSE DAMPING	OFF	OFF
REJECT	OFF	OFF

NA = NOT APPLICABLE TO THIS INSTRUMENT
 INITIAL CALIBRATION TIME 08:50 0-24 HR.

B-NOTCH AMP.	METAL PATH	TIME
<u>95%</u>	<u>5.2"</u>	<u>12:08</u>
<u>75%</u>	<u>5.2"</u>	<u>14:03</u>
<u>55%</u>	<u>5.2"</u>	<u>17:15</u>

LAST PHOTO NO.

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: A. J. Clay DATE: 2-13-81

GENERAL ELECTRIC CO. LEVEL II

S.A. Felton A. J. Clay
 2/14/81 OK-CC

SHEET NO. 16024 DATE 2/3/81 NOZZLE ID W4-B
CAL. NO. 16021

A.W. Davis
Transmittal

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
45	330	1 5/8"	50	4.0	cw	<p>These indications were typical weld metal indications recorded for "information only." These indications are not rejectable due to the high ⁴⁶gain used by this technique.</p> <p><i>Spec. i. Mark from 2-X-81</i></p>
45	330	1 1/2"	50	5.8"	cw	
45	345 + Z	1.0"	30	5.0"	cw	
45	345 + Z	1 1/4"	40	5.0"	ccw	
45	330	1 3/4"	40	5.0"	ccw	

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: *Spec. i. Mark from* DATE: 2-X-81
GENERAL ELECTRIC CO. LEVEL: 4
2/3/81
Ed. Feltner 2/11/81 ANSE

SHEET NO. 16028 DATE 2/3/81 NOZZLE ID W4-F
CAL. NO. 16021

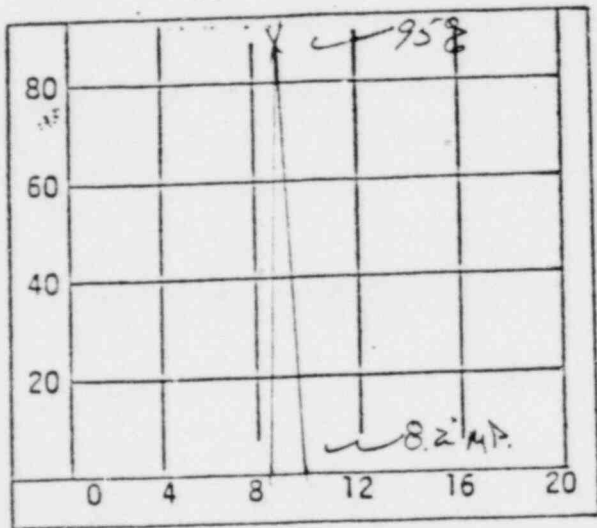
A.W. Clark
Chang and Co. Inc.

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSII	METAL PATH	SCAN CW OR CCW	COMMENTS
45	150 +2 3/4	1 5/8	40	4.4"	CW	* See IPIs 16024 for explanation See 2-1-81
					CCW	No Resorbable Indications.

REVIEWED BY: [Signature] DATE: 2-2-81
GENERAL ELECTRIC CO. LEVEL: 0
2/3/81
S.A. [Signature] 2/4/81

FIGURE 10 DATA RECORD SHEET

No. 16022
Date 2/3/81
SITE La Salle I ZONE 1 (2)
PROCEDURE NO. NIRZ-5751 EXAMINER A.W. Clay ASNT II
REV. 0 RECORDER Thomson ASNT II
CAL. BLOCK NO. MP-1 COUPLANT Glycerine
EQUIPMENT DATA: INSTRUMENT MODEL NO. KK-USM2 SERIAL NO. 811368
Transducer SN B1071L CALIBRATION EXP. DATE 7/21/81
TRANSDUCER TYPE Aerotech; SIZE 1.0" Ø FREQ. 1.0 MHZ
WEDGE ID NO. LS-N4-22-CW & CCW
CABLE TYPE RG-174; LENGTH 10'



VERT LIN	
A	B
100	50
90	45
80	40
70	35
60	30
50	25
40	20
30	15
20	10

B = 50% A
±5% FSH

CONT. LIN.			
SET	dBΔ		LIMITS
80	-6	42	32-48
80	-12	22	16-24
40	+6	78	64-96
20	+12	75	64-96

INSTRUMENT SETTINGS:

GAIN @ CTB
dB INCREASE
GAIN @ 1 X
GAIN @ 2 X
SWEEP COURSE
SWEEP FINE
DELAY COURSE
DELAY FINE
FREQ.
PULSE REP.
PULSE LEVEL
PULSE DAMPING
REJECT

38	38
26	26
64	64
70	70
10	10
N/A	N/A
802	802
N/A	N/A
N/A	N/A
Auto	Auto
N/A	N/A
OFF	OFF
OFF	OFF

NA = NOT APPLICABLE TO THIS INSTRUMENT
INITIAL CALIBRATION TIME 0850 0-24 HR.

B-NOTCH AMP.	METAL PATH	TIME
95	8.2"	1208
95	8.2"	1403
95	8.2"	1715

LAST PHOTO NO.

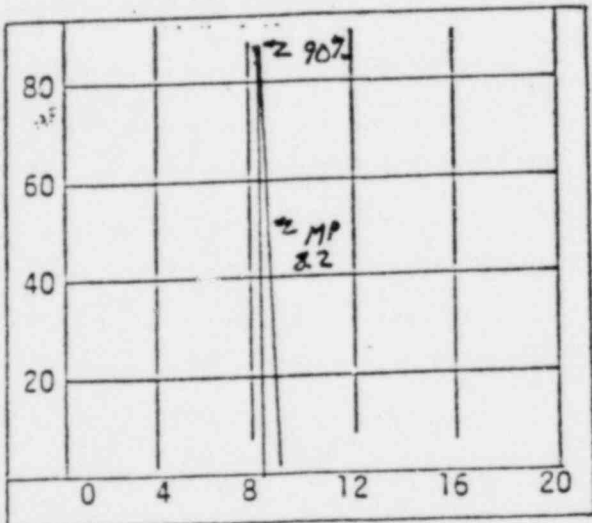
FIGURE 8 CALIBRATION SHEET

REVIEWED BY: James C. Henderson DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL II

2-151 GE-RC
S.A. Feltner 2/4/81 ANII

No. 73005
Date 2/4/81
SITE LASALLE I ZONE 1 (2)
PROCEDURE NO. NIRZ2-S751 EXAMINER Bob Dummer ASNT II
REV. 0 RECORDER Robert Livingston ASNT II
CAL. BLOCK NO. MP-1 COUPLANT GLYCERINE
EQUIPMENT DATA: INSTRUMENT MODEL NO. SONIC MARK I SERIAL NO. 732203
CALIBRATION EXP. DATE 4/28/81
S/N # K02612 TRANSDUCER TYPE AERITECH; SIZE 1.0" Ø FREQ. 1.0 MHZ
WEDGE ID NO. LS-N5-Z2-CW FCCW
CABLE TYPE RG-174; LENGTH 6'



VERT LIN	
A	B
100	50
90 99	44
80	40
70 72	36
60 58	28
50	24
40	18
30	13
20	8

CONT. LIN.			
SET	dBΔ		LIMITS
80	-6	42	32-48
80	-12	22	16-24
40	+6	82	64-96
20	+12	76	64-96

INSTRUMENT SETTINGS:

GAIN @ CTB	46	46
dB INCREASE	30	30
GAIN @ 1 X	76	76
GAIN @ 2 X	82	82
SWEEP COURSE	50	50
SWEEP FINE	1.11	1.11
DELAY COURSE	2.54	2.54
DELAY FINE	N/A	N/A
FREQ.	B	B
PULSE REP.	3K	3K
PULSE LEVEL	N/A	N/A
PULSE DAMPING	N/A	N/A
REJECT	OFF	OFF

NA = NOT APPLICABLE TO THIS INSTRUMENT
INITIAL CALIBRATION TIME 0845 0-24 HR.
B-NOTCH AMP. 90% METAL PATH 8.2 TIME 1220
LAST PHOTO NO. _____

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: [Signature] DATE: 2-3-81
GENERAL ELECTRIC CO. LEVEL II
S.A. Felton 2/4/81 ANIE

No. 73008

Date 2/4/81

ZONE 1 (2)

Nozzle Inner Radius UT Calibration
SITE LA SALLE I

PROCEDURE NO. NIRZ2-S751 EXAMINER Earl Dummer ASNT II

REV. 0 RECORDER Robert Smith ASNT II

CAL. BLOCK NO. MP-1 COUPLANT GLYCERINE

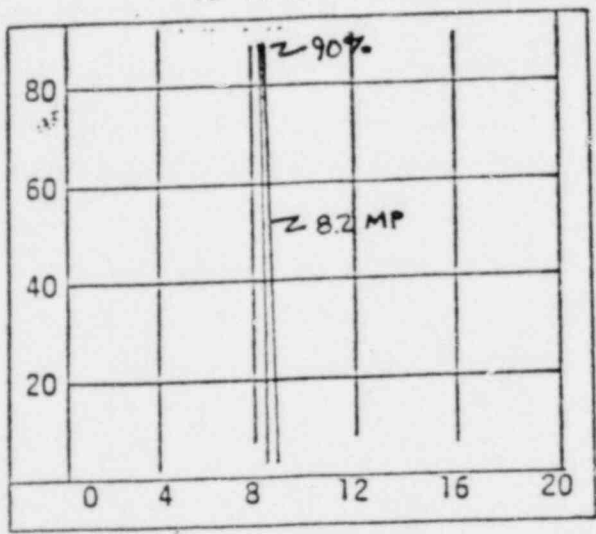
EQUIPMENT DATA: INSTRUMENT MODEL NO. SONIC MARK I SERIAL NO. 732203

CALIBRATION EXP. DATE 4/28/81

S/N # K02612 TRANSDUCER TYPE AEROTECH; SIZE 1.0" ϕ FREQ. 1.0 MHz

WEDGE ID NO. LS-N3-Z2-CW $\&$ CCW

CABLE TYPE RG-174; LENGTH 6'



INSTRUMENT SETTINGS:

GAIN @ CTB	46	46
dB INCREASE	26	26
GAIN @ 1 X	72	72
GAIN @ 2 X	78	78
SWEEP COURSE	50	50
SWEEP FINE	1.11	1.11
DELAY COURSE	2.54	2.54
DELAY FINE	N/A	N/A
FREQ.	B	B
PULSE REP.	3K	3K
PULSE LEVEL	N/A	N/A
PULSE DAMPING	N/A	N/A
REJECT	OFF	OFF

VERT LIN

A	B
100	50
90	44
80	40
70	36
60	28
50	24
40	18
30	13
20	8

CONT. LIN.

SET	dB Δ	LIMITS
80	-6	42 32-48
80	-12	22 16-24
40	+6	82 64-96
20	+12	76 64-96

NA = NOT APPLICABLE TO THIS INSTRUMENT
INITIAL CALIBRATION TIME 0845 0-24 HR.

B-NOTCH AMP. 90% METAL PATH 8.2 TIME 1220 Final

LAST PHOTO NO.

REVIEWED BY: Shuen C. Woodman DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL "1"

S.A. Felton 2/4/81 ANEE

FIGURE 8 CALIBRATION SHEET

SHEET NO. 43007 DATE 2/3/81 NOZZLE ID A3FA
 CAL. NO. 7308

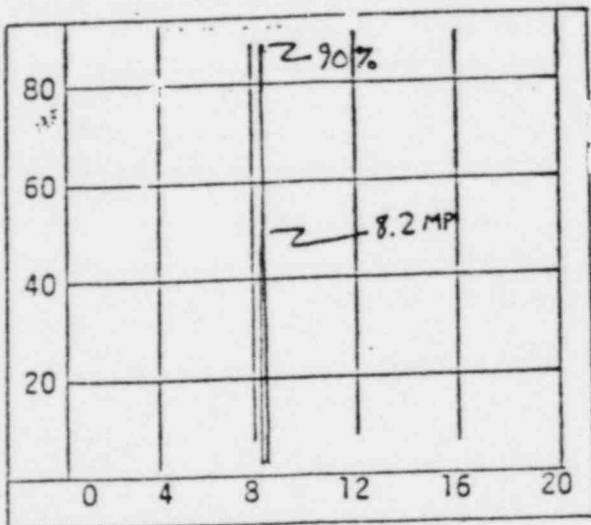
ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCM	COMMENTS
					CW + CCM	No Recordable Indications

EXAMINER Bud Dummer Level II
 Recorder Robert Long Level II

REVIEWED BY: James C. Anderson DATE: 2-3-81
 GENERAL ELECTRIC CO. LEVEL II
 J.C. Anderson 2/4/81 GE-QC
 S.D. Peltow 2/4/81 ANSE
 GENERAL ELECTRIC CO. LEVEL II
 S.D. Peltow 2/4/81 GE-QC
 S.D. Peltow 2/4/81 ANSE

FIGURE 10 DATA RECORD SHEET

No. 73013
Date 2/4/81
SITE LASALLE I ZONE 1 (2)
PROCEDURE NO. NIRZ2-S751 EXAMINER Bud Dummer ASNT II
REV. 0 RECORDER Robert [unclear] ASNT IT
CAL. BLOCK NO. MP-1 COUPLANT GLYCERINE
EQUIPMENT DATA: INSTRUMENT MODEL NO. SONIC MARK I SERIAL NO. 732203
CALIBRATION EXP. DATE 4/28/81
S/N# K02612 TRANSDUCER TYPE AEROTECH; SIZE 1.0" Ø FREQ. 1.0 MHz
WEDGE ID NO. LS-N4-22-CW & CCW
CABLE TYPE RG-174; LENGTH 6'



VERT. LIN	
A	B
100	50
90 89	44
80	40
70 72	36
60 58	28
50	24
40	18
30	13
20	8

B = 50% A
±5% FSH

CONT. LIN.			
SET	dBΔ		LIMITS
80	-6	42	32-48
80	-12	22	16-24
40	+6	82	64-96
20	+12	76	64-96

INSTRUMENT SETTINGS:

GAIN @ CTB	46	46
dB INCREASE	26	26
GAIN @ 1 X	72	72
GAIN @ 2 X	78	78
SWEEP COURSE	50	50
SWEEP FINE	1.11	1.11
DELAY COURSE	2.54	2.54
DELAY FINE	N/A	N/A
FREQ.	8	8
PULSE REP.	3K	3K
PULSE LEVEL	N/A	N/A
PULSF AMPING	N/A	N/A
REC	OFF	OFF

NOT APPLICABLE TO THIS INSTRUMENT
CALIBRATION TIME 0845 0-24 HR.

WITCH AMP.	METAL PATH	TIME
90%	8.2	1220
90%	8.2	1500
90%	8.2	1550 FINAL

LAST PHOTO NO.

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: [Signature] DATE: 2-3-81
GENERAL ELECTRIC CO. LEVEL II
[Signature] 2/4/81 GE-SC
S.A. [Signature] 2/4/81 ANSI

GENERAL ELECTRIC

GENERAL ELECTRIC COMPANY, 814 COMMERCE DR., OAK BROOK, ILL. 60521

INSTALLATION AND
SERVICE ENGINEERING
DIVISION

June 24, 1980

cc: N. R. Casey
S. D. Connelly
L. W. Wheatley
M. E. Williams
D. W. Zebrauskas

Mr. G. E. Groth
Station Construction Department
Commonwealth Edison Company
LaSalle County Nuclear Station
R. R. #1, Box 240
Marseilles, Illinois 61341

SUBJECT: EXEMPTION CLARIFICATION OF CONTROL ROD DRIVES (CRD)
FROM ASME SECTION XI CATEGORY B-0 EXAMINATIONS.

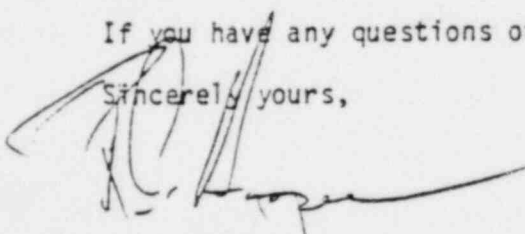
- Reference:
1. LaSalle County Station's Final Safety Analysis Report (FSAR), 4.6.2.3.1 Control Rod Drives (Safety Evaluation), specifically 4.6.2.3.1.2.5 Housing Wall Ruptures Page 4.6-22.
 2. R. C. Hooper, GE letter of March 7, 1979 to T. E. Watts, CECO, re: Pipe Size Exclusions.

Dear Mr. Groth:

The CRD's are exempted from ASME Section XI Category B-0 (Volumetric) Examinations by Section XI IWB-1220 (b) (1). The CRD nominal pipe size is 6" diameter; however, the effective cross-sectional area is 1.81" in diameter using Reference 1 of 1030 gpm maximum leak rate, and Reference 2, the water analysis. The maximum allowable pipe size excluded is 2.23" in diameter as calculated in Reference 2. Thus, the CRD's are exempt from Category B-0.

If you have any questions or comments, please don't hesitate to call or write.

Sincerely yours,


R. C. Hooper
NDE Supervisor
Central Nuclear Service Operation

RCH:ck

PSI Ref. No. RPV-3

6-24-80

GENERAL ELECTRIC

INSTALLATION AND
SERVICE ENGINEERING
DIVISION

GENERAL ELECTRIC COMPANY, 814 COMMERCE DR., OAK BROOK, ILL. 60521

March 7, 1979

Mr. T. E. Watts
Project Engineer
Commonwealth Edison Company
Post Office Box 767
Chicago, IL 60690

SUBJECT: Pipe Sizes Excluded Under Paragraph IWB-1220(b)(1) of ASME
B&PV Code Section XI of LaSalle County Station Unit 1
Reactor Coolant Systems

Dear Mr. Watts:

This letter is to clarify the basis for, and the results of, the analysis of pipe sizes excludable from examination by paragraph IWB-1220(b)(1) of the 1974 Edition through Summer, 1975 Addendum of Section XI ASME B&PV Code.

The criteria used in the analysis is as follows:

1. The leak rate at 1000 psi is
 - liquid - 8000 lb/sec/ft²
 - steam - 2000 lb/sec/ft²
2. If the core remains covered for a complete circumferential rupture of a given pipe (assuming AC power is available, but with no credit for ECCS) then the pipe may be excluded from examination.
3. The vessel design cooldown rate of 100°F/hr may be exceeded under emergency conditions.

The core will remain covered for a given break provided the flow rate from the make-up systems (RCIC, cycled condensate and feedwater) exceed the leak rate through the break. However, because shutdown following a break will take a substantial length of time, credit for the feedwater system is limited to (1) the capacity of the transfer pump supplying water from the condensate storage tanks to the feedwater system (2) RCIC pump and (3) the cycled condensate make-up pump.

PSI Ref. No. RPV-4

Page 1 of 4

3-7-79

With the above consideration, the pipe size for which examination is not required is that size which will leak at a rate just equal to the combined flow rates of the RCIC, condensate make-up, and transfer pumps.

LaSalle Unit 1 Leakage Analysis

1. Normal Make-Up Calculation:

1 RCIC pump @ 625 gpm	625 gpm
1 Cycled condensate make-up pump @ 450 gpm	450 gpm
1 Cycled condensate transfer pump @ 500 gpm	<u>500 gpm</u>

Total Make-Up 1575 gpm

2. Maximum Break Size Calculation for H₂O:

2.1 Leakage rate at 1000 psi for H₂O = 8000 lbs/sec/ft²

2.2 H₂O = 8.33 lbs/gal

2.3 Leakage rate in gpm/in²

$$\frac{8000 \text{ lbs/sec/ft}^2}{8.33 \text{ lbs/gal}} \times \frac{60 \text{ sec/min}}{\text{sec}} \times \frac{1}{\text{ft}^2 \times 144 \text{ in}^2/\text{ft}^2}$$

$$= 400 \text{ gpm/in}^2$$

2.4 Maximum area (in²) leakage that can be handled by normal make-up of 1575 gpm:

$$\frac{1575 \text{ gpm}}{400 \text{ gpm/in}^2} = 3.94 \text{ in}^2 \text{ H}_2\text{O} \quad 3.94 > 5$$

2.5 Pipe size calculation - H₂O:

$$\frac{\pi D^2}{4} = \text{pipe area}$$

$$\frac{\pi D^2}{4} = 3.94 \text{ in}^2$$

$$D^2 = 5.02 \text{ in}^2$$

$$D = 2.23" \text{ in diameter}$$

3. Maximum Break Size Calculation for Steam:

3.1 Leakage rate at 1000 psi for steam = 2000 lbs/sec/ft²

3.2 H₂O = 8.33 lbs/gal

3.3 Leakage rate in gpm/in²:

$$\frac{2000 \text{ lbs/sec/ft}^2}{8.33 \text{ lbs/gal}} \times \frac{60 \text{ sec/min}}{\text{sec}} \times \frac{1}{\text{ft}^2 \times 144 \text{ in}^2/\text{ft}^2}$$

$$= 100 \text{ gpm/in}^2$$

3.4 Maximum area (in²) leakage that can be handled by normal make-up of 1575 gpm:

$$\frac{1575 \text{ gpm}}{100 \text{ gpm/in}^2} = 15.75 \text{ in}^2 \text{ steam}$$

3.5 Pipe size calculation - steam:

$$\frac{\pi D^2}{4} = \text{pipe area}$$

$$\frac{\pi D^2}{4} = 15.75 \text{ in}^2$$

$$D^2 = 20.05 \text{ in}^2$$

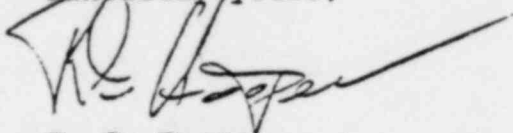
$$D = 4.47" \text{ in diameter}$$

Condensate Storage Tanks = 550,000 gallons

For a break 5.02 inches² at a leak rate of 1575 gpm, 318,150 gallons of make up water is required for 202 minutes, the time needed to cool down from 545°F to 210°F at a rate of 100°F per hour. The LaSalle County Station Unit 1 system has over 550,000 gallons in the condensate storage tanks alone.

If you have any questions or comments, please don't hesitate to call or write.

Sincerely yours,



R. C. Hooper
LaSalle Units 1&2
Site Project Supervisor
Central Region NSO

ak

cc: N. R. Casey	GE, Oak Brook
R. H. Holyoak	CECo, LaSalle
D. W. Zebrauskas	CECo, LaSalle
J. Groth	CECo, LaSalle

PSI Ref. No. RPV-4
Page 4 of 4

3-7-79


Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>1 & 2</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 0817

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. Smith</i>	<i>R. L. Jones</i>
1	11/2/77	Changed per G.E. comments	<i>J. M. Smith</i>	<i>R. L. Jones</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	JFA 59	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			22 10/5/78		
FIT-UP AND/OR ALIGNMENT	✓			22 10/5/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			22 10/5/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			22 10/5/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			22 10/9/78	PE-1	Rev. 5
Visual Exam	✓			22 10/9/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	
					RPV-8	
					Page 1 of 55	
POST WELD CLEANLINESS	✓			22 10/9/78		

*Revised - Pages 1 thru 55
w/ Caldwell A&E
3-13-81*





Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 Unit 1 & X RPV INTERNALS CRD SYSTEM OTHER *al*

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 0825

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. Miller</i>	<i>R. L. Quinn</i>
1	11/2/77	Changed per G.E. comments	<i>J. Miller</i>	<i>R. L. Quinn</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	QB-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			<i>RS 10/4/78</i>		
FIT-UP AND/OR ALIGNMENT	✓			<i>RS 10/4/78</i>		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			<i>RS 10/4/78</i>		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			<i>RS 10/4/78</i>		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>Auth II RW 10/9/78</i>		PE-1  Rev. 5
Visual Exam	✓			<i>Auth II RW 10/9/78</i>		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X		PSI Ref. No. -RPV-8	<i>10/17/78</i>
POST WELD CLEANLINESS	✓			<i>RW 10/9/78</i>		Page 2 of 55


Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet RPV INTERNALS cl
 Unit 1 & 2 CRD SYSTEM OTHER

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 0833

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John Miller</i>	<i>L.H. Green</i>
1	11/2/77	Changed per G.E. comments	<i>John Miller</i>	<i>R.R. Green</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	QC. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			22 10/4/78		
FIT-UP AND/OR ALIGNMENT	✓			22 10/4/78		SW-1  Rev. C
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			22 10/4/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			22 10/4/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			22 10/9/78	PE-1	Rev. 5
Visual Exam	✓			22 10/9/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.	RPV-8	10/17/78
					Page 3 of 55	
POST WELD CLEANLINESS	✓			22 10/9/78		



Client Commonwealth Edison Co.

Reactor Controls, Inc.
Production Weld
QC Data Sheet

WDS - 335 SHEET 1 OF 1

Site La Salle County Station

- RPV INTERNALS
- CRD SYSTEM
- OTHER

Unit 1 & ~~2~~


WELD DESCRIPTION: Incore Housing to Guide Tube

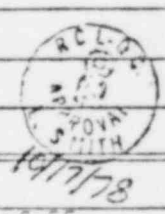
LOCATION: 0841

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John Smith</i>	<i>L.P. Jones</i>
1	11/2/77	Changed per G.E. comments	<i>John Smith</i>	<i>R.R. Jones</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	JFA 59	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A			Q.C. INSP.	AUTH. INSP.	COMMENTS
	R	N/A				
PRE-WELD CLEANLINESS	✓			222 10/3/78		
FIT-UP AND/OR ALIGNMENT	✓			322 10/3/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			322 10/3/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			222 10/3/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			222 10/9/78	PE-1	Rev. 5
Visual Exam	✓			222 10/9/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.	RPV-8	
					Page 4 of 55	
POST WELD CLEANLINESS	✓			222 10/9/78		



Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>1 & 2</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1849

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. Miller</i>	<i>L. C. [Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>J. M. Miller</i>	<i>R. K. [Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			7/2 10/2/77		
FIT-UP AND/OR ALIGNMENT	✓			7/2 10/2/77	SW-1	Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			7/2 10/2/77		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			7/2 10/2/77		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II BW 10/9/78	PE-1	Rev. 5
Visual Exam	✓			Level II BW 10/9/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.	RPV-8	10/17/78
					Page 5 of 55	

POST WELD CLEANLINESS ✓ BW 10/9/78

Client <u>Commonwealth Edison Co.</u> Site <u>La Salle County Station</u> Unit <u>1 & 2</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u> <input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
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WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1609

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>[Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>[Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A	B	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			22 10/5/78		
FIT-UP AND/OR ALIGNMENT	✓			22 10/5/78		SW-1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			22 10/5/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			22 10/5/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			22 10/9/78	PE-1	Rev. 5
Visual Exam	✓			22 10/9/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8 Page 6 of 55 <u>10/7/78</u>
POST WELD CLEANLINESS	✓			22 10/9/78		

Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 Unit 1 & 2 RPV INTERNALS al
 CRD SYSTEM
 OTHER

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1613

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. Miller</i>	<i>L. C. Quinn</i>
1	11/2/77	Changed per G.E. comments	<i>J. M. Miller</i>	<i>R. K. Quinn</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A	B	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			222 10/5/78		
FIT-UP AND/OR ALIGNMENT	✓			202 10/7/78	SW-1	1/1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			222 10/5/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			222 10/5/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			222 10/19/78	PE-1	Rev. 5
Visual Exam	✓			222 10/19/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PS	Ref. No	RPV-8 Page 7 of 55
POST WELD CLEANLINESS	✓			222 10/19/78		



Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>1 & 2</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1617

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>Tom Miller</i>	<i>L.P. Quinn</i>
1	11/2/77	Changed per G.E. comments	<i>Tom Miller</i>	<i>R.R. Quinn</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-17	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A	B	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RL 10/5/77		
FIT-UP AND/OR ALIGNMENT	✓			RL 10/5/77		SW-1 Δ Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RL 10/5/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RL 10/5/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II BW. 10/9/78	PE-1	Rev. 5
Visual Exam	✓			Level II BW. 10/9/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.	RPV-8	
					Page 8 of 55	
POST WELD CLEANLINESS	✓			BW. 10/9/78		




Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>(1) & 2</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1621

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. Miller</i>	<i>L. H. Green</i>
1	11/2/77	Changed per C.E. comments	<i>J. M. Miller</i>	<i>R. K. Green</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 57	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			728 10/4/79		
FIT-UP AND/OR ALIGNMENT	✓			728 10/4/79		SW-1  Rev. C
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			27 10/4/79		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE						
NDE OF ROOT:	✓			303 10/4/79		
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			824 10/19/78	PE-1	Rev. 5
Visual Exam	✓			824 10/19/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	10/17/78
POST WELD CLEANLINESS	✓			824 10/9/78		Page 9 of 55

Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>		<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>1 & X</u>		<u>1</u>

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1625

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>[Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>[Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A R N/A			Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			202 10/4/78		
FIT-UP AND/OR ALIGNMENT	✓			202 10/4/78		SIV-1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			202 10/4/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			202 10/4/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Sub II 202 10/9/78	PE-1	Rev. 5
Visual Exam	✓			Sub II 202 10/9/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X		PSI Ref. No.	
					RPV-8	10/17/78
					Page 10 of 55	
POST WELD CLEANLINESS	✓			202 10/9/78		


Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 Unit ① & X RPV INTERNALS CRD SYSTEM OTHER al

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1633

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. Miller</i>	<i>L. J. Green</i>
1	11/2/77	Changed per G.E. comments	<i>J. Miller</i>	<i>R. L. Green</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLET MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER-308	SFA 59	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			B.W. 10/4/78		
FIT-UP AND/OR ALIGNMENT	✓			B.W. 10/4/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			B.W. 10/4/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			B.W. 10/4/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			^{Seal 1} B.W. 10/19/78	PE-1	Rev. 5
Visual Exam	✓			^{Seal 2} B.W. 10/19/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PS. Ref. No	RPV-8	10/17/78
POST WELD CLEANLINESS	✓			B.W. 10/9/78	Page 11 of 55	



Client Commonwealth Edison Co.

Reactor Controls, Inc.
Production Weld
QC Data Sheet

WDS - 335 SHEET 1 OF 1

Site La Salle County Station

RPV INTERNALS
 CRD SYSTEM
 OTHER

W

Unit 1 & 2

WELD DESCRIPTION: Incore Housing to Guide Tube

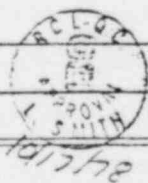
LOCATION: 1641

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John Miller</i>	<i>L.H. Green</i>
1	11/2/77	Changed per G.E. comments	<i>John Miller</i>	<i>R.R. Green</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	93-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A			Q.C. INSP.	AUTH. INSP.	COMMENTS
	R	N/A				
PRE-WELD CLEANLINESS	✓			222 10/3/77		
FIT-UP AND/OR ALIGNMENT	✓			222 10/3/77		SW-1 <u>1</u> Rev. C
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			222 10/3/77		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			222 10/3/77		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			222 10/9/78 <i>Level II</i>	PE-1	Rev. 5
Visual Exam	✓			222 10/9/78 <i>Level II</i>	VE-1	Rev. 2
SPECIAL REQUIREMENTS			X		PSI Ref. No. RPV-3	
					Page 12 of 55	
POST WELD CLEANLINESS	✓			222 10/9/78		



Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>		<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>(1) & 2</u>		<i>al</i>

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1645

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>[Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>[Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	JFA 5.9	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A R N/A			Q.C. INSP.	AUTH. INSP.	COMMENTS
	A	R	N/A			
PRE-WELD CLEANLINESS	✓			<i>[Signature]</i> 10/7/78		
FIT-UP AND/OR ALIGNMENT	✓			<i>[Signature]</i> 10/9/78	SW-1	Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			<i>[Signature]</i> 10/3/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			<i>[Signature]</i> 10/3/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>[Signature]</i> 10/9/78	PE-1	Rev. 5
Visual Exam	✓			<i>[Signature]</i> 10/9/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.	RPV-8	
					Page 13 of 55	
POST WELD CLEANLINESS	✓			<i>[Signature]</i> 10/9/78		



Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Site <u>La Salle County Station</u>			<i>al</i>
Unit <u>1 & X</u>			

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1649

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John Miller</i>	<i>L.P. Green</i>
1	11/2/77	Changed per G.E. comments	<i>John Miller</i>	<i>R.K. Green</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	B3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			<i>8W 10/3/78</i>		
FIT-UP AND/OR ALIGNMENT	✓					SW-1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			<i>7W 10/7/78</i>		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			<i>7W 10/7/78</i>		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>8W 10/19/78</i>	PE-1	Rev. 5
Visual Exam	✓			<i>8W 10/19/78</i>	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	
					Page 14	
POST WELD CLEANLINESS	✓			<i>8W 10/9/78</i>		



Client <u>Commonwealth Edison Co.</u> Site <u>La Salle County Station</u> Unit <u>① & ②</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u> <input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
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WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1653

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. Miller</i>	<i>R. L. Quinn</i>
1	11/2/77	Changed per G.E. comments	<i>J. M. Miller</i>	<i>R. L. Quinn</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/16	741106 760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			7/2 10/2/78		
FIT-UP AND/OR ALIGNMENT	✓			7/2 10/2/78		SW-1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			7/2 10/2/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			7/2 10/2/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			7/2 10/9/78	PE-1	Rev. 5
Visual Exam	✓			7/2 10/9/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	Page 15 of 55
POST WELD CLEANLINESS	✓			7/2 10/9/78		


Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 Unit 1 & X RPV INTERNALS CRD SYSTEM OTHER

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1657

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. Smith</i>	<i>R. G. Jones</i>
1	11/2/77	Changed per G.E. comments	<i>J. Smith</i>	<i>R. G. Jones</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	43-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/8"	741106	SANDVIK
			1/16"	760105	

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			10/2/78 JLL		
FIT-UP AND/OR ALIGNMENT	✓			10/2/78 JLL		SW-1  Rev. C
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			10/2/78 JLL		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			10/2/78 JLL		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			10/9/78 JLL	PE-1	Rev. 5
Visual Exam	✓			10/9/78 JLL	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	
POST WELD CLEANLINESS	✓			10/9/78 JLL		



Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>		<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER al
Unit <u>1 & X</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2409

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>[Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>[Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308A	1/16	760105	Sandwich

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			922 9/29/78		
FIT-UP AND/OR ALIGNMENT	✓			922 9/29/78		SW-1 1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			922 9/29/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			922 9/29/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>[Signature]</i> 10/10/78	PE-1	Rev. 5
Visual Exam	✓			<i>[Signature]</i> 10/10/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.	RPV-8	10/17/78
					Page 17 of 55	
POST WELD CLEANLINESS	✓			<i>[Signature]</i> 10/10/78		

Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>		<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER <u>W</u>
Unit <u>D & X</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2417

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John W. [Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>John W. [Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
019	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
E308	SFAS.9	ER308 ^{Weld}	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			22 10/9/78		
FIT-UP AND/OR ALIGNMENT	✓			22 10/9/78		SW-1 Δ 1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			22 10/9/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			22 10/9/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			22 10/9/78 Level I	PE-1	Rev. 5
Visual Exam	✓			22 10/9/78 Level II	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	Page 18 of 19/17/78
POST WELD CLEANLINESS	✓			22 10/10/78		

Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>(1) & 2</u>		<i>W</i>

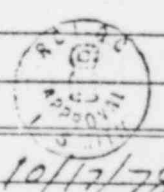
WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2425

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John Miller</i>	<i>R.R. Quinn</i>
1	11/2/77	Changed per G.E. comments	<i>John Miller</i>	<i>R.R. Quinn</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	<i>all</i>
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308X	1/16	760105	<i>Sandvik</i>

WELDING CHECK POINTS	A R N/A			Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			702 9/21/78		
FIT-UP AND/OR ALIGNMENT	✓			702 9/27/78	SW-1	Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE				702 9/27/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE				702 9/27/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>W.D. 10/11/78</i>	PE-1	Rev. 5
Visual Exam	✓			<i>W.D. 10/11/78</i>	VE-1	Rev. 2
SPECIAL REQUIREMENTS			X			
					PSI Ref. No. -	
					RPV-8	
					Page 19 of 55	
POST WELD CLEANLINESS	✓			<i>W.D. 10/11/78</i>		





Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 Uni: (1) & X RPV INTERNALS W
 CRD SYSTEM
 OTHER

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2429

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John Miller</i>	<i>L. L. Quinn</i>
1	11/2/77	Changed per G.E. comments	<i>John Miller</i>	<i>R. L. Quinn</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308X <i>with</i>	1/16	760105	<i>Sandwich</i>

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			<i>9/26/78</i>		
FIT-UP AND/OR ALIGNMENT	✓			<i>9/24/78</i>		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			<i>9/26/78</i>		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			<i>9/26/78</i>		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>10/10/78</i>	PE-1	Rev. 5
Visual Exam	✓			<i>10/10/78</i>	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	 10/17/78
POST WELD CLEANLINESS	✓			<i>10/10/78</i>		Page 20 of 55



Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>(7) & 8</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2433

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>Jomil</i>	<i>L. J. Jones</i>
1	11/2/77	Changed per G.E. comments	<i>Jomil</i>	<i>R. K. Jones</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandwich

WELDING CHECK POINTS	A	B	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			72 10/10/78		
FIT-UP AND/OR ALIGNMENT	✓			52 10/10/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			902 10/10/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			102 10/10/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>LD II</i> 10/11/78	PE-1	Rev. 5
Visual Exam	✓			<i>LD II</i> 12/11/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	 10/12/78
POST WELD CLEANLINESS	✓			<i>LD II</i> 1/10/79	Page 21 of 55	

Client Commonwealth Edison Co.
 Site La Salle County Station
 Unit 1 & X

Reactor Controls, Inc.
 Production Weld
 QC Data Sheet


WDS - 335 SHEET 1 OF 1
 RPV INTERNALS
 CRD SYSTEM
 OTHER w

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2437

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>[Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>[Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308X	1/16	760105	Sandvik

WELDING CHECK POINTS	A			R		N/A		Q.C. INSP.	AUTH. INSP.	COMMENTS
	✓			✓		✓				
PRE-WELD CLEANLINESS	✓							702 10/10/78		
FIT-UP AND/OR ALIGNMENT	✓							702 10/10/78		SW-1  Rev. 0
INSERT INSTALLATION				X						
BACKING RING INSTALLATION				X						
PRE-HEAT TEMPERATURE	✓							702 10/10/78		
PRE-PURGE				X						
PURGE				X						
INTERPASS TEMPERATURE	✓							702 10/10/78		
NDE OF ROOT:				X						
NDE INTERMEDIATE:				X						
NDE FINAL:										
Penetrant Exam	✓							10/10/78	PE-1	Rev. 5
Visual Exam	✓							10/10/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:				X				PSI Ref. No	RPV-8	
POST WELD CLEANLINESS	✓							10/10/78		



Client Commonwealth Edison Co.

Reactor Controls, Inc.
Production Weld
QC Data Sheet

WDS - 335 SHEET 1 OF 1

Site La Salle County Station

RPV INTERNALS
 CRD SYSTEM
 OTHER

Unit 1 & 2


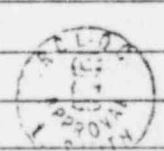
WELD DESCRIPTION: Incore Housing to Guide Tube

LOCATION: 2441

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>Jem [Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>Jem [Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760/105	Sandvick

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			202 10/6/78		
FIT-UP AND/OR ALIGNMENT	✓			202 10/6/78		SW-1  Rev. 3
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			202 10/6/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			202 10/6/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			202 10/11/78	PE-1	Rev. 5
Visual Exam	✓			202 10/11/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI RST. NO	RPV-8	 10/17/78
POST WELD CLEANLINESS	✓			202 10/11/78		Page 23 of 55



Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 Unit 1 & 2 RPV INTERNALS al
 CRD SYSTEM
 OTHER

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2449

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. Miller</i>	<i>R. L. ...</i>
1	11/2/77	Changed per G.E. comments	<i>J. M. Miller</i>	<i>R. L. ...</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			722 10/3/78		
FIT-UP AND/OR ALIGNMENT	✓			722 10/7/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			722 10/3/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			722 10/3/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			2nd I BW 10/9/78	PE-1	Rev. 5
Visual Exam	✓			2nd I BW 10/9/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	 10/17/78
POST WELD CLEANLINESS	✓			2nd I BW 11/9/78		Page 24 of 55


Client: Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site: La Salle County Station Production Weld QC Data Sheet
 RPV INTERNALS *al*
 CRD SYSTEM
 OTHER

Unit: 1 & X
 WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2457

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. Miller</i>	<i>L. C. [Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>J. M. Miller</i>	<i>R. K. [Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	φ3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/8 1/16	741106 760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			10/2/77 922		
... UP AND/OR ALIGNMENT	✓			10/2/77 922		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			10/2/77 922		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			10/2/77 922		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			822 10/9/78 <i>Feal II</i>	PE-1	Rev. 5
Visual Exam	✓			822 10/9/78 <i>Feal II</i>	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.	RPV-8	10/17/78
POST WELD CLEANLINESS	✓			822 10/9/78		Page 25 of 55



Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u>	SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER	
Unit <u>1 & X</u>			

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3209

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. ...</i>	<i>L. J. ...</i>
1	11/2/77	Changed per G.E. comments	<i>J. M. ...</i>	<i>R. K. ...</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			22 10/9/78		
FIT-UP AND/OR ALIGNMENT	✓			722 10/9/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION	✓		X			
PRE-HEAT TEMPERATURE	✓			22 10/9/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			22 10/9/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>GLD 10/10/78</i>	PE-1	 Rev. 5
Visual Exam	✓			<i>1/22 10/10/78</i>	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	10/7/78
POST WELD CLEANLINESS	U			<i>GLD 10/10/78</i>		Page 26 of 55

Client <u>Commonwealth Edison Co.</u> Site <u>La Salle County Station</u> Unit <u>1 & 2</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u> <input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
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WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3217

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>[Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>[Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	D3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			2/2 9/29/78		
FIT-UP AND/OR ALIGNMENT	✓			2/2 9/29/78		SW-1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			2/2 9/29/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			2/2 9/29/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>[Signature]</i> 10/10/78	PE-1	Rev. 5
Visual Exam	✓			<i>[Signature]</i> 10/10/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	
					Page 27 of 55	<i>[Signature]</i> 10/17/78
POST WELD CLEANLINESS	✓			<i>[Signature]</i> 10/10/78		


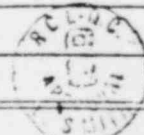
Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER <i>al</i>
Unit <u>7 & X</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3125

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John Miller</i>	<i>R.K. Green</i>
1	11/2/77	Changed per G.E. comments	<i>John Miller</i>	<i>R.K. Green</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
<i>B19</i>	<i>Q3-12</i>	<i>n/a</i>	<i>n/a</i>	<i>all</i>
		<i>n/a</i>	<i>n/a</i>	
		<i>n/a</i>	<i>n/a</i>	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
<i>ER308</i>	<i>SFA5.9</i>	<i>ER308A</i>	<i>1/16</i>	<i>760105</i>	<i>Sandvik</i>

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<i>22 9/27/78</i>		
FIT-UP AND/OR ALIGNMENT	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<i>22 9/27/78</i>		<i>SW-1</i>  <i>Rev. 0</i>
INSERT INSTALLATION			<input checked="" type="checkbox"/>			
BACKING RING INSTALLATION			<input checked="" type="checkbox"/>			
PRE-HEAT TEMPERATURE	<input checked="" type="checkbox"/>			<i>402 9/27/78</i>		
PRE-PURGE			<input checked="" type="checkbox"/>			
PURGE			<input checked="" type="checkbox"/>			
INTERPASS TEMPERATURE	<input checked="" type="checkbox"/>			<i>22 9/27/78</i>		
NDE OF ROOT:			<input checked="" type="checkbox"/>			
NDE INTERMEDIATE:			<input checked="" type="checkbox"/>			
NDE FINAL:						
<i>Penetrant Exam</i>	<input checked="" type="checkbox"/>			<i>W.D. Nichols Co II</i>	<i>PE-1</i>	<i>Rev. 5</i>
<i>Visual Exam</i>	<input checked="" type="checkbox"/>			<i>W.D. Nichols Co II</i>	<i>VE-1</i>	<i>Rev. 2</i>
SPECIAL REQUIREMENTS:			<input checked="" type="checkbox"/>	<i>PSi Ref. No</i>	<i>RPV-8</i>	
					Page 28 of 53	<i>10/17/78</i>
POST WELD CLEANLINESS	<input checked="" type="checkbox"/>			<i>W.D. Nichols Co II</i>		

Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>		<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER al
Unit <u>1 & X</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3229

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>[Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>[Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308X	1/16	760105	Landmark

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			9/26/78		
FIT-UP AND/OR ALIGNMENT	✓			9/26/78		SW-1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			9/26/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			9/26/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			10/11/78	PE-1	Rev. 5
Visual Exam	✓			10/11/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.	RPV-8	10/11/78
					Page 29 of 36	
POST WELD CLEANLINESS	✓			10/11/78		

Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER W
Unit <u>1 & X</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3233

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John Miller</i>	<i>A.L. Jones</i>
1	11/2/77	Changed per G.E. comments	<i>John Miller</i>	<i>R.R. Jones</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-17	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA.5.9	ER308 <i>Weld</i>	1/16	76010.5	<i>Sandvik</i>

WELDING CHECK POINTS	CLASSIFICATION			Q.C. INSP.	AUTH. INSP.	COMMENTS
	A	R	N/A			
PRE-WELD CLEANLINESS	✓			702 9/21/78		
FIT-UP AND/OR ALIGNMENT	✓			702 9/25/78		SIW-1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			702 9/21/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			702 9/25/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>W.D. Schmitt</i>	PE-1	Rev. 5
Visual Exam	✓			<i>W.D. Schmitt</i>	VE-1	Rev. 2
						11/17/78
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	
					Page 30 of 55	

POST WELD CLEANLINESS	✓			<i>W.D. Schmitt</i> 10/11/78		
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Client Commonwealth Edison Co.
 Site La Salle County Station
 Unit 1 & 2

Reactor Controls, Inc.
 Production Weld
 QC Data Sheet

WDS - 335 SHEET 1 OF 1

RPV INTERNALS
 CRD SYSTEM
 OTHER

al


WELD DESCRIPTION: Incore Housing to Guide Tube

LOCATION: 3137

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John Miller</i>	<i>L.E. Green</i>
1	11/2/77	Changed per G.E. comments	<i>John Miller</i>	<i>R.K. Green</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	<i>all</i>
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	1/16	760105	<i>Sandvik</i>

WELDING CHECK POINTS	A			Q.C. INSP.	AUTH. INSP.	COMMENTS
	R	N/A				
PRE-WELD CLEANLINESS	✓			<i>702 10/10/78</i>		
FIT-UP AND/OR ALIGNMENT	✓			<i>702 10/10/78</i>		<i>SW-1</i>  <i>Rev. 0</i>
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			<i>702 10/10/78</i>		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			<i>702 10/10/78</i>		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>702 10/10/78</i>	<i>PE-1</i>	<i>Rev. 5</i>
Visual Exam	✓			<i>702 10/10/78</i>	<i>VE-1</i>	<i>Rev. 2</i>
SPECIAL REQUIREMENTS:			X	<i>PSI</i>	<i>Ref. No</i>	<i>RPV-8</i> <i>Page 31 of 55</i>
POST WELD CLEANLINESS	✓			<i>702 10/10/78</i>		



Client <u>Commonwealth Edison Co.</u> Site <u>La Salle County Station</u> Unit <u>① & X</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u> <input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
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WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3241

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>Jom in 10/10</i>	<i>L.H. Green</i>
1	11/2/77	Changed per G.E. comments	<i>Jom in 10/10</i>	<i>R.R. Green</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	<i>all</i>
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	1/16	760105	<i>Sandwich</i>

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			<i>702 10/9/78</i>		
FIT-UP AND/OR ALIGNMENT	✓			<i>702 10/9/78</i>		<i>SW-1</i> <i>Rev. 0</i>
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			<i>502 10/9/78</i>		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			<i>502 10/9/78</i>		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>10/11/78</i>	PE-1	<i>Rev. 5</i>
Visual Exam	✓			<i>10/11/78</i>	VE-1	<i>Rev. 2</i>
SPECIAL REQUIREMENTS:			X	PSI Ref. No.	RPV-8	
POST WELD CLEANLINESS	✓			<i>10/11/78</i>	Page 32 of 55	



Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>① & ②</u>		<i>W</i>

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3249

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. Miller</i>	<i>L. J. ...</i>
1	11/2/77	Changed per G.E. comments	<i>J. Miller</i>	<i>R. K. ...</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/8	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			322 10/7/77		
FIT-UP AND/OR ALIGNMENT	✓			322 10/7/77		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			322 10/7/77		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			322 10/7/77		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			322 10/9/78 <i>Sub II</i>		PE-1 Rev. 5
Visual Exam	✓			322 10/9/78 <i>Sub II</i>		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X		PSI Ref. No	RPV-8 Page 33 of 55  10/12/78
POST WELD CLEANLINESS	✓			322 10/9/78		

Client Commonwealth Edison Co.

Site La Salle County Station

Unit 1 & X

Reactor Controls, Inc.
Production Weld
QC Data Sheet

WDS - 335 SHEET 1 OF 1

RPV INTERNALS
 CRD SYSTEM
 OTHER

al


WELD DESCRIPTION: Incore Housing to Guide Tube

LOCATION: 3257

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John Miller</i>	<i>L.H. Green</i>
1	11/2/77	Changed per G.E. comments	<i>John Miller</i>	<i>R.R. Green</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	QB-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/8	741106	SANDVIK
			1/16	760105	

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			7/2 10/2/77		
FIT-UP AND/OR ALIGNMENT	✓			7/2 10/2/77		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			7/2 10/2/77		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			7/2 10/2/77		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			8/2 10/9/77	PE-1	Rev. 5
Visual Exam	✓			8/2 10/9/77	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	
					RPV-8	
						10/17/78
						Page 34 of 55
POST WELD CLEANLINESS	✓			8/2 10/9/77		



Client <u>Commonwealth Edison Co.</u> Site <u>La Salle County Station</u> Unit <u>(1) & 2</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u> <input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
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WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4017

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. Miller</i>	<i>R. G. ...</i>
1	11/2/77	Changed per G.E. comments	<i>J. Miller</i>	<i>R. G. ...</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			22 9/27/79		
FIT-UP AND/OR ALIGNMENT	✓			22 9/29/79		SW-1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			22 9/29/79		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			22 9/29/79		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>ND 10/10/78</i>	PE-1	Rev. 5
Visual Exam	✓			<i>ND 10/10/78</i>	VE-1	Rev. 2

SPECIAL REQUIREMENTS: X PSI Ref. No. RPV-8
 Page 36 of 55

POST WELD CLEANLINESS ✓ *ND 10/10/78*



Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 RPV INTERNALS
 CRD SYSTEM
 OTHER

Unit 1 & 2 WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4021

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>[Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>[Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	1/16	760105	Lundvik

WELDING CHECK POINTS	A	F	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			702 9/27/78		
FIT-UP AND/OR ALIGNMENT	✓			702 9/27/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			702 9/27/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			702 9/27/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			702 10/17/78	PE-1	 Rev. 5
Visual Exam	✓			702 10/17/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	BC/CL/1
POST WELD CLEANLINESS	✓			702 10/17/78		Page 37 of 55

Client Commonwealth Edison Co.
 Site La Salle County Station
 Unit ① & ②

Reactor Controls, Inc.
 Production Weld
 QC Data Sheet

WDS - 335 SHEET 1 OF 1

- RPV INTERNALS
- CRD SYSTEM
- OTHER



WELD DESCRIPTION: Incore Housing to Guide Tube

LOCATION: 4025

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. Miller</i>	<i>R. L. Quinn</i>
1	11/2/77	Changed per G.E. comments	<i>J. Miller</i>	<i>R. L. Quinn</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE WELD CLEANLINESS	✓			702 9/27/78		
FIT-UP AND/OR ALIGNMENT	✓			702 9/27/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			702 9/27/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			702 9/27/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>W. J. Smith</i>	PE-1	Rev. 5
Visual Exam	✓			<i>W. J. Smith</i>	VE-1	Rev. 2
SPECIAL REQUIREMENTS			X	PSI Ref. No.	RPV-3	 10/17/78
						Page 38 of 55
POST WELD CLEANLINESS	✓			<i>W. J. Smith</i>		

Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>1 & 2</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4033

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. ...</i>	<i>L. P. ...</i>
1	11/2/77	Changed per G.E. comments	<i>J. M. ...</i>	<i>R. K. ...</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308X	1/16	760105	Sandvik

WELDING CHECK POINTS	A			Q.C. INSP.	AUTH. INSP.	COMMENTS
	R	N/A				
PRE-WELD CLEANLINESS	✓			WJ 9/25/78		
FIT-UP AND/OR ALIGNMENT	✓			WJ 9/25/78	SW-1	Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			WJ 9/25/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			WJ 9/25/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			WJ 10/11/78	PE-1	Rev. 5
Visual Exam	✓			WJ 10/11/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	10/17/78
POST WELD CLEANLINESS	✓			WJ 10/11/78		





Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 Unit ① & ② RPV INTERNALS al
 CRD SYSTEM
 OTHER

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4041

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. ...</i>	<i>L. L. ...</i>
1	11/2/77	Changed per G.E. comments	<i>J. M. ...</i>	<i>R. R. ...</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	76.0105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			762 10/9/78		
FIT-UP AND/OR ALIGNMENT	✓			762 10/9/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			762 10/9/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			762 10/9/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			762 10/11/78	PE-1	Rev. 5
Visual Exam	✓			762 10/11/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.	RPV-8	 10/7/78
POST WELD CLEANLINESS	✓			762 10/11/78	Page 40 of 55	


Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u>	SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER	
Unit <u>1 & 2</u>			

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4045

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>[Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changea per G.E. comments	<i>[Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			10/16/78		
FIT-UP AND/OR ALIGNMENT	✓			10/16/78		SW-1  Rev. C
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			10/16/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			10/16/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>[Signature]</i>	PE-1	Rev. 5
Visual Exam	✓			<i>[Signature]</i>	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	10/17/78
						Page 41 of 55
POST WELD CLEANLINESS	✓			<i>[Signature]</i>		

Client Commonwealth Edison Co. Reactor Controls, inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 RPV INTERNALS W
 CRD SYSTEM
 OTHER

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4049

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. Miller</i>	<i>R. L. Jones</i>
1	11/2/77	Changed per G.E. comments	<i>J. M. Miller</i>	<i>R. L. Jones</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Φ3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A R N/A			Q.C. INSP.	AUTH. INSP.	COMMENTS
	✓					
PRE-WELD CLEANLINESS	✓			222 10/7/78		
FIT-UP AND/OR ALIGNMENT	✓			222 10/7/78	SW-1	Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			222 10/7/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			222 10/7/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			222 10/9/78	PE-1	Rev. 5
Visual Exam	✓			222 10/9/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	10/17/78
POST WELD CLEANLINESS	✓			222 10/9/78		



Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERFACES <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>1 & 2</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4057

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John Miller</i>	<i>L. J. Quinn</i>
1	11/2/77	Changed per G.E. comments	<i>John Miller</i>	<i>R. K. Quinn</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
8-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/16	741106 760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			2/2 10/2/77		
FIT-UP AND/OR ALIGNMENT	✓			2/2 10/2/77		SW-1 Δ 1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			2/2 10/2/77		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			2/2 10/2/77		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			2/2 10/9/77	PE-1	Rev. 5
Visual Exam	✓			2/2 10/9/77	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X		PSI Ref. No	
					RPV-8	
					Page 43 of 55	
POST WELD CLEANLINESS	✓			2/2 10/9/77		



Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u>	SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER	
Unit <u>(1) & 2</u>			

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4809

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. Smith</i>	<i>L. J. ...</i>
1	11/2/77	Changed per G.E. comments	<i>J. Smith</i>	<i>R. K. ...</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandwich

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			SL2 10/10/78		
FIT-UP AND/OR ALIGNMENT	✓			SL2 10/10/78		SW-1 Rev. 3
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			SL2 10/10/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			222 10/11/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			SL2 10/11/78	PE-1	Rev. 5
Visual Exam	✓			SL2 10/11/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	
			-		Page 44 of 55	
POST WELD CLEANLINESS	✓			SL2 10/11/78		

Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u>	SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER	
Unit <u>1 & 2</u>			

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4813

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. Miller</i>	<i>L. L. Quinn</i>
1	11/2/77	Changed per G.E. comments	<i>J. M. Miller</i>	<i>R. R. Quinn</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			762 9/29/78		
FIT-UP AND/OR ALIGNMENT	✓			762 9/29/78		SW-1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			762 9/29/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			762 9/29/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>W.D. 10/11/78</i>	PE-1	Rev. 5
Visual Exam	✓			<i>W.D. 10/11/78</i>	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	
					Page 45 of 55	
POST WELD CLEANLINESS	✓			<i>W.D. 10/11/78</i>		



Client Commonwealth Edison Co.

Reactor Controls, Inc.
Production Weld
QC Data Sheet

WDS - 335 SHEET 1 OF 1

Site La Salle County Station

RPV INTERNALS
 CRD SYSTEM
 OTHER

Unit (1) & X

WELD DESCRIPTION: Incore Housing to Guide Tube

LOCATION: 4817

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. Miller</i>	<i>L. J. Jones</i>
1	11/2/77	Changed per G.E. comments	<i>J. Miller</i>	<i>R. K. Jones</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Lindvik

WELDING CHECK POINTS	A			Q.C. INSP.	AUTH. INSP.	COMMENTS
	R	N/A				
PRE-WELD CLEANLINESS	✓			7/29/79		
FIT-UP AND/OR ALIGNMENT	✓			7/29/78	SW-1	Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			7/29/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			7/29/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			7/29/78	PE-1	Rev. 5
Visual Exam	✓			7/29/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8
						10/17/78
						Page 46 of 55
POST WELD CLEANLINESS	✓			7/29/78		



Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>1 & 2</u>		<i>al</i>

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4825

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John W. Smith</i>	<i>L. J. Green</i>
1	11/2/77	Changed per G.E. comments	<i>John W. Smith</i>	<i>R. K. Green</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	<i>all</i>
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA59	ER308X	1/8	760105	<i>Induct</i>

WELDING CHECK POINTS	A	R	NTA	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	<input checked="" type="checkbox"/>			<i>702 9/27/78</i>		
FIT-UP AND/OR ALIGNMENT	<input checked="" type="checkbox"/>			<i>702 9/27/78</i>		<i>SW-1</i>  <i>Rev. 0</i>
INSERT INSTALLATION			<input checked="" type="checkbox"/>			
BACKING RING INSTALLATION			<input checked="" type="checkbox"/>			
PRE-HEAT TEMPERATURE	<input checked="" type="checkbox"/>			<i>202 9/27/78</i>		
PRE-PURGE			<input checked="" type="checkbox"/>			
PURGE			<input checked="" type="checkbox"/>			
INTERPASS TEMPERATURE	<input checked="" type="checkbox"/>			<i>202 9/27/78</i>		
NDE OF ROOT:			<input checked="" type="checkbox"/>			
NDE INTERMEDIATE:			<input checked="" type="checkbox"/>			
NDE FINAL:						
Penetrant Exam	<input checked="" type="checkbox"/>			<i>W. Nichols</i>	PE-1	 <i>Rev. 5</i>
Visual Exam	<input checked="" type="checkbox"/>			<i>W. Nichols</i>	VE-1	<i>Rev. 2</i>
SPECIAL REQUIREMENTS:			<input checked="" type="checkbox"/>	PS	Ref. No	RPV-8 <i>10/17/78</i>
POST WELD CLEANLINESS	<input checked="" type="checkbox"/>			<i>W. Nichols</i>		Page 47 of 55

Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>		<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER al
Unit <u>1 & 2</u>		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4833

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>John W. [Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>John W. [Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
<u>B19</u>	<u>Q3-12</u>	<u>n/a</u>	<u>n/a</u>	<u>All</u>
		<u>n/a</u>	<u>n/a</u>	
		<u>n/a</u>	<u>n/a</u>	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
<u>ER308</u>	<u>SFA5.9</u>	<u>ER308</u>	<u>1/16</u>	<u>760-05</u>	<u>Sandvik</u>

WELDING CHECK POINTS	A	B	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓	✓		<u>9/25/78</u>		
FIT-UP AND/OR ALIGNMENT	✓	✓		<u>9/25/78</u>		<u>SW-1</u> <u>Rev 0</u>
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓	✓		<u>9/25/78</u>		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓	✓		<u>9/25/78</u>		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<u>10/1/78</u>	<u>PE-1</u>	<u>Rev. 5</u>
Visual Exam	✓			<u>10/1/78</u>	<u>VE-1</u>	<u>Rev. 2</u>
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	
					Page 48 of 53	<u>10/1/78</u>
POST WELD CLEANLINESS	✓			<u>10/1/78</u>		



Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 RPV INTERNALS *al*
 CRD SYSTEM
 OTHER

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4841

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>Jomiliso</i>	<i>L.P. Gen</i>
1	11/2/77	Changed per G.E. comments	<i>Jomiliso</i>	<i>R.K. Gen</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			702 10/5/78		
FIT-UP AND/OR ALIGNMENT	✓			702 10/9/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			702 10/9/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			702 10/9/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>10/17/78</i>	PE-1	Rev. 5
Visual Exam	✓			<i>10/17/78</i>	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8  10/17/78
POST WELD CLEANLINESS	✓			<i>10/17/78</i>		Page 49 of 55

Client Commonwealth Edison Co.

Reactor Controls, Inc.

WDS - 335 SHEET 1 OF 1

Site La Salle County Station

Production Weld

QC Data Sheet

RPV INTERNALS

CRD SYSTEM

OTHER

Unit G & X



WELD DESCRIPTION: Incore Housing to Guide Tube

LOCATION: 4849

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>[Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>[Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			202 10/6/78		
FIT-UP AND/OR ALIGNMENT	✓			202 10/6/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			202 10/6/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			202 10/6/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			202 10/11/78	PE-1	 Rev. 5
Visual Exam	✓			202 10/11/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.	RPV-8	Page 50 of 55
POST WELD CLEANLINESS	✓			202 10/11/78		

Client Commonwealth Edison Co.
 Site La Salle County Station
 Unit 1 & A

Reactor Controls, Inc.
 Production Weld
 QC Data Sheet

WDS - 335 SHEET 1 OF 1



RPV INTERNALS
 CRD SYSTEM
 OTHER

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4853

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>[Signature]</i>	<i>[Signature]</i>
1	11/2/77	Changed per G.E. comments	<i>[Signature]</i>	<i>[Signature]</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308X	1/16	760105	Lantrite

WELDING CHECK POINTS	A	B	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			709 10/6/78		
FIT-UP AND/OR ALIGNMENT	✓			702 10/6/78		SIW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			702 10/6/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			702 10/8/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>[Signature]</i> 10/11/78	PE-1	Rev. 5
Visual Exam	✓			<i>[Signature]</i> 10/11/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.	RPV-8	 10/17/78
POST WELD CLEANLINESS	✓			<i>[Signature]</i> 10/11/78		Page 51 of 55

Client <u>Commonwealth Edison Co.</u>	Reactor Controls, Inc.	WDS - <u>335</u> SHEET <u>1</u> OF <u>1</u>
Site <u>La Salle County Station</u>	Production Weld QC Data Sheet	<input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
Unit <u>1 & 2</u>		



WELD DESCRIPTION: Incore Housing to Guide Tube

LOCATION: 5617

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>Tom Miller</i>	<i>R.K. Green</i>
1	11/2/77	Changed per G.E. comments	<i>Tom Miller</i>	<i>R.K. Green</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvick

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			7/2 10/7/78		
FIT-UP AND/OR ALIGNMENT	✓			7/2 10/9/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			7/2 10/8/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			7/2 10/9/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>W.D. 10/10/78</i>	PE-1	 Rev. 5
Visual Exam	✓			<i>W.D. 10/10/78</i>	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	
					Page 52 of 55	
POST WELD CLEANLINESS	✓			<i>W.D. 10/10/78</i>		



Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 Unit (1) & X RPV INTERNALS CRD SYSTEM OTHER *al*

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 5625

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>J. M. Miller</i>	<i>L. L. ...</i>
1	11/2/77	Changed per G.E. comments	<i>J. M. Miller</i>	<i>R. K. ...</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			202 9/27/78		
FIT-UP AND/OR ALIGNMENT				202 9/27/78		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			202 9/27/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			202 9/27/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			202 10/11/78	PE-1	 Rev. 5
Visual Exam	✓			202 10/11/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	10/17/78
POST WELD CLEANLINESS	✓			202 10/11/78		Page 53 of 55


Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 335 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 Unit 1 & X RPV INTERNALS CRD SYSTEM OTHER W

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 5633

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	<i>Jomil</i>	<i>L. J. Jones</i>
1	11/2/77	Changed per G.E. comments	<i>Jomil</i>	<i>R. K. Jones</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308X	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			4/2 9/25/77		
FIT-UP AND/OR ALIGNMENT	✓			2/2 9/25/79		SW-1  Rev. 0
INSERT INSTALLATION			X			
BACKING FING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			4/2 9/25/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			2/2 9/25/79		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			4/2 10/1/78	PE-1	Rev. 5
Visual Exam	✓			4/2 10/1/78	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No	RPV-8	10/17/78
POST WELD CLEANLINESS	✓			4/2 10/1/78		Page 54 of 55



Client Commonwealth Edison Co.

Reactor Controls, Inc.

WDS - 335 SHEET 1 OF 1

Site La Salle County Station

Production Weld
QC Data Sheet

- RPV INTERNALS
- CRD SYSTEM
- OTHER

al

Unit 1 & 2


WELD DESCRIPTION: Incore Housing to Guide Tube

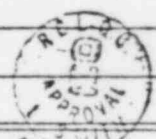
LOCATION: 5641

REV	DATE	REVISION	ENGR. APPROVED	O. A. APPROVED
0	10/7/77	Initial Issue	<i>John W. ...</i>	<i>R.K. ...</i>
1	11/2/77	Changed per G.E. comments	<i>John W. ...</i>	<i>R.K. ...</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	<i>all</i>
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	76010	<i>all</i>

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			<i>22 10/10/78</i>		
FIT-UP AND/OR ALIGNMENT	✓			<i>22 10/10/78</i>		<i>SW-1</i>  <i>Rev. 0</i>
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			<i>22 10/10/78</i>		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			<i>70 10/10/78</i>		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>W.A. 10/10/78</i>		<i>PE-1</i> <i>Rev. 5</i>
Visual Exam	✓			<i>W.A. 10/10/78</i>		<i>VE-1</i> <i>Rev. 2</i>
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	<i>RPV-8</i> <i>10/10/78</i>
POST WELD CLEANLINESS	✓			<i>W.A. 10/10/78</i>		Page 55 of 55



RESOLUTION OF REJECTION

REASON FOR REJECTION

Incomplete Inset melt Approximately 1/4" long at location MARKER #1

ACTION TAKEN

ACCEPTABLE

LIST STEPS TAKEN TO RESOLVE REJECTION

PER DOC.

DATE

INITIAL

- | | | | |
|--|-------------|---------|------------|
| 1. Grind down to root in unconsumed area | QC Hold #36 | 2/23/78 | ACC
WHL |
| 2. Re-pull unconsumed inset | QC Hold #36 | 2/23/78 | ACC
WHL |
| 3. Penetrant inspect re-pulled area | PE-1 REV3 | 2/23/78 | ACC
WHL |
| 4. Reweld area to completion | W15 318 | 2/23/78 | ACC
WHL |
| 5. Penetrant inspect final weld | PE-1 REV3 | 2/23/78 | ACC
WHL |
| 6. Radiograph final weld
RT REPORT #163 | PE-1 REV1 | 2/24/78 | ACC
WHL |

* Repair welder was S. Rexroat, P-4.

Filler Material was ER308, SFA5.9

1/16" HT# 760105 manufactured by

SANDVIK. Schmidt QC Supervisor

COMMENTS

PSI Ref. No. RPV-9

Page 4 of 6

Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 319 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 Unit 1 & X RPV INTERNALS CRD SYSTEM OTHER *al*

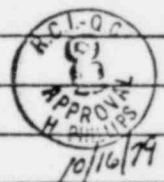
WELD DESCRIPTION: Cap to dp Line LOCATION: N/A

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	6/21/77	Initial Issue	<i>W. J. ...</i>	RCW/jm

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
P4	Q2 II	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308 ^{HP}	3/32	481771	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			<i>8/14/78</i>		
FIT-UP AND/OR ALIGNMENT	✓			<i>8/14/78</i>		
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			<i>8/14/78</i>		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			<i>8/14/78</i>		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			<i>4/4/79</i>	PE-1	Rev. 5
Visual Exam	✓			<i>4/4/79</i>	VE-1	Rev. 2
SPECIAL REQUIREMENTS:			X			
POST WELD CLEANLINESS	✓			<i>4/14/79</i>		



PSI Ref. No. RPV-9 Page 5 of 6
 PE-1 Rev. 5
 VE-1 Rev. 2

Client <u>Commonwealth Edison Co.</u> Site <u>La Salle County Station</u> Unit <u>1</u>	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - <u>506-1</u> SHEET <u>1</u> OF <u>1</u> <input checked="" type="checkbox"/> RPV INTERNALS <input type="checkbox"/> CRD SYSTEM <input type="checkbox"/> OTHER
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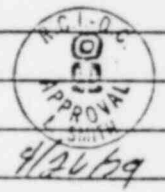
WELD DESCRIPTION: Adapter to RPV Pen. Socket LOCATION: N/A

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	6/20/77	Initial Issue	<i>WES/col</i>	<i>RCW/m</i>

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
<i>PH</i>	<i>Q43/43 CT</i>	<i>n/a</i>	<i>n/a</i>	<i>all</i>
		<i>n/a</i>	<i>n/a</i>	
		<i>n/a</i>	<i>n/a</i>	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
<i>Inco 82</i>	<i>SFA 5.14</i>	<i>ERNICR-3</i>	<i>3/3</i>	<i>NX8742D</i>	<i>Huntington</i>

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	<i>✓</i>			<i>8/21/78</i>		
FIT-UP AND/OR ALIGNMENT	<i>✓</i>			<i>8/21/78</i>		
INSERT INSTALLATION			<i>X</i>			
BACKING RING INSTALLATION			<i>X</i>			
PRE-HEAT TEMPERATURE	<i>✓</i>			<i>8/21/78</i>		
PRE-PURGE			<i>X</i>			
PURGE			<i>X</i>			
INTERPASS TEMPERATURE	<i>✓</i>			<i>8/21/78</i>		
NDE OF ROOT:			<i>X</i>			
NDE INTERMEDIATE:			<i>X</i>			
NDE FINAL:						
Penetrant Exam	<i>✓</i>			<i>4/4/79</i>	<i>PE-1</i>	<i>Rev. 5</i>
Visual Exam	<i>✓</i>			<i>4/4/79</i>	<i>VE-1</i>	<i>Rev. 2</i>
SPECIAL REQUIREMENTS:			<i>X</i>		<i>PSI</i>	<i>Ref. No. RPV-9</i>
						<i>Page 6 of 6</i>
POST WELD CLEANLINESS	<i>✓</i>			<i>4/4/79</i>		



Client Commonwealth Edison Co.

Reactor Controls, Inc.
Production Weld
QC Data Sheet

WDS - 503 SHEET 1 OF 1

Site La Salle County Station

RPV INTERNALS
 C-3 SYSTEM
 OTHER

Unit (1) & 2

WELD DESCRIPTION: Backing Ring to Shroud

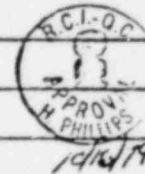
LOCATION: N/A

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	3/18/77	Initial Issue	<i>W. J. Phillips</i>	<i>P. J. Veltrop</i>
		<i>1/1/77 #1</i>		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-U. QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-1, B-2	Q43/43075-1	n/a	n/a	ALL
B-7, B-9	Q43/43075-1	n/a	n/a	ALL
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
<i>INCO 82T</i>	<i>SFA514</i>	<i>ERNICR3</i>	<i>3/32</i>	<i>NY2742D</i>	<i>Huntington</i>

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	<input checked="" type="checkbox"/>			<i>7/27/77</i>		
FIT-UP AND/OR ALIGNMENT	<input checked="" type="checkbox"/>			<i>7/27/77</i>		
INSERT INSTALLATION			<input checked="" type="checkbox"/>			
BACKING RING INSTALLATION			<input checked="" type="checkbox"/>			
PRE-HEAT TEMPERATURE	<input checked="" type="checkbox"/>			<i>7/27/77</i>		
PRE-PURGE			<input checked="" type="checkbox"/>			
PURGE			<input checked="" type="checkbox"/>			
INTERPASS TEMPERATURE	<input checked="" type="checkbox"/>			<i>7/27/77</i>		<i>Review pages 1+2 u of Caldwell ANES 3-13-81</i>
NDE OF ROOT:			<input checked="" type="checkbox"/>			
NDE INTERMEDIATE:			<input checked="" type="checkbox"/>			
NDE FINAL:						
Penetrant Exam	<input checked="" type="checkbox"/>			<i>8/1/77</i>	<i>PE-1</i>	<i>Rev. 2</i>
Visual Exam	<input checked="" type="checkbox"/>			<i>8/1/77</i>	<i>VE-1</i>	<i>Rev. 2</i>
SPECIAL REQUIREMENTS:			<input checked="" type="checkbox"/>	<i>PSI</i>	Ref. No	
					<i>RPV-10</i>	
					<i>Page 1 of 2</i>	
POST WELD CLEANLINESS	<input checked="" type="checkbox"/>			<i>8/1/77</i>		



Client Commonwealth Edison Co. Reactor Controls, Inc. WDS - 504 SHEET 1 OF 1
 Site La Salle County Station Production Weld QC Data Sheet
 RPV INTERNALS W
 CRD SYSTEM
 OTHER

Unit 1 & 2
 WELD DESCRIPTION: Shroud to Shroud Support Ring LOCATION: N/A

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	3/21/77	Initial Issue	<i>[Signature]</i>	<i>[Signature]</i>
		<i>Unit #1</i>		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B1, B-7	Q43/430TS-1	n/a	n/a	ALL
B-6, B-9	Q43/430TS-1	n/a	n/a	ALL
B-10	Q43/430TS-1	n/a	n/a	SMAW ONLY

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
INCO 82T	SFA 5.14	ENRICK 3	3/32"	NX8742D	Huntington
INCO 82T	SFA 5.11	ENCRFE-3	5/32"	CONT 4725, 4850	Huntington
INCO 82T	SFA 5.11	ENCRFE-3	1/8"	CONT 1223	Huntington

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			<i>[Signature]</i> 8/3/77		
FIT-UP AND/OP ALIGNMENT	✓			<i>[Signature]</i> 8/3/77		
INSERT INSTALLATION			X			
BACKING RING INSTALLATION	✓			<i>[Signature]</i> 8/3/77		
PRE-HEAT TEMPERATURE	✓			<i>[Signature]</i> 8/3/77		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			<i>[Signature]</i> 8/3/77		
NDE OF ROOT:						
Penetrant Exam @	✓			<i>[Signature]</i> 8/18/77	PF-1	Rev. 2
change of process				LEVEL II		
NDE INTERMEDIATE:						
Penetrant Exam 1/2T	✓			<i>[Signature]</i> 8/19/77	PE-1	Rev. 3
				LEVEL II		
NDE FINAL:						
Penetrant Exam	✓			<i>[Signature]</i> 8/19/77	PE-1	Rev. 3
Visual Exam	✓			<i>[Signature]</i> 8/20/77	VE-1	Rev. 2

SPECIAL REQUIREMENTS: X PS Ref. No RPV-10
 Page 2 of 2 *[Signature]*
 PRE-WELD CLEANLINESS ✓ *[Signature]* 8/20/77

12.2 PIPING, PUMP AND VALVE COMPONENTS

12.2.5 PUMP & VALVE INTERNAL CONSTRUCTION DATA SHEETS

<u>DESCRIPTION</u>	<u>TAB</u>	<u>PUMP OR VALVE NO.</u>	<u>PSI REF. NO.</u>
FW - Feedwater System Valve	27	1B21-F010A	FWV-1
		1B21-F010B	FWV-2
		1B21-F011A	FWV-3
		1B21-F011B	FWV-4
		1B21-F032A	FWV-5
		1B21-F032B	FWV-6
HP - High Pressure Core Spray System Valve	28	1E22-F004	HPV-1
		1E22-F005	HPV-2
		1E22-F038	HPV-3
LP - Low Pressure Core Spray System Valve	29	1E21-F005	LPV-1
		1E21-F006	LPV-2
		1E21-F051	LPV-3
MS - Main Steam System Valve	30	1B21-F013A	MSV-1
		1B21-F013B	MSV-2
		1B21-F013C	MSV-3
		1B21-F013D	MSV-4
		1B21-F013E	MSV-5
		1B21-F013F	MSV-6
		1B21-F013G	MSV-7
		1B21-F013H	MSV-8
		1B21-F013J	MSV-9
		1B21-F013K	MSV-10
		1B21-F013L	MSV-11
		1B21-F013M	MSV-12
		1B21-F013N	MSV-13
		1B21-F013P	MSV-14
		1B21-F013R	MSV-15
		1B21-F013S	MSV-16
		1B21-F013U	MSV-17
		1B21-F013V	MSV-18
		1B21-F022A	MSV-19
		1B21-F022B	MSV-20
		1B21-F022C	MSV-21
		1B21-F022D	MSV-22
		1B21-F023A	MSV-23
		1B21-F023B	MSV-24
		1B21-F028C	MSV-25
		1B21-F028D	MSV-26
RH - Residual Heat Removal System Valve	31	1E12-F008	RHV-1
		1E12-F009	RHV-2
		1E12-F019	RHV-3
		1E12-F020	RHV-4

12.2 PIPING, PUMP AND VALVE COMPONENTS

12.2.5 Pump & Valve Internal Construction Data Sheets (Cont'd)

<u>DESCRIPTION</u>	<u>TAB</u>	<u>PUMP OR VALVE NO.</u>	<u>PSI REF. NO.</u>		
RH - Residual Heat Removal System Valve (Continued)	31	1E12-F023	RHV-5		
		1E12-F041A	RHV-6		
		1E12-F041B	RHV-7		
		1E12-F041C	RHV-8		
		1E12-F042A	RHV-9		
		1E12-F042B	RHV-10		
		1E12-F042C	RHV-11		
		1E12-F050A	RHV-12		
		1E12-F050B	RHV-13		
		1E12-F053A	RHV-14		
		1E12-F053B	RHV-15		
		1E12-F090A	RHV-16		
		1E12-F090B	RHV-17		
		1E12-F092A	RHV-18		
		1E12-F092B	RHV-19		
		1E12-F092C	RHV-20		
		RI - Reactor Core Isolation Cooling System Valve	32	1E51-F013	RIV-1
				1E51-F063	RIV-2
				1E51-F064	RIV-3
				1E51-F065	RIV-4
1E51-F066	RIV-5				
RR - Reactor Recirculation System Pump	33	1B33-C001A	RRP-1		
		1B33-C001B	RRP-2		
RR - Reactor Recirculation System Valve	34	1B33-F023A	RRV-1		
		1B33-FC23B	RRV-2		
		1B33-F060A	RRV-3		
		1B33-F060B	RRV-4		
		1B33-F067A	RRV-5		
		1B33-F067B	RRV-6		
RT - Reactor Water Clean Up System Valve	35	1G33-F001	RTV-1		
		1G33-F004	RTV-2		
		1G33-F012	RTV-3		

INSTALLATION & SERVICE ENGINEERING DIVISION

LASALLE COUNTY NUCLEAR STATION UNIT 1

A. PROCEDURE NO. PP-S751 REV. 7

EXAMINATION PERSONNEL:

NAME ca Homler LEVEL II
 NAME N/A LEVEL N/A

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK
 b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014
 c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 79B109
 d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014
 e. DEVELOPER TYPE SKD-S BATCH NO. 79E033
 f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:
 1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES NO
 2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES NO

b. SURFACE PREPARATION:

*1. GRINDING *2. FLAPPING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

LINE NO.	DATE	PRE-CLEAN EVAP. TIME	PEN. DWELL TIME	PEN. REM. EVAP. TIME	DEV. TIME	EXAMINATION COMPONENT I.D. NO.	MAT'L	SURF. PREP. #	RELEVANT INDICATION		ACCEPTABLE		RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
									YES	NO	YES	NO	
1	2-19 1981	5	10	5	15	IRI-1014-7	CS	2	X		X		9/64" ROUND-90° FROM V-SURF 1 TO E.
2													
3													
4													
5													
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(S) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR W. J. Connelly DATE 2/20/81
 QC SUPERVISOR L. J. Whelan DATE 2/20/81
 AUTHORIZED INSPECTOR W. J. Connelly DATE 2-23-81



NUCLEAR ENERGY SERVICES, INC.
 CONAM INSPECTION DIVISION
 P. O. Box 160
 Grand Ridge, Illinois 61325

REPORT OF NONDESTRUCTIVE EXAMINATION

TYPE OF EXAMINATION: MT PT

Customer COMMONWEALTH EDISON COMPANY		Project LaSalle Station		Date 3/1/78
Contractor MCCO		Job No. 2466	P. O. No. —	Report No. - Request No. 1836 - M78 - 030
Examination Standard/Edition - Add ASME V-7 74 Summer <input checked="" type="checkbox"/> Winter <input type="checkbox"/>		Acceptance Standard/Edition - Add ASME III 74 Summer <input type="checkbox"/> Winter <input type="checkbox"/>		N.D.E. Procedure No. - Rev. MT-1-MP REV. 3
Line or Dwg. No. IRHC18B		Part No. or Description PARTIAL FLUED HEAD WELD No 813		Mat'l Thickness 2.000
Type of Work New <input checked="" type="checkbox"/> Repair <input type="checkbox"/>	Surface Condition AS WELDED	Temp. of Mat'l AMBIENT	Heat No. N/A	Heat Treat Before <input type="checkbox"/> After <input type="checkbox"/>
MAGNETIC PARTICLE TECHNIQUE DATA* N/A <input type="checkbox"/>				
Equipment MS-27 MAGNA MAGIC	Dry <input checked="" type="checkbox"/> Wet <input type="checkbox"/>	Visible <input checked="" type="checkbox"/> Fluorescent <input type="checkbox"/>	AC <input type="checkbox"/> DC <input checked="" type="checkbox"/>	Amperage 45
Type Liquid Penetrant Materials Used		Batch N/s.	Penetrant - Dwell Time Water Washable <input type="checkbox"/> Post Emulsified <input type="checkbox"/>	Development - Time Visible <input type="checkbox"/> Solvent Removable <input type="checkbox"/> Dry <input type="checkbox"/> Wet <input type="checkbox"/> Nonaqueous <input type="checkbox"/>
*Additional Data:			No. of Items Accepted 0	No. of Items Rejected 1

PC No. or SN No.	ACC	REJ	DEFECT CODE	REMARKS & DIAGRAM
IRHC18B WELD No II 813		X		MT FULL COVER PASS ONLY ONE SIDE LINEAR INDICATIONS NOTED AT REF POINTS (9, 19 1/2, 50 IN WELD AS MARKED)
T-47				
RECEIVED MAR 07 1978 MORRISON CONSTRUCTION COMPANY				

Conam Examiner Signature: <i>James H. Rubinoff II</i> Level: <i>II</i> Date: <i>3/1/78</i>	Contractor Review & Acceptance Company: <i>MCCO</i> Signature: <i>W. J. Caldwell</i> Date: <i>2-18-81</i>
Conam Examiner Signature: <i>James H. Rubinoff II</i> Level: <i>II</i> Date: <i>3-6/78</i>	Customer Acceptance Signature: <i>W. J. Caldwell</i> Date: <i>2-18-81</i>



NUCLEAR ENERGY SERVICES, INC.
 CONAM INSPECTION DIVISIO
 P. O. Box 160
 Grand Ridge, Illinois 61325

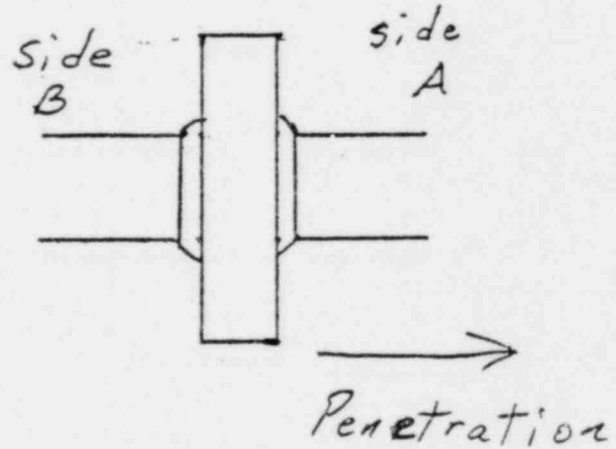
REPORT OF NONDESTRUCTIVE EXAMINATION

TYPE OF EXAMINATION: MT PT

Customer COMMONWEALTH EDISON COMPANY		Project LaSalle Station		Date 8-4-77
Contractor MCCO		Job No. 2466	P. O. No. N/A	Report No. - Request No. 1360 M77-078
Examination Standard/Edition - Add ASME Sec V-7 74 Summer <input checked="" type="checkbox"/> Winter <input type="checkbox"/>		Acceptance Standard/Edition - Add ASME Sec III NC 74 Summer <input type="checkbox"/> Winter <input type="checkbox"/>		N.D.E. Procedure No. - Rev. MT-1-NP REV 3
Line or Dwg. No. IRIO2A		Part No. or Description 10" Pipe to Plate		S & L Class B
Type of Work New <input checked="" type="checkbox"/> Repair <input type="checkbox"/>	Surface Condition As Welded	Temp. of Mat'l Ambient	Heat No. N/A	Heat Treat N/A Before <input type="checkbox"/> After <input type="checkbox"/>
MAGNETIC PARTICLE TECHNIQUE DATA*				N/A <input type="checkbox"/>
Equipment PARKER PROBE A210	Dry <input checked="" type="checkbox"/> Wet <input type="checkbox"/>	Visible <input checked="" type="checkbox"/> Fluorescent <input type="checkbox"/>	AC <input checked="" type="checkbox"/> DC <input type="checkbox"/> Amperage Per Proc.	Prod. Spacing 6" Head <input type="checkbox"/> Coil <input type="checkbox"/> Yoke <input checked="" type="checkbox"/>
LIQUID PENETRANT TECHNIQUE DATA*				N/A <input checked="" type="checkbox"/>
Type Liquid Penetrant Materials Used	Batch No.	Penetrant - Dwell Time Water Washable <input type="checkbox"/> Post Emulsified <input type="checkbox"/>	Development - Time Visible <input type="checkbox"/> Fluorescent <input type="checkbox"/>	Solvent Removable <input type="checkbox"/> Dry <input type="checkbox"/> Wet <input type="checkbox"/> Nonaqueous <input type="checkbox"/>
*Additional Data:			No. of Items Accepted 1	No. of Items Rejected 0

PC No. or S/N No.	ACC	REJ	DEFECT CODE	REMARKS & DIAGRAM
IRIO2A				Full weld cover pass only.
1-197	<input checked="" type="checkbox"/>			
1-13				

RECEIVED
 AUG 05 1977
 MORRISON CONSTRUCTION COMPANY



Examined By Red Raveling II Signature	Level II	Date 8-5-77	Contractor Review & Acceptance MCCO Company	Signature A. Rubin	Date 8-15-77
Conam Examiner Signature	Level	Date	Customer Acceptance Signature	Signature	Date
			AI Review w. Caldwell	2-18-81	

ORIGINAL PSI Ref. No. RI-5

MORRISON CONSTRUCTION COMPANY
 LaSalle County Station
 Job No. 2466

REPORT OF LIQUID PENETRANT EXAMINATION

P.T. PROCEDURE NO. NDE-L/2 REV. 7 P.T. REPORT NO. 869
 LINE NO. RI-1 DRAWING NO. ^{BFAM}844-125 S & L CLASS A
 DESCRIPTION OF PARTS Closure Plate TYPE OF MATERIAL SS. TRAVELLER NO. 7-218
 PENETRANT TYPE ^{SKL-HF}SKL3 Formula B DEVELOPER TYPE ^{SKD-NF}Formula B CLEANER TYPE ^{SKL-NF}Formula B
 BATCH NO. 5H059 BATCH NO. 78A017 BATCH NO. 78E068

WELD/PIECE NUMBER(S)	ACCEPT	REJECT	REMARKS
<u>W-RI-102B</u>	<u>✓</u>		<u>Final</u>

EXAMINER Carl Rubini LEVEL II DATE 7-11-78
 INTERPRETER Carl Rubini LEVEL II DATE 7-11-78
 ACCEPTANCE A. Labrad LEVEL III DATE 7-17-78
 Quality Control Department

revised
 W. G. Caldwell CECO AMFI
 2-18-81

PSI Ref. No. RI-6
 Liquid Penetrant NDE
 Report NDE/L-2/2, Rev. 3
 (3/78)