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LONG ISLAND LIGHTING COMPANY

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ANDREW W. WOFFORD
VICE PRESIDENT

SNRC-332

October 18, 1978

Mr. Robert T. Carlson, Chief
Reactor Construction & Engineering Support Branch
U.S. Nuclear Regulatory Commission, Region I
631 Park Avenue
King of Prussia, Pennsylvania 19406

NRC Inspection No. 78-12
Shoreham Nuclear Power Station - Unit No. 1
Docket No. 50-322

Dear Mr. Carlson:

This letter responds to your letter of August 30, 1978, which forwarded the report of the inspection of activities authorized by NRC License No. CPPR-95, conducted by Mr. Toth of your office on August 8-11, 1978. The letter stated that it appeared that certain of our activities were not conducted in full compliance with NRC requirements. The apparent noncompliances and our responses follow:

I. Apparent Noncompliance with 10CFR50, Appendix B, Criterion IX, and FSAR Section 17.1.9B

Contrary to the above references, on August 9, 1978, the single-bevel groove weld joint angles for pipe break restraints FWR1, 2 and 15 were 30° although the AWS Structural Welding Code D1.1, paragraph 2.9, limits such weld joint angles to 45° minimum.

Corrective Action and Results

Prior to the inspection, welding on pipe restraints using the 30° bevel was accomplished using technique sheets W70J and W70H, both of which required the use of a bevel angle of 45° minimum if the techniques were to be considered prequalified by AWS. A review of the essential variables of these technique sheets has shown that they are adequately supported for use with a 30° bevel angle by Welding Procedure Qualification Tests on file. Accordingly, welds made to these technique sheets are acceptable.

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Steps Taken to Prevent Recurrence

A qualified weld technique sheet (attached to E&DCR P-3071) has been issued to cover all subsequent welding on pipe restraint joints having 30° bevels. Additionally, the requirement that all welding meet the provisions of the applicable code has been reemphasized to all welding contractors.

Date Full Compliance Will Be Achieved

Full compliance has been achieved.

II. Apparent Noncompliance with 10CFR50, Appendix B, Criterion V, and FSAR Section 17.1.5B

Contrary to the above references, on August 9, 1978, the front weld (inside diameter) size on pipe spool slip-on flange 1B21-SLP-211-3-1 was less than 1/4 inch, and the back weld (outside diameter) size on pipe spool slip-on flanges 1B21-SLP-211-3-1 and 1B21-SLP-203-3-1 was less than 3/8 inch; although ASME III, paragraph ND 3661.1, requires these welds to be 1/4 inch and 0.511 inch, respectively.

Corrective Action and Results

The results of an initial sampling inspection of fillet welds on slip-on flanges revealed the need to inspect all such welds. Accordingly, all accessible slip-on flange welds will be inspected, and those found deficient will be repaired to meet ASME III requirements. Engineering will provide further instructions regarding welds not accessible for inspection when the number of these welds is determined.

Steps Taken to Prevent Recurrence

The slip-on flange welds were shop-fabricated. Therefore, this condition has been brought to the attention of Procurement Quality Assurance (PQA). Additionally, the Project QA Manager has been requested to require that PQA advise the vendor of this condition and assure that the vendor takes proper corrective/preventive action.

Date Full Compliance Will Be Achieved

Full compliance is expected by February 1, 1979.

Very truly yours,

A. W. Wofford
Vice President