

PUBLIC

CONVERSATION RECORD

TIME

DATE

1-26-94

VISIT

CONFERENCE

TELEPHONE

3A-00850-02

030-05641

INCOMING  
 OUTGOING

NAME OF PERSON(S) CONTACTED OR IN CONTACT

ORGANIZATION (OFFICE, DEPT. ETC.)

TELEPHONE NO.

Ralph Nades

Conner Pipe Systems

703-

966-2045

SUBJECT

1-21-94 and

Letter dated 1-25-94 with commitments and attached survey

SUMMARY

Confirmatory surveys had only been done on left half of high pressure Bay. Further, a detailed look at drawing (and confirmed by inspection by Mr. Nades) shows a near direct line of site with little shielding provided through the labyrinth at about a 45 degree angle.

I agreed to let them use the portion of the high pressure bay to the left of dotted line in diagram attached to 1-25-94 letter on basis of survey data & commitments submitted.

However, they must modify (lengthen) walls of labyrinth entrance to high pressure bay, amend license (probably not to be done) and submit confirmatory survey before we will authorize use to the right of dotted line in high pressure bay as depicted in diagram attached to 1-25-94 letter.

ACTION REQUIRED

NAME OF PERSON DOCUMENTING CONVERSATION

SIGNATURE

DATE

250069

Loren Hunter

1-26-94

ACTION TAKEN

9403110061 940126  
PDR ADOCK 03005641  
C PDR

SIGNATURE

TITLE

DATE

ML  
30 AH



PIPE SYSTEMS

January 25, 1994

United States Nuclear Regulatory Commission  
Region III  
801 Warrenville Road  
Lisle, Illinois 60532-4351

Attention: Mr. Loren J. Hueter <sup>02</sup>  
Reference: License Number 34-00850-22 Additional Information

Dear Loren:

Thank you for your response to my letter dated January 21, 1994. In response to your comments, I would like to submit the following:

1. Radiography will be limited to the area to the left of the Cell until a suitable wall is placed (High Pressure Bay).
2. During normal operations, a 6" X .280" exposure on center using 30 Ci of IR192 would take seven (7) seconds, with set-up time, recentering the isotope, film placement, etc., we could radiograph four (4) welds in one hour substantially reducing the MR/HR at the door (See Attachment 1).
3. For the Low Pressure Bay, lines will be painted on the floor, as indicated, to assure radiography will not be performed in these areas.

Please feel free to telephone me at 703-966-2045 for any additional information.

Sincerely,

*Ralph E. Nodes*  
Ralph E. Nodes  
Radiation Safety Officer

Attachment

cc: Don J. Leininger

PUBLIC

Connex Pipe Systems, Inc.  
One Connex Way  
Troutville  
Virginia 24175  
Phone: 703-882-1600  
Fax: 703-882-8100

030-05641

RECEIVED

JAN 28 1994

REGION III

A member of the Whessco Group

JAN 28 1994

ML  
38  
DH



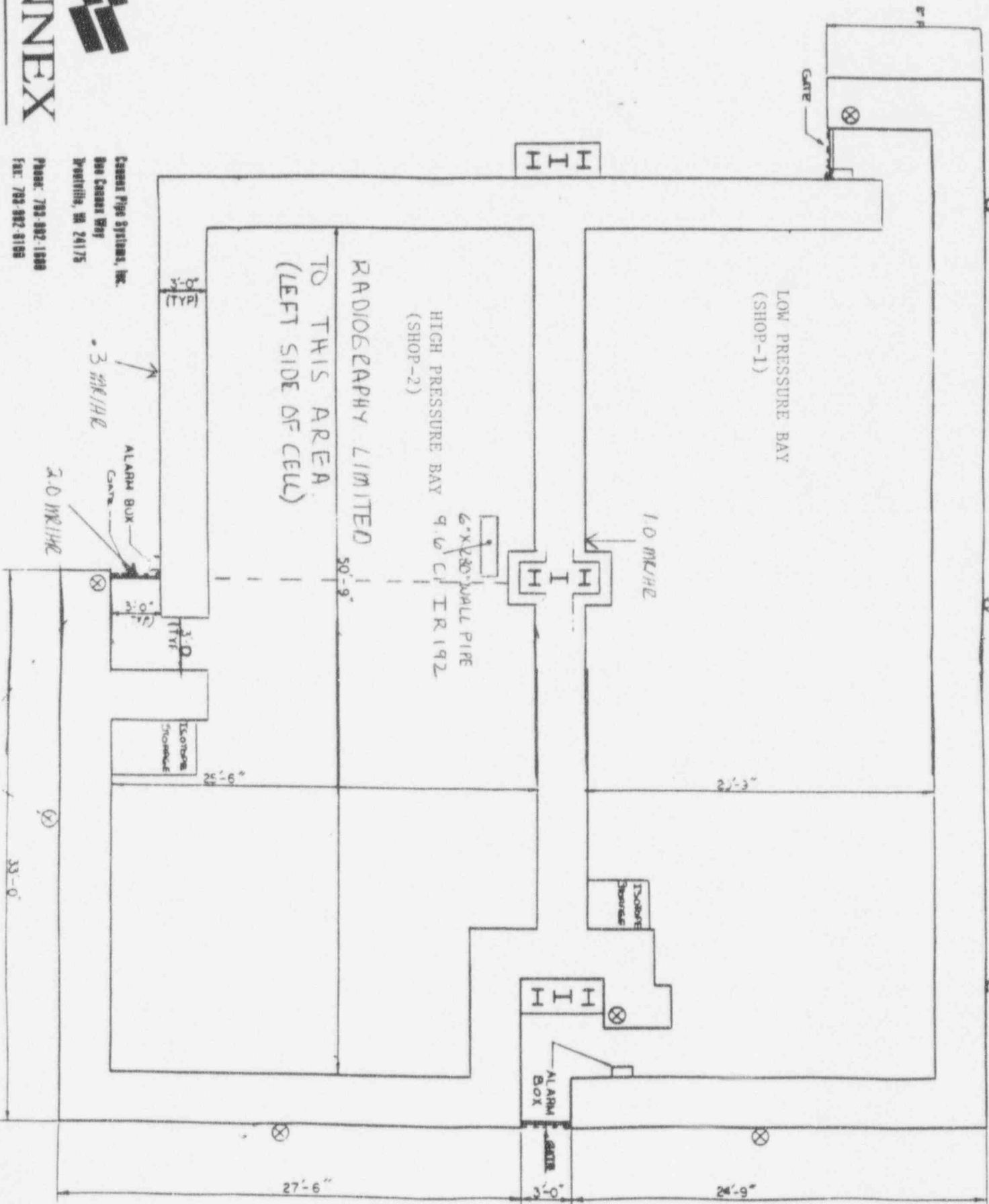
# CONNEX

## PIPE SYSTEMS

Connell Pipe Systems, Inc.  
One Connex Way  
Brentville, MO 24175

Phone: 783-982-1888  
Fax: 783-982-8199

A member of the Dresser Group





**CONNEX**

**PIPE SYSTEMS**

January 21, 1994

*PUBLIC*

Connex Pipe Systems, Inc.  
One Connex Way  
Troutville  
Virginia 24175  
Phone: 703-882-1600  
Fax: 703-882-6100

*030-05641*

United States Nuclear Regulatory Commission  
Region III  
801 Warrenton Road  
Lisle, Illinois 60532-4351

**Attention:** Mr. Loren J. Hueter *02*  
**Reference:** License Number 34-00850-~~22~~ Additional Information to  
Control Number 95761 Letters Dated December 6 and  
December 9, 1992

Dear Mr. Hueter:

Attached are the recent surveys of our Radiograph Cells as required by Paragraph 19 of License Amendment #41. These surveys should complete all the requirements of Paragraph 19.

Attachment #3 MR/HR at the gate is 2 MR/HR. In actual production, with 9.6 curies of IR192, each exposure would be 20 seconds thereby reducing the actual MR/HR substantially.

The area of the roof over the Radiograph Cell is posted with radiation area signs; a work permit system is in use which requires the R.S.O. to issue a radiation area work permit for access.

Please feel free to telephone me at 703-966-2045 for any additional information.

Sincerely,

*Ralph E. Nodes*  
Ralph E. Nodes  
Radiation Safety Officer

Attachment - 6 copies

cc: Don J. Leininger

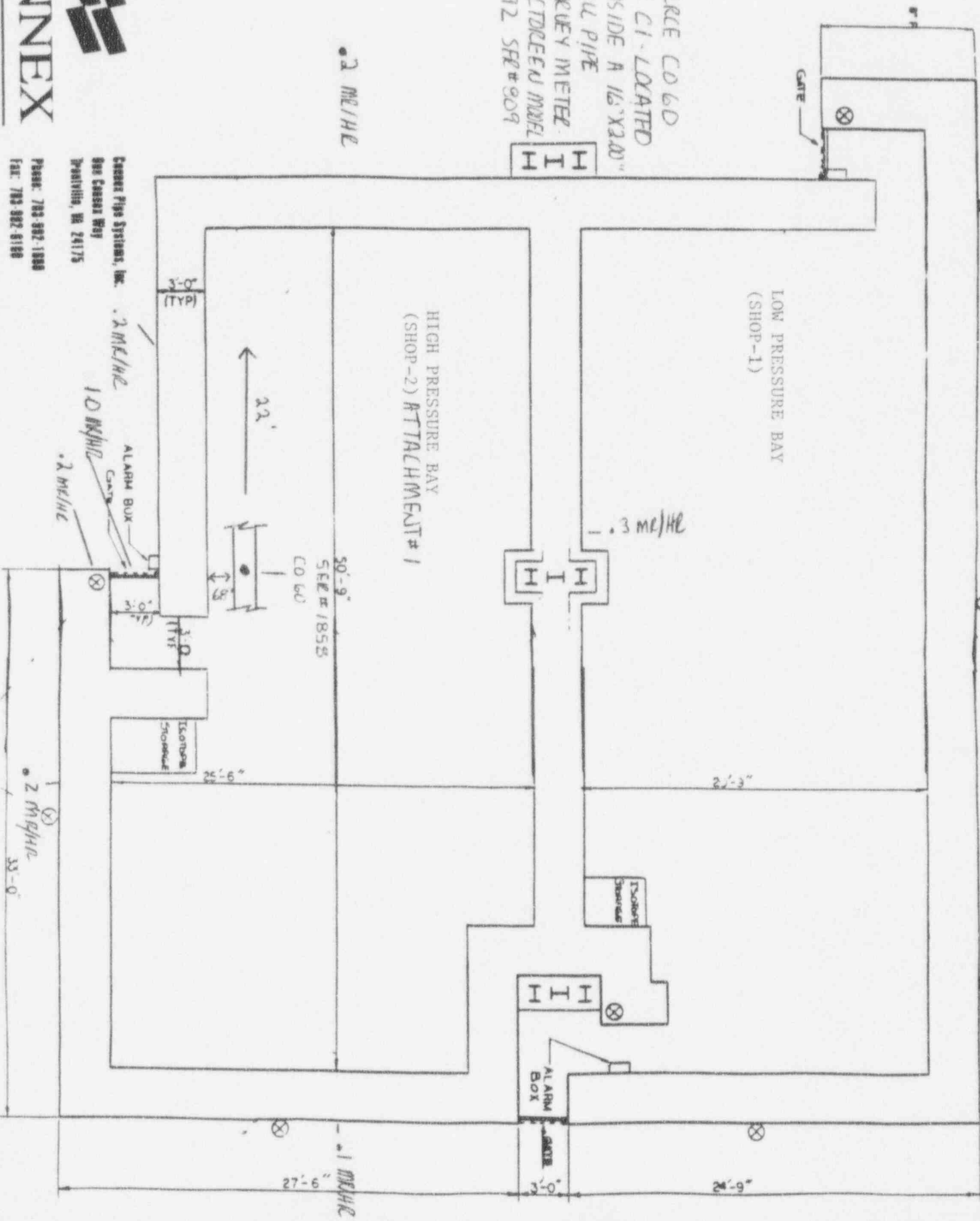
RECEIVED  
JAN 25 1994  
REGION III

A member of the Whessco Group

JAN 25 1994

*ML*  
*38*  
*DH*

NOTES: SOURCE CO 60  
 1.7 CI-LOCATED  
 INSIDE A 16" X 20"  
 WALL PIPE  
 SUCKEY METER  
 VICTOREN MODEL  
 492 SEE # 909



• 2 MCF/Hr

• 3 MCF/Hr

• 2 MCF/Hr

• 2 MCF/Hr

• 1 MCF/Hr

CONNEX  
 CONNEX PIPE SYSTEMS, INC.  
 800 CONNEX WAY  
 BOSTON, MA 02115

PHONE: 781-982-1888  
 FAX: 781-982-8188

PIPE SYSTEMS

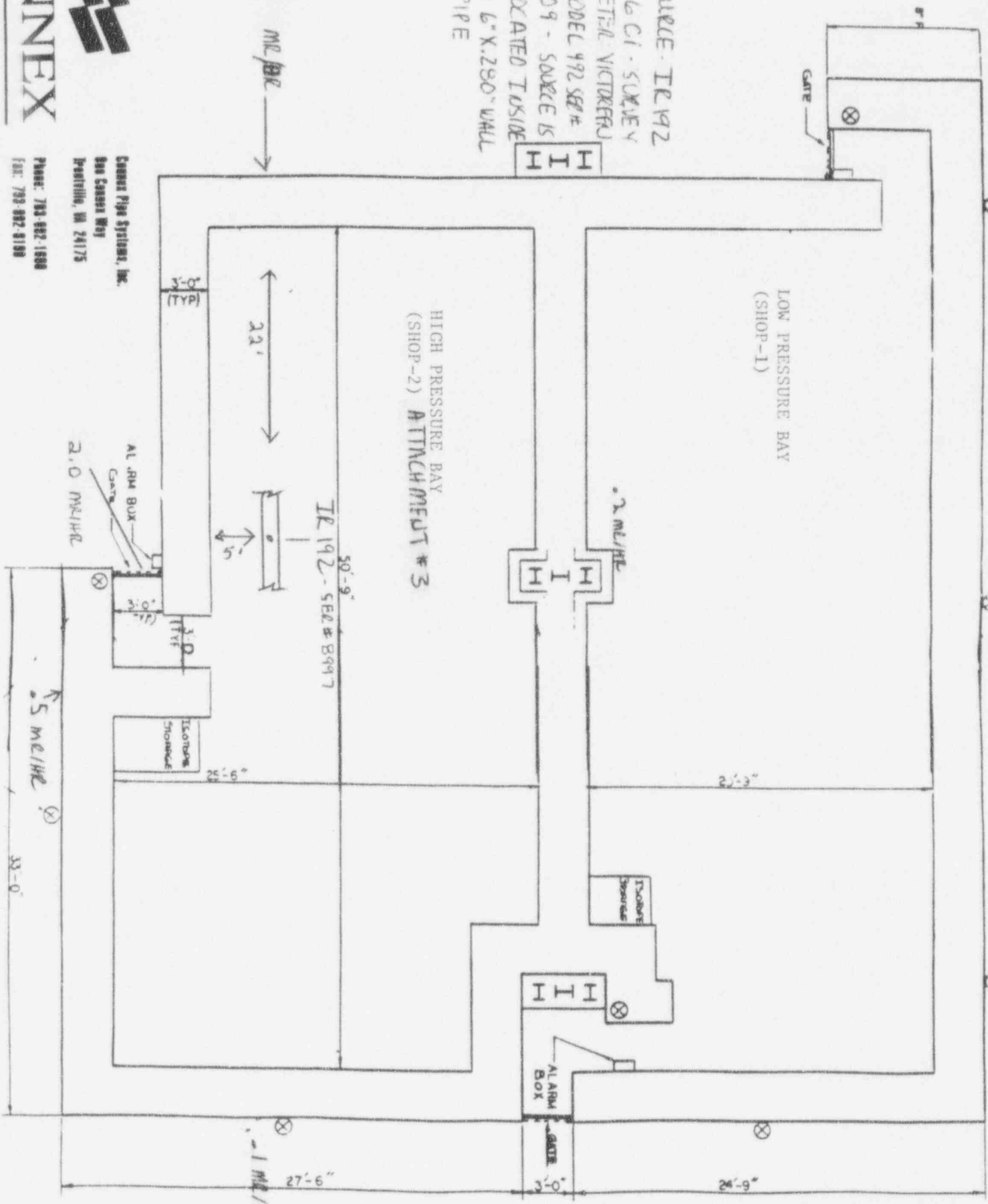
A member of the Messer Group



NOTES SOURCE: IR 192

9.6 CI - SURVEY  
METAL VICTREX  
MODEL 492 SEE #  
809 - SOURCE IS  
LOCATED INSIDE  
A 6" X 290" WALL  
PIPE

1 MIL/HR



# CONNEX

PIPE SYSTEMS

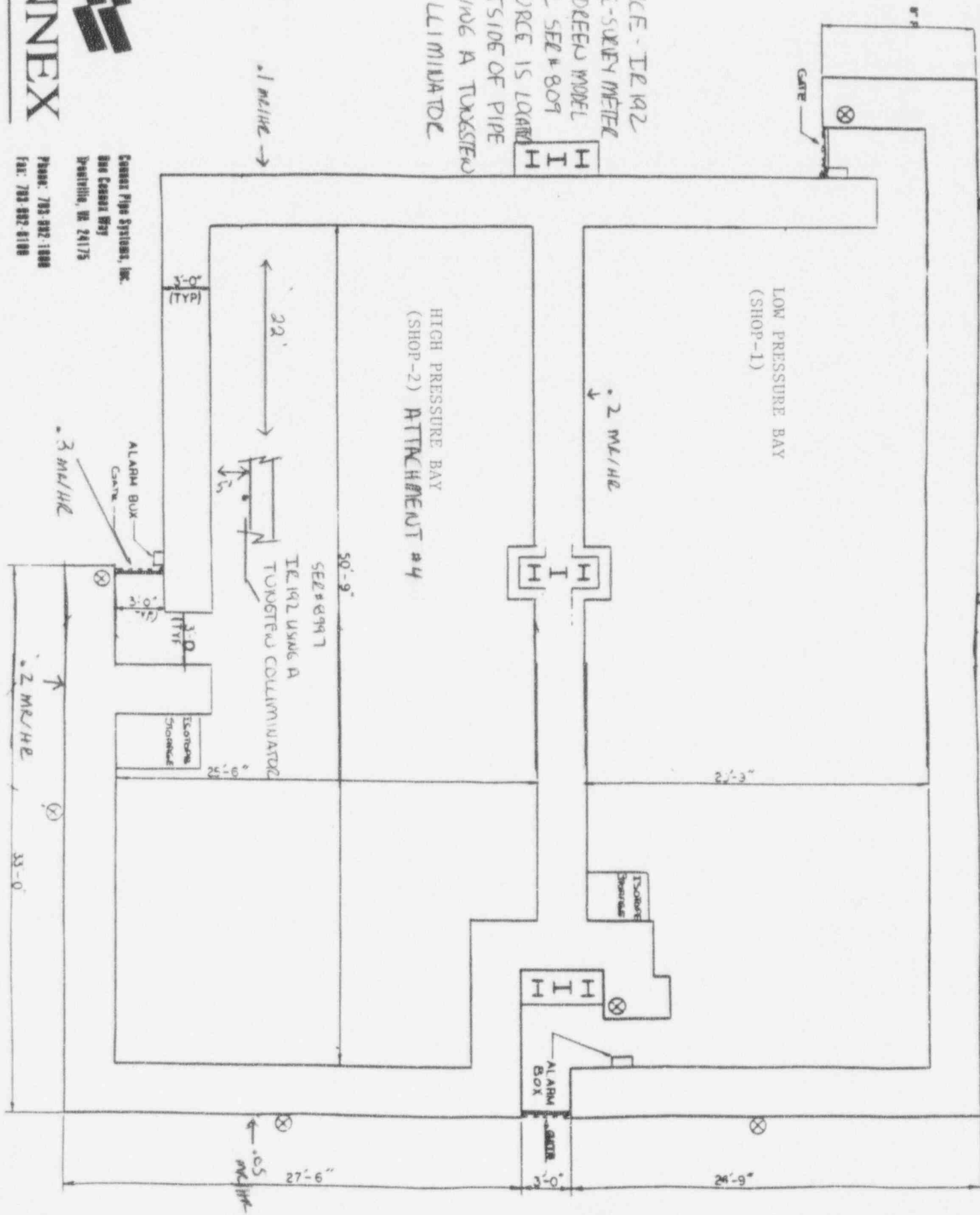
CONNEX Pipe Systems, Inc.  
800 Casson Way  
Brentville, VA 24175

Phone: 703-892-1800  
Fax: 703-892-8190

A member of the Wessco Group

ES SOURCE - TEL 192  
 96.62-SURETY METER  
 VICTREED MODEL  
 492 SEAL # 809  
 SOURCE IS LOCATED  
 OUTSIDE OF PIPE  
 US/INDE A TUGGESTED  
 COLLIMINATED

1 ML/HZ →



**CONNEX**

PIPE SYSTEMS

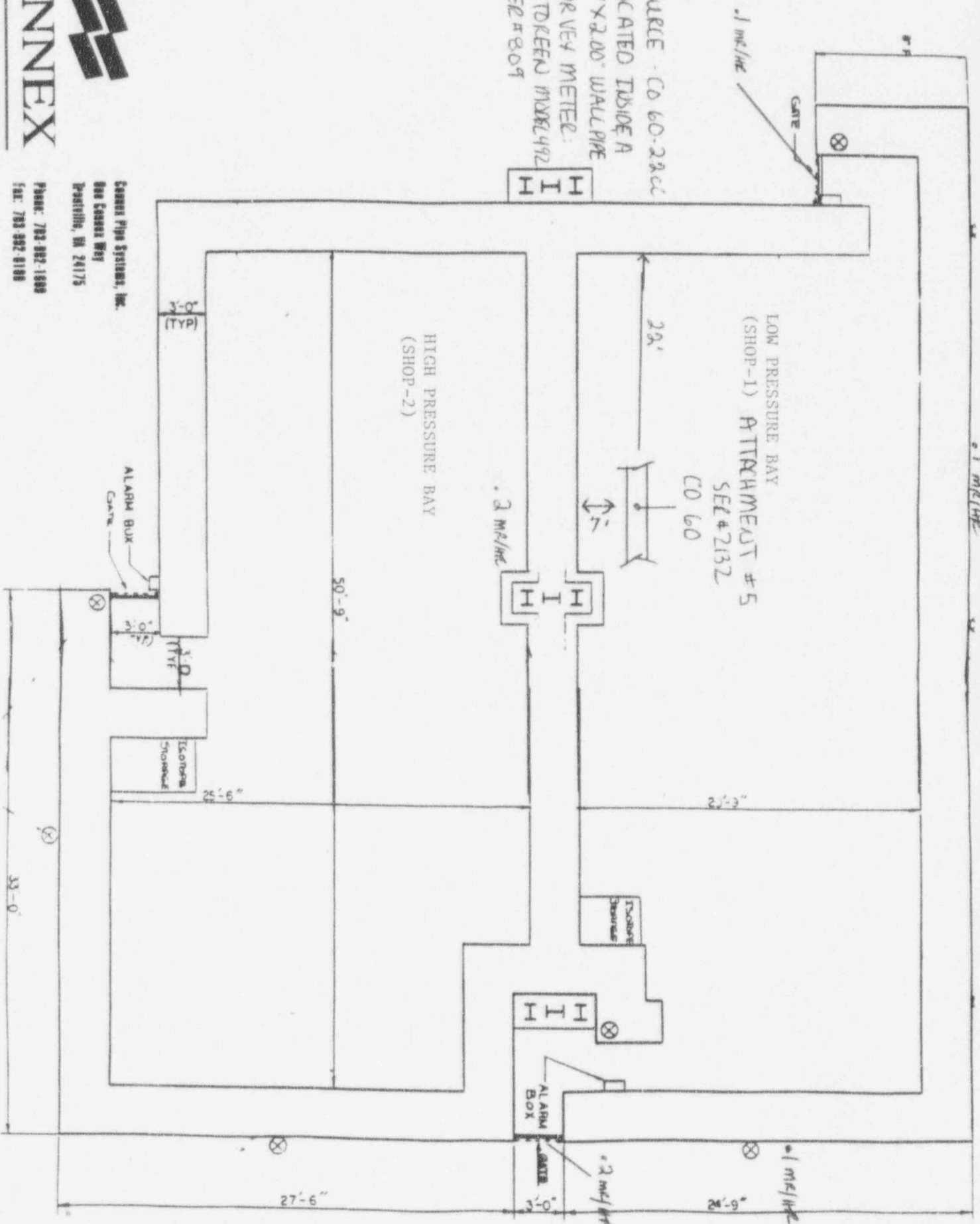
Connex Pipe Systems, Inc.  
 One Cassin Way  
 Danville, VA 24175

Phone: 783-892-1888  
 Fax: 783-892-8188

A member of the Whetstone Group



NOTES: SOURCE - CO 60-220C  
 LOCATED INSIDE A  
 12" X 2.00" WALL PIPE  
 SURVEY METER:  
 VICTOREEN MODEL 492  
 SER # 809



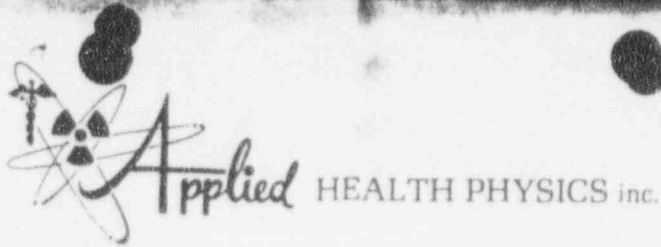
**CONNEX**

PIPE SYSTEMS

CONNEX Pipe Systems, Inc.  
 One Conner Way  
 Portsmouth, NH 24175

Phone: 781-922-1889  
 Fax: 781-922-9188

A member of the Whessco Group



2986 Industrial Blvd. — Bethel Park, Pa. 15102 — Phone 412 — 835-9555 — Fax No. 412 — 835-9559

### CERTIFICATE OF CALIBRATION

SHIPPING ADDRESS				BILLING ADDRESS (If Different)																																																
CONNER PIPE SYSTEMS				SAME																																																
115 GILMAN ST																																																				
MARIETTA OH 45750																																																				
CONTACT: <u>R. NODDS</u> PHONE: ( )				DATE: <u>11/1/93</u> P.O.# <u>27717</u>																																																
Receiving Comments:																																																				
Instrument Received:		<input checked="" type="checkbox"/> Within Toler. $\pm 10\%$	<input type="checkbox"/> $\pm 10-20\%$	<input type="checkbox"/> Out Toler.	<input type="checkbox"/> Requires Repair																																															
Mfg. Inst. <u>VICTORIN</u>		Model # <u>492</u>		Serial # <u>209</u>																																																
Detector <u>"</u>		Model # <u>—</u>		Serial # <u>INTEGR</u>																																																
<input checked="" type="checkbox"/> CALIBRATION	<input type="checkbox"/> REPAIR	<input type="checkbox"/> SALE	LOAN By: <u>[Signature]</u>																																																	
scale	source	reading	scale	source	reading	scale	source	reading																																												
	mR/hr			mR/hr			mR/hr																																													
<u>X1</u>	2	2.0	<u>X10</u>	19.2	19.8	<u>X100</u>	196	200																																												
	7.6	8.0		66	68		800	794																																												
Calibration Source: <input checked="" type="checkbox"/> GAMMA		<input type="checkbox"/> ALPHA		<input type="checkbox"/> BETA		<input type="checkbox"/> ELECTRONIC		<input type="checkbox"/> OTHER																																												
Description: <input checked="" type="checkbox"/> ra-226		<input type="checkbox"/> cs-137		<input type="checkbox"/> pu-239		<input type="checkbox"/> sr-90		<input type="checkbox"/> mp-1																																												
RESPONSE GRAPH <u>N/A</u>				PROBE EFFICIENCIES																																																
<table border="1" style="width:100%; height: 100px;"> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> </table>																																																	Alpha <u>—</u> & Beta <u>—</u>			
Check Source Reading <u>N/A</u>																																																				
Battery Check Reading <u>8.8 mR/hr</u>																																																				
Detector Angle <u>PERPENDICULAR</u>																																																				
Corrections <u>N/A <math>\pm 10\%</math></u>																																																				
TEMP/HUMIDITY <u>8.4 °F / 13 °</u>																																																				
Maintenance & Comments <u>REPAIR (2) DEUS HV-OK</u>																																																				
CALIBRATION		<u>60.00</u>		QA Dept. _____		Warranty _____																																														
LABOR				Shipping <u>UPS</u>		Date <u>11/1/93</u>																																														
MATERIALS		<u>(2) DEUS 1.7500 3.50</u>		Pick-Up _____		Date <u>1/1</u>																																														
&				This Certificate Expires In <u>3</u> Months																																																
SALES				Re-Calibrate On Or Before <u>2/1/94</u>																																																
SHIPPING		<u>UPS</u>		Job ID # _____																																																

ATTACHMENT 6

NOTICE: Applied Health Physics, Inc. certifies that the above instrument has been calibrated by standards traceable to the National Institute of Standards and Technology under Nuclear Regulatory Commission License #37-09135-01 and PA State License #PA-0228. This calibration system conforms to the requirements of NRC regulation 10-CFR-34, 10-CFR-35, MIL-STD 45662A and ANSI-STD N323-1978.



PUBLIC

Connex Pipe Systems, Inc.  
One Connex Way  
Troutville  
Virginia 24175  
Phone: 703-882-1600  
Fax: 703-882-8100

PIPE SYSTEMS

December 9, 1993

United States Nuclear Regulatory Commission  
Region III  
799 Roosevelt Road  
Glen Ellyn, Illinois 60137-5927

Attention: Mr. Loren J. Hueter

02

**Reference: License Number 34-00850-22**  
**Additional Information to Control Number 95761**

**Letter Faxed: 708-790-5183**

Dear Mr. Hueter:

I would like to submit the following:

1. Survey of Radiograph Cell is for the low pressure bay of our shop. Prior to using the Cell for the high pressure side for radiography, a complete survey for Co 60 and Ir 192 will be submitted to your attention. Until the survey for the high pressure Cell is complete and accepted, radiography will be limited to using Ir 192 on the low pressure side (Submitted survey).
2. The 3mr/hr intensity at each door for set-up #1 is based on the isotope being in exposed position for an hour. In Production, if a 46.0 ci of Ir 192 was used for this pipe diameter and thickness, the actual exposure would be approximately 5 seconds, (using Kodak M-film) thereby reducing the actual mr/hr per hour substantially. Of course, the maximum strength of Ir 192 on our license is 36 curies which also should be taken into account.

Please feel free to call me at 703-966-2045. for any additional information.

Sincerely,

*Ralph E. Nodes*  
Ralph E. Nodes  
Radiation Safety Officer

REN/aew

cc: Don J. Leininger

RECEIVED  
DEC 13 1993  
REGION III

A member of the Whesson Group

DEC 13 1993

ml  
30  
DH



PIPE SYSTEMS

December 6, 1993

PUBLIC

Connex Pipe Systems, Inc.  
One Connex Way  
Troutville  
Virginia 24175  
Phone: 703-892-1600  
Fax: 703-892-8100

030-05641

United States Nuclear Regulatory Commission  
Region III  
799 Roosevelt Road  
Glen Ellyn, Illinois 60137-5927

Attention: Mr. Loren J. Hueter

Reference: License Number 34-00850-22<sup>02</sup>  
Additional Information to Control Number 95761

Dear Mr. Hueter:

Attached is a recent survey of our Radiograph Cell as required by Paragraph 19 of License Amendment No. 41. As related in our telephone conversation of December 2, 1993, the Isotope used was 46.0 ci of IR 192 by an outside agency (Froehling and Robertson, Inc., Roanoke, Virginia).

Survey parameters are as listed below:

1. Isotope used: IR 192 - 46.0 ci (Outside Agency);
2. Survey Instrument: Make-Bicorn - calibrated 10/19/93 - due for recalibration 01/19/94 (Outside Agency)- calibration cert attached;
3. Position of Source:
  - Set-up #1 - Source centered inside a 8" x .322" wall carbon steel pipe approximately 30" above floor level;
  - Set-up #2 - Using a tungsten collimator at the same location source is outside of pipe;
4. During periods when the Isotope was in the exposed position, the area of the roof over the radiograph cell was under surveillance to assure individuals were not in the radiation area;

RECEIVED

DEC 07 1993

REGION III

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DEC 07 1993

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3P  
DH



Mr. Loren J. Hueter  
December 6, 1993  
Page 2 of 2

5. At the present time, survey is for IR 192 only. Prior to using a CO 60 source for radiography, a new survey will be submitted to your attention.

Please feel free to telephone me at 703-966-2045 for any additional information.

Sincerely,

*Ralph E. Nodes*  
Ralph E. Nodes.  
Radiation Safety Officer

REN/aew

cc: D. Leininger

# NDS PRODUCTS INC

P.O. BOX 1896  
PASADENA, TEXAS 77506  
PHONE: (713) 475-2986

CALIBRATION CERTIFICATE  
TEXAS LICENSE # LO0991

111 ANDERSON  
PASADENA, TEXAS 77506  
FAX: (713) 477-6741

CUSTOMER: FROEHLING & ROBERTSON, INC      ORDER NR.: 01527  
1734 SEIBEL DR NE  
ROANOKE VA 24012  
MFG: BICRON      MODEL: RADIOGRAPHER      SERIAL NR.: A829A  
CALIBRATION DATE: 10-19-93      CALIBRATION DUE DATE: 01-19-94

T. 71 DEG F      RH. 36 %      B.P. 759.9 mm Hg  
X: HIGH AND LOW VOLTAGES CHECKED.      X: BATTERIES CHECKED  
X: METER ZEROED      : REPLACED WITH EN95-93 ALKALINE  
: CURRENT CHECKED AND ADJUSTED.      : REPLACED WITH EV150 OR EV135  
X: SATURATION GREATER THAN 15 R/HR      : REPLACED WITH :  
X: INSPECTED FOR DAMAGE.      X: GEOTROPISM CHECKED  
X: TIGHTEN LOOSE HARDWARE      X: PROPER FUNCTIONING ASSURED  
PARTS REPLACED:

COMMENTS:

NDS PRODUCTS CERTIFIES THAT THE ABOVE INSTRUMENT HAS BEEN CALIBRATED BY STANDARDS TRACEABLE TO N.I.S.T. THE CALIBRATION SYSTEM CONFORMS TO THE REQUIREMENTS OF MIL-STD-45662, ANSI-N323-1978, N.R.C. 10 CFR PART 34.24, 10CFR 39.33, TEXAS TRCR PART 21.201, PART 31.14, AND PART 36.104

**CALIBRATED TO**  
**Cs-137 0.662 MeV S/N 310 (S-623) TRACEABLE CERT. TEST NR. 43823**  
CALBRATED BY NOEL D. SMITH RSO Q.A. MANAGER, KEVIN E. SMITH Q.A. TECH. OR QUINTIN STOKLEY Q.A. TECH.

SIGNATURE: \_\_\_\_\_ DATE: 10-19-93

INSTRUMENT RANGE mR/hr	INSTRUMENT READING mR/hr	CAL. REFERENCE POINT mR/hr	AS RECEIVED READING mR/hr
0 - 10,000		2000 - 8000	
0 - 1000	210 - 770	200 - 800	210 - 770
0 - 100	21 - 80	20 - 80	21 - 80
0 - 10	2.1 - 8.0	2 - 8	2.1 - 8.0
0 - 1		0.2 - 0.8	
0 - 2000		400 - 1600	
0 - 200		40 - 160	
0 - 20		4 - 16	
0 - 2		0.4 - 1.6	
0 - 0.2		0.1	
0 - 500		100 - 400	
0 - 50		10 - 40	
0 - 5		1 - 4	
0 - 0.5		0.1 - 0.4	