



NUCLEAR  
ENERGY  
SERVICES, INC.

5-23-82  
Date

ISI FIELD CHANGE AUTHORIZATION

Document Title Nozzle Safe Ends Document No. 80A0475 Rev. 6

Field Change No. FC-5 Originator Peter P. Ryan

Description of Field Change:

- 1) For 45° Axial and Circumferential Examinations of the Recirculation Outlet Safe-end welds, this field change supersedes Item 3 of field change #1.
- 2) Add Recirculation Outlet Angle Beam Examination Technique sheet.

Reason for Change:

- 1) To accommodate a more effective examination technique. (ie higher signal to noise ratios, better weld material penetration)

Approvals:

NEI  
LILCO

P. P. Ryan  
Peter P. Ryan UT-III  
J. [Signature] MK

9-24-82  
9-23-82

Distribute to all Controlled Copy holders of affected Document.

Note: A copy of this authorization shall be attached to the affected document until a subsequent revision incorporates the field change.

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Technique Sheet For Recirculation Outlet Angle  
Beam Examination- Technique Sheet, from the STAINLESS  
Steel Side including the weld.

- 1) The examination shall be conducted with a longitudinal search unit exhibiting a 1.0 MHz nominal frequency
- 2) The surface of the lucite wedge shall be contoured to the outside radius of the component being examined. (this is to enhance the percentage of sound induced into the material and increase the the signal to noise ratio.
- 3) Due to the curved lucite wedge design all angles will be measured directly from the component's designated calibration standard.
- 4) The calibration shall be conducted utilizing the technique referenced in section 8.4 of procedure 80A0475.
- 5) Scanning sensitivity will be 6db above reference.
- 6) All indications noted within the material shall utilize the typical recording levels noted in procedure 80A0475.
- 7) Due to the lower sensitivity of the notch response in relation to the DAC curve when examining with refracted longitudinal techniques, all indications found at the ID will be recorded at 50% of the notch response. This will enhance a more conservative examination.

Peter P. Ryan

HIES

Peter P. Ryan

UT-III

5-27-82