

JUN 04 1984

Docket No. 50-352

Philadelphia Electric Company  
ATTN: Mr. John S. Kemper  
Vice President  
Engineering and Research  
2301 Market Street  
Philadelphia, PA 19101

Gentlemen:

Subject: NRC Independent Measurements

The NRC will perform an independent verification inspection at Limerick Unit 1, using the NRC Nondestructive Examination (NDE) Van and contractor technicians under NRC direction. Construction activities and materials will be sampled through nondestructive examinations as a supplement to our existing inspection efforts. Similar future nondestructive examinations by the NRC are planned on a routine basis at other licensee construction and operating sites.

The inspection onsite will begin on July 9, 1984, and will conclude on July 20, 1984. Welds will be selected by the NRC resident inspector for examination by the NDE van team. We request that documentation packages be prepared by your staff for the selected welds. Additional information on the requested document packages is provided in Attachment A. It is requested that all document packages be in the NRC Region I office by June 25, 1984. The data packages will be reviewed by the Regional office for completeness and technical content. We will update our NDE procedures to be consistent and with your committed codes and standards. All documentation supplied by your staff will be returned upon request at the completion of the inspection.

Members of your staff will be kept informed of our inspection progress and significant findings. An exit meeting with you or members of your staff will be conducted on July 20, 1984, in accordance with our normal procedures.

The evaluation of examination results and preparation of an inspection report will be completed and the results of the inspection will be transmitted to you through the standard NRC inspection report.

Additional information relating to the NDE van activities at your facility are discussed in Attachments B and C.

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If you should have any further questions regarding this planned inspection, please contact the assigned Senior Resident Inspector, or Mr. Jacques P. Durr at (215) 337-5282 of the NRC Region I Office. Your cooperation in this matter is appreciated.

Sincerely,

ORIGINAL SIGNED BY

*Stewart D. Ebner*  
Thomas T. Martin, Director  
Division of Engineering and  
Technical Programs

Attachments:  
As Stated

cc w/encl:

V. S. Boyer, Senior Vice President, Nuclear Power  
Troy B. Conner, Jr., Esquire  
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OFFICIAL RECORD COPY

*D*  
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*5/25/87*

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Philadelphia Electric Company

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bcc:

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 Region I  
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DATA PACKAGES - ATTACHMENT A

After the welds have been selected for NDE inspection, we request that you prepare a package containing the following on each weld:

Inspection Report  
Weld History (QC History)  
Material Certifications for base materials  
Weld Wire Certifications  
Piping drawings, Isometric of Welds locations  
NDE Reports on all NDE performed  
NDE Procedures for RT, PT, MT and VT  
Weld Procedures  
Bolt Torquing procedures (Structural and  
pipe hangers)

The assembled packages should be forwarded to:

US Nuclear Regulatory Commission  
Region I  
631 Park Avenue  
King of Prussia, Pennsylvania 19406

ATTN: Mr. Harry Kerch

## SUPPLEMENTAL NDE VAN INFORMATION

### ATTACHMENT B

#### 1. NDE Van Support Requirements

We request that the NRC-NDE Van be positioned as near as practicable to the containment area entrance to facilitate the performance of inspections.

- a. The van requires the following connections while sited at your facility:
  - Site water with a garden hose connection - this water is for film rinse water.
  - Requirement for film rinse water drain (continual). No chemical disposal will occur from the van without prior concurrence from appropriate licensee personnel. At the end of the independent inspection, the NRC needs to dispose of the film developing chemicals prior to moving the van from the site.
  - Two 30 amp 110 volt circuits are required for operation of the van.
- b. The van will contain PT and MT approve materials. They will need two rolls of your chemically approved tape and two approved markers for identifying welds and marking weld areas.
- c. It will be necessary for you to remove the paint, rust or other material that could interfere with PT or MT on the selected welds. Also, we will require scaffolding for access and to have insulation removed as needed.

#### 2. Administrative Information

- a. The radiation source will be a nominal 100 curie IR-192 source. This source is licensed by NRC, but owned by the NRC contractor.
- b. The names of the NRC and contractor NDE personnel will be supplied to you by Region I. Clearance for these personnel is necessary.

Attachment B (Continued)

- c. We request that you hold a mini-radiation safety training course for the four NDE personnel. This course should familiarize the personnel with your facility and procedures and should not exceed 2 hours in length.
- d. A camera site pass will be needed for a Canon AE-1, 35 mm, camera, Serial No. 1969401.
- e. The NDE personnel will be using 5 watt Motorola radios on the site, the frequency used by the NRC is 165.6625 MHz.



## SCOPE OF INSPECTION

### ATTACHMENT C

The NDE van team will perform the following examinations and inspections as appropriate:

#### Radiography:

Pipe butt and socket welds and other appropriate pressure boundary components.

#### Ultrasonics:

Flaw detection and material thickness measurements, as appropriate, of piping, welds, structural components, vessels, heat exchangers, bolts and other equipment.

#### Liquid Penetrant:

Piping system components and structural elements.

#### Magnetic Particle

Piping system components and structural elements.

#### Hardness Testing:

All of the previously listed components.

#### Windsor Probe:

Safety related concrete.

#### Delta Ferrite Indications (Severn Gage):

Stainless steel welds.

#### Alloy Analysis:

Selected metallic components will have confirmatory chemical analysis performed.

#### Visual Examinations:

Weld quality and configuration verification of piping and structural systems.

#### Quality Records Review:

Welding documentation, materials and personnel certification, NDE records to include radiographs.