

# NORTHEAST UTILITIES



THE CONNECTICUT LIGHT AND POWER COMPANY  
WESTERN MASSACHUSETTS ELECTRIC COMPANY  
HOLYOKE WATER POWER COMPANY  
NORTHEAST UTILITIES SERVICE COMPANY  
NORTHEAST NUCLEAR ENERGY COMPANY

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March 16, 1984

Docket No. 50-423

F0454A

Mr. Thomas T. Martin, Director  
Division of Engineering and Technical Programs  
Region I  
U. S. Nuclear Regulatory Commission  
631 Park Avenue  
King of Prussia, PA 19406

- References: (1) T. T. Martin letter to W. G. Council, dated November 22, 1983.
- (2) W. G. Council letter to T. T. Martin, dated December 22, 1983.

Dear Mr. Martin:

Millstone Nuclear Power Station, Unit No. 3  
IE Inspection Report No. 50-423/83-14

In Reference (1), two Severity Level V Violations were identified and transmitted to us as a result of the subject inspection. Item A pertained to the placement of penetrameters across Tubeco welds and Item B pertained to radiographic film densities. Reference (2) identified our plans to resolve Item A and requested additional time to respond to Item B. We are now providing you with a final report on these items.

## Item A

A review of the five welds cited in Reference (1) determined that the subject concern occurred only on 6-inch and 8-inch schedule-40 weldments. Our architect-engineer, Stone & Webster Engineering Corporation, reviewed a sample consisting of two-hundred fifty-seven (257) Tubeco supplied welds of this size and 67 of them had additional penetrameters in the weld area of interest. All of these welds had correctly placed identifying numbers and markers. The density and contrast in the area of interest under the penetrameter was found to be within Code requirements and adequate to allow interpretation.

In response to our Code inquiry, the American Society of Mechanical Engineers (ASME) Boiler and Pressure Vessel Committee has confirmed that penetrameters may be placed on the weld when geometrically necessary or under Section V Code Case 1914. While penetrameter placement was not restricted in the

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Tubeco case, the placement was found to not preclude interpretation which has been documented by the Tubeco film interpreter.

Based on this review, the original interpretation performed by Tubeco, Inc. verifies acceptable weld quality.

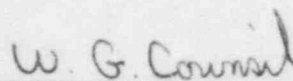
Item B

The radiographic film densities cited in Reference (1) were investigated by us as follows. A review of 777 (total welds x 3 minimum exposures assuming smallest diameter) of a total of 8220 separate Tubeco films were reviewed for compliance to the 3.8 density procedure requirement. Five exposures were found to be unacceptable. These five unacceptable exposures have been reradiographed and subsequent readings indicate all five to be acceptable.

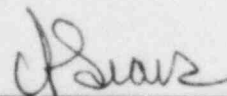
We view these occurrences to be isolated incidents of non-compliances to the code. Based on our reinspections, we see no technical nor safety concerns. We anticipate no reoccurrences because of our increased attention in this area and also because this phase of the work is essentially complete. Thus, no further corrective or preventative action is necessary.

We consider this to be our final report on this matter, closing out the two violations identified in IE Inspection Report No. 50-423/83-14. Based on a February 15, 1984 and March 16, 1984 telephone discussion between our Ms. P. Capello-Bandzes, and your Mr. R. H. Harris and Mr. H. W. Kerch, this letter is being provided on March 16, 1984 rather than February 15, 1984. We trust that the above information satisfactorily responds to your concerns.

Very truly yours,



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W. G. Council  
Senior Vice President



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By: C. F. Sears  
Vice President Nuclear and  
Environmental Engineering