



UNITED STATES  
NUCLEAR REGULATORY COMMISSION  
WASHINGTON, D.C. 20555-0001

WISCONSIN ELECTRIC POWER COMPANY  
DOCKET NO. 50-266  
POINT BEACH NUCLEAR PLANT, UNIT NO. 1  
AMENDMENT TO FACILITY OPERATING LICENSE

Amendment No. 166  
License No. DPR-24

1. The Nuclear Regulatory Commission (the Commission) has found that:
  - A. The application for amendment by Wisconsin Electric Power Company (the licensee) submitted by letter dated November 9, 1995, as supplemented by letters dated November 13, 1995, and November 16, 1995, complies with the standards and requirements of the Atomic Energy Act of 1954, as amended (the Act), and the Commission's rules and regulations set forth in 10 CFR Chapter I;
  - B. The facility will operate in conformity with the application, the provisions of the Act, and the rules and regulations of the Commission;
  - C. There is reasonable assurance (i) that the activities authorized by this amendment can be conducted without endangering the health and safety of the public, and (ii) that such activities will be conducted in compliance with the Commission's regulations;
  - D. The issuance of this amendment will not be inimical to the common defense and security or to the health and safety of the public; and
  - E. The issuance of this amendment is in accordance with 10 CFR Part 51 of the Commission's regulations and all applicable requirements have been satisfied.

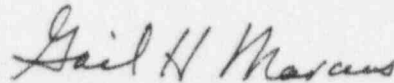
2. Accordingly, the license is amended by changes to the Technical Specifications as indicated in the attachment to this license amendment, and paragraph 3.B of Facility Operating License No. DPR-24 is hereby amended to read as follows:

B. Technical Specifications

The Technical Specifications contained in Appendices A and B, as revised through Amendment No. 166, are hereby incorporated in the license. The licensee shall operate the facility in accordance with the Technical Specifications.

3. This license amendment is effective immediately.

FOR THE NUCLEAR REGULATORY COMMISSION



Gail H. Marcus, Project Director  
Project Directorate III-3  
Division of Reactor Projects III/IV  
Office of Nuclear Reactor Regulation

Attachment:  
Changes to the Technical  
Specifications

Date of issuance: November 22, 1995



UNITED STATES  
NUCLEAR REGULATORY COMMISSION  
WASHINGTON, D.C. 20555-0001

WISCONSIN ELECTRIC POWER COMPANY

DOCKET NO. 50-301

POINT BEACH NUCLEAR PLANT, UNIT NO. 2

AMENDMENT TO FACILITY OPERATING LICENSE

Amendment No. 170  
License No. DPR-27

1. The Nuclear Regulatory Commission (the Commission) has found that:
  - A. The application for amendment by Wisconsin Electric Power Company (the licensee) submitted by letters dated November 9, 1995, as supplemented by letters dated November 13, 1995, and November 16, 1995, complies with the standards and requirements of the Atomic Energy Act of 1954, as amended (the Act), and the Commission's rules and regulations set forth in 10 CFR Chapter I;
  - B. The facility will operate in conformity with the application, the provisions of the Act, and the rules and regulations of the Commission;
  - C. There is reasonable assurance (i) that the activities authorized by this amendment can be conducted without endangering the health and safety of the public, and (ii) that such activities will be conducted in compliance with the Commission's regulations;
  - D. The issuance of this amendment will not be inimical to the common defense and security or to the health and safety of the public; and
  - E. The issuance of this amendment is in accordance with 10 CFR Part 51 of the Commission's regulations and all applicable requirements have been satisfied.

2. Accordingly, the license is amended by changes to the Technical Specifications as indicated in the attachment to this license amendment, and paragraph 3.B of Facility Operating License No. DPR-27 is hereby amended to read as follows:

B. Technical Specifications

The Technical Specifications contained in Appendices A and B, as revised through Amendment No. 170, are hereby incorporated in the license. The licensee shall operate the facility in accordance with the Technical Specifications.

3. This license amendment is effective immediately.

FOR THE NUCLEAR REGULATORY COMMISSION

*Gail H. Marcus*

Gail H. Marcus, Project Director  
Project Directorate III-3  
Division of Reactor Projects III/IV  
Office of Nuclear Reactor Regulation

Attachment:  
Changes to the Technical  
Specifications

Date of issuance: November 22, 1995

ATTACHMENT TO LICENSE AMENDMENT NOS. 166 AND 170  
TO FACILITY OPERATING LICENSE NOS. DPR-24 AND DPR-27  
DOCKET NOS. 50-266 AND 50-301

Revise Appendix A Technical Specifications by removing the pages identified below and inserting the enclosed pages. The revised pages are identified by amendment number and contain marginal lines indicating the area of change.

REMOVE

TS 15.4.2-2  
TS 15.4.2-4  
TS 15.4.2-6

INSERT

TS 15.4.2-2  
TS 15.4.2-4  
TS 15.4.2-6

Category C-1: Less than 5% of the total number of tubes examined are degraded but none are defective.

Category C-2: Between 5% and 10% of the total number of tubes examined are degraded, but none are defective or one tube to not more than 1% of the sample is defective.

Category C-3: More than 10% of the total number of tubes examined are degraded, but none are defective or more than 1% of the sample is defective.

In the first sample of a given steam generator during any inservice inspection, degraded tubes not beyond the plugging limit detected by the prior examinations in that steam generator shall be included in the above percentage calculations, only if these tubes are demonstrated to have a further wall penetration of greater than 10% of the nominal tube wall thickness.

- (c) Tubes shall be selected for examination primarily from those areas of the tube bundle where service experience has shown the most severe tube degradation.
- (d) In addition to the sample size specified in Table 15.4.2-1, the tubes examined in a given steam generator during the first examination of any inservice inspection shall include all non-plugged tubes in that steam generator that from prior examination were degraded.
- (e) In addition to the sample size required in Specifications 15.4.2.A.2(a) through (d), all F\* tubes shall be inspected in the F\* region. The results of F\* tube inspections are not to be used as a basis for additional inspections per Table 15.4.2-1.<sup>1</sup>
- (f) During the second and third sample examinations of any inservice inspection, the tube inspection may be limited to those sections of the tube lengths where imperfections were detected during the prior examination.

### 3. Examination Method and Requirements

The examination method shall meet the intent of the requirements in ASME Section XI Appendix IV. This includes equipment, personnel and procedure requirements, certification and calibration along with records and reports. The actual technique may be the latest industry accepted technique, provided the flaw detection capability is as good or better than the technique endorsed by the code in effect per Technical Specification 15.4.2.B.1. This allows the use of improvements in inspection techniques that were not included in the code in effect. However, it means that word-for-word compliance with Appendix IV of ASME Section XI may not be possible.

<sup>1</sup> This requirement applies only to the Westinghouse Model 44 steam generators in Unit 2. Following steam generator replacement in Unit 2, this requirement is null and void.



Defect is an imperfection of such severity that it exceeds the minimum acceptable tube wall thickness of 50%. A tube containing a defect is defective.

Plugging Limit is the imperfection depth beyond which the tube must be removed from service or repaired, because the tube may become defective prior to the next scheduled inspection. The plugging limit is 40% of the nominal tube wall thickness.

F\* Distance is the distance of the expanded portion of a tube which provides a sufficient length of undegraded tube expansion to resist pullout of the tube from the tubesheet. The F\* distance is 1.12 inches (including eddy current uncertainty). The F\* distance is measured from the bottom of the upper roll transition of the repair roll toward the bottom of the tubesheet.<sup>2</sup>

F\* Tube is a tube with degradation, below the F\* distance, equal to or greater than 40%, and not degraded within the F\* distance.<sup>2</sup>

6. Corrective Measures

All tubes that leak or have degradation exceeding the plugging limit shall be plugged or repaired by a process such as sleeving<sup>1</sup> or classification as an F\* tube<sup>2</sup> prior to return to power from a refueling or inservice inspection condition. Sleeved tubes having sleeve degradation exceeding 40% of the nominal sleeve wall thickness shall be plugged.

7. Reports

- (a) After each inservice examination, the number of tubes plugged or repaired in each steam generator shall be reported to the Commission as soon as practicable.
- (b) The complete results of the steam generator tube inservice inspection shall be included in the Annual Results and Data Report for the period in which the inspection was completed.

Reports shall include:

- 1. Number and extent of tubes inspected.
  - 2. Location and percent of all thickness penetration for each indication.
  - 3. Identification of tubes plugged or repaired.
- (c) Reports required by Table 15.4.2-1 - Steam Generator Tube Inspection shall provide the information required by Specification 15.4.2.A.7(b) and a description of investigations conducted to determine cause of the tube degradation and corrective measures taken to prevent recurrence. The report shall be submitted to the Commission prior to resumption of plant operation.

<sup>1</sup> Brazed joints shall not be employed. Tubes previously subject to explosive plugging shall not be sleeved.

<sup>2</sup> Applicable only to the Westinghouse Model 44 steam generators in Unit 2. Following steam generator replacement in Unit 2, the definitions and F\* repair option are null and void.

10 CFR 50. The same code is utilized for both Unit 1 and Unit 2. Safety-related components are classified as safety Class 1, 2, or 3. The code boundaries are defined based upon the following documents:

- (a) Regulatory Guide 1.26, "Quality Group Classifications and Standards for Water, Steam, and Radioactive Waste Containing Components of Nuclear Power Plants."
- (b) American National Standard N18.2, "Nuclear Safety Criteria for the Design of Stationary Pressurized Water Reactor Plants."
- (c) Point Beach Nuclear Plant Units 1 & 2 Final Safety Analysis Report.

Code classified components are tabulated showing each specific examination area and the examination requirements in an inspection interval long-term plan. This plan is completely revised for each ten-year inspection interval.

A sound roll expansion throughout the F\* distance provides a tube to tubesheet interface that ensures the requirements of Regulatory Guide 1.121 are met regardless of the severity of any tube degradation below the F\* distance. The F\* distance of 1.12 inches is comprised of 0.88 inches of sound roll expansion that ensures tube integrity requirements are met plus 0.24 inches which allows for eddy current measurement uncertainty.