

UNIT 2 REFUELING 17

INSERVICE INSPECTION FINAL REPORT

(Items examined by EBASCO Services are detailed in this report)

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ABBREVIATIONS

PBNP	Point Beach Nuclear Plant
ISI	Inservice Inspection
LTP	Long-Term Plan
NRC IE	Nuclear Regulatory Commission Inspection and Enforcement
NDE	Nondestructive Examination
WE	Wisconsin Electric Power Company
QTS	WE Quality Assurance Section, NDE Group
PWA	Professional Welding Associates
EBASCO	EBASCO Services Incorporated
P-G	Phillips Getchow, Inc.
ASME	American Society of Mechanical Engineers
SI	Safety Injection
RHR	Residual Heat Removal
VT	Visual Testing
PT	Dye Penetrant Testing
MT	Magnetic Particle Testing
UT	Ultrasonic Testing
RT	Radiographic Testing
IR	Indication Report
MWR	Maintenance Work Request

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UNIT 2 REFUELING 17

INSERVICE INSPECTION

1.0 INTRODUCTION

This report summarizes the inservice inspections performed since the previous refueling of Point Beach Nuclear Plant, Unit 2. This constitutes the third inspection of the third period of the second 10-year interval as defined in the Long-Term Inservice Examination Plan of PBNP Unit 2. This completed the second 10-year interval inspections. WE (QTS), EBASCO, P-G and PWA personnel performed nondestructive examinations from January 18, 1991 to November 11, 1991. The PBNP Unit 2 was shut down for Refueling Outage 17 from September 28, 1991 to November 14, 1991.

2.0 EXAMINATION AREAS

2.1 Determination of Scope

The ISI was performed in accordance with the following:

- 2.1.1 PBNP Technical Specification Section 15.4.2.B.
- 2.1.2 Long-Term Inservice Examination Plan (LTP) for Class 1, Class 2 and Class 3 Components and Systems of PBNP Unit 2.
- 2.1.3 ASME Code Case N-356 - Certification Period for Level III NDE personnel, Section XI, Divisions 1, 2 and 3.
- 2.1.4 Request of PBNP Personnel.

2.2 NDE Listings

Representative samples from the following components and systems were examined using NDE techniques. For more details on the inspections or systems, consult the Unit 2 LTP.

- 2.2.1 Reactor Pressure Vessel and Closure Head
Head to Flange
- 2.2.2 Valves (Class 1)
Pressure Retaining Bolting
- 2.2.3 Class 1 Piping and Pipe Supports
 - AC - 06 - SI - 2001
 - CVC - 02 - AS - 2001
 - CVC - 03 - CH - 2001
 - RC - 03 - CH - 2001
 - RC - 03 - PS - 2001
 - RC - 10 - AC - 2001
- 2.2.4 Class 2 Piping and Pipe Supports
 - AC - 08 - SI - 2001
 - AC - 08 - SI - 2002
 - MS - 30 - MS - 2001

- 2.2.5 Non-ASME Section XI Items
- Energy Absorber
 - Reactor Head Lift Rig
 - Reactor Coolant Pump Flywheel

2.3 Pressure Tests

The following pressure tests were conducted. These pressure tests were performed in accordance with the requirements of ASME Section XI, 1977 Edition, Summer 1979 Addenda, Technical Specifications and written PBNP procedures.

- 2.3.1 A system leak test of all safety-related Class 1 components (IT-235 and CL-235)
- 2.3.2 A 10-year hydrostatic test of the Class 3 portion of Auxillary Feedwater System. (IT-1095, Part 2)
- 2.3.3 A hydrostatic test of Class 2 portions of the SI full-flow test line and hrrif full-flow test line (Reference Modification 88-098)

3.0 SUMMARY OF INDICATIONS REPORTED

The nondestructive examinations conducted during this inspection resulted in two Indication Reports. The nondestructive examinations utilized VT, PT, MT, RT and UT techniques. All the examinations were performed in accordance with written procedures that conform to the applicable sections of the ASME Boiler and Pressure Vessel Code. An index of the applicable procedures used by QTS and EBASCO is provided in Appendix 5.1. Procedures used by P-G are in the documentation for Modification 88-098.

The following briefly describes the indication reports. The indication reports, along with evaluations, are included in Appendix 5.7. These were presented to the PBNP Managers Supervisory Staff for acceptance on November 7, 1991 (Ref. MSSM 91-19).

3.1 IR 7-P-007, Class 1 Pipe Support, CVC-02-AS-2001-25 PRC

One of the four mounting bolts was reported to be cut off at the building wall. A preliminary evaluation of the design loads, including seismic, showed the remaining bolts would be adequate. The support was accepted for continued service. Condition Report 91-435 and MWR 914993 were initiated to resolve the cut-off bolt issues.

3.2 IR 7-P-009, Class 2 Pipe Support, MS-30-MS-2001-MS-69/A-2

The magnetic particle examination produced numerous linear indications. The area of these indications was further examined by the dye penetrant and ultrasonic methods to evaluate and characterize the indications. It was determined that these indications were original forging imperfections which were acceptable by the original construction standards. The indications were accepted for continued service without further action.

4.0 SUMMARY TABLES

The summary table lists the examinations that were performed during this inspection. The summary table includes examinations selected from the Unit 2 Long-Term plan and the preservice for Modification 89-098. An explanation of the table headings and the coding used in the summary table follows.

Component	Component name
Exam Area	Identification of examination area
Fig	Figure number in the LTP
Item	ASME Section XI item number
Cat.	ASME Section XI category designation
Method	Examination method (VT, PT, etc.)
Proc	NDE procedure and revision
Ex Gr	Examination group that performed the examination (QAS, EBASCO or P-G)
Cal Block	Identification number of the UT calibration block as shown in the LTP
Ind RIGN	Code letter for examination results R - Recordable for PBNP evaluation I - Insignificant G - Geometric N - No indications recorded
Data Sheet	Data sheet number
Remarks	Remarks related to the examination

5.0 APPENDICES

INSERVICE INSPECTION - OUTAGE U2R17
 SUMMARY REPORT DATED 22 NOV. 1991 - MODIFICATION 88-098

COMPONENT: ACS PIPING

EXAM AREA	FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
AC-08-SI-2001-11A PIPE TO TEE	B-19	C5.11	C-F	UT	WEP-UT-86-1(0) Addenda 1	EBAS	31-P, B	N	14	REF. MOD 88-098. ALSO DATA SHTS 91PB2-UT-015 & -016. REF. MOD 88-098 AND PHILLIPS-GETCH OW TRAVELERS.
AC-08-SI-2001-11A PIPE TO TEE	B-19	C5.11	C-F	PT	QAP 14.1(4)	P-G		N		
AC-08-SI-2001-11B TEE TO ELBOW	B-19	C5.11	C-F	UT	WEP-UT-86-1(0) Addenda 1	EBAS	31-PTB	N	11	REF. MOD 88-098. ALSO DATA SHTS 91PB2-UT-012 & -013. REF. MOD 88-098 AND PHILLIPS-GETCH OW TRAVELERS.
AC-08-SI-2001-11B TEE TO ELBOW	B-19	C5.11	C-F	PT	QAP 14.1(4)	P-G		N		
AC-08-SI-2001-17R PIPE TO CAP	B-19	C5.11	C-F	RT	RT-1-WR (1)	P-G (PWA)		N		REF. MOD 88-098. WELD WAS RADIOGRAPH ED AS PART OF THE MODIFICATI ON. THE PRESERVEVIC VOLUMETRIC EXAMINATION IS MET BY THE RT. CLOSE TO WELD 17. REF. MOD 88-098 AND PHILLIPS-GETCH OW TRAVELERS. LOCATED APPROX. 1/2" FROM WELD 17.
AC-08-SI-2001-17R PIPE TO CAP	B-19	C5.11	C-F	PT	QAP 14.1(4)	P-G		N		
AC-06-SI-2002-01 TEE TO PIPE		C5.11	C-F	UT	WEP-UT-86-1(0) Addenda 1	EBAS	31-PTB	N	23	REF. MOD 88-098. ALSO DATA SHTS 91PB2-UT-024 & -025. REF. MOD 88-098 AND PHILLIPS-GETCH OW TRAVELERS.
AC-08-SI-2002-01 TEE TO PIPE		C5.11	C-F	PT	QAP 14.1(4)	P-G		N		
AC-08-SI-2002-02 PIPE TO ELBOW		C5.11	C-F	UT	WEP-UT-86-1(0) Addenda 1	EBAS	31-PTB	N	20	REF. MOD 88-098. ALSO DATA SHTS 91PB2-UT-021 & -022. REF. MOD 88-098 AND PHILLIPS-GETCH OW TRAVELERS.
AC-08-SI-2002-02 PIPE TO ELBOW		C5.11	C-F	PT	QAP 14.1(4)	P-G		N		
AC-08-SI-2002-03 ELBOW TO REDUCER		C5.11	C-F	UT	WEP-UT-86-1(0) Addenda 1	EBAS	31-PTB	N	17	REF. MOD 88-098. ALSO DATA SHTS 91PB2-UT-018 & -019. REF. MOD 88-098 AND PHILLIPS-GETCH OW TRAVELERS.
AC-08-SI-2002-03 ELBOW TO REDUCER		C5.11	C-F	PT	QAP 14.1(4)	P-G		N		

COMPONENT SYSTEM PRESSURE TESTS

EXAM AREA	FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
MOD-RHR PRESSURE RETAINING PIPING COMPONENTS	C7.21	C-H		VT-2/HT	NDE-750 QTS (10)			N	750015	REF. MOD 88-098 BY P-G DURING U2R17.
MOD-RHR PRESSURE RETAINING VALVE COMPONENTS	C7.41	C-H		VT-2/HT	NDE-750 QTS (10)			N	750015	REF. MOD 88-098 INSTALLED BY P-G DURING U2R17.
MOD-SIS PRESSURE RETAINING PIPING COMPONENTS	C7.21	C-H		VT-2/HT	NDE-750 QTS (10)			N	750014	REF. MOD 88-098 INSTALLED BY P-G DURING U2R17. PRESERVICE TEST.
MOD-SIS PRESSURE RETAINING VALVE COMPONENTS	C7.41	C-H		VT-2/HT	NDE-750 QTS (10)			N	750014	REF. MOD 88-098 INSTALLED BY P-G. PRESERVICE TEST.

ITEMS RETRIEVED 16

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COMPONENT ACS PIPING

E KAM AREA

AC-06-SI-2001-SI-13/7043 INT WELDED ATTACH

FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
A-27	B10.10	B-K-1	PT	NBS 451 (C)OTS			N	451001	

POINT BEACH NUCLEAR PLANT
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COMPONENT CVCS PIPING

2 XAM AREA

CVC-03-CH-2001-12 PIPE TO ELBOW

FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
A-38	B9.21	B-J	PT	NDE 457 (4)OTS			N	45.004	DEFERRED FROM U2R14

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COMPONENT: CVCS SUPPORT COMPONENTS

EXAM AREA	FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOC	IND RIGN	DATA SHEET	REMARKS
CVC-02-AS-2001-25PR-C PIPE RESTRAINT	A-40	F-1,2, C	F-B	VT-3	NBE 750 (10)01S			R	750012	RESCHEDULED FROM OUT3 (U2R11). ANCHOR BOLT IS CUT OFF AT THE WALL. REF. IDR 7-P-007. SEE CONDITION REPORT 91-435 FOR EVALUATION ACCEPTED FOR USE.

POINT BEACH NUCLEAR PLANT
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COMPONENT VALVES - PRESSURE RETAINING BOLTING

EXAM AREA	FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
RC-434	A-33	B7.70	B-G-2	VT-1	NDE 750 (10)	Q15		N	750008	EXAMINED DURING U2R17 SINCE THE VALVE WAS REMOVED AND ALL BOLTING WAS ACCESSIBLE
RC-435	A-33	B7.70	B-G-2	VT-1	NDE 750 (10)	Q15		N	750009	RESCHEDULED FOR U2R17 TO ASSURE ALL BOLTS WERE EXAM'D. VALVE WAS REMOVED AND 8 STUDS WITH NUTS EXAMINED.
RH-701	A-22	B7.70	B-G-2	VT-1	NDE 750 (10)	Q15		N	750010	SURFACE EXAM IN ADDITION TO VT-1 IF VALVE DISASSEMBLED. TAW IEB82-02.13 STUDS EXAM'D REMOVED DUE TO BORIC ACID LEAKAGE. 3 REMAINED IN PLACE.

POINT BEACH NUCLEAR PLANT
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COMPONENT MS PIPING

EXAM AREA	FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
MS-30-MS-2001-MS-69/A-2 IWA	B-30	C3.40	C-C	MT	NDE ISp (L) QTS NDE YSI (L)			R	350002	DEFERRED FROM U2R16. S LINEAR INDICATIONS 1 1/4" TO 7/8". SEE IGR 7-P-008 FOR EVALUATION AS ACCEPTABLE REF. DATA SHTS 451-P-002 & 91P82-INFO-1
MS-30-MS-2001-16 PIPE T PENETRATION	B-30	C5.21	C-F	MT	NDE ISp (L) QTS			N	350001	ADDITIONAL EXAM TO CORRESPOND WITH THE SUPPORT MS-69/A-2 ADDITIONAL EXAM ALSO
MS-30-MS-2001-16 PIPE TO PENETRATION	B-30	C5.21	C-F	UT	P8-W-1 (4) EBAS	45-PTB		N	7	ATA SHTS 91P82-UT-008, -009, & -010.

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COMPONENT: MS SUPPORT COMPONENTS

EXAM AREA

MS-30-MS-2001-MS-69/A-2 PIPE RESTRAINT

FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
B-30	F-1.2.3	F-B	VT-3	NDE T50 (w)TS			N	750011	SCAFFOLDING REQUIRED DEFERRED FROM U2R16

POINT BEACH NUCLEAR PLANT
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COMPONENT: RCP A

EXAM AREA

FLYWHEEL (REMOVED)

FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
A-9	B12.10	B-L-1	VT-2	NDE 750 QTS (co)		11-PTB .12-PT B	N	150001	EXAM IN ACCORDANCE WITH REG. GUIDE 1.14 FLYWHEEL TO BE REMOVED FOR EXAM. DEFERRED FROM U2R16 DUE TO PROCEDURE DISCREPANCY.
							N	750016	REQUIRED DURING EACH RCS SYSTEM OR HYDRO TEST.

PUMP CASING EXTERIOR

INTERVICE INSPECTION - OUTAGE U2R17
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COMPONENT: RCP B

EXAM AREA	FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
PUMP CASING EXTERIOR	A-B	B12.10	B-L-1	VT-2	NDE-750 QTS (10)			N	750016	REQUIRED DURING EACH RCS SYSTEM OR HYDRO TEST.

POINT BEACH NUCLEAR PLANT
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COMPONENT RCS PIPING

EXPM AREA

RC-03-CH-2001-24 ELBOW TO ELBOW	FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
	A-38	B9.21	B-J	PT	NDE 451 (4)	QTS		N	451005	ADDITIONAL EXAM SINCE IT WAS ACCESSIBLE DURING U2R17.
RC-03-PS-2001-01 BRANCH CONNECTION TO ELBOW	A-34	B9.21	B-J	PT	NDE 451 (4)	QTS		N	451006	DEFERRED FROM U2R15. REQUIRED COLD LEG INSULATION REMOVAL FOR ACCESS. INSULATION ABOVE WELD AREA IS ASBESTOS.
RC-10-AC-2001-08 ELBOW TO PIPE	A-21	B9.11	B-J	PT	NDE 451 (4)	QTS		N	451003	DEFERRED FROM U2R16. INSULATION IS REMOVABLE.
RC-10-AC-2001-08 ELBOW TO PIPE	A-21	B5.11	B-J	UT	PS-MT-1 (4)	EBAS	15-PT8	G	4	DEFERRED FROM U2R16. ALSO DATA SMTS 91PB2-UT-005, -006, & -028.

COMPONENT: REGENERATIVE HEAT EXCHANGER

E-AM AREA

FIG	ITEM	CAT	METHOD	PROC	FR GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
A-7	B3.160 B-D	B-D	VT-2	NDE-750 QTS (10)			N	750017	RR-2-11 VT-2 EACH SYST OR HYDRO TEST IN LIEU OF UT AND VT-1 EACH HYDRO TEST INSULATION REMOVAL REQUIRED FOR VT-1.
A-7	B3.160 B-D	B-D	VT-2	NDE-750 QTS (10)			N	750017	RR-2-11 VT-2 EACH SYST OR HYDRO TEST IN LIEU OF UT AND VT-1 EACH HYDRO TEST INSULATION REMOVAL REQUIRED FOR VT-1.
A-7	B3.160 B-D	B-D	VT-2	NDE-750 QTS (10)			N	750017	RR-2-11 VT-2 EACH SYST OR HYDRO TEST IN LIEU OF UT & VT-1 EACH HYDRO TEST INSULATION REMOVAL REQUIRED FOR VT-1.
A-7	B3.160 B-D	B-D	VT-2	NDE-750 QTS (10)			N	750017	RR-2-11 VT-2 EACH SYST OR HYDRO TEST IN LIEU OF UT & VT-1 EACH HYDRO TEST INSULATION REMOVAL REQUIRED FOR VT-1.
A-7	B3.160 B-D	B-D	VT-2	NDE-750 QTS (10)			N	750017	RR-2-11 VT-2 EACH SYST OR HYDRO TEST IN LIEU OF UT AND VT-1 EACH HYDRO TEST INSULATION REMOVAL REQUIRED FOR VT-1.

POINT BEACH NUCLEAR PLANT
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COMPONENT: RPV AND CLOSURE HEAD

EXAM AREA	FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
HEAD TO FLANGE	A-2	B1.40	B-A	MT	Nbc 350 (4)	QTS		N	350003	EXAMINE 33 1/3 % OF THE WELD LENGTH EACH DESIGNATE D OUTAGE. EXAM'D FROM CENTER OF STUD HOLE #33 TO CENTER OF #48 DURING U2R17.
HEAD TO FLANGE	A-2	B1.40	B-A	UT	PB-M-11 (0)	EBAS	12-PTB	N	1	EXAM 33 1/3 % OF WELD LENGTH @ DESIGNATED OUTAGE. EXAM FROM STUD #33 - #48. ALSO DATA SHTS 91PB2-UT-002 & -003.

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COMPONENT: SYSTEM PRESSURE TESTS

EXAM AREA

AFW PRESSURE RETAINING COMPONENTS	FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOC	IND SIGN	DATA SHEET	REMARKS
	D2.10	D-B		VT-2/HT	NDE-750 QTS (10)			I	750001	PART 2 OF IT-1095 REQUIRED STEAM TO COMPLETED ON 1/18/91. REF. IDR 7-P-001.
PRESSURE RETAINING PIPING COMPONENTS	B15.50	B-P		VT-2/LT	NDE-750 QTS (10)			N	750016	TO BE PERFORME D BY WEPCCO DURING SYSTEM LEAKAGE TEST.
PRESSURE RETAINING PRZ COMPONENTS	B15.20	B-P		VT-2/LT	NDE-750 QTS (10)			N	750016	TO BE PERFORME D BY WEPCCO DURING SYSTEM LEAKAGE TEST.
PRESSURE RETAINING PUMP COMPONENTS	B15.60	B-P		VT-2/LT	NDE-750 QTS (10)			N	750016	TO BE PERFORME D BY WEPCCO DURING SYSTEM LEAKAGE TEST.
PRESSURE RETAINING RHE COMPONENTS	B15.40	B-P		VT-2/LT	NDE-750 QTS (10)			N	750016	TO BE PERFORME D BY WEPCCO DURING SYSTEM LEAKAGE TEST.
PRESSURE RETAINING RPV COMPONENTS	B15.10	B-P		VT-2/LT	NDE-750 QTS (10)			N	750016	TO BE PERFORME D BY WEPCCO DURING SYSTEM LEAKAGE TEST.
PRESSURE RETAINING SG COMPONENTS	B15.30	B-P		VT-2/LT	NDE-750 QTS (10)			N	750016	TO BE PERFORME D DURING PRIMARY SYSTEM LEAK TEST.
PRESSURE RETAINING VALVE COMPONENTS	B15.70	B-P		VT-2/LT	NDE-750 QTS (10)			R	750016	TO BE PERFORME D BY WEPCCO DURING SYSTEM LEAKAGE TEST. ACCUMULATION OF BORIC ACID AT PACKINGS AND BODY/BONNET JOINTS

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COMPONENT : 2 NON ASME

EXAM AREA

EXAM AREA	FIG	ITEM	CAT	METHOD	PROC	EX GR	CAL BLOCK	IND RIGN	DATA SHEET	REMARKS
HEAD LIFT RIG/SIDE LUG-SLING ASSY LINK WELD#3 A-52				MT	NDE 350 (6)	QTS		N	350004	NOT AN ASME SECTION XI EXAM.
PRIMARY SYSTEM PRE-LEAK TEST	N/A	N/A	N/A	VT-2	NDE-750 (10)	QTS		R	750005	EXAM-D PER CL-225. VARIOUS BORIC ACID RESIDUES IDENTIFIED FOR ACTION DURING THE U2R17 OUTAGE.
2-EA-EB-2-1 ENERGY ABSORBER	B-37	N/A	N/A	VT-3	NDE 750 (10)	QTS		N	750013	NOT AN ASME SECTION XI EXAM. INSTALL D DURING U2R13. ANGLE IRON NOTED AGAINST ENERGY ABSORBER THREADS.

ITEMS RETRIEVED 36