



UNITED STATES
NUCLEAR REGULATORY COMMISSION

WASHINGTON, D.C. 20555-0001

January 25, 1996

Mr. D. L. Farrar
Manager, Nuclear Regulatory Services
Commonwealth Edison Company
Executive Towers West III
1400 OPUS Place, Suite 500
Downers Grove, IL 60515

SUBJECT: CORE SHROUD INSPECTION PLAN - QUAD CITIES, UNIT 1 (TAC NO. M94197)

Dear Mr. Farrar:

By letter dated November 22, 1995, Commonwealth Edison Company (ComEd) submitted a core shroud inspection plan for NRC review. The subject inspection plan will be implemented during the fourteenth refueling outage at Quad Cities, Unit 1, currently scheduled to begin in February 1996. ComEd's proposed inspection plan is summarized below:

1. For horizontal welds H8 (jet pump support plate to the shroud) and H9 (jet pump support plate to the reactor pressure vessel), a visual examination of about 12 inches at each of the four repair attachment sites will be performed.
2. For all 12 core shroud vertical welds, a visual examination of about 12 inches or ultrasonic examination of about 9 to 16 inches at each weld will be performed.
3. For all segment welds of the shroud head flange ring (four welds), the top guide support ring (six welds) and the core plate support ring (six welds), a visual examination of all accessible areas will be performed.
4. A visual examination of the attachment sites for the core shroud repair assemblies will be performed.

ComEd stated that either enhanced visual examination (VT-1), or ultrasonic examination (UT) or both will be used in the examination. When VT-1 is used alone, both sides of the core shroud will be inspected when accessibility permits. In the UT examination, three transducers (45 degrees shear wave, 60 degrees RL wave and creeping wave for near surface) will be used. In addition, eddy current techniques will be used to identify the ring segment welds, because these welds were machined after fabrication and are difficult to be visually identified. ComEd stated that, in performing these examinations, the guidelines recommended by the BWR Vessel Internals Project (BWRVIP) will be followed.

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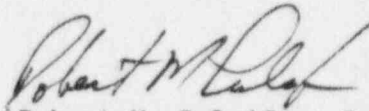
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During the upcoming outage, ComEd plans to repair the Unit 1 core shroud. The staff had previously reviewed and approved the core shroud repair for Units 1 and 2 in safety evaluations dated June 8, 1995, September 11, 1995, and January 23, 1996. Therefore, the inspection plan does not include the core shroud horizontal welds, H1 through H7, because the safety functions of these welds are designed to be replaced by the repair assemblies. ComEd also stated that the inspection plan was designed to verify the integrity of all design reliant structures to the degree needed to satisfy the repair design.

The staff has reviewed ComEd's proposed inspection plan and concludes that the inspection plan is acceptable to support the planned core shroud repair at Quad Cities, Unit 1.

Sincerely,



Robert M. Pulsifer, Project Manager
Project Directorate III-2
Division of Reactor Projects - III/IV
Office of Nuclear Reactor Regulation

Docket No. 50-254

cc: See next page

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Original signed by:

Robert M. Pulsifer, Project Manager
Project Directorate III-2
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