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JAMES D. SHIFFER  
VICE PRESIDENT  
NUCLEAR POWER GENERATION

REGION V

February 22, 1985

PGandE Letter No.: DCL-85-074

Mr. John B. Martin, Regional Administrator  
U. S. Nuclear Regulatory Commission, Region V  
1450 Maria Lane, Suite 210  
Walnut Creek, CA 94596-5368

Re: Docket No. 50-323  
Diablo Canyon Unit 2  
Final 50.55(e) Report - Rupture Restraints

Dear Mr. Martin:

PGandE letter dated May 3, 1979 informed your office that cracks were discovered during visual inspections of full penetration welds on Unit 1 pipe rupture restraints. The welds were made by Pullman Power Products Company. A program was initiated to identify the type, cause, and extent of the situation. This program was outlined in a PGandE letter dated May 3, 1979 and applied to Unit 1.

A final report for Unit 1 welds was submitted to the NRC on December 9, 1980. That report established the cause of the cracking as inadequate or improper control of welding parameters. The Unit 1 program included inspection of all accessible full penetration welds greater than 1-1/2 inches on rupture restraints. In the pipeway area where the original cracking was discovered, all accessible full penetration welds were inspected. Reportable indications were identified. Unacceptable welds were repaired or modified. Defective welds were discovered on only six specific joint configurations. To prevent recurrence, improved welding procedures and inspection methods were developed.

Based on results of the Unit 1 program, an inspection and repair program was initiated for Unit 2. The Unit 2 program is now complete. All full penetration welds having one of the six joint configurations identified in the Unit 1 test program as having potentially defective welds were reinspected or evaluated. Welds were either accepted or repaired using inspection criteria based on the requirements of AWS D1.0-69. All repaired welds were inspected and accepted in accordance with current QC procedures.

Welds that were partially or completely inaccessible for inspection were evaluated by Project Engineering. These welds were accepted based on current design requirements and existing documentation from the original inspections.

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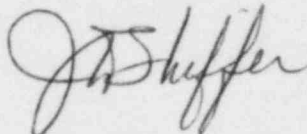
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PGandE believes the actions taken have corrected all deficiencies that were reportable under 10 CFR Part 50.55(e).

Kindly acknowledge receipt of this material on the enclosed copy of this letter and return it in the enclosed addressed envelope.

Sincerely,

A handwritten signature in cursive script, appearing to read "J. B. Martin".

cc: R. T. Dodds  
G. W. Knighton  
H. E. Schierling  
Service List