

10/22/84

13

Distribute for action as follows:

DOCKETED
USNRC

- 1) Design Review (G. Rogers) - Review as part of Design Review Task. Return to Quality Group a statement of acceptability (i.e., inspection information is sufficient for Design Review Group and no further inspections are required) or provide further detailed inspection/criteria, and add to Task Description "review information provided on TDR-Q-329", for each component affected.
- 2) SHO (J. Kammerer) - distribute for information.
- 3) LSU/QA - review for applicability and issue LDR as needed.
- 4) M. Schuster - obtain LDR number as issued for component file and closure.

NUCLEAR REGULATORY COMMISSION

Docket No. 50-322 Official Exh. No. D-74

In the matter of LILCO

Staff	IDENTIFIED	✓
Applicant	RECEIVED	✓
Intervener	REJECTED	
Cont'g Off'r	DATE	<u>10-22-84</u>
Contractor	Witness	✓
Other		
Recorder	<u>WKB</u>	

8412130277 841022
PDR ADOCK 05000322
G PDR



LIQUID PENETRANT EXAMINATION REPORT

Page 2 of 2

MATERIAL		TYPE <i>N/A</i>	FABRICATED PROCESS	☐ WELDED ☒ CAST ☐ WORKED	COMPONENT I.D. 03 3151	
GEOMETRY		☐ PIPE ☐ PLATE ☐ ROD ☒ OTHER:				CYLINDER NICK LINE LANDING
CROSS SECTION THICKNESS	MAX MIN <i>N/A</i>	PIPE DIA. <i>N/A</i>	SURFACE CONDITION	☒ MACHINED ☐ GROUND ☐ AS FABRICATED ☐ OTHER	SYSTEM	
B. NDE PROCEDURE No. <i>6.2 REV 1</i>		SURFACE/MAT'L. TEMP. <i>84°</i>		MATE. NO. <i>7-11-70</i>		MWR/RH. No.
INSPECTION MATERIALS		BRAND	DESIGNATION	BATCH NO.	PLANT/LOCATION	
1. PRE-CLEANER		<i>MAGNAFLUX</i>	<i>SKC-NF/70-73</i>	<i>841025</i>		
2. PENETRANT		<i>SPOTCHECK</i>	<i>SKC-NF/54-5</i>	<i>815180</i>		
3. EMULSIFIER AND/OR REMOVER		<i>MAGNAFLUX</i>	<i>SKC-NF/70-72</i>	<i>841025</i>		
4. DEVELOPER		<i>MAGNAFLUX</i>	<i>SKC-NF/75-72</i>	<i>834041</i>		
5. POST EXAMINATION CLEANER		<i>MAGNAFLUX</i>	<i>SKC-NF/70-73</i>	<i>841025</i>		
SKETCH OR OTHER DETAIL: USE OTHER SIDE IF NECESSARY <i>CYLINDER #1 LINE LANDING</i> <i>SEE SKETCH ON PAGE 1 OF 2</i>						
C. EVALUATION		REPORT BELOW THOSE INDICATIONS OBSERVED AND THE PERTINENT INFORMATION REQUIRED. WHERE ADDITIONAL SPACE IS REQUIRED USE OTHER SIDE.				PLANT/LOCATION
LOCATION	SIZE (INCHES)	DESCRIPTION	ACTION (ACCEPT/REJECT, AND COMMENT AS NECESSARY)			
1 SEE SKETCH	.15"	LINEAR	REJECT, 19 1/2" LONG, 15" DIAM, SHARP END, AT 2114			
2 SEE SKETCH	.25"	LINEAR	REJECT, 10 1/4" LONG, 21" DIAM, SHARP END, AT 2114			
3 SEE SKETCH	6"	LINEAR	REJECT, 18 1/2" LONG, 24" DIAM, SHARP END, AT 2114			
4 SEE SKETCH	8.75"	INTERMITTENT LINEAR	REJECT, 4' LONG, 11 1/4" DIAM, SHARP END, AT 2114			
D. ACCEPTANCE CRITERIA		12		OPERATOR <i>[Signature]</i> Level <i>[Signature]</i> Date <i>3/21/54</i>	PLANT/LOCATION	
E. ATTEST		<i>[Signature]</i>		<i>3/21/54</i>		

JOB NUMBER
11500.37

DATE
7/21/71

LOCATION(S)

REFERENCE
DOCUMENT(S)

DG- 101

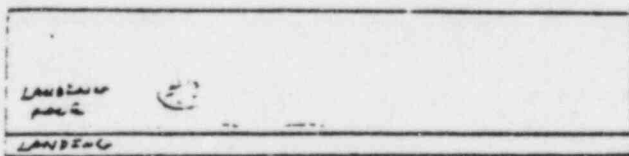
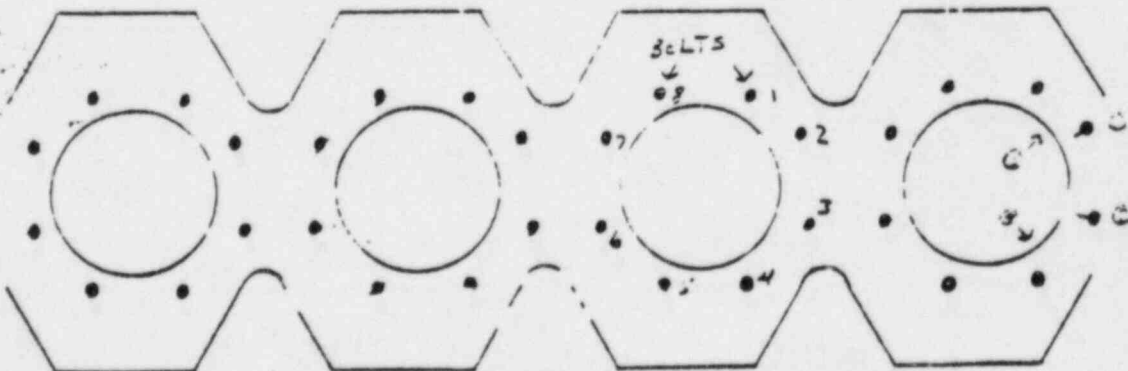
I.P. NO. 10 REV. 5 CHG C

TER 0 DR-52
0-95

LILCO LP PROC. C.2 REV. 1

DWG. NO. 2/12

COMPONENT NO. C3-315A

ITEM	QTY	DESCRIPTION(S) AND INSPECTION REMARK(S)
2	1	PERFORMED LP FLAMING ON CYL #1 UNDER BURNING. UNSAT. LANDING FACE  LANDING CYLINDER = 4 = 3 = 2 = 1  LANDING FACE INTERMEDIATE INCH 4 1/2 INCH 12 INCH LANDING M&TE NO. _____

REVIEWED: H. J. Stiller

QUALITY CONTROL INSPECTION
Stiller

DATE
7/21/71

PAGE
1

(3)

LIQUID PENETRANT EXAMINATION REPORT

PAGE 2 of 2

MATERIAL <i>CARBON STEEL</i>		TYPE <i>N/A</i>	FABRICATED PROCESS ☐ WELDED ☒ CAST ☐ WORKED
CROSS SECTION THICKNESS	MAX <i>N/A</i> MIN	GEOMETRY ☐ PIPE ☐ PLATE ☐ ROD ☒ OTHER:	
	PIPE DIA. <i>N/A</i>	SURFACE CONDITION ☒ MACHINED ☐ GROUND ☐ AS FABRICATED ☐ OTHER	

B. INSPECTION PROCEDURE No. <i>6.2 Rev 1</i>	SURFACE/MAT'L. TEMP. <i>84°</i>	M&TE. NO. <i>7-11-705</i>	MWR/RR. No.
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INSPECTION MATERIALS	BRAND	DESIGNATION	BATCH NO.
1. PRE-CLEANER	<i>ALCOA 100</i>	<i>SKC-NF/ZC-7P</i>	<i>84A025</i>
2. PENETRANT	<i>527 ALCOA</i>	<i>SKC-NF/SKL-5</i>	<i>81E150</i>
3. EMULSIFIER AND/OR REMOVER	<i>ALCOA 100</i>	<i>SKC-NF/ZC-7B</i>	<i>84A025</i>
4. DEVELOPER	<i>ALCOA 100</i>	<i>SKD-NF/ZD-9B</i>	<i>83H041</i>
5. POST EXAMINATION CLEANER	<i>ALCOA 100</i>	<i>SKC-NF/ZC-7P</i>	<i>84A025</i>

SKETCH OR OTHER DETAIL: USE OTHER SIDE IF NECESSARY

CYLINDER #2 LINEAR INDICATION

SEE SKETCH ON PAGE 1 OF 2

C. EVALUATION

REPORT BELOW THOSE INDICATIONS OBSERVED AND THE PEI LEVEL INFORMATION REQUIRED. WHERE ADDITIONAL SPACE IS REQUIRED USE OTHER SIDE.

LOCATION	SIZE (INCHES)	DESCRIPTION	ACTION (ACCEPT/REJECT, AND COMMENT AS NECESSARY)
<i>2 SEE SKETCH</i>	<i>1.25"</i>	<i>LINEAR</i>	<i>.65" DOWN LANDING FACE REJECT, 1.25" LINEAR FROM 2.5" HOLE, LANDING</i>
<i>2 SEE SKETCH</i>	<i>9/16" .65"</i>	<i>LINEAR</i>	<i>.5" DOWN LANDING FACE REJECT, .15" LINEAR ON FACE OF LANDING</i>
<i>3 SEE SKETCH</i>	<i>1/16"</i>	<i>LINEAR</i>	<i>REJECT 1.25" LINEAR ON LANDING FACE</i>
<i>4 SEE SKETCH</i>	<i>1.1"</i>	<i>LINEAR</i>	<i>REJECT 1.1" LINEAR ON LANDING FACE</i>

ACCEPTANCE CRITERIA

4.2

OPERATOR

Level *I*

Date *3/21/84*

E. ATTEST

[Signature]

II

3/21/84

COMPONENT I.D. *03-315A*

SYSTEM

12-1/2

PLANT/LOCATION
DC-101

(4)

11500.37

3/21/04

LOCATION(S)

REFERENCE DOCUMENT(S)

DG- 101

I.P. NO. 10 REV. 5 CHG 0

TER 0 DR-52 Q-95

LILCO LP PROC. 6.2 REV. 1

DWG. NO. N/A

COMPONENT NO. 03-315 A

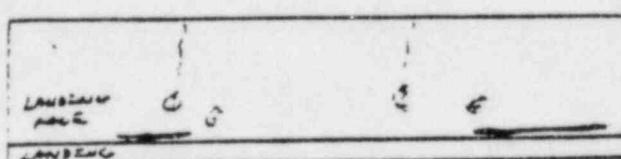
ITEM QTY.

DESCRIPTION(S) AND INSPECTION REMARK(S)

2

1

PERFORMED LP FIRM ON CYL #2 LEAK LANDING UNSAT.

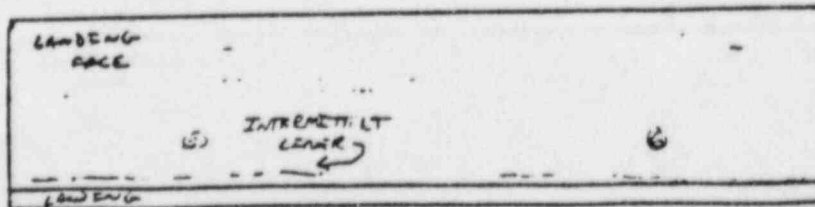
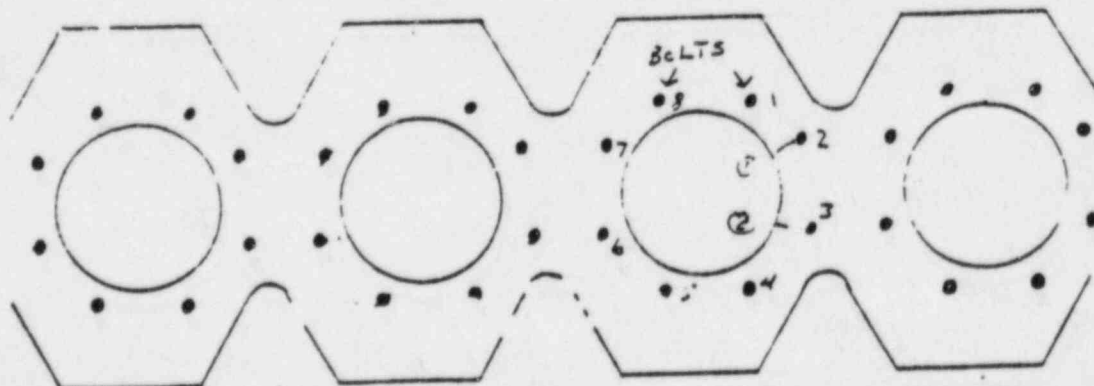


CYLINDER #4

#3

#2

#1



M&TE NO.

QUALITY CONTROL NSPBC. ENG

DATE

PAGE

REVIEWED N.S. 3/21/04

3-21-04

1 of 2

LIQUID PENETRANT EXAMINATION REPORT

Page 2 of 2

TYPE <u>N/A</u>		FABRICATED PROCESS	☐ WELDED ☒ CAST ☐ WORKED
GEOMETRY ☐ PIPE ☐ PLATE ☐ ROD ☒ OTHER:			
PIPE DIA. <u>N/A</u>	SURFACE CONDITION	☒ MACHINED ☐ GROUND	
		☐ AS FABRICATED ☐ OTHER	
PROCEDURE <u>6.2 REV 1</u>	SURFACE/MAT'L. TEMP. <u>500</u>	M&T. NO. <u>7-11-705</u>	MWR/RR. No.
INSPECTION MATERIALS	BRAND	DESIGNATION	BATCH NO.
1. PRE-CLEANER	<u>ALCOHOL</u>	<u>SKC NF/20-7B</u>	<u>84AC25</u>
2. PENETRANT	<u>ALCOHOL</u>	<u>SKC NF/50-5</u>	<u>84AC25</u>
3. EMULSIFIER AND/OR REMOVER	<u>ALCOHOL</u>	<u>SKC NF/20-7B</u>	<u>84AC25</u>
4. DEVELOPER	<u>ALCOHOL</u>	<u>SKC NF/20-9B</u>	<u>84AC25</u>
5. POST EXAMINATION CLEANER	<u>ALCOHOL</u>	<u>SKC NF/20-7B</u>	<u>84AC25</u>

SKETCH OR OTHER DETAIL: USE OTHER SIDE IF NECESSARY

SEE SKETCH ON OTHER SIDE

SEE SKETCH ON OTHER SIDE

C. EVALUATION

REPORT BELOW THOSE INDICATIONS OBSERVED AND THE PERTINENT INFORMATION REQUIRED. WHERE ADDITIONAL SPACE IS REQUIRED USE OTHER SIDE.

LOCATION	SIZE (INCHES)	DESCRIPTION	ACTION (ACCEPT/REJECT, AND COMMENT AS NECESSARY)
1 SEE SKETCH	19"	LEAKAGE	REJECT 24" diam. 11.5" thick. 100% NDT. 100% NDT.
2 SEE SKETCH	36"	INDENTATION LEAKAGE	REJECT 24" diam. 11.5" thick. 100% NDT. 100% NDT.
3			
4			
ACCEPTANCE CRITERIA	4.2	OPERATOR <u>John H. H. H.</u>	Level <u>1</u> Date <u>2/2/72</u>

E. ATTEST

RECEIVED BY: John H. H. H.

DATE

DATE

PLANT/LOCATION

20-12-1

6

ELEMENT NO. <u>03-315A</u>	LOCATION(S) DG- <u>10.1</u>	REFERENCE DOCUMENT(S) I.P. NO. <u>10</u> REV. <u>5</u> CHG <u>0</u> <u>DR-52</u> TER # <u>Q-95</u> LILCO LP PROC. <u>6.2</u> REV. <u>1</u> DWG. NO. <u>N/A</u>
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ITEM	DESCRIPTION AND INSPECTION REMARKS
2	PERFORMED EXTENSIVE CYLINDER LEAK TESTING. UNSAT. CYLINDER = 4 M&TE NO. _____

REVIEWED 4.5.5.7.6

QUALITY CONTROL INSPEC/ENG

DATE

PAGE

1/1/84

1 of 2

8

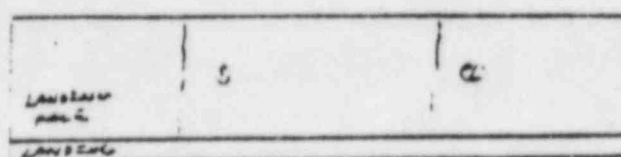
LOCATION(S)

REFERENCE
DOCUMENT(S)DG- 111I.P. NO. 10 REV. 5 CHG 0TER 0 95
DR-52LILCO LP PROC. 6.2 REV. 1DWG. NO. 111ITEM NO. 03-315A

ITEM QTY

DESCRIPTION(S) AND INSPECTION REMARK(S)

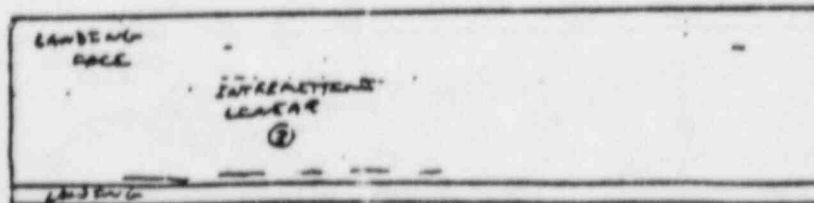
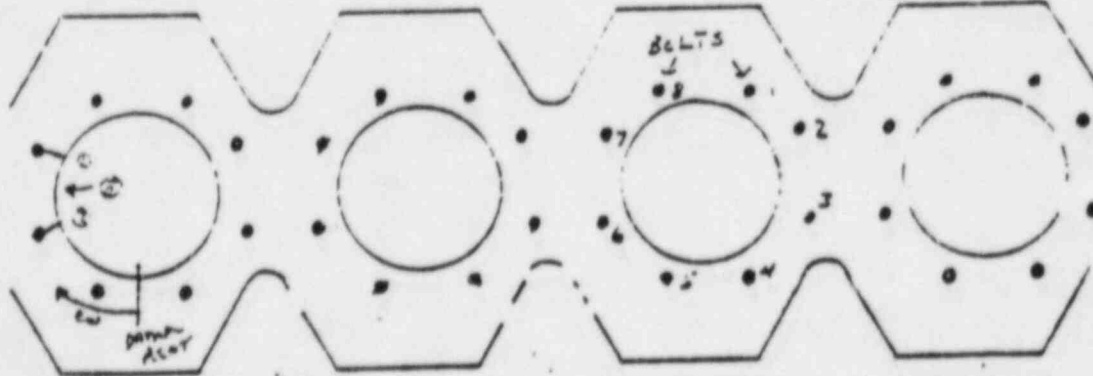
2 1 REFERRED TO DRAWING IN CYLINDER FOR LENS CHANGES TO SET

CYLINDER
= 4

= 3

= 2

= 1



MATE NO.

QUALITY CONTROL - NSPEC. ENG

DATE

PAGE

REVIEWED: H.S. BAKERFORNIA1/11/5411

A. MATERIAL		TYPE <u>W/A</u>	FABRICATED PROCESS		☐ WELDED ☒ CAST ☐ WORKED	PT CHINA'S RIVER LINE'S BRIDGE	COMPONENT I.D. 03-31511
		GEOMETRY ☐ PIPE ☐ PLATE ☐ ROD ☒ OTHER:					
CROSS SECTION THICKNESS	MAX <u>W/A</u> MIN	PIPE DIA. <u>W/A</u>	SURFACE CONDITION	☒ MACHINED ☐ GROUND ☐ AS FABRICATED ☐ OTHER			
B. NDE PROCEDURE No. <u>1001</u>		SURFACE/MAT'L. TEMP. <u>70</u>		M&T. NO. <u>7112</u>	MWR/RR. No.		
INSPECTION MATERIALS		BRAND	DESIGNATION	BATCH NO.			
1. PRE-CLEANER							
2. PENETRANT							
3. EMULSIFIER AND/OR REMOVER							
4. DEVELOPER							
5. POST EXAMINATION CLEANER							
SKETCH OR OTHER DETAIL: USE OTHER SIDE IF NECESSARY							
C. EVALUATION		REPORT BELOW THOSE INDICATIONS OBSERVED AND THE PERTINENT INFORMATION REQUIRED. WHERE ADDITIONAL SPACE IS REQUIRED USE OTHER SIDE.					
LOCATION	SIZE (INCHES)	DESCRIPTION	ACTION (ACCEPT, REJECT AND COMMENT AS NECESSARY)				
1 SEE SKETCH	1.2"	LEAKAGE	REJECT, 12" dia. hole in side of bridge				
2 SEE SKETCH	1.6"	LEAKAGE	REJECT, 1.6" dia. hole in side of bridge				
3 SEE SKETCH	.25"	LEAKAGE	REJECT, 12" dia. hole in side of bridge				
4							
D. ACCEPTANCE CRITERIA		4.2		OPERATOR <u>John Doe</u> Level <u>1</u> Date <u>10/1/94</u>			
E. ATTEST		<u>John Doe</u> DEPARTMENT OF CERTIFIED DISCOVERY					

SYSTEM

PLANT/LOCATION

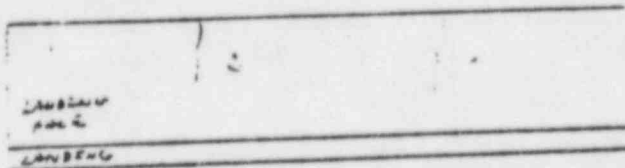
LOCATION(S)

REFERENCE
DOCUMENT(S)I.P. NO. 10 REV. 5 CHG. CTER 0 DR-52
Q-45LILCO LP PROC. 62 REV. 1DWG. NO. N/ADG- 101

NAME:

DATE: 8/1/64COMPONENT NO. 13-3-5A

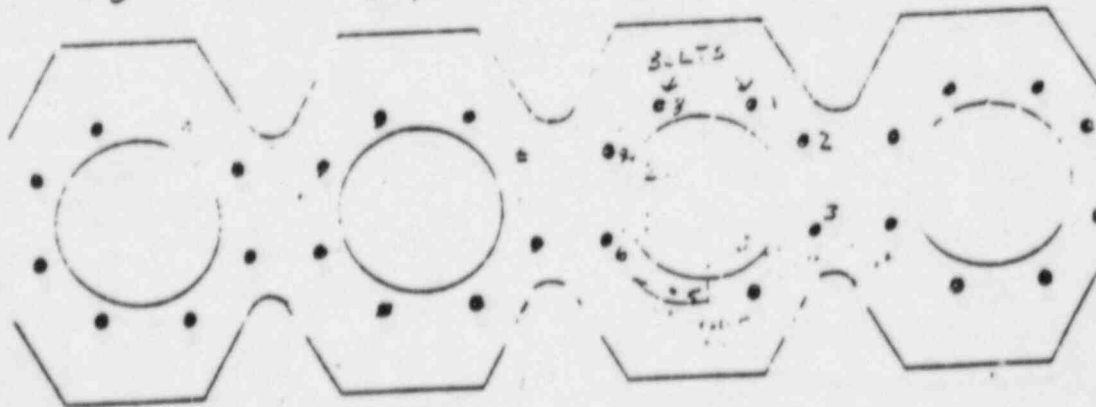
DESCRIPTION AND INSPECTION REMARKS

CYLINDER
#8

#7

#6

#5



M&TE NO. _____

QUALITY CONTROL INSPECTOR

DATE 3/2/64

PAGE

1 of 2

REVIEWED: J. S. Smith
3/2/64