



**Florida  
Power**  
CORPORATION

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July 2, 1985  
3F0785-05

Dr. J. Nelson Grace  
Regional Administrator, Region II  
Office of Inspection and Enforcement  
U.S. Nuclear Regulatory Commission  
101 Marietta Street N.W., Suite 2900  
Atlanta, GA 30323

Subject: Crystal River Unit 3  
Docket No. 50-302  
Operating License No. DPR-72  
IE Inspection Report No. 85-23

Dear Sir:

Florida Power Corporation provides the attached as our response to the subject inspection report.

Sincerely,

W. S. Wilgus  
Vice President  
Nuclear Operations

DDG/feb

Attachment

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PDR ADDCK 05000302  
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FLORIDA POWER CORPORATION  
RESPONSE  
INSPECTION REPORT 85-23

VIOLATION 85-23-04

10 CFR 50, Appendix B, Criterion V, and Final Safety Analysis Report (FSAR) Section 1.7.1.5 require that activities affecting quality shall be prescribed by documented instructions, procedures, or drawings... and shall be accomplished in accordance with these instructions, procedures, or drawings. Welding Procedure Specification (WPS) No. 8/8-TT-022 has been identified as the appropriate WPS for the welding of makeup system welds MU-85-128 and MU-85-129. WPS No. 8/8-TT-022 requires torch shielding gas flow rate of 15 to 25 cubic feet per hour (CFH).

Contrary to the above, activities affecting quality were not accomplished in accordance with documented procedures in that the torch shielding gas flow was 12 CFH for weld MU-85-128 and less than 10 CFH for weld MU-85-129.

This is a Severity Level IV violation (Supplement II).

RESPONSE

(1) FLORIDA POWER CORPORATION'S POSITION

Florida Power Corporation concurs with the stated violation in that the welder was not performing weld activities in accordance with approved procedures.

Subsequent radiographs of the welds have proven the quality of work to be acceptable. It should be noted that shielding gas flow rate is not an essential variable in the welding process specified.

(2) APPARENT CAUSE OF VIOLATION

The welder performing the welds was found to be using his experience and judgement to set the required shielding gas flow rate instead of the flow meter provided with the welding equipment.

(3) CORRECTIVE ACTION

The individual involved was counseled concerning compliance with procedures and was also given a written warning.

(4) CORRECTIVE ACTION TO PREVENT RECURRENCE

FPC considers the corrective action, as stated above, adequate to prevent recurrence.

(5) DATE OF FULL COMPLIANCE

Florida Power Corporation was in full compliance as of May 17, 1985.