

Northern States Power Company Operations & Maintenance Supt Materials & Special Processes	Prairie Island Unit 2 45' ULTRASONIC EXAMINATION REPORT (3rd 10yr)	Report# 97-0136 Source Doc=B 2. 40 S/N 2618
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System Steam Generator 22	ISO 2-ISI- 37B	Item W-A	Item Description Tube Sheet to Head
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Material SA216 WCC / SA508 CL2	Size/Length 135"	Thick/Dia 5.160	Temp 75'F	Surface Condition BLENDED
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Procedure ISI-UT-3 Rev 7 Field Change N/A	W R Number 9612227	ISI Contractor LMT	Exam Date 01/30/97
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Calibration Report Nbr TWT-002	Beam Angle 45' (Nominal)	Temp Gauge S/N NSP-049	Exam Start @ * hours Exam End @ * hours
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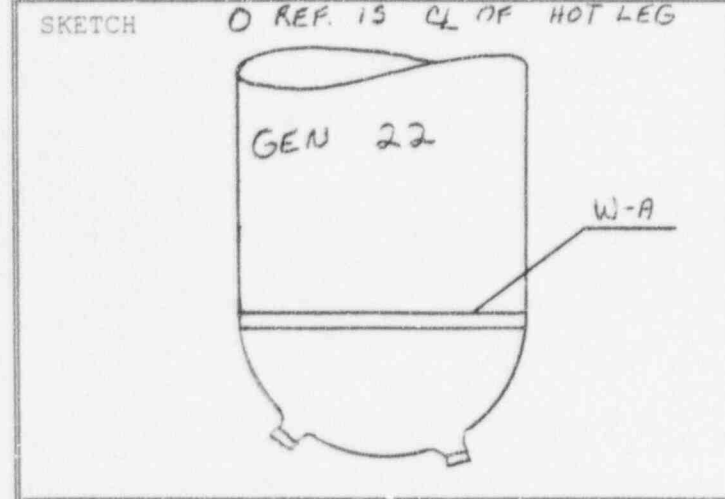
Evaluation Level 20% DAC	Reporting Level 20% DAC	Cal Block 25A	Ref Std LMT-109	Ref Sensitivity 20/7 dB Scan Sensitivity 20/16 dB
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RESULTS NAD = No Apparent Discontinuities; L = Linear; S = Spot; M = Multiple
GEO = Geometry Visual = Non-Section XI Visual Examination

Scan Nbr	Res-ults	Indication Type	Sweep Loc'n	Metal Path	Surf Dist	Circ Location	Axial Location	Indication Length	Amp %DAC
1	**L	LINEAR							
2	NAD								
3	**L	LINEAR							
4	**L	LINEAR							

LIMITATIONS: 2x2 Insulation Pads US: 1'-2", 10'-1", 19'-0"
2x2 Insulation Pads DS: 0'-0", 1'-2", 1'-10", 3'-8", 7'-3", 10'-1", 12'-4", 14'-1", 16'-1", 17'-10", 19'-6", 21'-2". Name Plate: 16'-1" to 16'6".

REMARKS: Exam meets 1/3 commitment for 3rd interval, 1st period and includes 0'-22' of weld.
* Exam Dates: 1/30/97 Start=1304; End=1704, 1/31/97 Start=0829; End=1532.
** Indications - See attached Indication Data Tabulation Sheet.

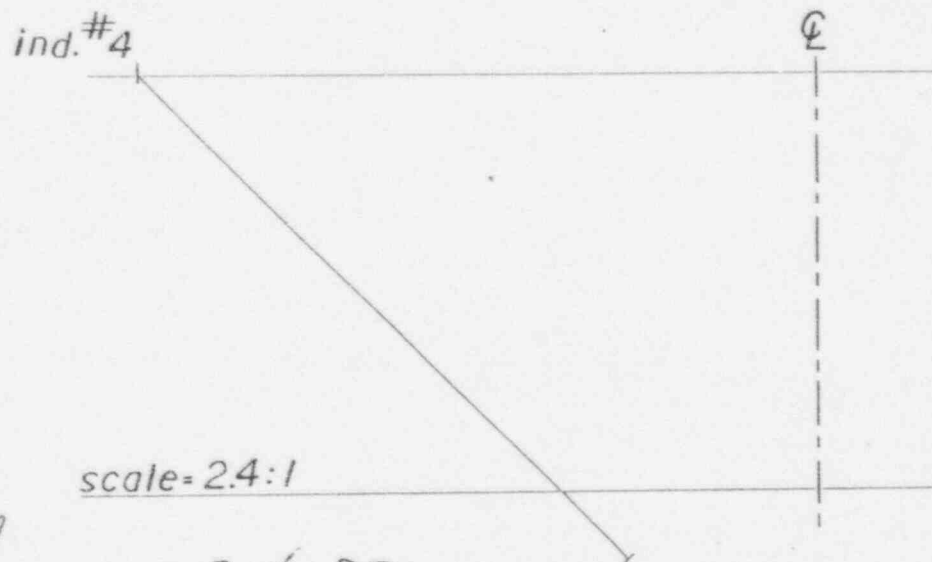


PERSONNEL	
Examiner: <u>T.W. Thomas</u>	II Level
Examiner: <u>B.E. Smart</u>	II Level
Contractor Review: <u>James P. W...</u>	2/19/97 Date
NSP Review: <u>[Signature]</u>	2/26/97 Date
ANII Review: <u>[Signature]</u>	3/7/97 Date

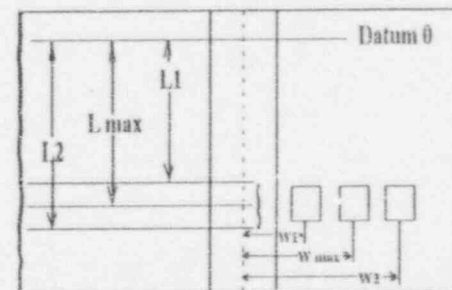
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Ind #	Scan #	% of DAC	@ MAX AMP			FORWARD * 20% DAC or 50% Max Amp			BACKWARD * 20% DAC or 50% Max Amp			L1 20% DAC	L MAX	L2 20% DAC	0° Back Amp	REMARKS
			W Max			W1	S Div	MP	W2	S Div	MP					
			W	S Div	MP											
1	1	52	2.2	6.1	5.75	1.8	5.8	5.50	2.8	6.6	6.21	233.8	234.2	234.6	N/A	45°
2	1	40	-1.3	1.9	1.82	-1.4	1.8	1.73	-1.1	2.0	1.91	122.4	122.6	123.2	N/A	45°
3	1	25	-2.4	5.8	5.47	-2.1	5.4	5.09	2.8	6.3	5.94	143	143.2	143.8	N/A	45°
4	1	120	8.23	8.9	8.41	-	-	-	-	-	-	-	43.1	-	N/A	GEO. 45° (TUBE SHEET)
5	1	30	-0.1	2.3	2.15	-0.4	2.0	1.92	0.2	2.5	2.38	38.5	39.2	39.5	N/A	45°
	2															NAD
6	3	37	-1.5	6.7	6.42	-1.4	6.7	6.40	-1.7	6.7	6.42	160.3	160.7	160.9	N/A	45°
7	3	54	-3.2	4.2	3.92	-2.9	4.0	3.76	-3.5	4.5	4.27	235.1	235.5	235.8	N/A	45°
8	3	156	-3.3	2.4	2.29	-2.9	2.2	2.05	-3.6	2.7	2.53	159.2	159.5	160.0	N/A	45°
9	3	44	-1.6	4.1	3.85	-1.5	3.7	3.49	-1.8	4.5	4.31	90.6	91.1	91.7	N/A	45°

SCALED PLOT



scale = 2.4:1



* NOTE - For flaw indications that peak at less than 20% DAC, dimensions are to be taken from the 50% Max Amp pts.

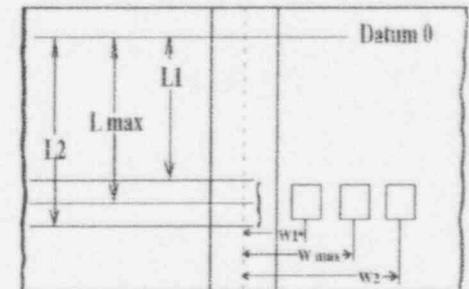
Examiner *Robert J. [Signature]*
 Examiner N/A

Date 3-4-97
 Date N/A

Examination Report # 97- 0136

Ind #	Scan #	% of DAC	@ MAX AMP			FORWARD * 20% DAC or 50% Max Amp			BACKWARD * 20% DAC or 50% Max Amp			L1 20% DAC	L MAX	L2 20% DAC	0° Back Amp	REMARKS
			W Max			W1	S Div	MP	W2	S Div	MP					
			W	S Div	MP											
10	4	48	-3.9	5.1	4.87	-3.6	4.6	4.39	-4.2	5.4	5.1	6.1	6.9	7.2	N/A	45°
11	4	71	-3.9	1.6	1.49	-3.5	1.2	1.15	-4.4	1.8	1.70	73.3	73.8	74.1	N/A	45°
12	4	36	-3.4	2.2	2.07	-3.1	1.5	1.40	-3.7	2.2	2.10	94.2	95.1	95.2	N/A	45°
13	4	62	-3.0	3.8	3.64	-2.8	3.4	3.20	-3.5	4.0	3.80	110.7	111.4	111.6	N/A	45°
14	4	53	-2.3	1.6	1.59	-2.1	1.5	1.41	-2.6	2.3	2.18	156.9	157.2	157.9	N/A	45°
15	4	37	-3.8	5.7	5.39	-3.6	5.3	5.06	-3.9	5.9	5.58	144.0	144.5	144.7	N/A	45°
16	4	41	-3.7	2.8	2.65	-3.5	2.5	2.37	-3.9	3.0	2.79	211.8	212.4	212.5	N/A	45°
17	4	45	-3.7	3.3	3.17	-3.3	2.9	2.75	-4.1	3.7	3.48	148.0	148.5	149.0	N/A	45°

SCALED PLOT



* NOTE - For flaw indications that peak at less than 20% DAC, dimensions are to be taken from the 50% Max Amp pts.

Examiner *Robert John*

Date 3-4-97

Examiner N/A

Date N/A