

U.S. NUCLEAR REGULATORY COMMISSION

REGION III

Reports No. 50-266/86007(DRS); 50-301/86007(DRS)

Docket Nos. 50-266; 50-301

Licenses No. DPR-24; DPR-27

Licensee: Wisconsin Electric Power Company  
231 West Michigan  
Milwaukee, WI 52303

Facility Name: Point Beach Nuclear Plant, Units 1 and 2

Inspection At: Point Beach site, Two Creeks, WI

Inspection Conducted: May 8 and 9, 1986

Inspector: *J. A. Gavula*  
J. A. Gavula

5/21/86  
Date

Approved By: *D. H. Danielson*  
D. H. Danielson, Chief  
Materials and Processes  
Section

5/21/86  
Date

Inspection Summary

Inspection on May 8 and 9, 1986 (Reports No. 50-266/86007(DRS);  
50-301/86007(DRS))

Areas Inspected: Unannounced special safety inspection of the licensee's actions taken in response to a 10 CFR Part 21 report issued for their steam generator hydraulic snubbers.

Results: No violations or deviations were identified.

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## DETAILS

### 1. Persons Contacted

#### Wisconsin Electric Power Company (WEPCo)

- \*J. J. Zach, Manager, Point Beach Nuclear Plant
- \*J. E. Knorr, Regulatory Engineer
- \*J. G. Schweitzer, Lead Mechanical Engineer
- \*F. A. Flentje, Administrative Specialist, EQRS
- J. C. Reisenbuechler, Superintendent, EQRS

#### Nuclear Regulatory Commission

- \*R. L. Hague, Senior Resident Inspector, Point Beach
- \*J. A. Gavula, Reactor Inspector, Mechanical
- \*R. J. Leemon, Resident Inspector, Point Beach

\*Denotes those attending the exit interview.

### 2. Licensee Action on 10 CFR 21 Items

- a. (Closed) 10 CFR 21 (266/86007-01; 301/86007-01): The original notification of a design deficiency in WEPCo's Point Beach Anker-Holth hydraulic snubbers was made on June 5, 1984. This documentation as well as subsequent correspondence on June 21 and August 10, 1984, detailed defective spherical bearings in the 500 KIP and 800 KIP hydraulic snubbers attached to the steam generators and main steam lines for both units. The subsequent information identified the blind end cover and piston rod for the 500 KIP snubber as also having design deficiencies. The manufacturer's recommendation was to replace the spherical bearings in the 500 KIP and 800 KIP snubbers and to replace the blind end covers and piston rod eyes on the 500 KIP snubbers.

An operability assessment was made for the 500 KIP and 800 KIP snubbers using the information provided by the snubber manufacturer as well as new snubber loads from the revised piping analyses. Although some theoretical localized yielding was predicted, the snubbers were determined to be operable and would have been able to perform their safety-related function. At the same time, a commitment was made to replace the defective parts during the first outage following the receipt of the replacement parts. This work was performed during the 1985 Spring outage for Unit 1 and during the 1984 and 1985 Fall outages for Unit 2.

The documentation reviewed by the NRC inspector showed that the revised maximum load and capacities of the snubber components were as follows:

Snubber Rating	500 KIP	800 KIP
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Maximum Design Load	386 KIP (compression) 228 KIP (tension)	360 KIP (tension or compression)
Blind End Cover (maximum capacity)	248 KIP	497 KIP
Rod End Eye (maximum capacity)	449 KIP	(not available greater than 497 KIP)

Using this information, it was decided that in addition to replacing the spherical bearings for the two sets of snubbers, the blind end covers would be replaced on the 500 KIP snubbers and both sets of snubbers would be derated to match their weakest component capacity. On this basis the 500 KIP snubber was derated to 449 KIPs and the 800 KIP snubber was derated to 497 KIPs. In both instances the derated capacity exceeded the maximum design load for each snubber.

Documentation for the replacement of the required components is covered in the Point Beach Nuclear Plant Modification Requests No. 84-179 and No. 84-180 for Units 1 and 2 respectively. The spherical bearings in four 800 KIP snubbers and six 500 KIP snubbers were replaced with part numbers PA 89492 and PA 89467. The blind end covers for the 500 KIP snubbers were replaced with part number PD 89555 made from ASTM-A-668-79. The installation and maintenance procedure used to perform the modification was Special Maintenance Procedure SMP No. 565 "500 KIP Anker-Holth Blind End Cover Replacement" Revision 0, dated February 18, 1985.

During the course of the modification work, it was found that the blind end cover on snubber LHS-10 had been elongated 0.068 inches in the direction of the load. This condition was determined to be the result of the full rated load test conducted by the manufacturer prior to shipment. Only one 500 KIP snubber was tested in this manner. Inspection of the rod end eye showed that no deformation or elongation had occurred and continuation of service was justified.

Additional documentation reviewed by the NRC inspector included the following:

Point Beach Construction Instruction Manual PBCI-85-1511 Manual No. 21.12620.007 "449K Hydraulic Shock Suppressor" Revision 4, dated December 3, 1985.

PBCI-85-679 Manual No. 21.16620.013 "497K Hydraulic Shock Suppressor" Revision 1, dated May 31, 1985.

Based on a review of the above information, the NRC inspector agrees with the actions taken and considers this item closed.

3. Exit Interview

The inspector met with site representatives (denoted in Paragraph 1) at the conclusion of the inspection. The inspector summarized the scope and findings of the inspection noted in this report. The inspector also discussed the likely informational content of the inspection report with regard to documents or processes reviewed by the inspector during the inspection. The licensee did not identify any such documents/processes as proprietary.