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FILE X

JUN 17 1987

Mr. A. Bert Davis
June 4, 1987
Page 2
LAC-12254

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TL/SwRI Reading File

All other distribution received only cover letter.

PC1-28

ENCLOSURE 1

Please remove the following pages from the "1986 Inservice Inspection Report of Dairyland Power Cooperative's La Crosse BWR", prepared by MQS Inspection, Inc. and dated March 25, 1986. Replace the pages with the revised pages attached to this sheet.

Appendix 5, cover sheets for the following five procedures:

- 22.A.11 - Summer 1981
- 22.A.600 - Summer 1975
- 22.A.615 - Summer 1975
- 22.A.639 - Summer 1975
- 22.G.100

Appendix 6, sheet 26 of 44 sheets (Form 23-A1)

MAGNAFLUX

Quality Services

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MAGNAFLUX QUALITY SERVICES

TEST & INSPECTION PROCEDURE

22.A.11 - Summer 1981

CALIBRATION AND CERTIFICATION OF ULTRASONIC EQUIPMENT

UNCONTROLLED
COPY

Reference: ASME - Section V (1980 Edition) including all Addenda through Summer 1981

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MQS INSPECTION INC.
TEST & INSPECTION PROCEDURES
22.A.600 - SUMMER 1975
ULTRASONIC EXAMINATION
GENERAL REQUIREMENTS
SECTION XI

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Reference: ASME Section XI, 1974 Edition with all addenda through Summer 1975

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MQS INSPECTIONS INC.
TEST & INSPECTIONS PROCEDURE
22.A.615 - SUMMER 1975

ULTRASONIC EXAMINATION OF CLASS 1 & CLASS 2
FERRITIC VESSEL WELDS

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Reference: ASME Section XI, 1974 Edition with all addenda through Summer 1975

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MQS INSPECTION INC.
TEST & INSPECTION PROCEDURES
22.A.639 - SUMMER 1975

ULTRASONIC EXAMINATION OF
NOZZLE INNER RADIUS SECTIONS

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Reference: ASME Section XI, 1974 Edition with all addenda through Summer 1975

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TEST & INSPECTION PROCEDURE

22.G.100

PHOTO-CERTIFICATION OF ULTRASONIC

WAVEFORM PER REG. GUIDE 1.150

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NDE TECHNIQUE RECORD/PENETRANT

CERTIFIED TEST REPORT Form 23-A1

Milwaukee, WI. 53208

414-771-3060

CORRECTED COPY

MFS
11-4-86

Work Order No.

Technique No. LBR-86-027

Client WA CROSSE BWR Project 90/517.6105/26
Item Description MAIN STEAM NOZZLE - TO - SAFE END Item # 000600
Part No. S2 Drawing No. A-13
Specification ASME XI 74-575 Acceptance Class ASME Sect. XI 74-575
Procedure 23.A.100-575 REV 8-1 MFS
11-4-86

WELDS	OTHER TEST ITEMS
Weld Joint <u>Butt</u>	Type of Item <u>N/A</u>
Weld Process <u>Unknown</u>	Processing <u></u>
Base Material <u>CS/SS</u>	Material <u></u>
Material Thickness <u>0.594 in.</u>	Dimensions <u></u>
Weld Length/OD <u>28.9 in. / 9.188 in.</u>	Additional Info <u></u>
Surface Condition <u>Ground w/ Rounded Crown</u>	Surface Condition <u>N</u>

PRECLEAN: Method Flush & Wipe Material MX SKC-NF/ZL-7B
Batch No. 86A054 Drying Time 5 min
PENETRANT: Material MX SKL-HF/S Batch No. 85K050
Application Spray Dwell Time 25 min
EMULSIFICATION: Material N/A Batch No. N/A
Application N/A Emulsification Time N/A

EXCESS PENETRANT REMOVAL: Material MX SKC-NF/ZL-7B Batch No. 86A054
Method Wipe w/ lint free towels Drying Time 10 min

DEVELOPER: Material MX SKD-NF/ZP-9B Batch No. 85E065
Application Spray Drying Time 10 min ^{N/A} Developing Time 10 min *

POSTCLEAN: Material MX SKC-NF/ZL-7B Batch No. 86A054
Method Wipe, Flush, & Wipe

OTHER INFORMATION:

* Re-read after 30 minutes of developing time

No Recordable Indications

No valid exam on C.S (Nozzle) side of the weld
due to painted surface.

Next weld Downstream (weld #1) is 0.625 inches from S2,
weld edge to weld edge.

Prepared By:
Michael F. Sherwin
Level III 7683

Approved By:
W.G. Blankenship
LEVEL III

Date
3/29/86

Other side may be used
for sketch or additional
information