



**UNITED STATES  
NUCLEAR REGULATORY COMMISSION**

REGION III  
2443 WARRENVILLE ROAD, SUITE 210  
LISLE, ILLINOIS 60532-4352

February 4, 2021

Mr. David Rhoades  
Senior VP, Exelon Generation Company, LLC  
President and CNO, Exelon Nuclear  
4300 Winfield Road  
Warrenville, IL 60555

SUBJECT: QUAD CITIES NUCLEAR POWER STATION – INTEGRATED INSPECTION  
REPORT 05000254/2020004 AND 05000265/2020004

Dear Mr. Rhoades:

On December 31, 2020, the U.S. Nuclear Regulatory Commission (NRC) completed an inspection at Quad Cities Nuclear Power Station and discussed the results of this inspection with Mr. K. Ohr, Site Vice President, and other members of your staff. The results of this inspection are documented in the enclosed report.

No findings or violations of more than minor significance were identified during this inspection.

This letter, its enclosure, and your response (if any) will be made available for public inspection and copying at <http://www.nrc.gov/reading-rm/adams.html> and at the NRC Public Document Room in accordance with Title 10 of the *Code of Federal Regulations* 2.390, "Public Inspections, Exemptions, Requests for Withholding."

Sincerely,

*/RA/*

Kenneth R. Riemer, Chief  
Branch 1  
Division of Reactor Projects

Docket Nos. 05000254 and 05000265  
License Nos. DPR-29 and DPR-30

Enclosure:  
As stated

cc w/ encl: Distribution via LISTSERV®

Letter to David Rhoades from Kenneth Riemer dated February 4, 2021.

SUBJECT: QUAD CITIES NUCLEAR POWER STATION – INTEGRATED INSPECTION  
REPORT 05000254/2020004 AND 05000265/2020004

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**U.S. NUCLEAR REGULATORY COMMISSION  
Inspection Report**

Docket Numbers: 05000254 and 05000265

License Numbers: DPR-29 and DPR-30

Report Numbers: 05000254/2020004 and 05000265/2020004

Enterprise Identifier: I-2020-004-0065

Licensee: Exelon Generation Company, LLC

Facility: Quad Cities Nuclear Power Station

Location: Cordova, IL

Inspection Dates: October 1, 2020 to December 31, 2020

Inspectors: J. Cassidy, Senior Health Physicist  
M. Garza, Emergency Preparedness Inspector  
R. Murray, Project Engineer  
D. Tesar, Senior Resident Inspector  
C. Mathews, Illinois Emergency Management Agency

Approved By: Kenneth R. Riemer, Chief  
Branch 1  
Division of Reactor Projects

Enclosure

## SUMMARY

The U.S. Nuclear Regulatory Commission (NRC) continued monitoring the licensee's performance by conducting an integrated inspection at Quad Cities Nuclear Power Station, in accordance with the Reactor Oversight Process. The Reactor Oversight Process is the NRC's program for overseeing the safe operation of commercial nuclear power reactors. Refer to <https://www.nrc.gov/reactors/operating/oversight.html> for more information.

### List of Findings and Violations

No findings or violations of more than minor significance were identified.

### Additional Tracking Items

Type	Issue Number	Title	Report Section	Status
LER	05000254,05000265/20 20-002-00	LER 2020-002-00 for Quad Cities Nuclear Power Station, Unit 1, Main Steam Line Drain Valve Declared Inoperable Due to Improper Torque Switch Setting	71153	Closed

## PLANT STATUS

### Unit 1

The unit began the inspection period at full-rated thermal power, where it remained for the entire inspection period, with the exception of planned power reductions for turbine testing, scram timing testing, control rod pattern adjustments, and other short-term power reductions as requested by the transmission system operator.

### Unit 2

The unit began the inspection period at full-rated thermal power, where it remained for the entire inspection period, with the exception of planned power reductions for turbine testing, scram timing testing, control rod pattern adjustments, and other short-term power reductions as requested by the transmission system operator.

## INSPECTION SCOPES

Inspections were conducted using the appropriate portions of the inspection procedures (IPs) in effect at the beginning of the inspection unless otherwise noted. Currently approved IPs with their attached revision histories are located on the public website at <http://www.nrc.gov/reading-rm/doc-collections/insp-manual/inspection-procedure/index.html>. Samples were declared complete when the IP requirements most appropriate to the inspection activity were met consistent with Inspection Manual Chapter (IMC) 2515, "Light-Water Reactor Inspection Program - Operations Phase." The inspectors reviewed selected procedures and records, observed activities, and interviewed personnel to assess licensee performance and compliance with Commission rules and regulations, license conditions, site procedures, and standards.

Starting on March 20, 2020, in response to the National Emergency declared by the President of the United States on the public health risks of the Coronavirus Disease 2019 (COVID-19), resident inspectors were directed to begin telework and to remotely access licensee information using available technology. During this time, the resident inspectors performed periodic site visits each week; conducted plant status activities as described in IMC 2515, Appendix D, "Plant Status"; observed risk-significant activities; and completed on-site portions of IPs. In addition, resident and regional baseline inspections were evaluated to determine if all or portions of the objectives and requirements stated in the IP could be performed remotely. If the inspections could be performed remotely, they were conducted per the applicable IP. In some cases, portions of an IP were completed remotely and on-site. The inspections documented below met the objectives and requirements for completion of the IP.

## REACTOR SAFETY

### 71111.04 - Equipment Alignment

#### Partial Walkdown Sample (IP Section 03.01) (2 Samples)

The inspectors evaluated system configurations during partial walkdowns of the following systems/trains:

- (1) Unit 2 reactor core isolation cooling on October 26, 2020
- (2) Turbine building closed cooling water on October 26, 2020

Complete Walkdown Sample (IP Section 03.02) (1 Sample)

- (1) The inspectors evaluated system configurations during a complete walkdown of the control rod drive system on October 26, 2020.

71111.05 - Fire Protection

Fire Area Walkdown and Inspection Sample (IP Section 03.01) (4 Samples)

The inspectors evaluated the implementation of the fire protection program by conducting a walkdown and performing a review to verify program compliance, equipment functionality, material condition, and operational readiness of the following fire areas:

- (1) Fire Zone 8.2.2.A, Unit 2 turbine building, elevation 572'-6", control rod drive pumps on October 19, 2020
- (2) Fire Zone 8.2.7.C, Unit 1/2 turbine building, elevation 611'-6", turbine building closed cooling water area on October 19, 2020
- (3) Fire Zone 11.2.3, Unit 1 reactor building, elevation 554'-0", northwest corner room - 1A core spray on October 26, 2020
- (4) Fire Zone 11.3.1, Unit 2 reactor building, elevation 554'-0", southwest corner room - 2B core spray on October 26, 2020

71111.07A - Heat Sink Performance

Annual Review (IP Section 03.01) (1 Sample)

The inspectors evaluated readiness and performance of:

- (1) 1A residual heat removal thermal performance test on November 30, 2020

71111.11A - Licensed Operator Requalification Program and Licensed Operator Performance

Requalification Examination Results (IP Section 03.03) (1 Sample)

- (1) The inspectors reviewed and evaluated the licensed operator examination failure rates for the requalification annual operating test which was administered between October 13 and November 17, 2020.

71111.11Q - Licensed Operator Requalification Program and Licensed Operator Performance

Licensed Operator Performance in the Actual Plant/Main Control Room (IP Section 03.01) (2 Samples)

- (1) The inspectors observed and evaluated licensed operator performance in the control room during downpower, rod pattern adjustment, and scram timing tests on October 20, 2020.
- (2) The inspectors observed and evaluated licensed operator performance in the control room during downpower, rod pattern adjustment, and turbine testing on November 7, 2020.

Licensed Operator Regualification Training/Examinations (IP Section 03.02) (1 Sample)

- (1) The inspectors observed and evaluated observation of licensed operator requalification training on October 5, 2020.

71111.12 - Maintenance Effectiveness

Maintenance Effectiveness (IP Section 03.01) (3 Samples)

The inspectors evaluated the effectiveness of maintenance to ensure the following structures, systems, and components remain capable of performing their intended function:

- (1) High pressure coolant injection on November 30, 2020
- (2) Core spray on December 1, 2020
- (3) Turbine building closed cooling water on December 7, 2020

71111.13 - Maintenance Risk Assessments and Emergent Work Control

Risk Assessment and Management Sample (IP Section 03.01) (1 Sample)

The inspectors evaluated the accuracy and completeness of risk assessments for the following planned and emergent work activities to ensure configuration changes and appropriate work controls were addressed:

- (1) Work week risk reviews and PARAGON updates on November 2, 2020

71111.15 - Operability Determinations and Functionality Assessments

Operability Determination or Functionality Assessment (IP Section 03.01) (1 Sample)

The inspectors evaluated the licensee's justifications and actions associated with the following operability determinations and functionality assessments:

- (1) Issue Report 4386700, "Pin-Hole Leaks 'B' HVAC [heating, ventilation, and air conditioning] System Operability," on November 30, 2020

71111.18 - Plant Modifications

Temporary Modifications and/or Permanent Modifications (IP Section 03.01 and/or 03.02) (3 Samples)

The inspectors evaluated the following temporary or permanent modifications:

- (1) Engineering Change 626394, "Install Bypass Switches for GRP 1 MSIV [main steam isolation valve] Isolation"
- (2) Engineering Change 395100, "Replace HPCI [high pressure coolant injection] Obsolete Temperature Indicating Switches and Thermowells"
- (3) Engineering Change 621167, "RCIC [reactor core isolation cooling] Flow Controllers FIC 1(2)-1304-1 Upgrade"

### 71111.19 - Post-Maintenance Testing

#### Post-Maintenance Test Sample (IP Section 03.01) (4 Samples)

The inspectors evaluated the following post-maintenance test activities to verify system operability and functionality:

- (1) Standby gas treatment post-maintenance testing QCOS-7500-05, -06, -07 on October 22, 2020
- (2) Station blackout diesel quarterly on October 29, 2020
- (3) Unit 2 emergency diesel generator following 12-year preventive maintenance on November 5, 2020
- (4) QCOS 1400-1, "'B' Core Spray Pump Flow Rate Test," on November 16, 2020

### 71111.22 - Surveillance Testing

The inspectors evaluated the following surveillance tests:

#### Surveillance Tests (other) (IP Section 03.01) (1 Sample)

- (1) QCOS 1000-04, "RHR [residual heat removal] Service Water Pump 'B' Flow (IST)," on October 22, 2020

#### FLEX Testing (IP Section 03.02) (1 Sample)

- (1) Emergency portable pump (B.5.B/FLEX) on November 7, 2020

### 71114.04 - Emergency Action Level and Emergency Plan Changes

#### Inspection Review (IP Section 02.01-02.03) (1 Sample)

- (1) The inspectors completed an evaluation of submitted emergency action level and emergency plan changes on December 2, 2020. This evaluation does not constitute NRC approval.

### 71114.06 - Drill Evaluation

#### Drill/Training Evolution Observation (IP Section 03.02) (2 Samples)

The inspectors evaluated:

- (1) Chemical, spill, anticipated transient without scram, loss of torus level on October 20, 2020
- (2) Emergency preparedness drill - contaminated injured man on December 9, 2020



## **OTHER ACTIVITIES – BASELINE**

### 71151 - Performance Indicator Verification

The inspectors verified licensee performance indicators submittals listed below:

#### MS07: High Pressure Injection Systems (IP Section 02.06) (2 Samples)

- (1) Unit 1 (10/01/2019-09/30/2020)
- (2) Unit 2 (10/01/2019-09/30/2020)

#### MS08: Heat Removal Systems (IP Section 02.07) (2 Samples)

- (1) Unit 1 (10/01/2019-09/30/2020)
- (2) Unit 2 (10/01/2019-09/30/2020)

#### MS09: Residual Heat Removal Systems (IP Section 02.08) (2 Samples)

- (1) Unit 1 (10/01/2019-09/30/2020)
- (2) Unit 2 (10/01/2019-09/30/2020)

#### MS10: Cooling Water Support Systems (IP Section 02.09) (2 Samples)

- (1) Unit 1 (10/01/2019-09/30/2020)
- (2) Unit 2 (10/01/2019-09/30/2020)

#### BI01: Reactor Coolant System (RCS) Specific Activity Sample (IP Section 02.10) (2 Samples)

- (1) Unit 1 (10/01/2019-09/30/2020)
- (2) Unit 2 (10/01/2019-09/30/2020)

#### OR01: Occupational Exposure Control Effectiveness Sample (IP Section 02.15) (1 Sample)

- (1) (10/01/2019-09/30/2020)

#### PR01: Radiological Effluent Technical Specifications/Offsite Dose Calculation Manual Radiological Effluent Occurrences (RETS/ODCM) Radiological Effluent Occurrences Sample (IP Section 02.16) (1 Sample)

- (1) (04/01/2019-09/30/2020)

### 71152 - Problem Identification and Resolution

#### Semiannual Trend Review (IP Section 02.02) (2 Samples)

The inspectors reviewed the licensee's corrective action program for potential adverse trends in:

- (1) Elevated offgas flow and radiation monitor adjustments on November 9, 2020, that might be indicative of a more significant safety issue.

- (2) Control rod drive hydraulic accumulator unit trend review on December 14, 2020, that might be indicative of a more significant safety issue.

Annual Follow-up of Selected Issues (IP Section 02.03) (1 Partial)

The inspectors reviewed the licensee’s implementation of its corrective action program related to the following issues:

- (1) (Partial)  
Issue Report 4371385, "[Unit] 1C RHRSW [residual heat removal service water] Seal Cooling Line Break," follow-up on December 9, 2020

71153 – Follow-up of Events and Notices of Enforcement Discretion

Event Report (IP Section 03.02) (1 Sample)

The inspectors evaluated the following licensee event reports (LERs): LER 2020-002-00 for Quad Cities Nuclear Power Station, Unit 1, Main Steam Line Drain Valve Declared Inoperable Due to Improper Torque Switch Setting

- (1) LER 2020-002-00, Quad Cities Nuclear Power Station, Unit 1, Main Steam Line Drain Valve Declared Inoperable Due to Improper Torque Switch Setting (ADAMS Accession No. ML20315A447). The inspection conclusions associated with this LER are documented in NRC Integrated Inspection Report 05000254; 05000265/2020003 under Inspection Results Section 71111.15.

**INSPECTION RESULTS**

Observation: Follow-Up of Residual Heat Removal Service Water Low Pressure Pump Seal Line Break	71152
<p>As documented in NRC Integrated Inspection Report 05000254; 05000265/2020003, the inspectors noted that on September 23, 2020, the licensee generated Issue Report 4371385, "Documenting a Seal Cooling Line Leak from the Unit 1C RHRSW Pump." The inspectors walked down the pump on the same day and noted that the seal cooling line had sheared at a union elbow joint. Additionally, the inspectors noted the piping at the elbow was completely blocked with debris and/or corrosion products and discussed with the licensee. The licensee documented the as found conditions in Issue Report 4371588, "As Found Condition of 1C RHRSW Pump Seal Cooling Line Leak," on September 23, 2020. The inspectors performed additional inspection activities to review the licensee's causal evaluation, and corrective actions associated with this issue during this inspection period as indicated in NRC Integrated Inspection Report 05000254; 05000265/2020003.</p> <p>The inspectors reviewed the work group evaluation associated with Issue Report 4371385 as well as the documented response from the vendor regarding the loss of seal water flow to the RHRSW pump low pressure seals. In addition, inspectors reviewed the actions from Issue Reports 4371385 and 4371588.</p> <p>All actions from Issue Report 4371588 are documented as complete with no issues identified. Actions from Issue Report 4371385 are in progress with extent-of-condition work orders generated and scheduled for completion during the next available work windows for each of the remaining RHRSW pumps. In addition, Action Item 02 to evaluate the need for scheduled</p>	

preventive maintenance on the low-pressure pump seal lines is in progress and scheduled for completion on January 21, 2021.

The inspectors reviewed the work group evaluation and vendor response associated with Issue Report 4371385. The inspectors requested clarification of statements in the work group evaluation. All questions have been resolved with no additional concerns identified.

The inspectors did identify that the low-pressure seal water piping was not included in the aging management program, the preventive maintenance program, nor were there steps included in the scheduled scope of work to disassemble, clean or inspect the low-pressure seal water piping. The inspectors did not identify any violations of procedural or regulatory requirements during this review.

## **EXIT MEETINGS AND DEBRIEFS**

The inspectors verified no proprietary information was retained or documented in this report.

- On December 31, 2020, the inspectors presented the integrated inspection results to Mr. K. Ohr, Site Vice President, and other members of the licensee staff.
- On December 16, 2020, the inspectors presented the licensed operator annual exam inspection results to Mr. R. Ramsay, Operations Training Manager, and other members of the licensee staff.
- On December 17, 2020, the inspectors presented the IP 71114.04 exit meeting inspection results to Mr. D. Moore, Senior Manager - Emergency Preparedness, and other members of the licensee staff.

**DOCUMENTS REVIEWED**

Inspection Procedure	Type	Designation	Description or Title	Revision or Date
71111.04	Procedures	QCOP 0300-01	CRD System Startup and Operation	35
		QCOP 0300-02	CRD System Shutdown	11
		QCOP 1300-01	RCIC System Preparation for Standby Operation	46
		QCOP 3800-02	Unit 1 TBCCW System Operation	4
		QCOP 3800-03	Unit 2 TBCCW System Operation	4
		QOM 1-3800-01	Unit 1 TBCCW Valve Checklist	16
		QOM 2-3800-01	Unit 2 TBCCW Valve Checklist	16
71111.05	Fire Plans	FZ 11.2.3	Unit 1 RB 554'-0" Elev. NW Corner Room - 1A Core Spray	November 2011
		FZ 11.3.1	Unit 2 RB 544'-0" Elev. SW Corner Room - 2B Core Spray	October 2013
		FZ 8.2.2.A	Unit 2 Turbine Building, Elevation 572'-6", Control Rod Drive Pumps	October 2019
		FZ 8.2.7.C	Unit 1/2 Turbine Building, Elevation 611'-6", Turbine Building Closed Cooling Water Area	October 2019
71111.07A	Work Orders	WO 4678906-01	1A RHR HX Thermal Performance Test	11/30/2020
71111.12	Corrective Action Documents	IR 4299841	1B TBCCW Hx Requires Additional Maintenance	11/25/2019
		IR 4304891	1A TBCCW Hx Requires Additional Maintenance	12/17/2019
		IR 4306910	Abnormal Pressure on Keepfill During 2A Core Spray Surveillance	12/30/2019
		IR 4329527	902-3 C-4 Core Spray Pump 'A' High Seal Leakage Alarm Received	03/25/2020
		IR 4333976	Q2R25 As-Left LLRT on HPCI MO 2-2301-5 Exceeds Alert	04/09/2020
		IR 4337637	Light to Moderate Corrosion Observed During HPCI Walkdown	04/22/2020
		IR 4347201	EO ID's Excessive No Flow Time During HPCI Venting	06/01/2020
		IR 4348145	U2 HPCI Check Valve Response During QCOS 2300-11	06/04/2020
		IR 4349837	Unexpected 2B Core Spray Header Low Pressure Alarm	06/11/2020
		IR 4350782	U2 HPCI Room Temp High	06/16/2020
		IR 4360041	Suspected Crack/Flange Leak in 2B Core Spray Floor Drain	07/30/2020
IR 4363378	U2 HPCI TG MGU Signal Converter Display Not Functioning	08/15/2020		

Inspection Procedure	Type	Designation	Description or Title	Revision or Date
		IR 4367470	U2 HPCI Check Valve Response During QCOS 2300-11	09/04/2020
		IR 4371330	EO ID: 2B TBCCW Pump Oil Leak	09/22/2020
71111.15	Corrective Action Documents	IR 4386700	Pin-Hole Leaks Found at Weld for 0-5799-381 'B' HVAC Train	11/27/2020
	Engineering Changes	EC 633107	N-513 Evaluation for Line 1/2-57479-2 1/2" Through-Wall Leak	1
	Operability Evaluations	Op Eval 633095	CR HVAC 'B' Train Piping Line 0-57479-2 1/2" Through-Wall Leak	0
	Procedures	OP-AA-108-115	Operability Determinations (CM-1)	23
71111.18	Engineering Changes	EC 395100, Rev. 001	Replace HPCI Obsolete Temperature Indicating Switches and Thermowells	04/03/2019
		EC 621167, Rev. 000	RCIC Flow Controllers FIC 1(2)-1340-1 Upgrade	01/08/2020
		EC 626394, Rev. 000	U-2 Install Bypass Switches for -59" Group 1 MSIV Isolation	12/03/2019
	Work Orders	WO 1529963	Replace U2 HPCI TIS 2-2341-3B	09/02/2020
		WO 1731449	Failed Instrument, TIS 2-2341-2B	09/02/2020
		WO 4943032	Install Bypass Switches for GRP 1 MSIV Isolation 626394	04/16/2020
71111.19	Procedures	QCOS 1400-01	Core Spray System Flow Rate Test	50
		QCOS 1400-10	Core Spray Operability Verification	27
		QCOS 6600-42	Unit 2 Emergency Diesel Generator Load Test	55
		QCOS 6600-45	Unit 2 Diesel Generator Timed Start Test	27
		QCOS 6620-01	SBO DG 1(2) Quarterly Load Test	54
		QCOS 7500-05	SBGTS Monthly Operability Test	31
		QCOS 7500-06	SBGTS Power Operated Valve Test	25
		QCOS 7500-07	SBGT System 24-Month Operability Test	17
71111.22	Procedures	OP-AA-201-010-1001	Mitigating Strategies Equipment Expectations	6
		QCOS 1000-04	RHR Service Water Pump Operability Test	64
	Work Orders	WO 5085804	(Flex) Emergency Portable Pump (B.5.B/Flex)	11/07/2020
71114.04	Corrective Action Documents	IR 4325295	Perform an Impact Review of EAL Revisions for EOP/SAMG Revision 4	03/10/2020
		IR 4328154	EP FAQ EAL Change License Amendment Implementation	03/20/2020

Inspection Procedure	Type	Designation	Description or Title	Revision or Date
			Actions	
		IR 4329864	NOS ID: Revise Standardized Emergency Plan	03/26/2020
		IR 4334253	Emergency Plan: CDAM 50.54(q) Potential Deficiencies	04/09/2020
	Miscellaneous	Eval No. 19-29	Exelon Nuclear Standardized Radiological Emergency Plan	09/04/2019
		Eval No. 19-65	Exelon Nuclear Standardized Radiological Emergency Plan	09/06/2019
		Eval No. 19-79	Various Station Emergency Plan Annexes	11/08/2019
		Eval No. 19-80	On-Shift Staffing Assessments	11/08/2019
		Eval No. 20-28	EALs for Quad Cities Station	03/24/2020
71151	Miscellaneous	CY-QC-120-720, Attachment 2	Actual Dose Data - Unit 1	April 2019 - September 2020
		CY-QC-120-720, Attachment 2	Actual Dose Data - Unit 2	April 2019 - September 2020
		LS-AA-2090	Monthly Data Elements for NRC ROP Indicator - Reactor Coolant System (RCS) Specific Activity	October 2019 - September 2020
		SP-AA-3000, Attachment A	Site Performance Indicator Information	October 2019 - September 2020
71152	Corrective Action Documents	IR 4317442	U1 MCR Received Alarm 901-3 D2 Offgas High Radiation	02/13/2020
		IR 4318180	U1 MCR Received Alarm 901-3 D2 Offgas High Radiation	02/15/2020
		IR 4353803	Unexpected Receipt of 901-3 D-2 (Offgas High Rad)	06/30/2020
		IR 4356753	901-D2 Offgas High Radiation Alarm	07/14/2020
		IR 4358010	Offgas Rad Monitor Setpoint Need Adjusted	07/21/2020
		IR 4363085	Unexpected Offgas High Radiation Alarm	08/14/2020
		IR 4371385	U1C RHRSW Pump Seal Line Leak	09/23/2020
		IR 4371588	As Found Condition of 1C RHRSW Pump Seal Cooling Line Leak	09/23/2020
		IR 4383062	Offgas Rad Monitor Setpoints Need Adjusted	11/08/2020
		IR 4383559	'B' CREV HVAC AHU Motor Overload	11/11/2020
IR 4389289	2D RHR Pump Breaker Auxiliary Contracts High Resistance	12/09/2020		

Inspection Procedure	Type	Designation	Description or Title	Revision or Date
	Procedures	CY-QC-170-301	Offsite Dose Calculation Manual (ODCM) Special Distribution (Change SRRS ID Number to 2C.110 Before Archiving)	14