

# BWRVIP

BWR Vessel & Internals Project \_\_\_\_\_ 2002-081

March 26, 2002

Document Control Desk  
U. S. Nuclear Regulatory Commission  
11555 Rockville Pike  
Rockville, MD 20852

Attention: C. E. Carpenter

Subject: Project No. 704 – Revision to BWRVIP-84

Reference: Letter from Carl Terry (BWRVIP Chairman) to Document Control Desk (NRC),  
“Project 704 – BWR Vessel and Internals Project, Guidelines for Selection and Use  
of Materials for Repairs to BWR Internals (BWRVIP-84), EPRI Report 1000248,  
October 2000,” dated November 6, 2000.

The purpose of this letter is to inform the NRC staff of a revision to the BWRVIP document  
entitled “BWR Vessel and Internals Project, Guidelines for Selection and Use of Materials for  
Repairs to BWR Internal Components (BWRVIP-84).”

The published version of BWRVIP-84 transmitted to the NRC by the reference letter prohibits  
electrical discharge machining (EDM) of alloy X-750 material, although EDM on other materials  
is allowed with certain restrictions. The revision to BWRVIP-84 allows the use of EDM on alloy  
X-750 material with requirements similar to those in BWRVIP-84 for other materials. The  
specific revision to BWRVIP-84 is to revise Section B.8.9.4 of BWRVIP-84 to read as follows:

#### B.8.9.4 Electrical Discharge Machining (EDM)

A minimum of 1/16-inch of material, or an amount demonstrated by the vendor to be  
adequate to assure that the surface is free of cracks and the resulting surface is acceptable  
for BWR service, shall be mechanically removed from surfaces processed by EDM. One  
approach for determining the amount of material that must be removed for the application  
is by use of the criteria contained in ASME Section XI, IWA-4461.4. NRC approval is  
required if EDM-processed X-750 is used in a repair to a component which is subject to  
the requirements of ASME Section XI.

This change will be included in any future publication of a revision to BWRVIP-84.

If you have any questions on this subject, please contact Denver Atwood (Southern Nuclear, BWRVIP Repair Focus Group Chairman) by telephone at 205.992.7461.

Sincerely,

A handwritten signature in cursive script, appearing to read 'C. Terry'.

Carl Terry  
Constellation Nuclear, Nine Mile Point LLC  
Chairman, BWR Vessel and Internals Project