



REGULATORY GUIDE

OFFICE OF NUCLEAR REGULATORY RESEARCH

REGULATORY GUIDE 1.147

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INSERVICE INSPECTION CODE CASE ACCEPTABILITY, ASME SECTION XI, DIVISION 1

A. INTRODUCTION

General Design Criterion (GDC) 1, "Quality Standards and Records," of Appendix A, "General Design Criteria for Nuclear Power Plants," to Title 10, Part 50, of the *Code of Federal Regulations* (10 CFR Part 50), "Domestic Licensing of Production and Utilization Facilities," requires, in part, that structures, systems, and components important to safety be designed, fabricated, erected, and tested to quality standards commensurate with the importance of the safety functions to be performed. Where generally recognized codes and standards are used, Criterion 1 requires that they be identified and evaluated to determine their applicability, adequacy, and sufficiency and be supplemented or modified as necessary to ensure a quality product in keeping with the required safety function.

Provisions of the American Society of Mechanical Engineers (ASME) Boiler and Pressure Vessel (B&PV) Code have been used since 1971 as one part of the framework to establish the necessary design, fabrication, construction, testing, and performance requirements for structures, systems, and components important to safety. Among other things, ASME standards committees develop improved methods for the construction and inservice inspection (ISI) of ASME Class 1, 2, 3, MC (metal containment), and CC (concrete containment) nuclear power plant components. A broad spectrum of stakeholders participates in the ASME process, which helps to ensure that the various interests are considered.

This regulatory guide identifies the Code Cases that have been determined by the NRC to be acceptable alternatives to applicable parts of Section XI. The latest editions and addenda of Section XI that the U.S. Nuclear Regulatory Commission (NRC) has approved for use are referenced in 10 CFR 50.55a(b).

This guide was issued after consideration of comments received from the public. The NRC staff encourages and welcomes comments and suggestions in connection with improvements to published regulatory guides, as well as items for inclusion in regulatory guides that are currently being developed. The NRC staff will revise existing guides, as appropriate, to accommodate comments and to reflect new information or experience. Written comments may be submitted to the Rules and Directives Branch, Office of Administration, U.S. Nuclear Regulatory Commission, Washington, DC 20555-0001.

Regulatory guides are issued in 10 broad divisions: 1, Power Reactors; 2, Research and Test Reactors; 3, Fuels and Materials Facilities; 4, Environmental and Siting; 5, Materials and Plant Protection; 6, Products; 7, Transportation; 8, Occupational Health; 9, Antitrust and Financial Review; and 10, General.

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The regulation in 10 CFR 50.55a(g), “Inservice Inspection Requirements,” requires, in part, that Class 1, 2, 3, MC, and CC components and their supports meet the requirements of Section XI, “Rules for Inservice Inspection of Nuclear Power Plant Components,”¹ of the ASME BPV Code or equivalent quality standards. Every 3 years, the ASME publishes a new edition of the BPV Code, including Section XI, and new addenda are published every year. The latest editions and addenda of Section XI that the U.S. Nuclear Regulatory Commission (NRC) has approved for use are referenced in 10 CFR 50.55a(b). The ASME also publishes Code Cases quarterly. Code Cases provide alternatives to existing Code requirements that the ASME developed and approved. This regulatory guide identifies the Code Cases that the NRC has determined to be acceptable alternatives to applicable parts of Section XI. Licensees may use these Code Cases without requesting authorization from the NRC, provided that they are used with any identified limitations or modifications. Section XI Code Cases that the NRC has not yet endorsed may be implemented through 10 CFR 50.55a(a)(3), which permits the use of alternatives to the Code requirements referenced in 10 CFR 50.55a, provided that the proposed alternatives result in an acceptable level of quality and safety and that their use is authorized by the Director of the NRC’s Office of Nuclear Reactor Regulation.

The ASME Code is incorporated by reference into 10 CFR 50.55a, which the NRC will amend to incorporate this guide by reference; 10 CFR 50.55a states the requirements governing the use of Code Cases. Because of the continuing change in the status of Code Cases, the NRC staff plans periodic updates to 10 CFR 50.55a and this guide to accommodate new Code Cases and any revisions of existing Code Cases. NRC approved Code Cases provide an acceptable voluntary alternative to the mandatory ASME Code provisions.

This regulatory guide does not contain a new or amended information collection requirement subject to the Paperwork Reduction Act of 1995 (44 U.S.C. 3501 *et seq.*). This revision of Regulatory Guide 1.147 would decrease the paperwork burden for those licensees choosing to use ASME Code Cases N-508-2 and N-600. The paperwork burden reduction is discussed in detail in the rulemaking package for this guide. Because the burden for this information collection is insignificant, Office of Management and Budget (OMB) clearance is not required. The existing information collections are covered by the requirements of 10 CFR Part 50, which the Office of Management and Budget (OMB) approved under OMB control number 3150-0011. The NRC may neither conduct nor sponsor, and a person is not required to respond to, an information collection request or requirement unless the requesting document displays a currently valid OMB control number.

¹ Copies may be obtained from the American Society of Mechanical Engineers, Three Park Avenue, New York, NY 10016-5990; phone (212) 591-8500; fax (212) 591-8501; www.asme.org.

B. DISCUSSION

For Revision 14 to Regulatory Guide 1.147, the NRC staff reviewed the Section XI Code Cases listed in Supplement 12 to the 1998 Edition of the ASME B&PV Code through Supplement 6 to the 2001 Edition. Appendix A to this guide lists the supplements reviewed, the edition, supplement number, and the date on which each supplement was approved by the ASME's Board on Nuclear Codes and Standards. Appendix B is a list of the Section III Code Cases addressed in the seven supplements. Finally, Appendix C is a current list of all Section XI Code Cases. The Code Cases addressed by this regulatory guide are listed in five tables:

- (1) Table 1, "Acceptable Section XI Code Cases," lists the Code Cases that are acceptable to the NRC for implementation in the ISI of light-water-cooled nuclear power plants.
- (2) Table 2, "Conditionally Acceptable Section XI Code Cases," lists the Code Cases that are acceptable provided that they are used with the identified limitations or modifications (i.e., the Code Case is generally acceptable, but the NRC has determined that the alternative requirements must be supplemented in order to provide an acceptable level of quality and safety).
- (3) Table 3, "Annulled Unconditionally Approved Section XI Code Cases," lists Code Cases annulled by the ASME that the NRC previously determined to be fully acceptable.
- (4) Table 4, "Annulled Conditionally Acceptable Section XI Code Cases," lists the Code Cases that the NRC determined to be acceptable, provided that they were used with the identified limitations or modifications, but that the ASME subsequently annulled.
- (5) Table 5, "Section XI Code Cases That Have Been Superseded by Revised Code Cases," lists Code Cases that have been superseded through revision. Code Cases that the NRC determined to be unacceptable are listed in Regulatory Guide 1.193, "ASME Code Cases Not Approved for Use."

When a licensee initially implements a Code Case, 10 CFR 50.55a requires that the most recent version of that Code Case as listed in Tables 1 and 2 of this guide be implemented. If a Code Case is implemented by a licensee and a later version of the Code Case is approved by the NRC and listed in Tables 1 and 2 during the licensee's present 120-month ISI program interval, that licensee may use either the later version or the previous version. An exception to this provision would be the inclusion of a limitation or condition on the use of the Code Case that is necessary, for example, to enhance safety. Licensees who choose to continue use of the Code Case during the subsequent 120-month ISI program interval will be required to implement the latest version incorporated by reference into 10 CFR 50.55a and listed in Tables 1 and 2.

Code Cases may expire or be annulled because the provisions have been incorporated into the Code, the application for which it was specifically developed no longer exists, or experience has shown that an examination or testing method is no longer adequate. After the ASME annuls a Code Case and the NRC amends 10 CFR 50.55a and this guide, licensees may not implement that Code Case for the first time. However, a licensee who implemented the Code Case prior to annulment may continue to use that Code Case through the end of the present ISI interval. An annulled Code Case cannot be used in the subsequent ISI interval unless implemented as an approved alternative under 10 CFR 50.55a(a)(3). If a Code Case is incorporated by reference into 10 CFR 50.55a and later annulled by the ASME because experience has shown that an examination or testing method is inadequate, the NRC will amend 10 CFR 50.55a and this guide to remove the approval of the annulled Code Case. Licensees should not begin to implement such annulled Code Cases in advance of the rulemaking. Notwithstanding these requirements, the Commission may impose new or revised Code requirements, including implementation schedules, that it determines are consistent with the backfit rule (10 CFR 50.109).

With regard to the use of any Code Case, it is the responsibility of the user to make certain that the provisions of the Code Case do not conflict with regulatory requirements or licensee commitments.

C. REGULATORY POSITION

1. Acceptable Section XI Code Cases

The Code Cases listed in Table 1 are acceptable to the NRC for application in licensees' Section XI inservice inspection programs. The ASME issues a new edition of Section XI every 3 years. Code Cases are published quarterly in supplements to each edition. Hence, there are 12 supplements to each edition. Column 3 of Table 1 lists the date of ASME approval or the supplement and edition in which each Code Case was published (e.g., 3/01E means Code Case Supplement 3 to the 2001 Edition).

Table 1. Acceptable Section XI Code Cases

Code Case Number	Table 1. Acceptable Section XI Code Cases	Date or Supplement/Edition
N-307-3	<i>Revised Ultrasonic Examination Volume for Class 1 Bolting, Table IWB-2500-1, Examination Category B-G-1, When the Examinations Are Conducted from the End of the Bolt or Stud or from the Center-Drilled Hole, Section XI, Division 1</i>	1/01E
N-311	<i>Alternative Examination of Outlet Nozzle on Secondary Side of Steam Generators, Section XI, Division 1</i>	4/19/02
N-322	<i>Examination Requirements for Integrally Welded or Forged Attachments to Class 1 Piping at Containment Penetrations, Section XI, Division 1</i>	3/28/02
N-323-1	<i>Alternative Examination for Welded Attachments to Pressure Vessels, Section XI, Division 1</i>	4/8/02
N-334	<i>Examination Requirements for Integrally Welded or Forged Attachments to Class 2 Piping at Containment Penetrations, Section XI, Division 1</i>	3/28/00
N-416-3	<i>Alternative Pressure Test Requirement for Welded Repairs or Installation of Replacement Items by Welding, Class 1, 2, and 3, Section XI, Division 1</i>	2/01E
N-432-1	<i>Repair Welding Using Automatic or Machine Gas Tungsten-Arc Welding (GTAW) Temper Bead Technique, Section XI, Division 1</i>	12/98E
N-435-1	<i>Alternative Examination Requirements for Vessels With Wall Thickness 2 in. or Less, Section XI, Division 1</i>	R3/28/01
N-460	<i>Alternative Examination Coverage for Class 1 and Class 2 Welds, Section XI, Division 1</i>	3/28/00
N-471	<i>Acoustic Emission for Successive Inspections, Section XI, Division 1</i>	4/19/02

Code Case Number	Table 1. Acceptable Section XI Code Cases	Date or Supplement/Edition
N-481	<i>Alternative Examination Requirements for Cast Austenitic Pump Casings, Section XI, Division 1</i>	5/20/98
N-485-1	<i>Eddy Current Examination of Coated Ferritic Surfaces as an Alternative to Surface Examination, Section XI, Division 1</i>	3/28/00
N-490-1	<i>Alternative Vision Test Requirements for Nondestructive Examiners, Section XI, Divisions 1, 2, and 3</i>	3/28/00
N-491-2	<i>Rules for Examination of Class 1, 2, 3, and MC Component Supports of Light-Water Cooled Power Plants, Section XI, Division 1</i>	3/28/00
N-494-3	<i>Pipe Specific Evaluation Procedures and Acceptance Criteria for Flaws in Class 1 Ferritic Piping that Exceed the Acceptance Standards of IWB-3514.2 and in Class 1 Austenitic Piping that Exceed the Acceptance Standards of IWB-3514.3, Section XI, Division 1</i>	4/19/02
N-496-2	<i>Helical-Coil Threaded Inserts, Section XI, Division 1</i>	3/01E (Reinstated)
N-503	<i>Limited Certification of Nondestructive Examination Personnel, Section XI, Division 1</i> (Note: Because of the statistical screening criteria used for Appendix VIII to Section XI qualifications, this Code Case is not applicable to Appendix VIII, "Performance Demonstration for Ultrasonic Examination Systems.")	10/2/00
N-508-2	<i>Rotation of Serviced Snubbers and Pressure Relief Valves for the Purpose of Testing, Section XI, Division 1</i>	1/01E
N-522	<i>Pressure Testing of Containment Penetration Piping, Section XI, Division 1</i>	4/8/02
N-523-2	<i>Mechanical Clamping Devices for Class 2 and 3 Piping, Section XI, Division 1</i>	3/28/01
N-526	<i>Alternative Requirements for Successive Inspections of Class 1 and 2 Vessels, Section XI, Division 1</i>	8/20/02
N-534	<i>Alternative Requirements for Pneumatic Pressure Testing, Section XI, Division 1</i>	10/2/00
N-537	<i>Location of Ultrasonic Depth-Sizing Flaws, Section XI, Division 1</i>	3/28/01
N-545	<i>Alternative Requirements for Conduct of Performance Demonstration Detection Test of Reactor Vessel, Section XI, Division 1</i>	5/20/98
N-553-1	<i>Inservice Eddy Current Surface Examination of Pressure Retaining Pipe Welds and Nozzle-to-Safe End Welds, Section XI, Division 1</i>	12/98E
N-566-2	<i>Corrective Action for Leakage Identified at Bolted Connections, Section XI, Division 1</i>	12/98E

Code Case Number	Table 1. Acceptable Section XI Code Cases	Date or Supplement/Edition
N-573	<i>Transfer of Procedure Qualification Records Between Owners, Section XI, Division 1</i>	3/12/97
N-588	<i>Attenuation to Reference Flaw Orientation of Appendix G for Circumferential Welds in Reactor Vessels, Section XI, Division 1</i>	3/28/01
N-592	<i>ASNT Central Certification Program, Section XI, Division 1</i>	3/28/01
N-598	<i>Alternative Requirements to Required Percentages of Examinations, Section XI, Division 1</i>	3/28/01
N-600	<i>Transfer of Welder, Welding Operator, Brazier, and Brazing Operator Qualifications Between Owners, Section XI, Division 1</i>	2/01E
N-601	<i>Extent and Frequency of VT-3 Visual Examination for Inservice Inspection of Metal Containments, Section XI, Division 1</i>	3/2/01
N-603	<i>Alternative to the Requirements of IWL-2421, Sites with Two Plants, Section XI, Division 1</i>	3/2/01
N-604	<i>Alternative to Bolt Torque or Tension Test Requirements of Table IWE-2500-1, Category E-G, Item E8.20, Section XI, Division 1</i>	7/30/98
N-605	<i>Alternative to the Requirements of IWE-2500(c) [sic, should state IWE-2500(b)] for Augmented Examination of Surface Areas, Section XI, Division 1</i> (Note: Draft Regulatory Guide DG-1070, "Sampling Plans Used for Dedicating Simple Metallic Commercial Grade Items for Use in Nuclear Power Plants," is being developed to provide acceptable guidelines for sampling criteria.)	3/2/01
N-609	<i>Alternative Requirements to Stress-Based Selection Criteria for Category B-J Welds, Section XI, Division 1</i>	7/30/98
N-613-1	<i>Ultrasonic Examination of Penetration Nozzles in Vessels, Examination Category B-D, Item Nos. B3.10 and B3.90, Reactor Nozzle-to-Vessel Welds, Figs. IWB-2500-7(a), (b), and (c), Section XI, Division 1</i>	6/01E
N-617	<i>Alternative Examination Distribution Requirements for Table IWC-2500-1, Examination Category C-G, Pressure Retaining Welds in Pumps and Valves, Section XI, Division 1</i>	4/19/02
N-623	<i>Deferral of Inspections of Shell-to-Flange and Head-to-Flange Welds of a Reactor Vessel, Section XI, Division 1</i>	4/19/02
N-624	<i>Successive Inspections, Section XI, Division 1</i>	4/19/02
N-629	<i>Use of Fracture Toughness Test Data to Establish Reference Temperature for Pressure Retaining Materials, Section XI, Division 1</i>	8/20/02
N-640	<i>Alternative Reference Fracture Toughness for Development of P-T Limit Curves, Section XI, Division 1</i>	4/19/02

Code Case Number	Table 1. Acceptable Section XI Code Cases	Date or Supplement/Edition
N-641	<i>Alternative Pressure-Temperature Relationship and Low Temperature Overpressure Protection System Requirements, Section XI, Division 1</i>	1/17/00
N-643	<i>Fatigue Crack Growth Rate Curves for Ferritic Steels in PWR Water Environment, Section XI, Division 1</i>	10/2/00
N-649	<i>Alternative Requirements for IWE-5240 Visual Examination, Section XI, Division 1</i>	12/98E
N-651	<i>Ferritic and Dissimilar Metal Welding Using SMAW Temper Bead Technique Without Removing the Weld Bead Crown for the First Layer, Section XI, Division 1</i>	1/01E
N-652	<i>Alternative Requirements to Categorize B-G-1, B-G-2, and C-D Bolting Examination Methods and Selection Criteria, Section XI, Division 1</i>	1/01E
N-658	<i>Qualification Requirements for Ultrasonic Examination of Wrought Austenitic Piping Welds, Section XI, Division 1</i>	4/01E
N-663	<i>Alternative Requirements for Classes 1 and 2 Surface Examinations, Section XI, Division 1</i>	6/01E
N-664	<i>Performance Demonstration Requirements for Examination of Unclad Reactor Pressure Vessel Welds, Excluding Flange Welds, Section XI, Division 1</i>	6/01E
N-695	<i>Qualification Requirements for Dissimilar Metal Piping Welds, Section XI, Division 1</i>	10/01E

2. Conditionally Acceptable Section XI Code Cases

The Code Cases listed in Table 2 are acceptable to the NRC for application in licensees' Section XI inservice inspection programs within the limitations imposed by the NRC staff. Unless otherwise stated, limitations imposed by the NRC are in addition to the conditions specified in the Code Case. A new edition of Section XI is published every 3 years, and the ASME issues Section XI Code Cases quarterly in supplements to a specific edition. Hence, there are 12 supplements to each edition. Column 3 of Table 1 lists the date of ASME approval or the supplement and edition in which each Code Case was published (e.g., 3/01E means Code Case Supplement 3 to the 2001 Edition).

Table 2. Conditionally Acceptable Section XI Code Cases

Code Case Number	Table 2. Conditionally Acceptable Section XI Code Cases	Supplement/Edition
	Condition	
N-498-4	<i>Alternative Requirements for 10-Year System Hydrostatic Testing for Class 1, 2, and 3 Systems, Section XI, Division 1</i>	4/8/02
	Prior to conducting the VT-2 examination of Class 2 and Class 3 components not required to operate during normal plant operation, a 10 minute holding time is required after attaining test pressure. Prior to conducting the VT-2 examination of Class 2 and Class 3 components required to operate during normal plant operation, no holding time is required, provided the system has been in operation for at least 4 hours for insulated components or 10 minutes for non-insulated components.	
N-504-2	<i>Alternative Rules for Repair of Class 1, 2, and 3 Austenitic Stainless Steel Piping, Section XI, Division 1</i>	3/28/00
	The provisions of Section XI, Nonmandatory Appendix Q, "Weld Overlay Repair of Class 1, 2, and 3 Austenitic Stainless Steel Piping Weldments," must also be met. The appendix is available on the ASME Board on Nuclear Codes and Standards web site at: http://cstools.asme.org/csconnect/CommitteePages.cfm?Committee=O10000000	
N-513-1	<i>Evaluation Criteria for Temporary Acceptance of Flaws in Moderate Energy Class 2 or 3 Piping, Section XI, Division 1</i>	12/98E
	(1) Specific safety factors in paragraph 4.0 must be satisfied. (2) Code Case N-513 may not be applied to: (a) Components other than pipe and tube. (b) Leakage through a gasket. (c) Threaded connections employing nonstructural seal welds for leakage prevention (through seal weld leakage is not a structural flaw; thread integrity must be maintained). (d) Degraded socket welds.	
N-516-3	<i>Underwater Welding, Section XI, Division 1</i>	5/01E

Code Case Number	Table 2. Conditionally Acceptable Section XI Code Cases	Supplement/Edition
	Condition	
	Licensees must obtain NRC approval in accordance with 10 CFR 50.55a(a)(3) regarding the technique to be used in the weld repair or replacement of irradiated material underwater.	
N-517-1	<i>Quality Assurance Program Requirements for Owners, Section XI, Division 1</i>	3/28/01
	The Owner's Quality Assurance (QA) Program that is approved under Appendix B to 10 CFR Part 50 must address the use of this Code Case and any unique QA requirements identified by the Code Case that are not contained in the owner's QA Program description. This would include the activities performed in accordance with this Code Case that are subject to monitoring by the Authorized Nuclear Inspector.	
N-528-1	<i>Purchase, Exchange, or Transfer of Material Between Nuclear Plant Sites, Section XI, Division 1</i>	4/19/02
	The requirements of 10 CFR Part 21 are to be applied to the nuclear plant site supplying the material as well as to the nuclear plant site receiving the material that has been purchased, exchanged, or transferred between sites.	
N-532-1	<i>Alternative Requirements to Repair and Replacement Documentation Requirements and Inservice Summary Report Preparation and Submission as Required by IWA-4000 and IWA-6000, Section XI, Division 1</i>	3/28/01
	Code Case N-532-1 requires an Owner's Activity Report Form OAR-1 to be prepared and certified upon completion of each refueling outage. The OAR-1 forms must be submitted to the NRC within 90 days of the completion of the refueling outage.	
N-533-1	<i>Alternative Requirements for VT-2 Visual Examination of Class 1, 2, and 3 Insulated Pressure-Retaining Bolted Connections, Section XI, Division 1</i>	4/8/02
	Prior to conducting the VT-2 examination of Class 2 and Class 3 components not required to operate during normal plant operation, a 10 minute holding time is required after attaining test pressure. Prior to conducting the VT-2 examination of Class 2 and Class 3 components required to operate during normal plant operation, no holding time is required, provided the system has been in operation for at least 4 hours for insulated components or 10 minutes for non-insulated components.	
N-546	<i>Alternative Requirements for Qualification of VT-2 Examination Personnel, Section XI, Division 1</i>	9/18/01
	This Code Case is applicable only to the performance of VT-2 examinations and may not be applied to other VT-2 functions such as verifying the adequacy of procedures and training VT-2 personnel.	

Code Case Number	Table 2. Conditionally Acceptable Section XI Code Cases	Supplement/Edition
	Condition	
N-552	<i>Alternative Methods - Qualification for Nozzle Inside Radius Section from the Outside Surface, Section XI, Division 1</i>	4/19/02
	<p>To achieve consistency with the 10 CFR 50.55a rule change published September 22, 1999 (64 FR 51370), incorporating Appendix VIII, "Performance Demonstration for Ultrasonic Examination Systems," to Section XI, add the following to the specimen requirements:</p> <p>"At least 50 percent of the flaws in the demonstration test set must be cracks and the maximum misorientation must be demonstrated with cracks. Flaws in nozzles with bore diameters equal to or less than 4 inches may be notches."</p> <p>Add to detection criteria, "The number of false calls must not exceed three."</p>	
N-554-2	<i>Alternative Requirements for Reconciliation of Replacement Items and Addition of New Systems, Section XI, Division 1</i>	3/28/00
	The component used for repair/replacement must be manufactured, procured, and controlled as a safety-related component under an NRC-approved Quality Assurance program meeting the requirements of Appendix B to 10 CFR Part 50.	
N-557-1	<i>In-Place Dry Annealing of a PWR Nuclear Reactor Vessel, Section XI, Division 1</i>	8/20/02
	The secondary stress allowable of $3S_m$, shown in Figure 1 of the Code Case, must be applied to the entire primary plus secondary stress range during the anneal.	
N-567-1	<i>Alternative Requirements for Class 1, 2, and 3 Replacement Components, Section XI, Division 1</i>	4/19/02
	The component used for repair/replacement must have been manufactured, procured, and controlled as a safety-related component under an NRC-approved Quality Assurance program meeting the requirements of Appendix B to 10 CFR Part 50.	
N-568	<i>Alternative Examination Requirements for Welded Attachments, Section XI, Division 1</i>	1/17/00
	This Code Case may only be used for examination of the accessible portions of lugs on piping where riser clamps (i.e., clamps on vertical runs of pipe) obstruct access to welded surfaces.	

Code Case Number	Table 2. Conditionally Acceptable Section XI Code Cases	Supplement/Edition
	Condition	
N-569-1	<i>Alternative Rules for Repair by Electrochemical Deposition of Class 1 and 2 Steam Generator Tubing, Section XI, Division 1</i>	4/19/02
	NOTES: Steam generator tube repair methods require prior NRC approval through the Technical Specifications. This Code Case does not address certain aspects of this repair (e.g., the qualification of the inspection and plugging criteria necessary for staff approval of the repair method). In addition, if the user plans to “reconcile,” as described in Footnote 2, the reconciliation is to be performed in accordance with IWA-4200 in the 1995 Edition, 1996 Addenda of ASME Section XI.	
N-576-1	<i>Repair of Class 1 and 2 SB-163, UNS N06600 Steam Generator Tubing, Section XI, Division 1</i>	4/19/02
	NOTES: Steam generator tube repair methods require prior NRC approval through the Technical Specifications. This Code Case does not address certain aspects of this repair (e.g., the qualification of inspection and plugging criteria necessary for staff approval of the repair method). In addition, if the user plans to “reconcile,” as described in the footnote, the reconciliation is to be performed in accordance with IWA-4200 in the 1995 Edition, 1996 Addenda of ASME Section XI.	
N-583	<i>Annual Training Alternative, Section XI, Division 1</i>	10/2/00
	(1) Supplemental practice shall be performed on material or welds that contain cracks, or by analyzing prerecorded data from material or welds that contain cracks. (2) The training must be completed no earlier than 6 months prior to performing ultrasonic examinations at a licensee’s facility.	
N-586	<i>Alternative Additional Examination Requirements for Class 1, 2, and 3 Piping, Components, and Supports, Section XI, Division 1</i>	4/8/02
	The engineering evaluations addressed under Item (a) and the additional examinations addressed under Item (b) shall be performed during this outage. If the additional examinations performed under Item (b) reveal indications exceeding the applicable acceptance criteria of Section XI, the engineering evaluations and the examinations shall be further extended to include additional evaluations and examinations at this outage.	
N-593	<i>Alternative Examination Requirements for Steam Generator Nozzle to Vessel Welds, Section XI, Division 1</i>	12/8/00
	Essentially 100 percent (not less than 90 percent) of the examination volume A-B-C-D-E-F-G-H must be inspected.	

Code Case Number	Table 2. Conditionally Acceptable Section XI Code Cases	Supplement/Edition
	Condition	
N-597-1	<i>Requirements for Analytical Evaluation of Pipe Wall Thinning, Section XI, Division 1</i>	3/28/01
	<p>(1) Code Case must be supplemented by the provisions of EPRI Nuclear Safety Analysis Center Report 202L-R2, April 1999, “Recommendations for an Effective Flow Accelerated Corrosion Program,” for developing the inspection requirements, the method of predicting the rate of wall thickness loss, and the value of the predicted remaining wall thickness. As used in NSAC-202L-R2, the terms “should” and “shall” have the same expectation of being completed.</p> <p>(2) Components affected by flow-accelerated corrosion to which this Code Case are applied must be repaired or replaced in accordance with the construction code of record and Owner’s requirements or a later NRC-approved edition of Section III of the ASME Code prior to the value of t_p reaching the allowable minimum wall thickness, t_{min}, as specified in -3622.1(a)(1) of this Code Case. Alternatively, use of the Code Case is subject to NRC review and approval.</p> <p>(3) For Class 1 piping not meeting the criteria of -3221, the use of evaluation methods and criteria is subject to NRC review and approval.</p> <p>(4) For those components that do not require immediate repair or replacement, the rate of wall thickness loss is to be used to determine a suitable inspection frequency so that repair or replacement occurs prior to reaching allowable minimum wall thickness, t_{min}.</p> <p>(5) For corrosion phenomena other than flow-accelerated corrosion, use of the Code Case is subject to NRC review and approval. Inspection plans and wall thinning rates may be difficult to justify for certain degradation mechanisms such as MIC and pitting.</p>	
N-599	<i>Alternatives to Qualification of Nondestructive Examination Personnel for Inservice Inspection of Metal (Class MC) and Concrete (Class CC) Containments, Section XI, Division 1</i>	9/18/01
	This Code Case may not be used when a licensee updates to the 1992 or later Edition of Section XI that requires the use of ANSI/ASNT CP-189, “Standard for Qualification and Certification of Nondestructive Testing Personnel.”	

Code Case Number	Table 2. Conditionally Acceptable Section XI Code Cases	Supplement/Edition
	Condition	
N-606-1	<i>Similar and Dissimilar Metal Welding Using Ambient Temperature Machine GTAW Temper Bead Technique for BWR CRD Housing/Stub Tube Repairs, Section XI, Division 1</i>	8/20/02
	Prior to welding, an examination or verification must be performed to ensure proper preparation of the base metal, and that the surface is properly contoured so that an acceptable weld can be produced. The surfaces to be welded, and surfaces adjacent to the weld, are to be free from contaminants, such as, rust, moisture, grease, and other foreign material or any other condition that would prevent proper welding and adversely affect the quality or strength of the weld. This verification is to be required in the welding procedures.	
N-616	<i>Alternative Requirements for VT-2 Visual Examination of Classes 1, 2, 3 Insulated Pressure Retaining Bolted Connections, Section XI, Division 1</i>	4/8/02
	<ol style="list-style-type: none"> (1) Insulation must be removed for VT-2 examination during the system pressure test for any 17-4 Precipitation Hardening stainless steel stud or bolt aged at a temperature below 1100EF, or 410 stainless steel stud or bolt aged at a temperature below 1100EF or with hardness above R_c 30. (2) For A-286 stainless steel studs or bolts, the preload must be verified to be below 100 Ksi or the thermal insulation must be removed and the joint visually examined. (3) Prior to conducting the VT-2 examination of Class 2 and Class 3 components not required to operate during normal plant operation, a 10 minute holding time is required after attaining test pressure. Prior to conducting the VT-2 examination of Class 2 and Class 3 components required to operate during normal plant operation, no holding time is required, provided the system has been in operation for at least 4 hours for insulated components or 10 minutes for non-insulated components. 	
N-619	<i>Alternative Requirements for Nozzle Inner Radius Inspections for Class 1 Pressurizer and Steam Generator Nozzles, Section XI, Division 1</i>	4/8/02
	In lieu of a UT examination, licensees may perform a visual examination with enhanced magnification that has a resolution sensitivity to detect a 1-mil width wire or crack, utilizing the allowable flaw length criteria of Table IWB-3512-1 with limiting assumptions on the flaw aspect ratio. The provisions of Table IWB-2500-1, Examination Category B-D, continue to apply except that, in place of examination volumes, the surfaces to be examined are the external surfaces shown in the figures applicable to this table.	

Code Case Number	Table 2. Conditionally Acceptable Section XI Code Cases	Supplement/Edition
	Condition	
N-638-1	<i>Similar and Dissimilar Metal Welding Using Ambient Temperature Machine GTAW Temper Bead Technique, Section XI, Division 1</i>	8-9/01E
	UT examinations shall be demonstrated for the repaired volume using representative samples which contain construction type flaws. The acceptance criteria of NB-5330 of Section III edition and addenda approved in 10 CFR 50.55a apply to all flaws identified within the repaired volume.	
N-639	<i>Alternative Calibration Block Material, Section XI, Division 1</i>	8/20/02
	Chemical ranges of the calibration block may vary from the materials specification if (1) it is within the chemical range of the component specification to be inspected, and (2) the phase and grain shape are maintained in the same ranges produced by the thermal process required by the material specification.	
N-647	<i>Alternative to Augmented Examination Requirements of IWE-2500, Section XI, Division 1</i>	12/8/00
	A VT-1 examination is to be used in lieu of the “detailed visual examination.” (Note: Draft Regulatory Guide DG-1070, “Sampling Plans Used for Dedicating Simple Metallic Commercial Grade Items for Use in Nuclear Power Plants,” is being developed to provide acceptable guidelines for sampling criteria.)	
N-648-1	<i>Alternative Requirements for Inner Radius Examination of Class 1 Reactor Vessel Nozzles, Section XI Division 1</i>	9/18/01
	In place of a UT examination, licensees may perform a visual examination with enhanced magnification that has a resolution sensitivity to detect a 1-mil width wire or crack, utilizing the allowable flaw length criteria of Table IWB-3512-1 with limiting assumptions on the flaw aspect ratio. The provisions of Table IWB-2500-1, Examination Category B-D, continue to apply except that, in place of examination volumes, the surfaces to be examined are the external surfaces shown in the figures applicable to this table.	
N-660	<i>Risk-Informed Safety Classification for Use in Risk-Informed Repair/Replacement Activities, Section XI, Division 1</i>	5/01E
	The Code Case must be applied only to ASME Code Classes 2 and 3, and non-Code Class pressure retaining components and their associated supports.	

Code Case Number	Table 2. Conditionally Acceptable Section XI Code Cases	Supplement/Edition
	Condition	
N-661	<i>Alternative Requirements for Wall Thickness Restoration of Classes 2 and 3 Carbon Steel Piping for Raw Water Service, Section XI, Division 1</i>	5/01E
	(a) If the root cause of the degradation has not been determined, the repair is only acceptable for one cycle. (b) Weld overlay repair of an area can only be performed once in the same location. (c) When through-wall repairs are made by welding on surfaces that are wet or exposed to water, the weld overlay repair is only acceptable until the next refueling outage.	
N-662	<i>Alternative Repair/Replacement Requirements for Items Classified in Accordance with Risk-Informed Processes, Section XI, Division 1</i>	6/01E
	The Code Case must be applied only to ASME Code Classes 2 and 3, and non-Code Class pressure retaining components and their associated supports.	

3. Annulled Unconditionally Approved Section XI Code Cases

The Code Cases listed in Table 3 were previously unconditionally approved by the NRC and have been annulled by the ASME. The third column of the table lists the date that the Code Case was annulled by the ASME, and the Supplement and Edition if the Code Case was annulled in Supplement 12 to the 1998 Edition through Supplement 6 to the 2001 Edition (e.g., 3/01E means Supplement 3 to the 2001 Edition).

Table 3. Annulled Unconditionally Approved Section XI Code Cases

Code Case Number	Table 3. Annulled Unconditionally Approved Section XI Code Cases	Annulment Date; Supplement/Edition
N-34 (1551)	<i>Inservice Inspection of Welds of Nuclear Components, Section XI</i>	11/20/81
N-72 (1646)	<i>Partial Postponement of Category B-C Examination for Class 1 Components, Section XI</i>	1/1/81
N-73 (1647)	<i>Partial Postponement of Category B-D Examination for Class 1 Components, Section XI</i>	1/1/81
N-98 (1705-1)	<i>Ultrasonic Examination - Calibration Block Tolerances, Section XI, Division 1</i>	8/9/96
N-112 (1730)	<i>Acceptance Standards for Class 2 and 3 Components, Section XI, Division 1</i>	7/1/79
N-113-1	<i>Basic Calibration Block for Ultrasonic Examination of Weld 10 in. to 14 in. Thick, Section XI, Division 1</i>	8/9/96
N-167 (1804)	<i>Minimum Section Thickness Requirements for Repair of Nozzles, Section XI, Division 1</i>	1/14/80
N-198-1	<i>Exemption from Examination for ASME Class 1 and 2 Piping Located at Containment Penetrations, Section XI, Division 1</i>	3/28/01; 1/01E
N-211	<i>Recalibration of Ultrasonic Equipment Upon Change of Personnel, Section XI, Division 1</i> (The Code Case was annulled on 3/20/81 and reinstated on 7/13/81. There was no change in the Code Case, and the NRC considers that the Code Case was in effect during the period 3/20/81 through 7/13/81)	4/30/93
N-216	<i>Alternative Rules for Reactor Vessel Closure Stud Examination, Section XI, Division 1</i>	5/7/90
N-234	<i>Time Between Ultrasonic Calibration Checks, Section XI, Division 1</i>	12/3/90
N-235	<i>Ultrasonic Calibration Checks per Section V, Section XI, Division 1</i>	8/9/96
N-236-1	<i>Repair and Replacement of Class MC Vessels, Section XI, Division 1</i>	8/5/97
N-288	<i>Hydrostatic Test Requirements for Class 1 and Class 2 Components, Section XI, Division 1</i>	5/25/83

Code Case Number	Table 3. Annulled Unconditionally Approved Section XI Code Cases	Annulment Date; Supplement/Edition
N-306	<i>Calibration Block Material Selection, Appendix I, 1-3121, Section XI, Division 1</i>	5/7/90
N-308	<i>Documentation of Repairs and Replacements of Components in Nuclear Power Plants, Section XI, Division 1</i>	9/30/90
N-335-1	<i>Rules for Ultrasonic Examination of Similar and Dissimilar Metal Piping Welds, Section XI, Division 1</i>	5/11/97
N-343	<i>Alternative Scope of Examination of Attachment Welds for Examination Categories B-H, B-K-1, and C-C, Section XI, Division 1</i>	12/3/90
N-355	<i>Calibration Block for Angle Beam Ultrasonic Examination of Large Fittings in Accordance with Appendix III-3410, Section XI, Division 1</i>	8/9/96
N-356	<i>Certification Period for Level III NDE Personnel, Section XI, Division 1</i> (July 1, 1988, is the date that the provisions of the Code Case were acceptable to the NRC)	8/5/97
N-375-2	<i>Rules for Ultrasonic Examination of Bolts and Studs, Section XI, Division 1</i>	5/7/90
N-389-1	<i>Alternative Rules for Repairs, Replacements, or Modifications, Section XI, Division 1</i>	4/19/02; 4/01E
N-401-1	<i>Eddy Current Examination, Section XI, Division 1</i>	5/11/97
N-402-1	<i>Eddy Current Calibration Standards, Section XI, Division 1</i>	5/11/97
N-406	<i>Alternative Rules for Replacement, Section XI, Division 1</i>	5/7/90
N-408-3	<i>Alternative Rules for Examination of Class 2 Piping, Section XI, Division 1</i>	4/19/02; 4/01E
N-409-3	<i>Procedure and Personnel Qualification Requirements for Ultrasonic Detection and Sizing of Flaws in Piping Welds, Section XI, Division 1</i>	4/30/96
N-415	<i>Alternative Rules for Testing Pressure Relief, Section XI, Division 1</i>	8/14/94
N-419	<i>Extent of VT-1 Examinations, Category B-G-1 of Table IWB-2500-1, Section XI, Division 1</i>	5/13/94
N-424	<i>Qualification of Visual Examination Personnel, Section XI, Division 1</i>	7/18/88
N-426	<i>Extent of VT-1 Examinations, Category B-G-2 of Table IWB-2500-1, Section XI, Division 1</i>	5/13/94
N-427	<i>Code Cases in Inspection Plans, Section XI, Division 1</i>	12/16/94

Code Case Number	Table 3. Annulled Unconditionally Approved Section XI Code Cases	Annulment Date; Supplement/Edition
N-429-2	<i>Alternative Rules for Ultrasonic Instrument Calibration, Section XI, Division 1</i>	7/27/95
N-436-1	<i>Alternative Methods for Evaluation of Flaws in Austenitic Piping, Section XI, Division 1</i>	12/3/90
N-437	<i>Use of Digital Readout and Digital Measurement Devices for Performing Pressure Tests, Section XI, Division 1</i>	7/27/95
N-444	<i>Preparation of Inspection Plans, Section XI, Division 1</i> (Valve stroke times may be documented outside of the IST program. However, if included within the IST program and it becomes necessary to revise the maximum stroke time required by “Supplement 4—Content of IWV Valve Test Tables,” it is not necessary to submit a revised IST program to the NRC solely to document a revision in valve stroke time)	12/30/90
N-445	<i>Use of Later Editions of SNT-TC-1A for Qualification of Nondestructive Examination Personnel, Section XI, Division 1, 2, and 3</i>	5/7/90
N-446	<i>Recertification of Visual Examination Personnel, Section XI, Division 1</i>	5/7/90
N-448	<i>Qualification of VT-2 and VT-3 Visual Examination Personnel, Section XI, Division 1</i>	4/30/96
N-449	<i>Qualification of VT-4 Visual Examination Personnel, Section XI, Division 1</i>	4/30/96
N-457	<i>Qualification Specimen Notch Location for Ultrasonic Examination of Bolts and Studs, Section XI, Division 1</i>	4/19/02; 4/01E
N-458-1	<i>Magnetic Particle Examination of Coated Materials, Section XI, Division 1</i>	3/38/01; 12/98E
N-461-1	<i>Alternative Rules for Piping Calibration Block Thickness, Section XI, Division 1</i>	3/28/01; 12/98E
N-463-1	<i>Evaluation Procedures and Acceptance Criteria for Flaws in Class 1 Ferritic Piping That Exceed the Acceptance Standards of IWB-3514.2, Section XI, Division 1</i>	3/28/01 12/98E
N-465	<i>Alternative Rules for Pump Testing, Section XI, Division 1</i>	8/14/94
N-472	<i>Use of Digital Readout and Digital Measurement Devices for Performing Pump Vibration Testing, Section XI, Division 1</i>	8/14/97
N-473	<i>Alternative Rules for Valve Testing, Section XI, Division 1</i>	12/16/94
N-478	<i>Inservice Inspection for Class CC Concrete Components of Light-Water Cooled Power Plants, Section XI, Division 1</i>	3/2/98
N-479-1	<i>Boiling Water Reactor (BWR) Main Steam Hydrostatic Test, Section XI, Division 1</i>	4/19/02; 4/01E

Code Case Number	Table 3. Annulled Unconditionally Approved Section XI Code Cases	Annulment Date; Supplement/Edition
N-489	<i>Alternative Rules for Level III NDE Qualification Examinations, Section XI, Divisions 1, 2, and 3</i>	4/19/02; 4/01E
N-495	<i>Hydrostatic Testing of Relief Valves, Section XI, Division 1</i>	4/19/02; 4/01E
N-496-1	<i>Helical-Coil Threaded Inserts, Section XI, Division 1</i>	5/11/97
N-514	<i>Low Temperature Overpressure Protection, Section XI, Division 1</i>	4/19/02; 4/01E
N-515	<i>Class 1 Mechanical Joint Pressure Tests, Section XI, Division 1</i>	4/19/02; 4/01E
N-521	<i>Alternative Rules for Deferral of Inspections of Nozzle-to-Vessel Welds, Inside Radius Sections, and Nozzle-to-Safe End Welds of a Pressurized Water Reactor (PWR) Vessel, Section XI, Division 1</i>	4/19/02; 4/01E
N-524	<i>Alternative Examination Requirements for Longitudinal Welds in Class 1 and 2 Piping, Section XI, Division 1</i>	4/19/02; 4/01E
N-535	<i>Alternative Requirements for Inservice Inspection Intervals, Section XI, Division 1</i>	3/28/01; 12/98E
N-538	<i>Alternative Requirements for Length Sizing Performance Demonstration in Accordance with Appendix VIII, Supplements 2, 3, 10, 11, and 12, Section XI, Division 1</i>	4/19/02; 4/01E
N-541	<i>Alternative Requirements for Performance Demonstration in Accordance with Appendix VIII, Supplements 4 and 6, Section XI, Division 1</i>	3/28/01; 12/98E
N-543	<i>Alternative to Performing Periodic Calibration Checks, Section XI, Division 1</i>	9/18/01; 2/01E
N-544	<i>Repair/Replacement of Small Items, Section XI, Division 1</i>	3/28/01
N-555	<i>Use of Section II, V, and IX Code Cases, Section XI, Division 1</i>	4/8/02; 5/05E
N-556	<i>Alternative Requirements for Verification of Acceptability of Replacements, Section XI, Division 1</i>	4/19/02; 4/01E
N-563	<i>Grading of Examinations, IWA-2320, Section XI, Division 1</i>	4/19/02; 4/01E
N-627	<i>VT-1 Visual Examination in Lieu of Surface Examination for RPV Closure Nuts, Section XI, Division 1</i>	5/7/02; 4/01E

4. Annulled Conditionally Acceptable Section XI Code Cases

The Code Cases listed in Table 4 were conditionally approved by the NRC but were subsequently annulled by the ASME. The third column of the table lists the date that the Code Case was annulled by the ASME, and the Supplement and Edition if the Code Case was annulled in Supplement 12 to the 1998 Edition through Supplement 6 to the 2001 Edition (e.g., 3/01E means Supplement 3 to the 2001 Edition).

Table 4. Annulled Conditionally Acceptable Section XI Code Cases

Code Case Number	Table 4. Annulled Conditionally Acceptable Section XI Code Cases	Annulment Date; Supplement/ Edition
N-118 (1738)	<i>Examination—Acceptance Standards for Surface Indications in Cladding, Section XI</i>	12/3/90
	The last sentence of the “Reply” is to be replaced with the following: “The provisions of this Code Case may not be applied for the examination of clad surfaces of nozzles, including the inner surface of the nozzle-to-vessel insert welds.”	
N-210	<i>Exemption to Hydrostatic Tests After Repairs, Section XI, Division 1</i>	3/20/81
	Paragraph (3) of the “Reply” is to be replaced with the following: “Repairs to piping, pumps, and valves where the depth of the repaired cavity does not exceed 25 percent of the wall thickness.”	
N-252	<i>Low Energy Capacitive Discharge Welding Method for Temporary or Permanent Attachments to Components and Supports, Section III, Division 1, and Section XI</i>	7/16/82
	The applicant should indicate in the Safety Analysis Report the application, the material, and the thickness of the material to which the strain gage or thermocouple will be attached by CD welding.	
N-278	<i>Alternative Ultrasonic Calibration Block Configuration I-3131 and T-434.3, Section XI, Division 1</i> (Code Case N-278 was inadvertently allowed to expire because of an ASME administrative error on 3/17/83. The Code Case was reinstated without technical change on 5/25/93. Thus, the NRC considered the Code Case to be in effect during the period 3/17/83 through 5/25/93.)	2/19/92
	When a universal calibration block is used and some or all of the reference holes are larger than the reflector holes at comparable depths recommended by Article IV, Section V, 1980 Edition of the ASME Code, a correction factor should be used to adjust the DAC level to compensate for the larger reflector holes. Also, if the reactor pressure vessel was previously examined by using a conventional block, a ratio between the DAC curves obtained from the two blocks should be noted (for reference) with the significant indication data.	

Code Case Number	Table 4. Annulled Conditionally Acceptable Section XI Code Cases	Annulment Date; Supplement/ Edition
N-509	<i>Alternative Rules for the Selection and Examination of Class 1, 2, and 3 Integrally Welded Attachments, Section XI, Division 1</i>	5/20/01; 1/01E
	A minimum 10% sample of integrally welded attachments for each item in each Code class per interval should be examined.	
N-512-1	<i>Assessment of Reactor Vessels With Low Upper Shelf Charpy Impact Energy Levels, Section XI, Division 1</i>	5/20/01; 1/01E
	The material properties and transient selection must follow the guidance in Regulatory Guide 1.161, "Evaluation of Reactor Pressure Vessels with Charpy Upper-Shelf Energy Less Than 50 ft-lb," or an equivalent method approved by the NRC staff.	
N-630	<i>Alternatives to VT-1C and VT-3C Visual Examination for Inservice Inspection of Concrete and VT-1 Visual Examination for Inservice Inspection of Anchorage Hardware and Surrounding Concrete for Concrete Containments, Section XI, Division 1</i>	4/8/02 5/01E
	The Responsible Engineer's written practice must define qualification requirements for concrete and tendon hardware examination personnel in accordance with IWA-2300 in lieu of the Owner defined qualification requirements specified in Paragraph (c) of the Code Case. However, limited certification in accordance with IWA-2350 is permitted.	

5. Code Cases That Have Been Superseded

Table 5 lists Code Cases that have been superseded by revision. The third column of the table indicates the date on which each Code Case was superseded. Note: Some of these Code Cases were not approved for use by the NRC in previous versions of Regulatory Guide 1.147.

Table 5. Section XI Code Cases That Have Been Superseded

Code Case Number	Table 5. Section XI Code Cases That Have Been Superseded	Date
N-113 (1731)	<i>Basic Calibration Block for Ultrasonic Examination of Weld 10 in. To 14 in. Thick, Section XI, Division 1</i>	N-113-1 Published on 12/31/82
N-236	<p><i>Repair and Replacement of Class MC Vessels, Section XI, Division 1</i></p> <p>(a) In paragraph 1.0(a), second sentence, the phrase, “while the plant is not in service,” refers to a refueling outage.</p> <p>(b) In paragraph 1.0(a), third sentence, the phrase, “the next scheduled plant outage,” refers to the next schedule refueling outage.</p> <p>For clarification, “Repair and Replacement of Class MC Vessels” means Repair and Replacement of Class MC Vessels and Components (systems). Acceptance of this Code Case in no way provides/constitutes NRC approval to violate the technical specification or any NRC requirements with regard to breach of containment during repair and replacement procedures while the plant is in operation.</p> <p>Where a numbered Code paragraph is not identified by a particular edition of the Code, the Code in effect at the time of the ASME meeting (11/3/78) that approved the Code Case should be governing.</p>	N-236-1 Published on 9/5/85
N-307 N-307-1 N-307-2	<i>Revised Ultrasonic Examination Volume for Class 1 Bolting, Table IWB-2500-1, Examination Category B-G-1, When the Examinations Are Conducted from the Center-Drilled Hole, Section XI, Division 1</i>	N-307-1 Published on 12/5/84 N-307-2 Published on 9/24/99 N-307-3 Published on 3/28/01
N-335	<i>Rules for Ultrasonic Examination of Similar and Dissimilar Metal Piping Welds, Section XI, Division 1</i>	N-335-1 Published on 6/20/85
N-375 N-375-1	<i>Rules for Ultrasonic Examination of Bolts and Studs, Section XI, Division 1</i>	N-375-1 Published on 4/14/83; N-375-2 Published on 4/5/84

Code Case Number	Table 5. Section XI Code Cases That Have Been Superseded	Date
N-389	<i>Alternative Rules for Repairs, Replacements, or Modifications, Section XI, Division 1</i>	N-389-1 Published on 12/9/93
	The applicant should submit for approval the appropriate edition and addenda of the Code that is to be used for the repair, replacement, or modification before the start of the work.	
N-401	<i>Eddy Current Examination, Section XI, Division 1</i>	N-401-1 Published on 5/4/88
N-402	<i>Eddy Current Calibration Standards, Section XI, Division 1</i>	N-402-1 Published on 3/14/91
N-408	<i>Alternative Rules for Examination of Class 2 Piping, Section XI, Division 1</i>	N-408-1 Published on 3/8/89
N-408-1 N-408-2	<i>Alternative Rules for Examination of Class 2 Piping, Section XI, Division 1</i>	N-408-2 Published on 7/24/89
	The applicant for an operating license should define the Class 2 piping subject to volumetric and surface examination in the preservice inspection for determination of acceptability by the NRC staff.	N-408-3 Published on 8/9/93
N-409	<i>Procedure and Personnel Qualification Requirements for Ultrasonic Detection and Sizing of Flaws in Piping Welds, Section XI, Division 1</i>	N-409-1 Published on 12/7/87
N-409-1 N-409-2	<i>Procedure and Personnel Qualification Requirements for Ultrasonic Detection and Sizing of Flaws in Piping Welds, Section XI, Division 1</i>	N-409-2 Published on 7/27/88;
	The applicant should give prior notification to the NRC of the intention to use the Code Case.	N-409-3 Published on 4/30/93
N-416 N-416-1 N-416-2	<i>Alternative Pressure Test Requirements for Welded Repairs or Installation of Replacement Items by Welding, Class 1, 2, and 3, Section XI, Division 1</i>	N-416-1 Published on 2/15/94 N-416-2 Published on 5/5/00 N-416-3 Published on 7/7/01
N-429 N-429-1	<i>Alternative Rules for Ultrasonic Instrument Calibration, Section XI, Division 1</i>	N-429-1 Published on 2/23/87; N-429-2 Published on 7/27/92
N-432	<i>Repair Welding Using Automatic or Machine Gas Tungsten-Arc Welding (GTAW) Temper Bead Technique, Section XI, Division 1</i>	N-432-1 Published on 3/28/01
N-435	<i>Alternative Examination Requirements for Vessels With Wall Thickness 2 in. Or Less, Section XI, Division 1</i>	N-435-1 Published on 7/30/86

Code Case Number	Table 5. Section XI Code Cases That Have Been Superseded	Date
N-436	<i>Alternative Methods for Evaluation of Flaws in Austenitic Piping, Section XI, Division 1</i>	N-436-1 Published on 12/7/87
N-458	<i>Magnetic Particle Examination of Coated Materials, Section XI, Division 1</i>	N-458-1 Published on 3/14/95
N-461	<i>Alternative Rules for Piping Calibration Block Thickness, Section XI, Division 1</i>	N-461-1 Published on 3/14/95
N-463	<i>Evaluation Procedures and Acceptance Criteria for Flaws in Class 1 Ferritic Piping That Exceed the Acceptance Standards of IWB-3514.2, Section XI, Division 1</i>	N-463-1 Published on 3/5/90
N-479	<i>Boiling Water Reactor (BWR) Main Steam Hydrostatic Test, Section XI, Division 1</i>	N-479-1 Published on 12/3/90
N-485	<i>Eddy Current Examination of Coated Ferritic Surfaces as an Alternative to Surface Examination, Section XI, Division 1</i>	N-485 Published on 8/14/91
N-490	<i>Alternative Vision Test Requirements for Nondestructive Examiners, Section XI, Divisions 1, 2, and 3</i>	N-490-1 Published on 5/13/91
N-491 N-491-1	<i>Alternative Rules for Examination of Class 1, 2, 3, and MC Component Supports of Light-Water Cooled Power Plants, Section XI, Division 1</i>	N-491-1 Published on 4/30/93; N-491-2 Published on 3/12/97
N-494 N-494-1 N-494-2	<i>Pipe Specific Evaluation Procedures and Acceptance Criteria for Flaws in Class 1 Ferritic Piping that Exceed the Acceptance Standards of IWB-3514.2, Section XI, Division 1</i>	N-494-1 Published on 7/27/92; N-494-2 Published on 12/9/93 N-494-3 Published on 8/9/96
N-496 N-496-1	<i>Helical-Coil Threaded Inserts, Section XI, Division 1</i>	N-496-1 Published on 5/11/94; N-496-1 Annulled on 5/11/97 N-496-2 Published on 9/18/01
N-498 N-498-1 N-498-2 N-498-3	<i>Alternative Rules for 10-Year System Hydrostatic Testing for Class 1, 2, and 3 Systems, Section XI, Division 1</i>	N-498-1 Published on 5/11/94 N-498-2 Published on 6/9/95 N-498-3 Published on 5/20/98 N-498-4 Published on 2/15/99
N-504 N-504-1	<i>Alternative Rules for Repair of Class 1, 2, and 3 Austenitic Stainless Steel Piping, Section XI, Division 1</i>	N-504-1 Published on 8/9/93 N-504-2 Published on 3/12/97

Code Case Number	Table 5. Section XI Code Cases That Have Been Superseded	Date
N-508 N-508-1	<i>Rotation of Serviced Snubbers and Pressure Relief Valves for the Purpose of Testing, Section XI, Division 1</i>	N-508-1 Published on 5/11/94 N-508-2 Published on 3/28/01
N-512	<i>Assessment of Reactor Vessels With Low Upper Shelf Charpy Impact Energy Levels, Section XI, Division 1</i>	N-512-1 Published on 8/24/95
N-513	<i>Evaluation Criteria for Temporary Acceptance of Flaws in Class 3 Piping, Section XI, Division 1</i>	N-513-1 Published on 3/28/01
N-516 N-516-1	<i>Underwater Welding, Section XI, Division 1</i> When welding is to be performed on high neutron fluence Class 1 material, then a mockup, using material with similar fluence levels, should be welded to verify that adequate crack prevention measures were used.	N-516-1 Published on 12/31/96; N-516-2 Published on 1/17/00
N-516-2	<i>Underwater Welding, Section XI, Division 1</i> Licensees must obtain NRC approval in accordance with 10 CFR 50.55a(a)(3) regarding the method to be used in the weld repair or replacement of irradiated material underwater.	N-516-3 Published on 4/8/02
N-517	<i>Quality Assurance Program Requirements for Owners, Section XI, Division 1</i>	N-517-1 Published on 7/30/98
N-523 N-523-1	<i>Mechanical Clamping Devices for Class 2 and 3 Piping, Section XI, Division 1</i>	N-523-1 Published on 8/24/95 N-523-2 Published on 10/2/00
N-528	<i>Purchase, Exchange, or Transfer of Material Between Nuclear Plant Sites, Section XI, Division 1</i>	N-528-1 Published on 5/7/99
N-532	<i>Alternative Requirements to Repair and Replacement Documentation Requirements and Inservice Summary Report Preparation and Submission as Required by IWA-4000 and IWA-6000, Section XI, Division 1</i>	N-532-1 Published on 3/28/01
N-533	<i>Alternative Requirements for VT-2 Visual Examination of Class 1 Insulated Pressure-Retaining Bolted Connections, Section XI, Division 1</i>	N-533-1 Published 2/26/99
N-553	<i>Inservice Eddy Current Surface Examination of Pressure Retaining Pipe Welds and Nozzle-to-Safe End Welds, Section XI, Division 1</i>	N-553-1 Published on 3/28/01
N-554 N-554-1	<i>Alternative Requirements for Reconciliation of Replacement Items, Section XI, Division 1</i>	N-554-1 Published on 7/98E; N-554-2 Published on 2/25/00

Code Case Number	Table 5. Section XI Code Cases That Have Been Superseded	Date
N-557	<i>In-Place Dry Annealing of a PWR Nuclear Reactor Vessel, Section XI, Division 1</i>	N-557-1 Published on 12/31/96
N-560 N-560-1	<i>Alternative Examination Requirements for Class 1, Category B-J Piping Welds, Section XI, Division 1</i>	N-560-1 Published on 8/9/96; N-560-2 Published on 3/28/00
N-561	<i>Alternative Requirements for Wall Thickness Restoration of Class 2 and High Energy Class 3 Carbon Steel Piping, Section XI, Division 1</i>	N-561-1 Published on 7/30/98
N-562	<i>Alternative Requirements for Wall Thickness Restoration of Class 3 Moderate Energy Carbon Steel Piping, Section XI, Division 1</i>	N-562-1 Published on 7/30/98
N-566 N-566-1	<i>Corrective Action for Leakage Identified at Bolted Connections, Section XI, Division 1</i>	N-566-1 Published on 2/15/99 N-566-2 Published on 3/28/01
N-567	<i>Alternative Requirements for Class 1, 2, and 3 Replacement Components, Section XI, Division 1</i>	N-567-1 Published on 2/26/99
N-569	<i>Alternative Rules for Repair by Electrochemical Deposition of Class 1 and 2 Steam Generator Tubing, Section XI, Division 1</i>	N-569-1 Published on 5/7/99
N-576	<i>Repair of Class 1 and 2 SB-163, UNS N06600 Steam Generator Tubing, Section XI, Division 1</i>	N-576-1 Published on 5/7/99
N-577	<i>Risk-Informed Requirements for Class 1, 2, and 3 Piping, Method A, Section XI, Division 1</i>	N-577-1 Published on 3/28/00
N-578	<i>Risk-Informed Requirements for Class 1, 2, and 3 Piping, Method B, Section XI, Division 1</i>	N-578-1 Published on 3/28/00
N-597	<i>Requirements for Analytical Evaluation of Pipe Wall Thinning, Section XI, Division 1</i>	N-597-1 Published on 7/7/01
N-606	<i>Similar and Dissimilar Metal Welding Using Ambient Temperature Machine GTAW Temper Bead Technique, Section XI, Division 1</i>	N-606-1 Published on 9/24/99
N-638	<i>Similar and Dissimilar Metal Welding Using Ambient Temperature Machine GTAW Temper Bead Technique, Section XI, Division 1</i>	N-638-1 Published on 5/9/03
	The Construction Code of Record acceptance criteria must be used for volumetric examinations.	
N-648	<i>Alternative Requirements for Inner Radius Examination of Class 1 Reactor Vessel Nozzles, Section XI, Division 1</i>	N-648-1 Published on 7/7/01

D. IMPLEMENTATION

The purpose of this section is to provide information to applicants and licensees regarding the NRC staff's plans for using this guide. No backfitting is intended or approved in connection with the issuance of this guide.

Except when an applicant or licensee proposes or has previously established an acceptable alternative method for complying with specified portions of the NRC's regulations, the methods described in this guide will be used in evaluating (1) submittals in connection with applications for construction permits, design certifications, operating licenses, and combined licenses, and (2) submittals from operating reactor licensees who voluntarily propose to initiate system modifications that have a clear nexus with this guidance.

E. REGULATORY ANALYSIS

A separate regulatory analysis was not prepared for this regulatory guide. The regulatory basis for this guide is the regulatory analysis prepared for the amendment to 10 CFR 50.55a, "Codes and Standards," that incorporates by reference this regulatory guide.

A copy of the regulatory analysis for the amendment to 10 CFR 50.55a is available for inspection and copying for a fee at the NRC's Public Document Room (PDR), which is located at 11555 Rockville Pike, Rockville, Maryland; the PDR's mailing address is USNRC PDR, Washington, DC 20555-0001. The PDR can also be reached by telephone at (301) 415-4737 or (800) 397-4205, by fax at (301) 415-3548, and by email to PDR@nrc.gov. In addition, the regulatory analysis is available electronically through the NRC's Agencywide Documents Access and Management System (ADAMS) at <http://www.nrc.gov/reading-rm/adams.html>, under Accession No. ML043640544.

APPENDIX A

SUPPLEMENTS ADDRESSED IN PROPOSED REVISION 14 TO REGULATORY GUIDE 1.147

Edition	Supplement Number	BNCS¹ Approval Date of Code Cases in Supplement²
1998	12	March 28, 2001
2001	1	August 14, 2001
2001	2	September 18, 2001
2001	3	September 18, 2001
2001	4	April 19, 2002
2001	5	July 23, 2002
2001	6	September 17, 2002
¹ BNCS = ASME Board on Nuclear Codes and Standards		
² Publication in supplement was between 5 and 8 months after BNCS approval.		

APPENDIX B

NUMERICAL LISTING OF SECTION XI CODE CASES IN SUPPLEMENT 12, 1998 EDITION, THROUGH SUPPLEMENT 6, 2001 EDITION

N-198-1	N-532-1	N-598
N-307-3	N-532-2 ¹	N-599
N-323-1	N-533-1	N-600
N-389-1	N-535	N-601
N-408-3	N-537	N-603
N-416-3	N-538	N-605
N-432-1	N-541	N-606-1
N-435-1	N-542 ¹	N-613-1
N-457	N-543	N-615 ¹
N-458-1	N-544	N-616
N-461-1	N-546	N-617
N-463-1	N-547 ¹	N-619
N-471	N-552	N-622 ¹
N-479-1	N-553-1	N-623
N-480 ¹	N-555	N-624
N-489	N-556	N-627
N-494-3	N-557-1	N-629
N-495	N-561-1	N-630
N-496-2	N-562-1	N-638
N-498-4	N-563	N-639
N-508-2	N-566-2	N-640
N-509	N-567-1	N-648-1
N-512-1	N-569-1	N-649
N-513-1	N-576-1	N-651
N-514	N-586	N-652
N-515	N-588	N-653 ¹
N-516-3	N-589 ¹	N-654
N-517-1	N-589-1 ¹	N-658
N-521	N-590	N-660
N-522	N-591	N-661
N-523-2	N-592	N-662
N-524	N-597	N-663
N-526	N-597-1	N-664
N-528-1		

¹ Code case is unacceptable for use. See Revision 1 to Regulatory Guide 1.193.

APPENDIX C

NUMERICAL LISTING OF SECTION XI CODE CASES AND TABLE WHERE EACH CODE CASE IS LISTED

N-34 [T3]	N-389 [T5]	N-449 [T3]	N-498-2 ¹ [T5]
N-72 [T3]	N-389-1 [T3]	N-457 [T3]	N-498-3 ¹ [T5]
N-73 [T3]	N-401 [T5]	N-458 [T5]	N-498-4 [T2]
N-98 [T3]	N-401-1 [T3]	N-458-1 [T3]	N-503 [T1]
N-112 [T3]	N-402 [T5]	N-460 [T1]	N-504 [T5]
N-113 [T5]	N-402-1 [T3]	N-461 [T5]	N-504-1 [T5]
N-113-1 [T3]	N-406 [T3]	N-461-1 [T3]	N-504-2 [T2]
N-118 [T4]	N-408 [T5]	N-463 [T5]	N-508 [T5]
N-167 [T3]	N-408-1 [T5]	N-463-1 [T3]	N-508-1 [T5]
N-198-1 [T3]	N-408-2 [T5]	N-465 ¹ [T3]	N-508-2 [T1]
N-210 [T4]	N-408-3 [T3]	N-465-1 ¹	N-509 [T4]
N-211 [T3]	N-409 [T5]	N-471 [T1]	N-512 [T5]
N-216 [T3]	N-409-1 [T5]	N-472 [T3]	N-512-1 [T4]
N-234 [T3]	N-409-2 [T5]	N-473 ¹ [T3]	N-513 [T5]
N-235 [T3]	N-409-3 [T3]	N-473-1 ¹	N-513-1 [T2]
N-236 [T5]	N-415 [T3]	N-478 [T3]	N-514 [T3]
N-236-1 [T3]	N-416 [T5]	N-479 [T5]	N-515 [T3]
N-252 [T4]	N-416-1 [T5]	N-479-1 [T3]	N-516 [T5]
N-278 [T4]	N-416-2 [T5]	N-480 ¹	N-516-1 [T5]
N-288 [T3]	N-416-3 [T1]	N-481 [T1]	N-516-2 [T5]
N-306 [T3]	N-419 [T3]	N-485 [T5]	N-516-3 [T2]
N-307 [T5]	N-424 [T3]	N-485-1 [T1]	N-517 [T5]
N-307-1 [T5]	N-426 [T3]	N-489 [T3]	N-517-1 [T2]
N-307-2 [T5]	N-427 [T3]	N-490 [T5]	N-521 [T3]
N-307-3 [T1]	N-429 [T5]	N-490-1 [T1]	N-522 [T1]
N-308 [T3]	N-429-1 [T5]	N-491 [T5]	N-523 [T5]
N-311 [T1]	N-429-2 [T3]	N-491-1 [T5]	N-523-1 [T5]
N-322 [T1]	N-432 [T5]	N-491-2 [T1]	N-523-2 [T1]
N-323-1 [T1]	N-432-1 [T1]	N-494 [T5]	N-524 [T3]
N-334 [T1]	N-435 [T5]	N-494-1 [T5]	N-526 [T1]
N-335 [T5]	N-435-1 [T1]	N-494-2 [T5]	N-528 [T5]
N-335-1 [T3]	N-436 [T5]	N-494-3 [T1]	N-528-1 [T2]
N-343 [T3]	N-436-1 [T3]	N-495 [T3]	N-532 [T5]
N-355 [T3]	N-437 [T3]	N-496 [T5]	N-532-1 [T2]
N-356 [T3]	N-444 [T3]	N-496-1 [T3] [T5]	N-532-2 ¹
N-375 [T5]	N-445 [T3]	N-496-2 [T1]	N-533 [T5]
N-375-1 [T5]	N-446 [T3]	N-498 [T5]	N-533-1 [T2]
N-375-2 [T3]	N-448 [T3]	N-498-1 ¹ [T5]	N-534 [T1]

¹ Code case is unacceptable for use. See Revision 1 to Regulatory Guide 1.193.

² Code case approved February 13, 2003, published in Supplements 8 and 9, 2001 Edition.

³ Code case approved May 21, 2003, published in Supplement 11, 2001 Edition.

N-535 [T3]	N-583 [T2]	N-652 [T1]
N-537 [T1]	N-586 [T1]	N-653 ¹
N-538 [T3]	N-587 ¹	N-654 ¹
N-541 [T3]	N-588 [T1]	N-658 [T1]
N-542 ¹	N-589 ¹	N-660 [T2]
N-543 [T3]	N-589-1 ¹	N-661 [T2]
N-544 [T3]	N-590 ¹	N-662 [T2]
N-545 [T1]	N-591 ¹	N-663 [T1]
N-546 [T2]	N-592 [T1]	N-664 [T1]
N-547 ¹	N-593 [T2]	N-695 ³ [T1]
N-552 [T2]	N-597 [T5]	
N-553 [T5]	N-597-1 [T2]	
N-553-1 [T1]	N-598 [T1]	
N-554 [T5]	N-599 [T2]	
N-554-1 [T5]	N-600 [T1]	
N-554-2 [T2]	N-601 [T1]	
N-555 [T3]	N-603 [T1]	
N-556 [T3]	N-604 [T1]	
N-557 [T5]	N-605 [T1]	
N-557-1 [T2]	N-606 [T5]	
N-560 [T5]	N-606-1 [T2]	
N-560-1 ¹ [T5]	N-609 [T1]	
N-560-2 ¹	N-613 ¹	
N-561 ¹ [T5]	N-613-1 [T1]	
N-561-1 ¹	N-615 ¹	
N-562 ¹ [T5]	N-616 [T2]	
N-562-1 ¹	N-617 [T1]	
N-563 [T3]	N-619 [T2]	
N-566 [T5]	N-622 ¹	
N-566-1 [T5]	N-623 [T1]	
N-566-2 [T1]	N-624 [T1]	
N-567 [T5]	N-627 [T3]	
N-567-1 [T2]	N-629 [T1]	
N-568 [T2]	N-630 [T4]	
N-569 [T5]	N-638 [T5]	
N-569-1 [T2]	N-638-1 [T2] ²	
N-573 [T1]	N-639 [T2]	
N-574 ¹	N-640 [T1]	
N-575 ¹	N-641 [T1]	
N-576 [T5]	N-643 [T1]	
N-576-1 [T2]	N-647 [T2]	
N-577 ¹ [T5]	N-648 [T5]	
N-577-1 ¹	N-648-1 [T2]	
N-578 ¹ [T5]	N-649 [T1]	
N-578-1 ¹	N-651 [T1]	

¹ Code case is unacceptable for use. See Revision 1 to Regulatory Guide 1.193.

² Code case approved February 13, 2003, published in Supplements 8 and 9, 2001 Edition.

³ Code case approved May 21, 2003, published in Supplement 11, 2001 Edition.