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September 8, 2005

U.S. Nuclear Regulatory Commission
Attention: Document Control Desk
Washington, D.C. 20555

Subject: Duke Energy Corporation
Catawba Nuclear Station, Unit 1
Docket Number 50-413
Request for Relief Number 05-CN-004
Limited Weld Examinations During End-of-Cycle 15
Refueling Outage

Pursuant to 10 CFR 50.55a(g)(5)(iii), please find attached Request for Relief 05-CN-004. This request for relief is associated with limited weld examination coverage during the subject outage.

The attachment to this letter contains all technical information necessary in support of this request for relief. Duke Energy Corporation is requesting NRC review and approval of this request at your earliest opportunity.

There are no regulatory commitments contained in this letter or its attachment.

If you have any questions concerning this material, please call L.J. Rudy at (803) 831-3084.

Very truly yours,

Bill Putesa for

D.M. Jamil

LJR/s

Attachment

A047



Document Control Desk
Page 2
September 8, 2005

xc (with attachment):

W.D. Travers, Regional Administrator
U.S. Nuclear Regulatory Commission, Region II
Atlanta Federal Center
61 Forsyth St., SW, Suite 23T85
Atlanta, GA 30303

E.F. Guthrie, Senior Resident Inspector
U.S. Nuclear Regulatory Commission
Catawba Nuclear Station

S.E. Peters, Project Manager (addressee only)
U.S. Nuclear Regulatory Commission
Mail Stop O-8 G9
Washington, D.C. 20555-0001

Proposed Relief in Accordance with 10 CFR50.55a(g)(5)(iii)
Inservice Inspection Impracticality

Duke Energy Corporation
Catawba Nuclear Station – Unit 1 (EOC-15)
Second 10-Year Interval – Inservice Inspection Plan
Interval Start Date - June 29, 1995 Interval End Date - June 29, 2005
ASME Section XI Code – 1989 Edition with No Addenda

Request Number	I. Limited Weld I.D. Number	II. System / Component for Which Relief is Requested: Area or Weld to be Examined	III. Code Requirement from Which Relief is Requested: 100% Exam Volume Coverage Exam Category Item No. Fig. No. Limitation Percentage	IV. & V. Impracticality/ Burden Caused by Code Compliance	VI. Proposed Alternate Examinations or Testing	VII. Implementation Schedule and Duration	VIII. Justification for Granting Relief
1	IRPV-W03	Reactor Vessel Shell-to-Lower Head Circumferential Weld	Category B-A, Item Number B01.011.001 Figure Number IWB-2500-1(b) Volume Limitation 72.76% (Attachment A)	See Paragraph "A"	See Paragraph "G"	See Paragraph "H"	See Paragraph "I"
2	IRPV-W01	Reactor Vessel Lower Head to Bottom Head Circumferential Weld	Category B-A, Item Number B01.021.001 Figure Number IWB-2500-3 Volume Limitation 87.19% (Attachment B)	See Paragraph "A"	See Paragraph "G"	See Paragraph "H"	See Paragraph "I"
3	1PZR-W1	Pressurizer Surge Nozzle to Lower Head	Category B-D, Item Number B03.110.001A Figure Number IWB-2500-7(b) Volume Limitation 77.20% (Attachment C)	See Paragraph "B"	See Paragraph "G"	See Paragraph "H"	See Paragraph "J"
4	1PZR-W4A	Pressurizer Safety Nozzle to Upper Head	Category B-D, Item Number B03.110.004A Figure Number IWB-2500-7(b) Volume Limitation 79.20% (Attachment D)	See Paragraph "B"	See Paragraph "G"	See Paragraph "H"	See Paragraph "J"
5	1PZR-W4B	Pressurizer Safety Nozzle to Upper Head	Category B-D, Item Number B03.110.005 Figure Number IWB-2500-7(b) Volume Limitation 79.20% (Attachment E)	See Paragraph "B"	See Paragraph "G"	See Paragraph "H"	See Paragraph "J"

	I.	II.	III.	IV. & V.	VI.	VII.	VIII.
Request Number	Limited Weld I.D. Number	System / Component for Which Relief is Requested: Area or Weld to be Examined	Code Requirement from Which Relief is Requested: 100% Exam Volume Coverage Exam Category Item No. Fig. No. Limitation Percentage	Impracticability/ Burden Caused by Compliance	Proposed Alternate Examinations or Testing	Implementation Schedule and Duration	Justification for Granting Relief
6	1PZR-W4C	Pressurizer Safety Nozzle to Upper Head	Category B-D, Item Number B03.110.006A Figure Number IWB-2500-7(b) Volume Limitation 79.20% (Attachment F)	See Paragraph "B"	See Paragraph "G"	See Paragraph "H"	See Paragraph "J"
7	1RPV-W18-SE 1NC23-01	Reactor Vessel Outlet Nozzle to Safe End and Safe- End to Pipe (Buttering Weld)	Category B-F, Item Number B05.010.008, B05.010.008A B05.130.005, B05.130.005A Figure Number IWB-2500-8 (c) Volume Limitation 82.45% (Attachment G)	See Paragraph "C"	See Paragraph "G"	See Paragraph "H"	See Paragraph "I"
8	1NC286-1	NC System UHI Adapter to Pipe Cap	Category B-J, Item Number B09.011.048 Figure Number IWB-2500-8(c) Volume Limitation 37.50% (Attachment H)	See Paragraph "D"	See Paragraph "G"	See Paragraph "H"	See Paragraph "K"
9	1ND-37A	ND System Valve 1ND-37A Valve Body to Bonnet Weld	Category B-M-1, Item Number B12.040.002D Figure Number IWB-2500-17 Volume Limitation 69.30% (Attachment I)	See Paragraph "E"	See Paragraph "G"	See Paragraph "H"	See Paragraphs "L"
10	1ND39-12	ND System Valve 1ND2A-to- Pipe Circumferential Weld	Category C-F-1, Item Number C05.011.049 Figure Number IWC-2500-7(a) Volume Limitation 76.10% (Attachment J)	See Paragraph "F"	See Paragraph "G"	See Paragraph "H"	See Paragraphs "L"

IV. & V. Impracticality/Burden Caused by Code Compliance

Paragraph A:

During the ultrasonic examination of Weld ID Number 1RPV-W03, Reactor Vessel Shell to Lower Head Circumferential Weld, 100% coverage of the required examination volume could not be obtained. Scanning limitations were caused by proximity of the bottom mounted instrument tubes, which prevented scanning 100% of the weld length from four orthogonal directions. The procedure, qualified through the Performance Demonstration Initiative, requires scanning in four orthogonal directions using 45° single element shear waves, 45° single element refracted longitudinal waves (RL), and 45° dual element RL waves.

During the ultrasonic examination of Weld ID Number 1RPV-W01, Reactor Vessel Lower Head to Bottom Head Circumferential Weld, 100% coverage of the required examination volume could not be obtained. Scanning limitations were caused by the core support lugs, which prevented scanning 100% of the weld length from four orthogonal directions. The procedure, qualified through the Performance Demonstration Initiative requires scanning in four orthogonal directions using 45° single element shear waves, 45° single element refracted longitudinal waves (RL), and 45° dual element RL waves.

The percent of coverage reported represents the aggregate coverage from all scans performed on the welds. In order to scan all of the required surfaces for the inspection of the shell to lower head circumferential weld and the lower head to bottom head circumferential weld, the interferences would have to be moved to allow scanning the full length of the welds, which is impractical. These examinations were performed using personnel, procedures and equipment qualified in accordance with ASME Section XI, Appendix VIII, 1995 Edition through the 1996 Addenda as administered through the Performance Demonstration Initiative (PDI).

(Examination Data is shown in Attachments A and B)

Paragraph B:

During the ultrasonic examination of Weld ID Number 1PZR-W1, 100% coverage of the required examination volume could not be obtained. Scanning limitations were caused by the nozzle geometry that restricts scanning from the nozzle side. The percent coverage reported represents the aggregate coverage of all scans performed. The examination volume was scanned using 35° and 45° shear waves, and straight beam longitudinal waves in accordance with ASME Section V, Article 4, T-441.3.2.1.

The 35° beam covered 88.5% of the examination volume perpendicular to the weld from the vessel head side and 62.5% of the examination volume perpendicular to the weld from the nozzle side. Scans parallel to the weld with the 35° beam covered 79.3% of the examination volume in two opposite directions.

The 45° beam covered 81.2% of the examination volume perpendicular to the weld from the vessel head side and 59.7% of the examination volume perpendicular to the weld from the nozzle side. Scans parallel to the weld with the 45° beam covered 79.3% of the examination volume in two opposite directions.

The straight beam covered 79.3% of the examination volume. In order to achieve more coverage, the nozzle would have to be re-designed to allow scanning in four orthogonal directions. This examination was performed using procedures prepared in accordance with ASME Section V, Article 4 using personnel qualified in accordance with ASME Section XI, IWA-2300, including Appendix VII, 1995 Edition through the 1996 Addenda.

(Examination Data is shown in Attachment C)

During the ultrasonic examination of Weld ID Numbers 1PZR-W4A, 1PZR-W4B and 1PZR-W4C, 100% coverage of the required examination volume could not be obtained. Scanning limitations were caused by the nozzle geometry

that restricts scanning from the nozzle side. The percent coverage reported represents the aggregate coverage of all scans performed. The examination volume was scanned using 45°; 60° shear waves, and straight beam longitudinal waves in accordance with ASME Section V, Article 4, T-441.3.2.1.

The 45° beam covered 92.0% of the examination volume perpendicular to the weld from the vessel head side and 66.7% of the examination volume perpendicular to the weld from the nozzle side. Scans parallel to the weld with the 45° beam covered 79.6% of the examination volume in two opposite directions.

The 60° beam covered 94.2% of the examination volume perpendicular to the weld from the vessel head side and 60.5% of the examination volume perpendicular to the weld from the nozzle side. Scans parallel to the weld with the 60° beam covered 79.6% of the examination volume in two opposite directions.

The straight beam covered 79.6% of the examination volume. In order to achieve more coverage, the nozzle would have to be re-designed to allow scanning in four orthogonal directions. This examination was performed using procedures prepared in accordance with ASME Section V, Article 4 using personnel qualified in accordance with ASME Section XI, IWA-2300, including Appendix VII, 1995 Edition through the 1996 Addenda.

(Examination Data is shown in Attachments D, E and F)

Paragraph C:

During the ultrasonic examination of Weld ID Numbers 1RPV-W18-SE and 1NC23-01, 100% coverage of the required examination volume could not be obtained. Limitations were due to the ID configuration which consists of counter-bore and root protrusion. Ultrasonic detection scans for the DM welds were examined from the ID surface using 70 degree L wave transducers applied four-directionally. This exam interrogated the inner 1/3 thickness volume. Eddy Current examination was also employed to examine inner surfaces of the dissimilar metal welds and the adjacent examination volumes where ID geometry presented a limitation to the detection of axial flaws as defined in the PDQS for the qualified Appendix VIII techniques.

The percent of coverage reported represents the aggregate coverage from all scans performed on the welds. In order to scan all of the required surfaces, the counter bore and root protrusions would have to be removed, which is impractical. These examinations were performed using personnel, procedures and equipment qualified in accordance with ASME Section XI, Appendix VIII, 1995 Edition through the 1996 Addenda as administered through the Performance Demonstration Initiative (PDI).

(Examination Data is shown in Attachment G)

Paragraph D:

During the ultrasonic examination of Weld ID Number 1NC286-1, 100% coverage of the required examination volume could not be obtained. Single sided access caused by the proximity of the pipe cap prevented scanning from the cap side of the weld. The percent coverage reported represents the aggregate coverage of all scans performed. The examination volume was scanned using 45° and 60° shear waves.

The 45° beam covered 50% of the required volume in two opposite circumferential directions. The 60° beam covered 50% of the required volume in one axial direction from the pipe side of the weld. Because of the requirements of 10CFR50.55a(b)(2)(xv)(A)(2), coverage of the far side of the weld was not claimed.

In order to achieve more coverage, the weld would have to be re-designed to allow scanning from four orthogonal directions. This examination was performed using personnel, procedures and equipment qualified in accordance with ASME Section XI, Appendix VIII, Supplement 2, 1995 Edition through the 1996 Addenda as administered through the Performance Demonstration Initiative (PDI).

(Examination Data is shown in Attachment H)

Paragraph E:

During the ultrasonic examination of weld ID Number 1ND-37A, 100% coverage of the required examination volume could not be obtained. Single sided access caused by the valve body and bonnet geometry prevented scanning from two opposing circumferential and axial directions. The percent coverage reported represents the aggregate coverage of all scans performed. The examination volume was scanned using 45° and 60° shear waves.

The 45° beam covered 72.8% of the required volume in two opposite circumferential directions. A combination of 45° and 60° beams covered 65.81% of the required volume perpendicular to the weld.

In order to achieve more coverage, the weld would have to be re-designed to allow scanning from four orthogonal directions. This examination was performed using personnel, qualified in accordance with ASME Section XI, ASME Section XI, IWA-2300, and Appendix VII, 1995 Edition through the 1996 Addenda.

(Examination Data is shown in Attachment I)

Paragraph F

During the ultrasonic examination of Weld ID Number 1ND39-12, 100% coverage of the required examination volume could not be obtained. Single sided access caused by the valve configuration prevented scanning from the valve side of the weld. The percent coverage reported represents the aggregate coverage of all scans performed. The examination volume was scanned using 45° and 60° shear waves.

The 45° beam covered 100% of the required volume in two opposite circumferential directions. The 60° beam covered 52.9% of the required volume in one axial direction from the pipe side of the weld, and 51.4% from the valve side. A supplemental 60° longitudinal wave best effort scan covered 100% of the inside surface within the required volume in one axial direction from the pipe side of the weld but was not included in the coverage calculation because of the requirements of 10CFR50.55a(b)(2)(xv)(A)(2).

In order to achieve more coverage, the weld would have to be re-designed to allow scanning from four orthogonal directions. This examination was performed using personnel, procedures and equipment qualified in accordance with ASME Section XI, Appendix VIII, 1995 Edition through the 1996 Addenda as administered through the Performance Demonstration Initiative (PDI).

(Examination Data is shown in Attachment J)

VI. Proposed Alternate Examinations or Testing**Paragraph G:**

The scheduled 10-year code examination was performed on the referenced welds and resulted in the noted limited coverage of the required ultrasonic volume. No alternate examinations or testing are planned for the welds during the current inspection interval which ended on 6/29/05.

VII. Implementation Schedule and Duration**Paragraph H:**

The scheduled second 10-year interval plan code examination was performed on the referenced welds resulting in limited volumetric coverage. No additional examinations are planned for the welds and components during the current inspection interval which ended on 6/29/05. The same welds may be examined again as part of the next (third) 10-year interval plan, depending on the applicable code year edition and addenda requirements adopted in the future.

VIII. Justification for Granting Relief

Paragraph I:

Design and fabrication of the reactor vessel is carried out in strict accordance with ASME Code, Section III, Class I requirements. The head flanges, nozzles, and cylindrical portions of the unit 1 vessel are manufactured as forgings. The hemispherical heads are made from dished plates. The reactor vessel parts are joined by welding, using the single or multiple wire submerged arc and the shielded metal arc processes. The non-destructive examination of the reactor vessel and its appurtenances is conducted in accordance with the ASME Code Section III requirements; also numerous examinations are performed in addition to ASME Code Section III requirements. Nondestructive examination of the reactor vessel is discussed in UFSAR Section 5.3.1.3 and the reactor vessel quality assurance program is given in UFSAR Table 5-11.

The reactor vessel materials meet the fracture toughness requirements of 10CFR 50, Appendix G, to the extent possible. A summary of the fracture toughness data is given in UFSAR Table 5-13 and 5-15. Appendix G of 10 CFR 50 requires heatup and cooldown of the reactor vessel be accomplished within established pressure-temperature limits. The heatup and cooldown rates imposed by plant operating procedures are 50°F per hour and 80°F per hour, respectively, for normal operation. The heatup and cooldown rate limits are 60 °F per hour and 100 °F per hour, respectively, for abnormal or emergency conditions. The rate of 100°F per hour is the vessel design specification as a normal condition for conservatism for both heatup and cooldown. For Catawba unit 1, the heatup and cooldown limit curves for normal operation at 34 years provides a predicted operation window that is sufficient to conduct heatup and cooldowns. In addition, cyclic loads are introduced by normal power changes, reactor trips, and startup / shutdown operations. These design base cycles are selected for fatigue evaluation and constitute a conservative design envelope for the projected plant life. Vessel analysis results in a usage factor that is less than 1.

The reactor vessel has four inlet and four outlet nozzles located in a horizontal plane just below the upper head flange, but above the top of the core. Welds 1PRV-W18-SE and 1NC23-01 are located on the reactor vessel outlet (i.e., hot leg) nozzle, which are typically covered with mirror insulation.. During each refueling outage while the primary system remains at temperature and pressure (Mode 3), all accessible areas within containment are inspected for any evidence of boric acid leaks. During this walkdown, any leakage from these welds would be recognized by a boron deposit buildup around the piping and mirror insulation.

Plant Technical Specifications dictate that a reactor coolant system water inventory balance be performed on a regular basis (i.e. at least once every three days). The normal operating practice is to perform this computer based program on a daily frequency and/or whenever the operators suspect any abnormal changes to other leakage detection systems. A Plant Technical Specification requires system leakage from "unidentified" sources be maintained below 1 gpm; however, plant operation procedure (PT/1(2)/A/4150/001D, NC System Leakage Calculation) establish an administrative limit of 0.15 gpm above which the source of leakage will be investigated. Leakage as a result of a failed weld discussed in this section would show up as unidentified leakage and subject to the 0.15 gpm administrative limit. The water inventory balance provides repeatable results less than the 0.15 gpm administrative limit; however, an evaluation of sensitivity below this leak rate level has not been performed. No analysis has been done to quantify the flaw size in the reactor vessel which would be detectable by the leakage detection system.

Other leakage detection systems available to the operator per plant technical specifications are:

- Containment Atmosphere Particulate Radioactivity (EMF 38) Monitoring System which would detect airborne radiological activity;

- Containment Ventilation Unit Condensate Drain Tank Level Monitoring which collects and measures as unidentified leakage the moisture removed from the containment atmosphere.

The above leakage detection methods are dependant upon the Lower Containment Ventilation System, which provides for forced circulation of cooling air across the reactor vessel and for subsequent air return to lower containment. This provides the motive force for transporting moisture and radioactivity from any through wall leak in the reactor vessel to the above described leakage detection monitors.

Paragraph J:

100% bare metal visual (BMV) examinations were performed on all Alloy 600 / Alloy 82/182 weld locations on the pressurizer during IEOC15; Reference Duke's Response to NRC Bulletin 2004-01, dated June 14, 2005, (See Attachment K) and W/O 98683639-01. The inspection scope included the surge line nozzle to lower head location and the three (3) pressurizer safety valve nozzle to upper head locations (i.e., including welds 1PZR-W1, 1PZR-W4A, 1PZR-W4B, and 1PZR-W4C). No evidence of leakage or boric acid deposits was observed at any of these locations. There was no wastage identified on the external surface of the pressurizer vessel head.

Plant Technical Specifications dictate that a reactor coolant system water inventory balance be performed on a regular basis (i.e. at least once every three days). The normal operating practice is to perform this computer based program on a daily frequency and/or whenever the operators suspect any abnormal changes to other leakage detection systems. A Plant Technical Specification requires system leakage from "unidentified" sources be maintained below 1 gpm; however, plant operation procedure (PT/1(2)/A/4150/001D, NC System Leakage Calculation) establish an administrative limit of 0.15 gpm above which the source of leakage will be investigated. Leakage as a result of a failed weld discussed in this section would show up as unidentified leakage and subject to the 0.15 gpm administrative limit. The water inventory balance provides repeatable results less than the 0.15 gpm administrative limit; however, an evaluation of sensitivity below this leak rate level has not been performed.

Other leakage detection systems available to the operator and dictated per plant technical specifications are:

- Containment Atmosphere Particulate Radioactivity (EMF 38) Monitoring System which would detect airborne radiological activity;
- Containment Ventilation Unit Condensate Drain Tank Level Monitoring Subsystem which collects and measures as unidentified leakage the moisture removed from the containment atmosphere;
- Containment Floor and Equipment Sump Level and Flow Monitoring Subsystem where unidentified accumulated water on the containment floor would be monitored and evaluated as sump level changes.

Paragraph K:

The reactor pressure vessel upper head originally had four connections for the Upper Head Injection (UHI) system. Three of the four UHI penetrations are capped off. The other one serves as the Alternate Reactor Vessel Head Vent penetration. Weld 1NC286-1 is located at the pipe cap on a capped-off UHI nozzle at Catawba Unit 1. To meet the requirements of NRC Order EA-03-009, Catawba has established periodic inspection of the reactor vessel head area (Ref. SLC 16.5-8-2). This includes visual inspections performed each refueling outage to identify boric acid leaks for pressure-retaining components above the reactor vessel head. Any boric acid leakage from capped-off UHI nozzles would be identified during this inspection.

Plant Technical Specifications dictate that a reactor coolant system water inventory balance be performed on a regular basis (i.e. at least once every three days). The normal operating practice is to perform this computer based program on a daily frequency and/or whenever the operators suspect any abnormal changes to other leakage detection systems. A Plant Technical Specification requires system leakage from "unidentified" sources

be maintained below 1 gpm; however, plant operation procedure (PT/1(2)/A/4150/001D, NC System Leakage Calculation) establish an administrative limit of 0.15 gpm above which the source of leakage will be investigated. Leakage as a result of a failed weld discussed in this section would show up as unidentified leakage and subject to the 0.15 gpm administrative limit. The water inventory balance provides repeatable results less than the 0.15 gpm administrative limit; however, an evaluation of sensitivity below this leak rate level has not been performed.

Other leakage detection systems available to the operator per plant technical specifications are:

- Containment Atmosphere Particulate Radioactivity (EMF 38) Monitoring System which would detect airborne radiological activity;
- Containment Ventilation Unit Condensate Drain Tank Level Monitoring which collects and measures as unidentified leakage the moisture removed from the containment atmosphere.

The above leakage detection methods are dependant upon the Lower Containment Ventilation System, which provides for forced circulation of cooling air across the reactor vessel and for subsequent air return to lower containment. This provides the motive force for transporting moisture and radioactivity from any through wall leak in the reactor vessel to the above described leakage detection monitors.

Paragraph L:

The 1ND37A Body-to-Bonnet (1ND-37A) and 1ND2A Body-to-Pipe (1ND39-12) welds are located within the reactor building. These valves are second boundary isolation which remains normally closed to isolate the low pressure residual heat removal system from the high pressure reactor coolant system (i.e., Reactor Coolant Pressure Isolation Valves). These valves are opened to provide core cooling during plant shutdown. This piping and these welds are normally covered by mirror insulation. During each refueling outage while the primary system remains at temperature and pressure (Mode 3), all accessible areas within containment are inspected for any evidence of boric acid leaks. During this walkdown, any leakage from these welds would be recognized by a boron deposit buildup around the piping and mirror insulation.

In addition, any leakage at welds 1ND-37A or 1ND39-12 would be detected via other leakage detection systems available to the operator. These systems identified with plant technical specifications include:

- Containment Atmosphere Particulate Radioactivity (EMF 38) Monitoring System which would detect airborne radiological activity;
- Containment Ventilation Unit Condensate Drain Tank Level Monitoring Subsystem which collects and measures as unidentified leakage the moisture removed from the containment atmosphere;
- Containment Floor and Equipment Sump Level and Flow Monitoring Subsystem where unidentified accumulated water on the containment floor would be monitored and evaluated as sump level changes.

IX. Other Information

The following individuals contributed to the development of this relief request:

- Jim McArdle (Principle NDE Level III Inspector) provided UT related information for Sections III through VI
- Steve Mays (Mechanical Engineer) and Bill Callaway (Civil Engineer) provided information for Section VIII
- Andy Hogge (Sponsor) compiled the remaining sections

Sponsored By: A. J. Hogge, Jr. Date 9/7/2005

Approved By: L. Kevin Rhyne Date 9/7/05

Attachment A	Weld ID Number 1RPV-W03
Attachment B	Weld ID Number 1RPV-W01
Attachment C	Weld ID Number 1PZR-W1
Attachment D	Weld ID Number 1PZR-W4A
Attachment E	Weld ID Number 1PZR-W4B
Attachment F	Weld ID Number 1PZR-W4C
Attachment G	Weld ID Number 1RPV-W18-SE and INC23-01
Attachment H	Weld ID Number INC286-1
Attachment I	Weld ID Number 1ND-37A
Attachment J	Weld ID Number 1ND39-12
Attachment K	D. M. Jamil to U. S. Nuclear Regulatory Commission letter dated June 14, 2005, Duke Energy Corporation Catawba Nuclear Station Unit 1 Docket No. 50-413 Response to NRC Bulletin 2004-01 Inspection of Alloy 82/182/600 Materials Used in the Fabrication of Pressurizer Penetrations and Steam Space Piping Connections at Pressurized - Water Reactors

WesDyne International
Reactor Vessel Weld Results Summary

CATAWBA UNIT 1

WELD NO.	<u>W4</u>	DESCRIPTION	<u>LOWER SHELL TO</u>
	<u>(1RPV-W03)</u>		<u>LOWER HEAD CIRC.</u>
	<u>(B01.011.001)</u>		

LIMITATIONS NO ☐ YES ☒ COVERAGE = 72.76%

RESULTS NI RI

☒ ☐

NO. OF INDICATIONS 0

STATUS N/A

EXAM DOCUMENTATION

INDICATION DOCUMENTATION

☒ ANALYSIS LOG

☐ ASSESSMENT SHEET

☒ ACQUISITION LOG

☐ PARAGON HARD COPY

☒ SCAN PRINTOUT

☐ OTHER (specify)

☒ COVERAGE BREAKDOWN

WESDYNE ANALYST

JSch

ATTACHMENT A

RFR #05-CN-004

Pg. 1 OF 5

CATAWBA UNIT 1

RPV COVERAGE ESTIMATE BREAKDOWNS

DIRECTION / ORIENTATION

PARALLEL SCANS

CCW/CW

PERP. SCANS

UP/DN

WELD
DESCRIPTION

LOWER SHELL TO
LOWER HEAD CIRC.

WELD NO.

W4 (1RPV-W03)

BEAM ANGLES

BEAM DIRECTION	45° L Dual		45° L Single		45° Shear					
	WELD	VOLUME	WELD	VOLUME	WELD	VOLUME	WELD	VOLUME	WELD	VOLUME
CCW	63.67	22.0	100	80.02	100	80.02				
CW	63.67	22.0	100	80.02	100	80.02				
UP	63.67	63.67	63.67	63.67	81.83	100				
DOWN	63.67	63.67	63.67	63.67	63.67	100				
Combined Average = 72.76%		LIMITATION DUE TO CORE SUPPORT LUGS.								

ANALYST



CATAWBA UNIT 1

J. S. do

CATAWBA UNIT 1

RPV COVERAGE ESTIMATE BREAKDOWNS

DIRECTION / ORIENTATION

PARALLEL SCANS

CCW/CW

PERP. SCANS

UP/DN

WELD

LOWER HEAD TO
BOTTOM HEAD CIRC.

WELD NO.

W5 (1RPV-W01)

DESCRIPTION

BEAM ANGLES

BEAM DIRECTION	45° L Dual		45° L Single		45° Shear					
	WELD	VOLUME	WELD	VOLUME	WELD	VOLUME	WELD	VOLUME	WELD	VOLUME
CCW	86.6	87.5	100	93	100	93				
CW	86.6	87.5	100	93	100	93				
UP	85.97	81.65	81.29	78.43	78.77	79.07				
DOWN	85.97	77.93	81.29	80.95	78.77	82.37				
Combined Average = 87.19%		LIMITATION DUE TO PROXIMITY OF PERIPHERAL BMI TUBES.								

ANALYST

SAJ



UT Vessel Examination

Site/Unit: Catawba / 1

Procedure: NDE-640

Outage No.: CNS1EOC15

Summary No.: B03.110.001A

Procedure Rev.: 3

Report No.: UT-05-154

Workscope: ISI

Work Order No.: 98688944

Page: 1 of 1

Code: Asme Section XI 1989 Cat./Item: B-D- /B3.110.1A Location: N/A

Drawing No.: CNM 1201.01-175/1 Description: PZR Surge Nozzle to Lower Head

System ID: NC

Component ID: B03.110.001A/1PZR-W1 Size/Length: N/A Thickness/Diameter: 2.55" / 24.5"

Limitations: Yes-See Attached Limitation Report Start Time: 1330 Finish Time: 1338

Examination Surface: Inside ☐ Outside ☒ Surface Condition: AS GROUND

Lo Location: 9.2.3 Wo Location: Centerline of Weld Couplant: ULTRAGEL II Batch No.: 03125

Temp. Tool Mfg.: D.A.S Serial No.: MCNDE32798 Surface Temp.: 82 °F

Cal. Report No.: CAL-05-169

Angle Used	0	45	45T	60	60T	
Scanning dB	31.5					

Indication(s): Yes ☐ No ☒ Scan Coverage: Upstream ☒ Downstream ☒ CW ☒ CCW ☒

Comments:

Results: Accept ☒ Reject ☐ Info ☐ *** - See Report No. UT-05-155 for actual percentage of coverage

Percent Of Coverage Obtained > 90%: Yes-*** 77.2% Reviewed Previous Data: Yes

Examiner	Level	II	Signature	Date	Reviewer	Signature	Date
Resor, James H.			<i>James H. Resor</i>	5/17/2005	<i>JE Houser</i>		5-21-05
Examiner	Level	II	Signature	Date	Site Review	Signature	Date
Leeper, Winfred C.			<i>Winfred C. Leeper</i>	5/17/2005	N/A		
Other	Level	N/A	Signature	Date	ANII Review	Signature	Date
N/A					<i>Nancy C. Ritchie Slaughter</i>		5/24/05

RFR#05-CN-004 ATTACHMENT C P3 of 12



UT Vessel Examination

Site/Unit: Catawba / 1
Summary No.: B03.110.001A
Workscope: ISI

Procedure: NDE-820
Procedure Rev.: 2
Work Order No.: 98688944

Outage No.: CNS1EOC15
Report No.: UT-05-155
Page: 1 of 2

Code: Asme Section XI 1989 Cat./Item: B-D- /B3.110.1A Location: N/A
Drawing No.: CNM 1201.01-175/1 Description: PZR Surge Nozzle to Lower Head
System ID: NC
Component ID: B03.110.001A/1PZR-W1 Size/Length: N/A Thickness/Diameter: 2.55" / 24.5"
Limitations: Yes-See Attached Limitation Report Start Time: 1350 Finish Time: 1410

Examination Surface: Inside ☐ Outside ☒ Surface Condition: AS GROUND
Lo Location: 9.2.3 Wo Location: Centerline of Weld Couplant: ULTRAGEL II Batch No.: 03125
Temp. Tool Mfg.: D.A.S Serial No.: MCNDE32798 Surface Temp.: 82 °F
Cal. Report No.: CAL-05-170, CAL-05-171

Angle Used
Scanning dB

0	45	45T	60	60T	35
	67.2	67.2			62.8

Indication(s): Yes ☐ No ☒ Scan Coverage: Upstream ☒ Downstream ☒ CW ☒ CCW ☒

Comments:

Results: Accept ☒ Reject ☐ Info ☐

Percent Of Coverage Obtained > 90%: Yes - 77.2%

Reviewed Previous Data: Yes

Examiner	Level III	Signature	Date	Reviewer	Signature	Date
Eaton, Jay A.			5/17/2005	DE/Hansen		5.21.05
Examiner	Level II	Signature	Date	Site Review	Signature	Date
Jones, Russel			5/17/2005	N/A		
Other	Level II-N	Signature	Date	ANII Review	Signature	Date
Keene, Douglas L.			5/17/2005	Nancy C Ritchie Slough		5/24/05

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Determination of Percent Coverage for UT Examinations - Vessels

Site/Unit: <u>Catawba / 1</u>	Procedure: <u>NDE-820</u>	Outage No.: <u>CNS1EOC15</u>
Summary No.: <u>B03.110.001A</u>	Procedure Rev.: <u>2</u>	Report No.: <u>UT-05-155</u>
Workscope: <u>ISI</u>	Work Order No.: <u>98688944</u>	Page: <u>2</u> of <u>2</u>

0 deg Planar

Scan 100.000 % Length X 79.300 % volume of length / 100 = 79.300 % total for 0 deg

45 deg

Scan 1 100.000 % Length X 81.200 % volume of length / 100 = 81.200 % total for Scan 1

Scan 2 100.000 % Length X 59.700 % volume of length / 100 = 59.700 % total for Scan 2

Scan 3 100.000 % Length X 79.300 % volume of length / 100 = 79.300 % total for Scan 3

Scan 4 100.000 % Length X 79.300 % volume of length / 100 = 79.300 % total for Scan 4

Add totals and divide by # scans = 74.875 % total for 45 deg

Other deg 35

Scan 1 100.000 % Length X 88.500 % volume of length / 100 = 88.500 % total for Scan 1

Scan 2 100.000 % Length X 62.500 % volume of length / 100 = 62.500 % total for Scan 2

Scan 3 100.000 % Length X 79.300 % volume of length / 100 = 79.300 % total for Scan 3

Scan 4 100.000 % Length X 79.300 % volume of length / 100 = 79.300 % total for Scan 4

Add totals and divide by # scans = 77.400 % total for 35 deg

Percent complete coverage

Add totals for each angle and scan required and divide by # of angles to determine;

77.192 % Total for complete exam

Note:

Supplemental coverage may be achieved by use of other angles / methods. When used, the coverage for volume not obtained with angles as noted above shall be calculated and added to the total to provide the percent total for the complete examination.

Site Field Supervisor: David K. Zimmerman *David K. Zimmerman* Date: 5/17/2005

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CNS UNIT I PZR SURGE NOZZLE/LOWER
ITEM NO. B03.110.001A
I.D. NO. 1PZR-W1

ANGLE	SCAN	BASE METAL%	WELD METAL%	AGGREGATE%
0	0	58.6	100.0	79.3
35	1	70.7	91.6	81.2
35	2	70.7	48.7	59.7
35	3	58.6	100.0	79.3
35	4	58.6	100.0	79.3
45	1	81.7	95.2	88.5
45	2	81.7	43.2	62.5
45	3	58.6	100.0	79.3
45	4	58.6	100.0	79.3

UT-05-155
Attachment 1 of 9

David K. B. III 05/17/05
pg 4 of 12

DUKE POWER COMPANY

ISI LIMITATION REPORT

Component/Weld ID: <u>1PZR-W1</u> Item No: <u>B03.110.001A</u>		remarks:
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/</u> INCHES FROM W0 <u>1.15</u> to <u>Beyond</u> ANGLE: <input type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG		Nozzle Configuration
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/A</u> INCHES FROM W0 <u>1.25</u> to <u>Beyond</u> ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other <u>35</u> FROM <u>0</u> DEG to <u>360</u> DEG		Nozzle Configuration
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/A</u> INCHES FROM W0 <u>0.85</u> to <u>Beyond</u> ANGLE: <input type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG		Nozzle Configuration
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/A</u> INCHES FROM W0 <u>0.75</u> to <u>Beyond</u> ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other <u>35</u> FROM <u>0</u> DEG to <u>360</u> DEG		Nozzle Configuration
		Sketch(s) attached <input checked="" type="checkbox"/> yes <input type="checkbox"/> No
Prepared By: <u>David Zimmerman</u> Level: <u>III</u> Date: <u>05/17/05</u> Sheet <u>2</u> of <u>9</u> <u>UT-05-155</u>		
Reviewed By: <u>[Signature]</u> Date: <u>5-21-05</u> Authorized Inspector: <u>Nancy C. Richey Slaughter</u> Date: <u>5/24/05</u>		

PS 50F12

DUKE POWER COMPANY

ISI LIMITATION REPORT

Component/Weld ID: <u>1PZR-W1</u> Item No: <u>B03.110.001A</u>		remarks: <div style="border: 1px solid black; padding: 2px; margin-bottom: 2px;">Nozzle Configuration</div> <div style="border: 1px solid black; height: 15px; margin-bottom: 2px;"></div> <div style="border: 1px solid black; height: 15px; margin-bottom: 2px;"></div> <div style="border: 1px solid black; height: 15px; margin-bottom: 2px;"></div> <div style="border: 1px solid black; height: 15px; margin-bottom: 2px;"></div>
<input checked="" type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input checked="" type="checkbox"/> cw <input checked="" type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/</u> INCHES FROM W0 <u>1.3</u> to <u>Beyond</u> ANGLE: <input checked="" type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input type="checkbox"/> 60 other <u>35</u> FROM <u>0</u> DEG to <u>360</u> DEG	<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG	
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG	<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG	
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG	<div style="border: 1px solid black; padding: 2px; margin-bottom: 2px;">Sketch(s) attached</div> <input checked="" type="checkbox"/> yes <input type="checkbox"/> No	
Prepared By: <u>David Zimmerman</u> Level: <u>III</u> Date: <u>05/17/05</u> Sheet <u>3</u> of <u>9</u> <u>UT-05-155</u>		
Reviewed By: <u>DE Houser</u> Date: <u>5.21.05</u> Authorized Inspector: <u>Wendy R. Stoughton</u> Date: <u>5/24/05</u>		

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CNS-I PZR SURGE NOZZLE / LOWER HEAD

SURGE NOZZLE

S2

TOTAL AREA - BASE METAL

$$ABCD: 1.65in \left(\frac{1.25in + 1.7in}{2} \right) = 2.43in^2$$

$$CDEF: 0.9in \left(\frac{1.7in + 1.85in}{2} \right) = 1.60in^2$$

$$GHIJ: 0.9in \left(\frac{1.8in + 1.9in}{2} \right) = 1.67in^2$$

$$GJKL: 1.65in \left(\frac{1.25in + 1.8in}{2} \right) = 2.52in^2$$

$$KL: \frac{0.8in \times 0.35in}{2} = 0.14in^2$$

$$TOTAL BASE = 8.36in^2$$

TOTAL AREA - WELD METAL

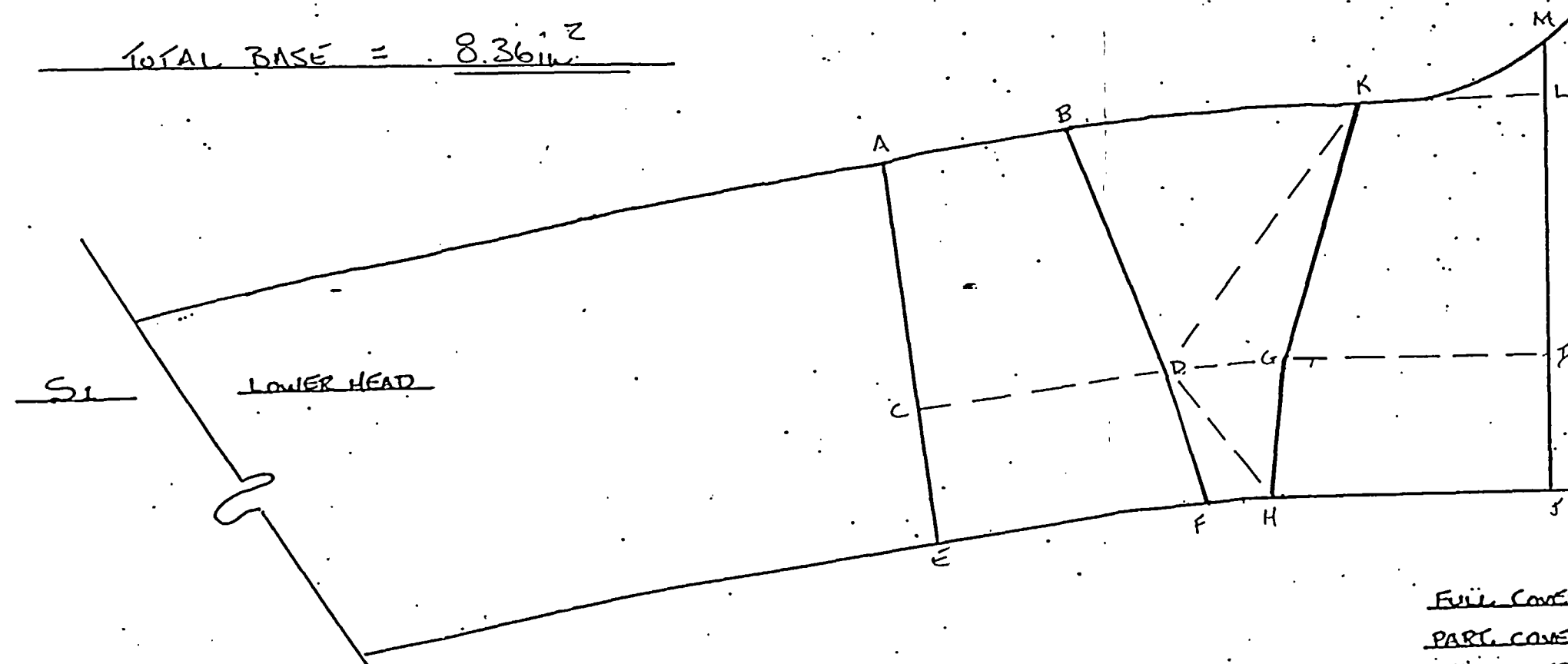
$$BDK: \frac{1.8in \times 2.0in}{2} = 1.8in^2$$

$$DGK: \frac{0.8in \times 1.8in}{2} = 0.72in^2$$

$$DPH: \frac{0.45in \times 0.95in}{2} = 0.43in^2$$

$$DGH: \frac{0.95in \times 0.8in}{2} = 0.38in^2$$

$$TOTAL WELD = 3.33in^2$$



FULL COVERAGE ☐
 PART COVERAGE ☒
 NO COVERAGE ☐

ID No: B03.110.001A
 ITEM: IPZR-W1
 INSP: *[Signature]*
 DATE: 05/17/05
 ATTACHMENT 4 of 9

PS 1 of 2

CNS-I PZR SURGE NOZZLE / LOWER HEAD

0° SCAN / 35° & 45° CIRC SCAN (WELD)

100% COVERAGE

SURGE NOZZLE

S2

S1

LOWER HEAD

FULL COVERAGE ☐

PART COVERAGE ☒

NO COVERAGE ☐

ID NO: B03-110-001A

UT-05-155

ITEM: IPZR-W1

INSP: *David C. [Signature]* DATE: 05/17/05

SCALE: Full Attachment 5 of 9

PS 8 of 12

CNS-I PZR SURGE NOZZLE / LOWER HEAD

SCAN 12- 35° & 45° AXIAL (BASE)

35°

$$BCD = \frac{0.8in \times 0.35in}{2} = 0.14in^2$$

$$ADGH = 0.7in \left(\frac{1.3in + 1.5in}{2} \right) = 0.95in^2$$

$$GHI = \frac{1.5in \times 1.85in}{2} = 1.39in^2$$

$$TOTAL LOSS = 2.48in^2$$

$$8.46in^2 - 2.48in^2 = 5.98in^2$$

$$TOTAL COVERAGE(%) = 5.98in^2 / 8.46in^2 (100) = 70.7\%$$

45°

$$BCD = \frac{0.8in \times 0.35in}{2} = 0.14in^2$$

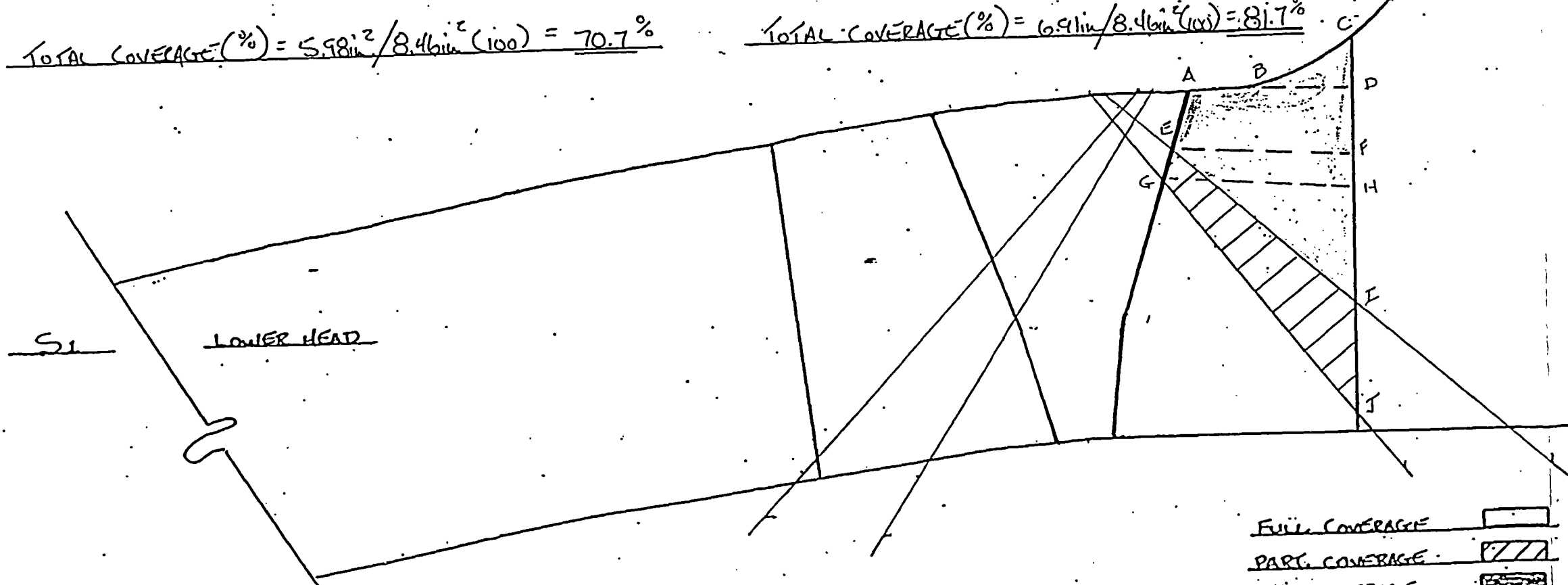
$$AEDF = 0.45in \left(\frac{1.25in + 1.4in}{2} \right) = 0.60in^2$$

$$EFI = \frac{1.15in \times 1.4in}{2} = 0.81in^2$$

$$TOTAL LOSS = 1.55in^2$$

$$8.46in^2 - 1.55in^2 = 6.91in^2$$

$$TOTAL COVERAGE(%) = 6.91in^2 / 8.46in^2 (100) = 81.7\%$$



FULL COVERAGE ☐
PART COVERAGE ☒
NO COVERAGE ☐

ID NO: B03-110-001A
ITEM: IPZR-111
INSP: David C. [signature] DATE: 05/17/05
SCALE: Full Attachment 6 of 9

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CNS-I. PZR SURGE NOZZLE / LOWER HEAD

0° SCAN / SCAN 3, 4 - 35° & 45° CIRC (BASE)

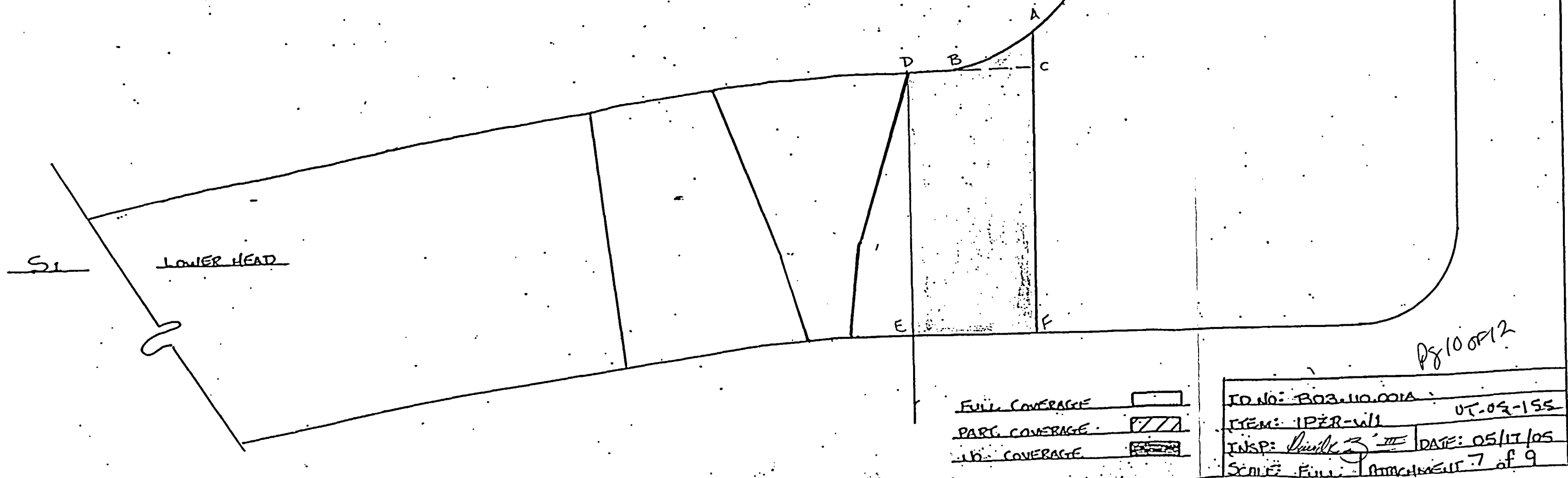
$$ABC: \frac{0.8in \times 0.35in}{2} = 0.14in^2$$

$$CDEF: 1.3in \times 2.55in = 3.32in^2$$

$$TOTAL LOSS = 3.46in^2$$

$$8.36in^2 - 3.46in^2 = 4.9in^2$$

$$TOTAL COVERAGE(\%) = 4.9in^2 / 8.36in^2 (100) = 58.6\%$$



FULL COVERAGE ☐
 PART COVERAGE ☒
 NO COVERAGE ☐

ID No: B03.110.001A
 ITEM: IPZR-W1
 INSP: David 3 DATE: 05/17/05
 SCALE: Full ATTACHMENT 7 of 9

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CNS-I PZR SURGE NOZZLE / LOWER HEAD

SCAN 1 - 35° & 45° AXIAL - (WELD)

SURGE NOZZLE

S2

45°

35°

BCD: $\frac{0.65in \times 0.5in}{2} = 0.16in^2$

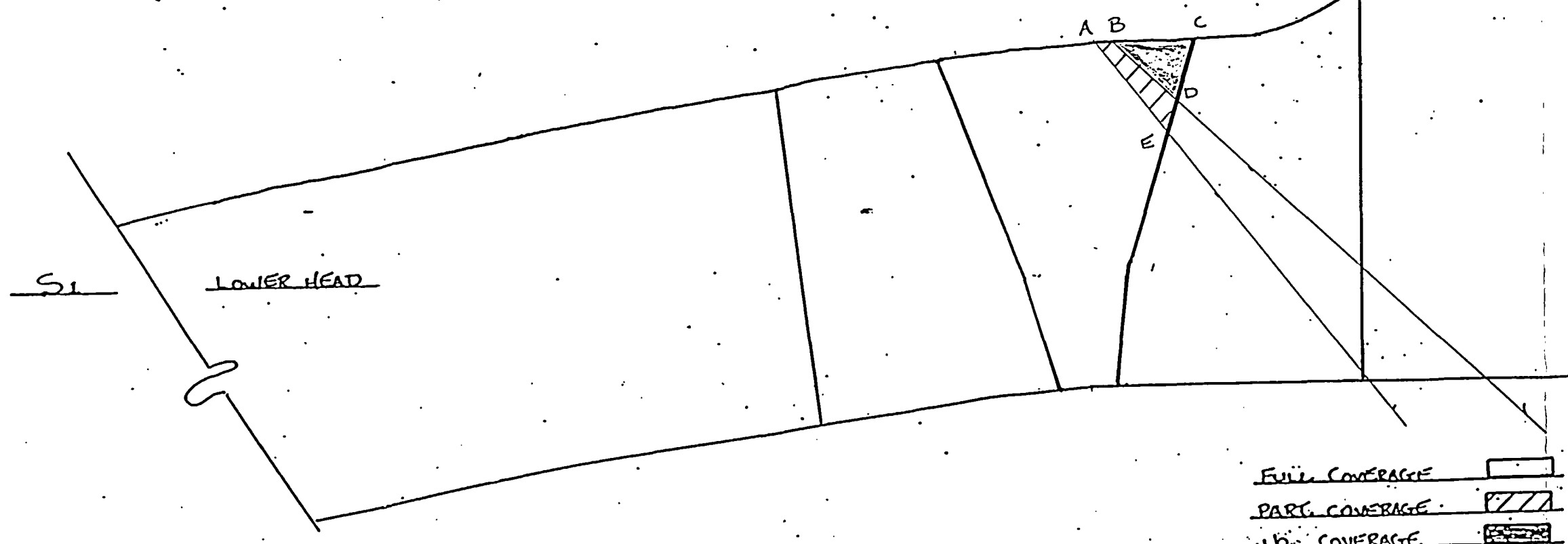
ACE: $\frac{0.75in \times 0.75in}{2} = 0.28in^2$

$3.33in^2 - 0.16in^2 = 3.17in^2$

$3.33in^2 - 0.28in^2 = 3.05in^2$

TOTAL COVERAGE(%) = $3.17in^2 / 3.33in^2 (100) = 95.2\%$

TOTAL COVERAGE(%) = $3.05in^2 / 3.33in^2 (100) = 91.6\%$



Full Coverage	<input type="checkbox"/>
Part Coverage	<input checked="" type="checkbox"/>
No Coverage	<input type="checkbox"/>

PS110F12

ID NO: B03.110.001A	UT-05-155
ITEM: IPZR-W1	DATE: 05/17/05
INSP: David C. 2	SCALE: Full Attachment B of 9

CNS-I PZR SURGE NOZZLE / LOWER HEAD

SCAN 2 - 35° & 45° AXIAL (WELD)

35°

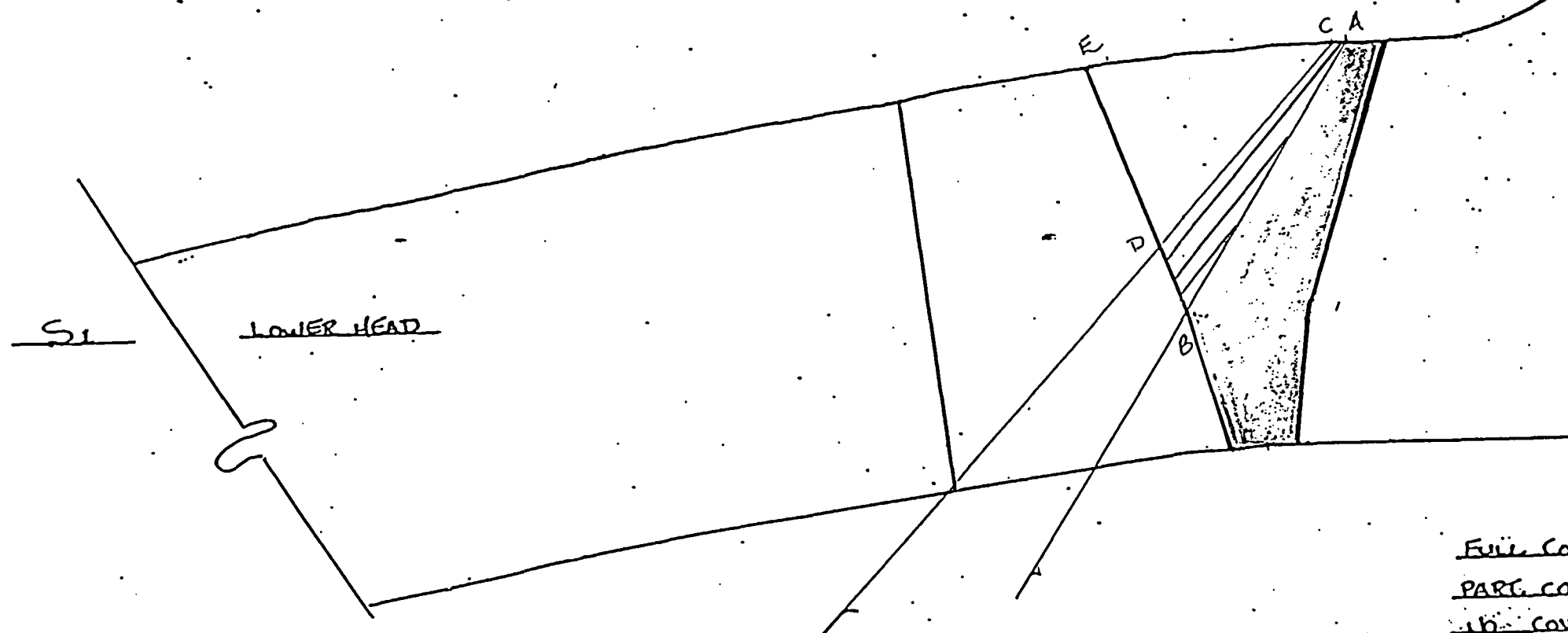
$$ABE = \frac{1.75\text{in} \times 1.85\text{in}}{2} = 1.62\text{in}^2$$

$$\text{TOTAL COVERAGE (\%)} = \frac{1.62\text{in}^2}{3.33\text{in}^2} (100) = \underline{48.7\%}$$

45°

$$CDE = \frac{1.65\text{in}^2 \times 1.75\text{in}^2}{2} = 1.44\text{in}^2$$

$$\text{TOTAL COVERAGE (\%)} = \frac{1.44\text{in}^2}{3.33\text{in}^2} (100) = \underline{43.2\%}$$



SURGE NOZZLE

S2

FULL COVERAGE ☐
 PART COVERAGE ☒
 NO COVERAGE ☐

ID No: B03.110.001A UT-05-155
 ITEM: IPZR-W1
 INSP: *Quill* III DATE: 05/17/05
 SCALE: Full Attachment 9 of 9

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UT Vessel Examination

Site/Unit: Catawba / 1

Procedure: NDE-640

Outage No.: CNS1EOC15

Summary No.: B03.110.004A

Procedure Rev.: 3

Report No.: UT-05-215

Workscope: ISI

Work Order No.: 98688945

Page: 1 of 1

Code: Asme Section XI 1989 Cat./Item: B-D- /B3.110.4A Location: N/A

Drawing No.: CNM 1201.01-175/1 Description: PZR Safety Nozzle to Upper Head

System ID: NC

Component ID: B03.110.004A/1PZR-W4A Size/Length: N/A Thickness/Diameter: 1.9" / 15.0"

Limitations: Yes - See Limitation Report for 820 Exam Start Time: 1249 Finish Time: 1253

Examination Surface: Inside ☐ Outside ☒ Surface Condition: AS GROUND

Lo Location: 9.2.3 Wo Location: Centerline of Weld Couplant: ULTRAGEL II Batch No.: 05125

Temp. Tool Mfg.: D.A.S Serial No.: MCNDE32798 Surface Temp.: 69 °F

Cal. Report No.: CAL-05-228

Angle Used	0	45	45T	60	60T	
Scanning dB	31.5					

Indication(s): Yes ☐ No ☒ Scan Coverage: Upstream ☐ Downstream ☒ CW ☒ CCW ☒

Comments:

Results: Accept ☒ Reject ☐ Info ☐

Percent Of Coverage Obtained > 90%: No - 79.2% Reviewed Previous Data: Yes

Examiner	Level	Signature	Date	Reviewer	Signature	Date
Leeper, Winfred C.	II	<i>Winfred C. Leeper</i>	5/26/2005	<i>McHouser</i>		5-29-05
Examiner	Level	Signature	Date	Site Review	Signature	Date
Keene, Douglas L.	II-N	<i>Douglas L. Keene</i>	5/26/2005	N/A		
Other	Level	Signature	Date	ANII Review	Signature	Date
Ransom, Greg	II-N	<i>Greg Ransom</i>	5/26/2005	<i>Robert M. Gill</i>		6-8-05

RF#05-CN-004 ATTACHMENT D

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UT Vessel Examination

Site/Unit: Catawba / 1

Procedure: NDE-820

Outage No.: CNS1EOC15

Summary No.: B03.110.004A

Procedure Rev.: 2

Report No.: UT-05-218

Workscope: ISI

Work Order No.: 98688945

Page: 1 of 3

Code: Asme Section XI 1989 Cat./Item: B-D- /B3.110.4A Location: N/A

Drawing No.: CNM 1201.01-175/1 Description: PZR Safety Nozzle to Upper Head

System ID: NC

Component ID: B03.110.004A/1PZR-W4A Size/Length: N/A Thickness/Diameter: 1.9" / 15.0"

Limitations: Yes - See Attached Limitation Report Start Time: 1227 Finish Time: 1244

Examination Surface: Inside ☐ Outside ☒ Surface Condition: AS GROUND

Lo Location: 9.2.3 Wo Location: Centerline of Weld Couplant: ULTRAGEL II Batch No.: 05125

Temp. Tool Mfg.: D.A.S Serial No.: MCNDE32798 Surface Temp.: 69 °F

Cal. Report No.: CAL-05-229, CAL-05-230

Angle Used	0	45	45T	60	60T	
Scanning dB		53		67.4		

Indication(s): Yes ☐ No ☒ Scan Coverage: Upstream ☐ Downstream ☒ CW ☒ CCW ☒

Comments:

Results: Accept ☒ Reject ☐ Info ☐

Percent Of Coverage Obtained > 90%: No - 79.2 % Reviewed Previous Data: Yes

Examiner	Level	Signature	Date	Reviewer	Signature	Date
Leeper, Winfred C.	II	<i>Winfred C. Leeper</i>	5/26/2005	<i>DE Hansen</i>		5.29.05
Examiner	Level	Signature	Date	Site Review	Signature	Date
Keene, Douglas L.	II-N	<i>Douglas L. Keene</i>	5/26/2005	N/A		
Other	Level	Signature	Date	ANII Review	Signature	Date
Ransom, Greg	II-N	<i>Greg Ransom</i>	5/26/2005	<i>Robert m. Sullivan</i>		6.8.05

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Determination of Percent Coverage for UT Examinations - Vessels

Site/Unit: <u>Catawba / 1</u>	Procedure: <u>NDE-820</u>	Outage No.: <u>CNS1EOC15</u>
Summary No.: <u>B03.110.004A</u>	Procedure Rev.: <u>2</u>	Report No.: <u>UT-05-218</u>
Workscope: <u>ISI</u>	Work Order No.: <u>98688945</u>	Page: <u>2</u> of <u>3</u>

0 deg Planar

Scan 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for 0 deg

45 deg

Scan 1 100.000 % Length X 92.000 % volume of length / 100 = 92.000 % total for Scan 1

Scan 2 100.000 % Length X 66.710 % volume of length / 100 = 66.710 % total for Scan 2

Scan 3 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for Scan 3

Scan 4 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for Scan 4

Add totals and divide by # scans = 79.493 % total for 45 deg

Other deg 60

Scan 1 100.000 % Length X 94.230 % volume of length / 100 = 94.230 % total for Scan 1

Scan 2 100.000 % Length X 60.520 % volume of length / 100 = 60.520 % total for Scan 2

Scan 3 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for Scan 3

Scan 4 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for Scan 4

Add totals and divide by # scans = 78.503 % total for 60 deg

Percent complete coverage

Add totals for each angle and scan required and divide by # of angles to determine;

79.208 % Total for complete exam

Note:

Supplemental coverage may be achieved by use of other angles / methods. When used, the coverage for volume not obtained with angles as noted above shall be calculated and added to the total to provide the percent total for the complete examination.

Site Field Supervisor: David K. J. III

Date: 05/26/05

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Limitation Record

Site/Unit: Catawba / 1
Summary No.: B03.110.004A
Workscope: ISI

Procedure: NDE-820
Procedure Rev.: 2
Work Order No.: 98688945

Outage No.: CNS1EOC15
Report No.: UT-05-218
Page: 3 of 3

Description of Limitation:

See Attachment for Limitation Calculations.
Coverage

Aggregate %

Sketch of Limitation:

<u>4</u>	<u>SCAN</u>	<u>WELD %</u>	<u>BASE %</u>	<u>AGGREGATE</u>
45°	1	100.00	84.00	92.00
	2	49.41	84.00	66.71
	3	100.00	59.26	79.63
	4	100.00	59.26	79.63
60°	1	100.00	88.45	94.23
	2	37.04	84.00	60.52
	3	100.00	59.26	79.63
	4	100.00	59.26	79.63
0°		100.00	59.26	79.63

Limitations removal requirements:

Radiation field:

Examiner	Level	II	Signature	Date	Reviewer	Signature	Date
Leeper, Winfred C.			<i>Winfred C. Leeper</i>	5/26/2005	<i>DE Hauer</i>		5-29-05
Examiner	Level	II-N	Signature	Date	Site Review	Signature	Date
Keene, Douglas L.			<i>Douglas L. Keene</i>	5/26/2005	N/A		
Other	Level	II-N	Signature	Date	ANII Review	Signature	Date
Ransom, Greg			<i>Greg Ransom</i>	5/26/2005	<i>Robert M. Hall</i>		6-8-05

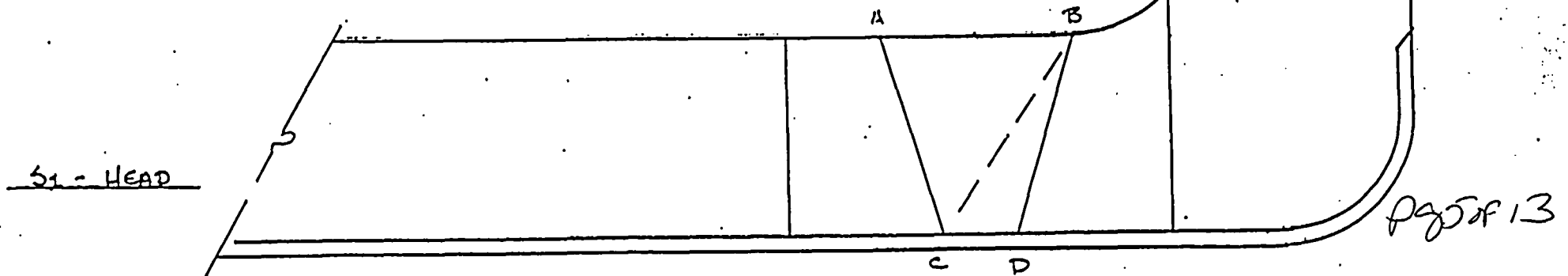
P840 FL3

TOTAL AREA - WELD

$$ABC : \frac{2.5in \times 2.7in}{2} = 3.375in^2$$

$$BCD : \frac{2.7in \times 1.0in}{2} = 1.35in^2$$

$$TOTAL WELD = 4.725 in^2$$



SCALE: $\frac{1}{2}'' = 1.0''$

NOTE: All dimensions taken
directly from dwg.

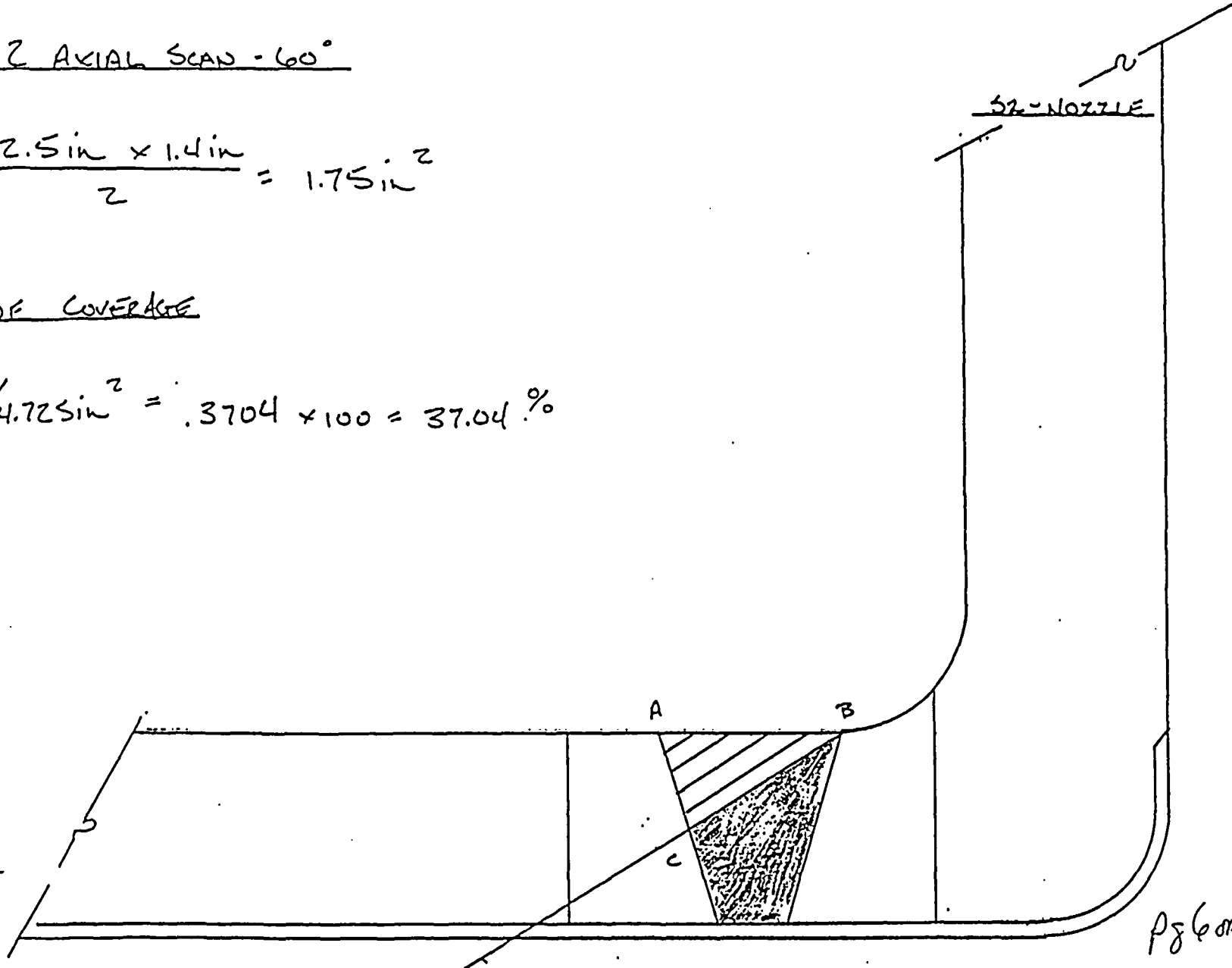
WELD

SCAN 2 AXIAL SCAN - 60°

$$ABC: \frac{2.5 \sin \times 1.4 \sin}{2} = 1.75 \sin^2$$

PERCENT OF COVERAGE

$$1.75 \sin^2 / 4.72 \sin^2 = .3704 \times 100 = 37.04 \%$$



S1 - HEAD

S2 - NOZZLE

SCALE: 1/2" = 1.0"

NOTE: All dimensions taken
directly from data

pg 6 of 13

Attachment 2 of 9

WELD

SCAN 2 AXIAL SCAN - 45°

$$ABC: \frac{2.8 \text{ in} \times 0.6 \text{ in}}{2} = 0.84 \text{ in}^2$$

$$BCD: \frac{3.1 \text{ in} \times 1.0 \text{ in}}{2} = 1.55 \text{ in}^2$$

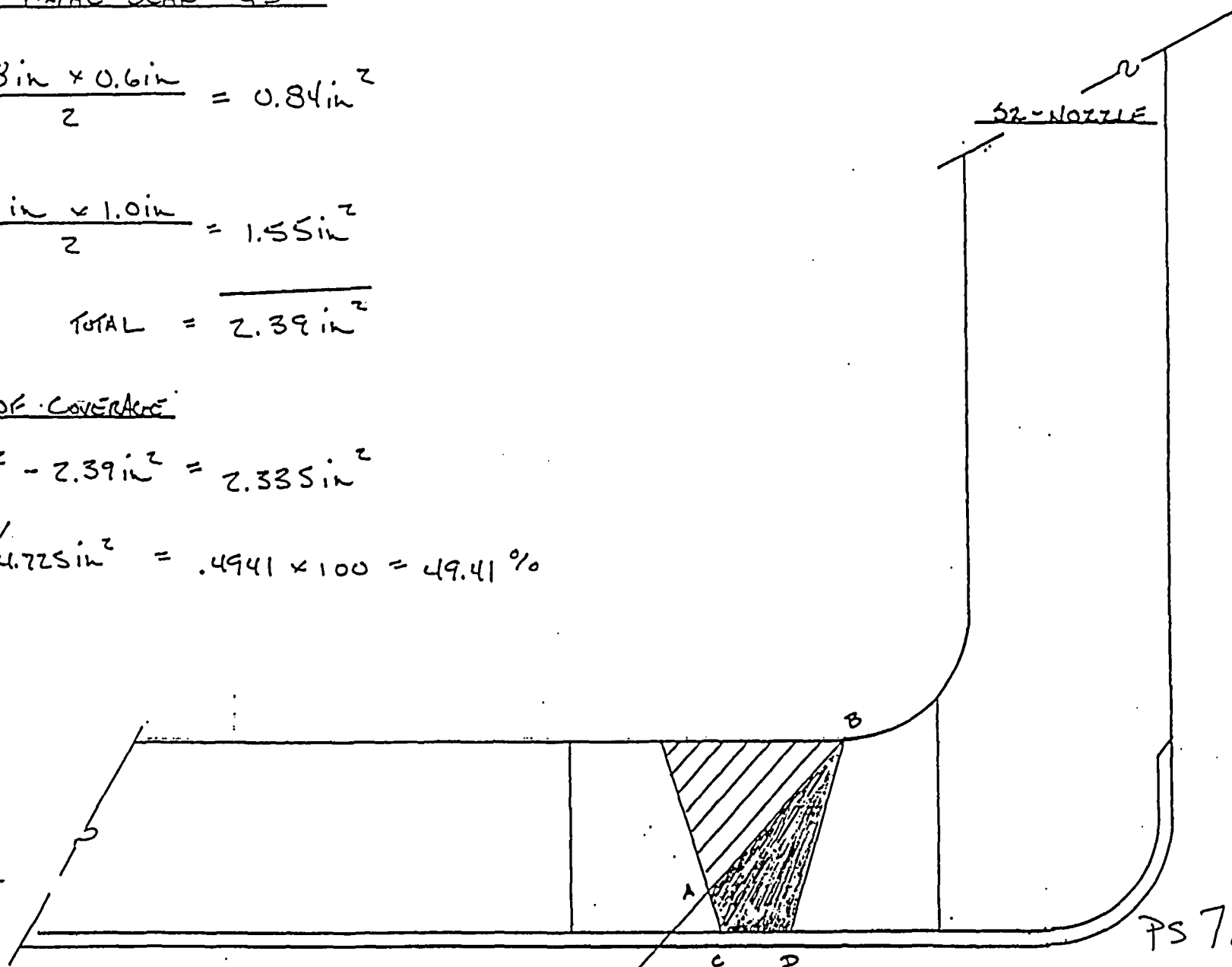
$$\text{TOTAL} = 2.39 \text{ in}^2$$

PERCENT OF COVERAGE

$$4.725 \text{ in}^2 - 2.39 \text{ in}^2 = 2.335 \text{ in}^2$$

$$\frac{2.335 \text{ in}^2}{4.725 \text{ in}^2} = .4941 \times 100 = 49.41\%$$

S2 - HEAD



SCALE: 1/2" = 1.0"

NOTE: All dimensions taken
directly from drawing

Attachment 3 of 9

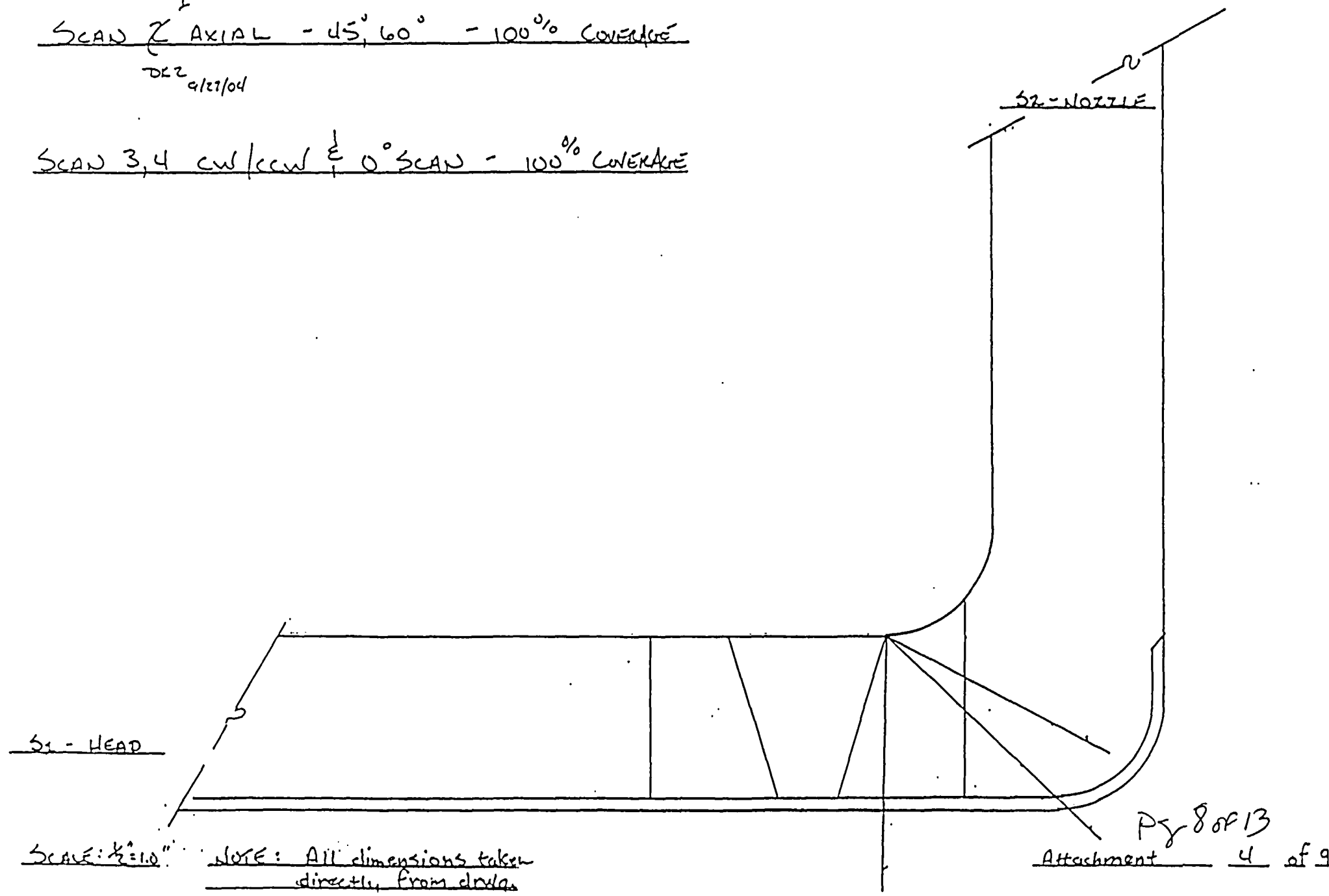
UNIT 1 PFR - NOZZLE / HEAD WELD

ITEM NO. 03.110.004A
I.D. NO. 1PFR-004A
INSP Smilek, B. III
DATE 05/26/05

WELD

SCAN 1 AXIAL - 45°, 60° - 100% COVERAGE
DLZ 9/27/04

SCAN 3, 4 CW/CCW & 0° SCAN - 100% COVERAGE



UNIT 1 PZR - NOZZLE H EAD WELD

ITEM NO. 303.110.004A
I.D. NO. 1PZR-W41A
INSP David K. Z
DATE 05/26/05

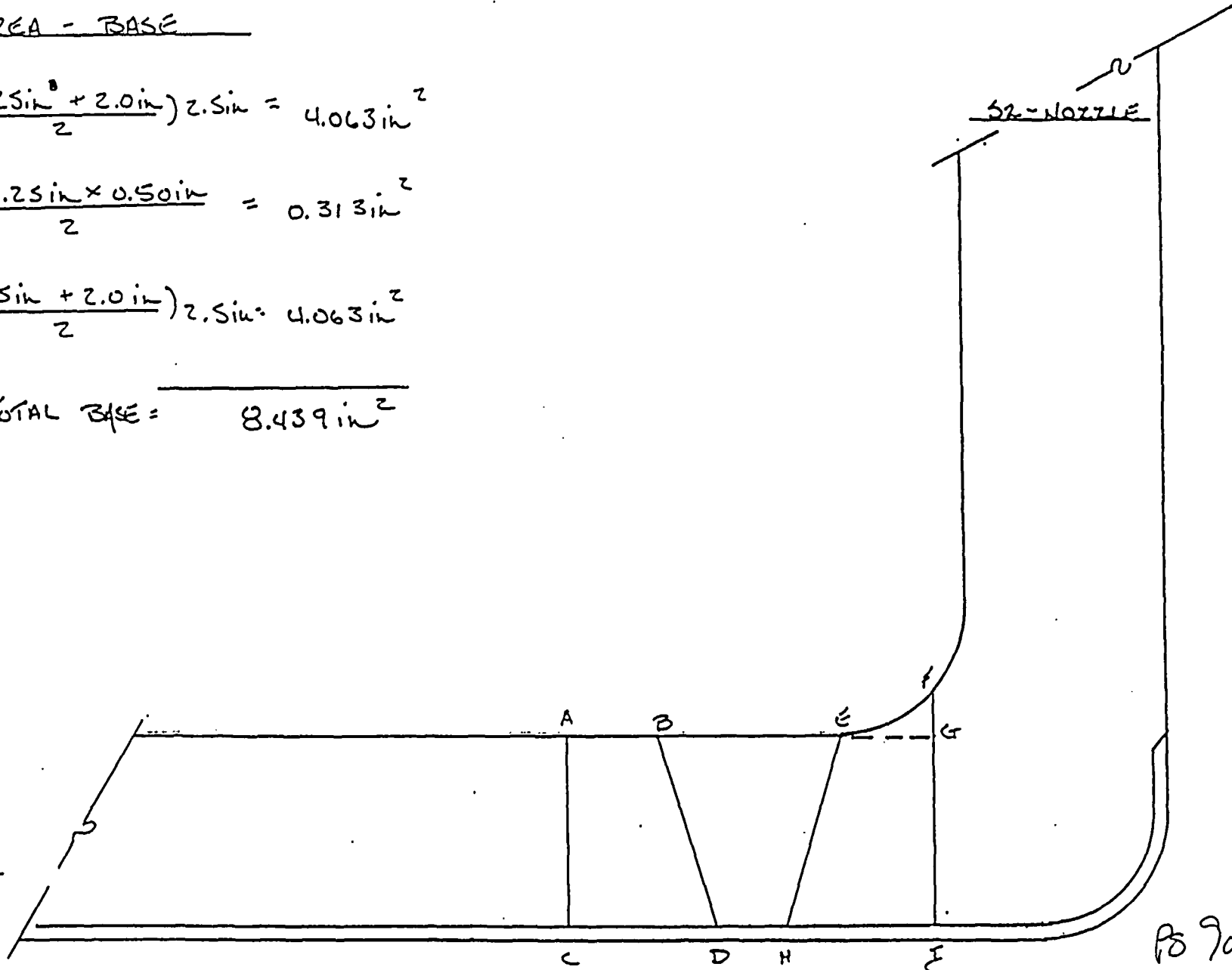
TOTAL AREA - BASE

$$ABCD : \left(\frac{1.25\text{in} + 2.0\text{in}}{2} \right) 2.5\text{in} = 4.063\text{in}^2$$

$$EFG : \frac{1.25\text{in} \times 0.50\text{in}}{2} = 0.313\text{in}^2$$

$$EGHI : \left(\frac{1.25\text{in} + 2.0\text{in}}{2} \right) 2.5\text{in} = 4.063\text{in}^2$$

$$\text{TOTAL BASE} = 8.439\text{in}^2$$



S1 - HEAD

S2 - NOZZLE

SCALE: 1/2" = 1.0"

NOTE: All dimensions taken
directly from drawing.

PS 7 OF 13

Attachment 5 of 9

UNIT 1 PZR - NOZZLE / HEAD WELD

ITEM NO. 03.110.004A
I.D. NO. 1PZR-004A
INSP Ravi K B II
DATE 05/26/05

BASE METAL AXIAL SCAN 1 - (45°, 60°)

60° $ABC: \frac{1.5 \text{ in} \times 1.3 \text{ in}}{2} = 0.975 \text{ in}^2$

60° PERCENT OF COVERAGE

$$8.439 \text{ in}^2 - 0.975 \text{ in}^2 = 7.464 \text{ in}^2$$

$$7.464 \text{ in}^2 / 8.439 \text{ in}^2 = .8845 \times 100 = 88.45 \%$$

45°

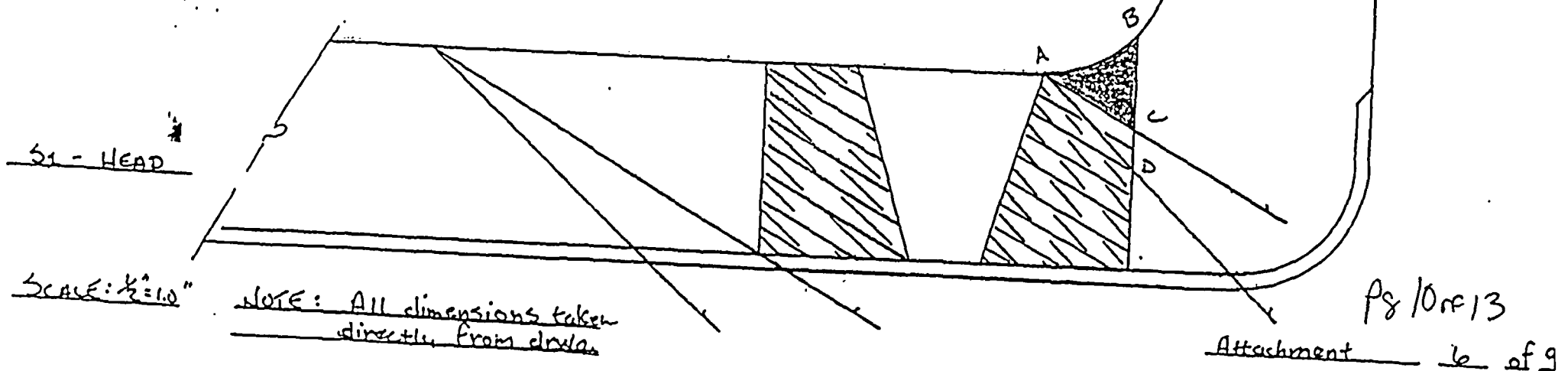
$$ABC: \frac{1.5 \text{ in} \times 1.3 \text{ in}}{2} = 0.975 \text{ in}^2$$

$$ACD: \frac{1.5 \text{ in} \times 0.5 \text{ in}}{2} = \frac{0.375 \text{ in}^2}{1.35 \text{ in}^2}$$

45° PERCENT OF COVERAGE

$$8.439 \text{ in}^2 - 1.35 \text{ in}^2 = 7.089 \text{ in}^2$$

$$7.089 \text{ in}^2 / 8.439 \text{ in}^2 = .8400 \times 100 = 84.0 \%$$

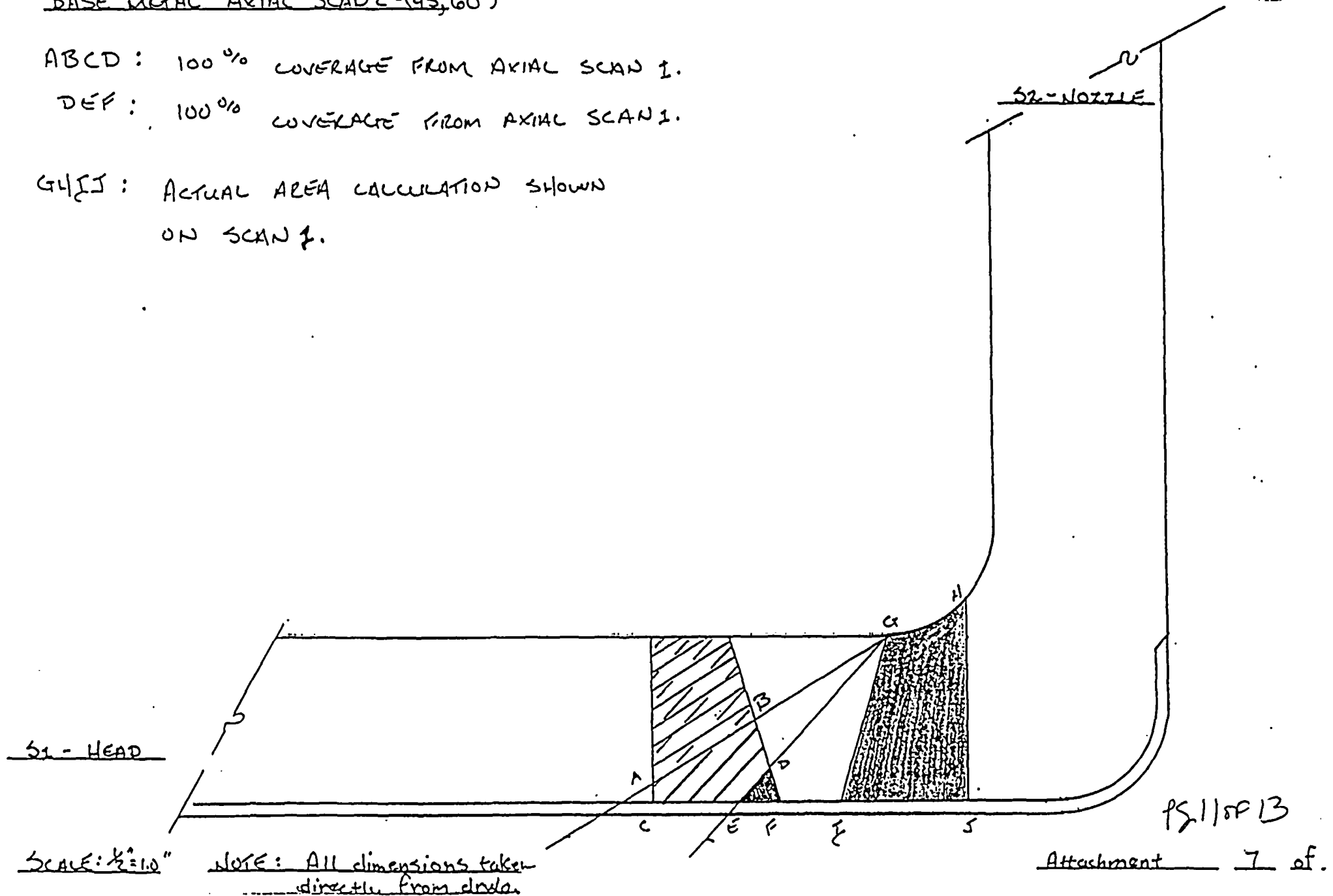


ITEM NO. B03.110.0044
I.D. NO. 1PZR-WYA
INSP *Danilk 3-III*
DATE 05/26/05

ABCD : 100% COVERAGE FROM AXIAL SCAN 1.

DEF: 100% coverage from AXIAL SCAN 1.

GLIS: ACTUAL AREA CALCULATION SHOWN
ON SCAN 1.



BASE - 0° & CW/CCW SCAN (45°, 60°)

$$ABC : \frac{1.25 \text{ in} \times 0.50 \text{ in}}{2} = 0.313 \text{ in}^2$$

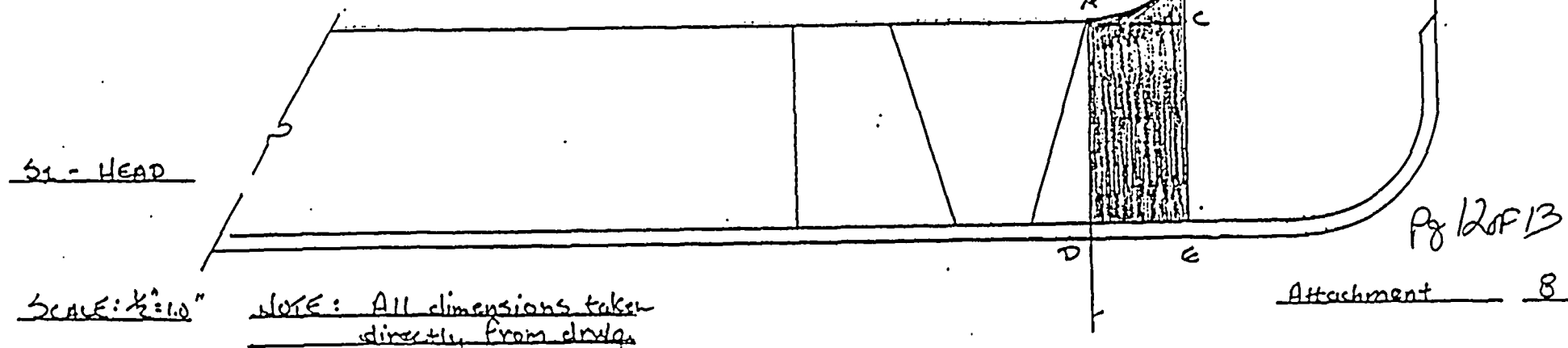
$$ACDE : 1.25 \text{ in} \times 2.5 \text{ in} = 3.125 \text{ in}^2$$

$$\frac{3.438 \text{ in}^2}{3.438 \text{ in}^2}$$

$$8.439 \text{ in}^2 - 3.438 \text{ in}^2 = 5.001 \text{ in}^2$$

PERCENT OF COVERAGE

$$5.001 \text{ in}^2 / 8.439 \text{ in}^2 = .5926 \times 100 = 59.26\%$$

SCALE: 1/2" = 1.0"NOTE: All dimensions taken directly from drawings

DUKE POWER COMPANY

ISI LIMITATION REPORT

Component/Weld ID: <u>1PZR-W4A</u> Item No: <u>B03.110.004A</u>		remarks:
<input checked="" type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> cw <input checked="" type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 <u>C/L+</u> to <u>Beyond</u> ANGLE: <input checked="" type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input checked="" type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG		Nozzle Configuration
<input checked="" type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 <u>C/L+</u> to <u>Beyond</u> ANGLE: <input type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input checked="" type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG		Nozzle Configuration
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG		
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG		
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG		Sketch(s) attached <input checked="" type="checkbox"/> yes <input type="checkbox"/> No
Prepared By: <u>David Zimmerman</u> <i>David Zimmerman</i> Level: <u>III</u> Date: <u>05262005</u> Attachment <u>Sheet 9</u> of <u>9</u>		
Reviewed By: <u>DeHansen</u> Date: <u>5-29-05</u> Authorized Inspector: <u>Robert McCall</u> Date: <u>6-8-05</u>		

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UT Vessel Examination

Site/Unit: Catawba / 1

Procedure: NDE-640

Outage No.: CNS1EOC15

Summary No.: B03.110.005

Procedure Rev.: 3

Report No.: UT-05-216

Workscope: ISI

Work Order No.: 98688945

Page: 1 of 1

Code: Asme Section XI 1989 Cat./Item: B-D- /B3.110.5 Location: N/A

Drawing No.: CNM 1201.01-175/1 Description: PZR Safety Nozzle to Upper Head

System ID: NC

Component ID: B03.110.005 /1PZR-W4B Size/Length: N/A Thickness/Diameter: 1.9" / 15.0"

Limitations: Yes - See Limitation Report for 820 Exam Start Time: 1245 Finish Time: 1249

Examination Surface: Inside ☐ Outside ☒ Surface Condition: AS GROUND

Lo Location: 9.2.3 Wo Location: Centerline of Weld Couplant: ULTRAGEL II Batch No.: 05125

Temp. Tool Mfg.: D.A.S Serial No.: MCNDE32798 Surface Temp.: 69 °F

Cal. Report No.: CAL-05-228

Angle Used	0	45	45T	60	60T	
Scanning dB	31.5					

Indication(s): Yes ☐ No ☒ Scan Coverage: Upstream ☐ Downstream ☒ CW ☒ CCW ☒

Comments:

Results: Accept ☒ Reject ☐ Info ☐

Percent Of Coverage Obtained > 90%: No - 79.2% Reviewed Previous Data: Yes

Examiner	Level	Signature	Date	Reviewer	Signature	Date
Leeper, Winfred C.	II	<i>Winfred C. Leeper</i>	5/26/2005	<i>DE Housen</i>	<i>5-29-05</i>	
Examiner	Level	Signature	Date	Site Review	Signature	Date
Keene, Douglas L.	II-N	<i>Douglas L. Keene</i>	5/26/2005	N/A		
Other	Level	Signature	Date	ANII Review	Signature	Date
Ransom, Greg	II-N	<i>Greg Ransom</i>	5/26/2005	<i>Robert M. Hill</i>	<i>6-8-05</i>	

RFR#05-CN-004 ATTACHMENT E

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UT Vessel Examination

Site/Unit: Catawba / 1

Procedure: NDE-820

Outage No.: CNS1EOC15

Summary No.: B03.110.005

Procedure Rev.: 2

Report No.: UT-05-219

Workscope: ISI

Work Order No.: 98688945

Page: 1 of 3

Code: Asme Section XI 1989 Cat./Item: B-D- /B3.110.5 Location: N/A

Drawing No.: CNM 1201.01-175/1 Description: PZR Safety Nozzle to Upper Head

System ID: NC

Component ID: B03.110.005 /1PZR-W4B Size/Length: N/A Thickness/Diameter: 1.9" / 15.0"

Limitations: Yes-See Attached Limitation Report Start Time: 1212 Finish Time: 1235

Examination Surface: Inside ☐ Outside ☒ Surface Condition: AS GROUND

Lo Location: 9.2.3 Wo Location: Centerline of Weld Couplant: ULTRAGEL II Batch No.: 05125

Temp. Tool Mfg.: D.A.S Serial No.: MCNDE32798 Surface Temp.: 69 °F

Cal. Report No.: CAL-05-229, CAL-05-230

Angle Used	0	45	45T	60	60T	
Scanning dB		53		67.4		

Indication(s): Yes ☐ No ☒ Scan Coverage: Upstream ☐ Downstream ☒ CW ☒ CCW ☒

Comments:

Results: Accept ☒ Reject ☐ Info ☐

Percent Of Coverage Obtained > 90%: No- 79.2% Reviewed Previous Data: Yes

Examiner	Level	Signature	Date	Reviewer	Signature	Date
Leeper, Winfred C.	II	<i>Winfred C. Leeper</i>	5/26/2005	<i>Steve Hansen</i>		5-27-05
Examiner	Level	Signature	Date	Site Review	Signature	Date
Keene, Douglas L.	II-N	<i>Douglas L. Keene</i>	5/26/2005	N/A		
Other	Level	Signature	Date	ANII Review	Signature	Date
Ransom, Greg	II-N	<i>Greg Ransom</i>	5/26/2005	<i>Robert M. Bell</i>		6-8-05

PS 2 of 13



Determination of Percent Coverage for UT Examinations - Vessels

Site/Unit:	<u>Catawba / 1</u>	Procedure:	<u>NDE-820</u>	Outage No.:	<u>CNS1EOC15</u>
Summary No.:	<u>B03.110.005</u>	Procedure Rev.:	<u>2</u>	Report No.:	<u>UT-05-219</u>
Workscope:	<u>ISI</u>	Work Order No.:	<u>98688945</u>	Page:	<u>2</u> of <u>3</u>

0 deg Planar

Scan 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for 0 deg

45 deg

Scan 1 100.000 % Length X 92.000 % volume of length / 100 = 92.000 % total for Scan 1

Scan 2 100.000 % Length X 66.710 % volume of length / 100 = 66.710 % total for Scan 2

Scan 3 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for Scan 3

Scan 4 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for Scan 4

Add totals and divide by # scans = 79.493 % total for 45 deg

Other deg 60

Scan 1 100.000 % Length X 94.230 % volume of length / 100 = 94.230 % total for Scan 1

Scan 2 100.000 % Length X 60.520 % volume of length / 100 = 60.520 % total for Scan 2

Scan 3 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for Scan 3

Scan 4 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for Scan 4

Add totals and divide by # scans = 78.503 % total for 60 deg

Percent complete coverage

Add totals for each angle and scan required and divide by # of angles to determine;

79.208 % Total for complete exam

Note:

Supplemental coverage may be achieved by use of other angles / methods. When used, the coverage for volume not obtained with angles as noted above shall be calculated and added to the total to provide the percent total for the complete examination.

Site Field Supervisor:

David C. III

Date: 05/26/05

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Limitation Record

Site/Unit: Catawba / 1
Summary No.: B03.110.005
Workscope: ISI

Procedure: NDE-820
Procedure Rev.: 2
Work Order No.: 98688945

Outage No.: CNS1EOC15
Report No.: UT-05-219
Page: 3 of 3

Description of Limitation:

See Attachment for Limitation Calculations.
Coverage

Aggregate %

Sketch of Limitation:

<u>4</u>	<u>SCAN</u>	<u>WELD %</u>	<u>BASE %</u>	<u>AGGREGATE</u>
45°	1	100.00	84.00	92.00
	2	49.41	84.00	66.71
	3	100.00	59.26	79.63
	4	100.00	59.26	79.63
60°	1	100.00	88.45	94.23
	2	37.04	84.00	60.52
	3	100.00	59.26	79.63
	4	100.00	59.26	79.63
0°		100.00	59.26	79.63
				79.63

Limitations removal requirements:

Radiation field:

Examiner	Level	Signature	Date	Reviewer	Signature	Date
Leeper, Winfred C.	II	<i>Winfred C. Leeper</i>	5/26/2005	<i>ME Hanner</i>		5.29.05
Examiner	Level	Signature	Date	Site Review	Signature	Date
Keene, Douglas L.	II-N	<i>Douglas L. Keene</i>	5/26/2005	N/A		
Other	Level	Signature	Date	ANII Review	Signature	Date
Ransom, Greg	II-N	<i>Greg Ransom</i>	5/26/2005	<i>Robert McNeil</i>		6.8.05

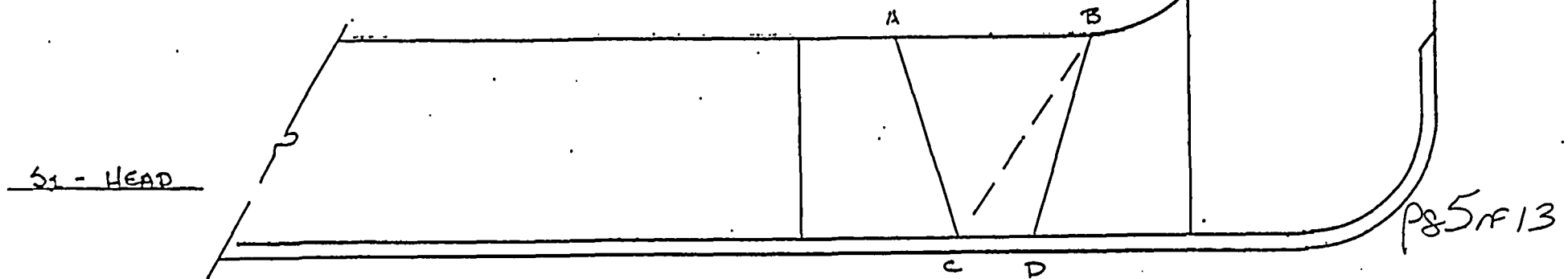
P84rF13

TOTAL AREA - WELD

$$ABC : \frac{2.5\text{in} \times 2.7\text{in}}{2} = 3.375\text{in}^2$$

$$BCD : \frac{2.7\text{in} \times 1.0\text{in}}{2} = 1.35\text{in}^2$$

$$\text{TOTAL WELD} = 4.725\text{in}^2$$



SCALE: 1/2" = 1.0"

NOTE: All dimensions taken
directly from drawings

Attachment - 1 of 9

UNIT 1 PZR - NOZZLE / HEAD WELD

ITEM NO. 303.110.005
I.D. NO. 1PZR-W4B
INSP David K. 2-III
DATE 05/26/05

WELD

SCAN 2 AXIAL SCAN - 60°

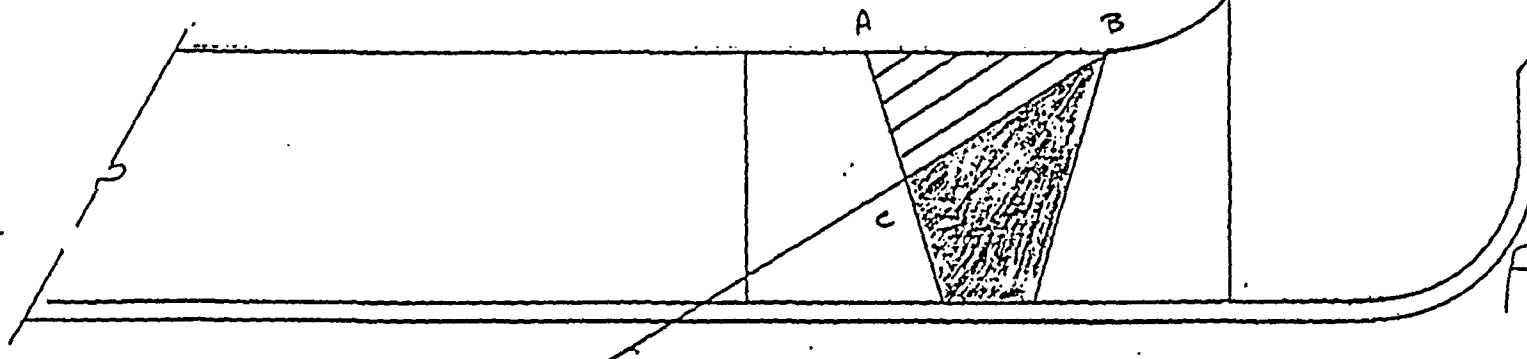
$$ABC: \frac{2.5 \text{ in} \times 1.4 \text{ in}}{2} = 1.75 \text{ in}^2$$

PERCENT OF COVERAGE

$$\frac{1.75 \text{ in}^2}{4.72 \text{ in}^2} = .3704 \times 100 = 37.04 \%$$

S1 - HEAD

S2 - NOZZLE



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SCALE: 1/2" = 1.0"

NOTE: All dimensions taken directly from data

Attachment 2 of 9

WELD

UNIT 1 PZR - NOZZLE / 1" AD WELD

ITEM NO. 03.110.005
I.D. NO. PZR-W4B
INSP David K. Z. III
DATE 05/26/05

SCAN 2 AXIAL SCAN - 45°

$$ABC: \frac{2.8 \text{ in} \times 0.6 \text{ in}}{2} = 0.84 \text{ in}^2$$

$$BCD: \frac{3.1 \text{ in} \times 1.0 \text{ in}}{2} = 1.55 \text{ in}^2$$

$$\text{TOTAL} = 2.39 \text{ in}^2$$

PERCENT OF COVERAGE

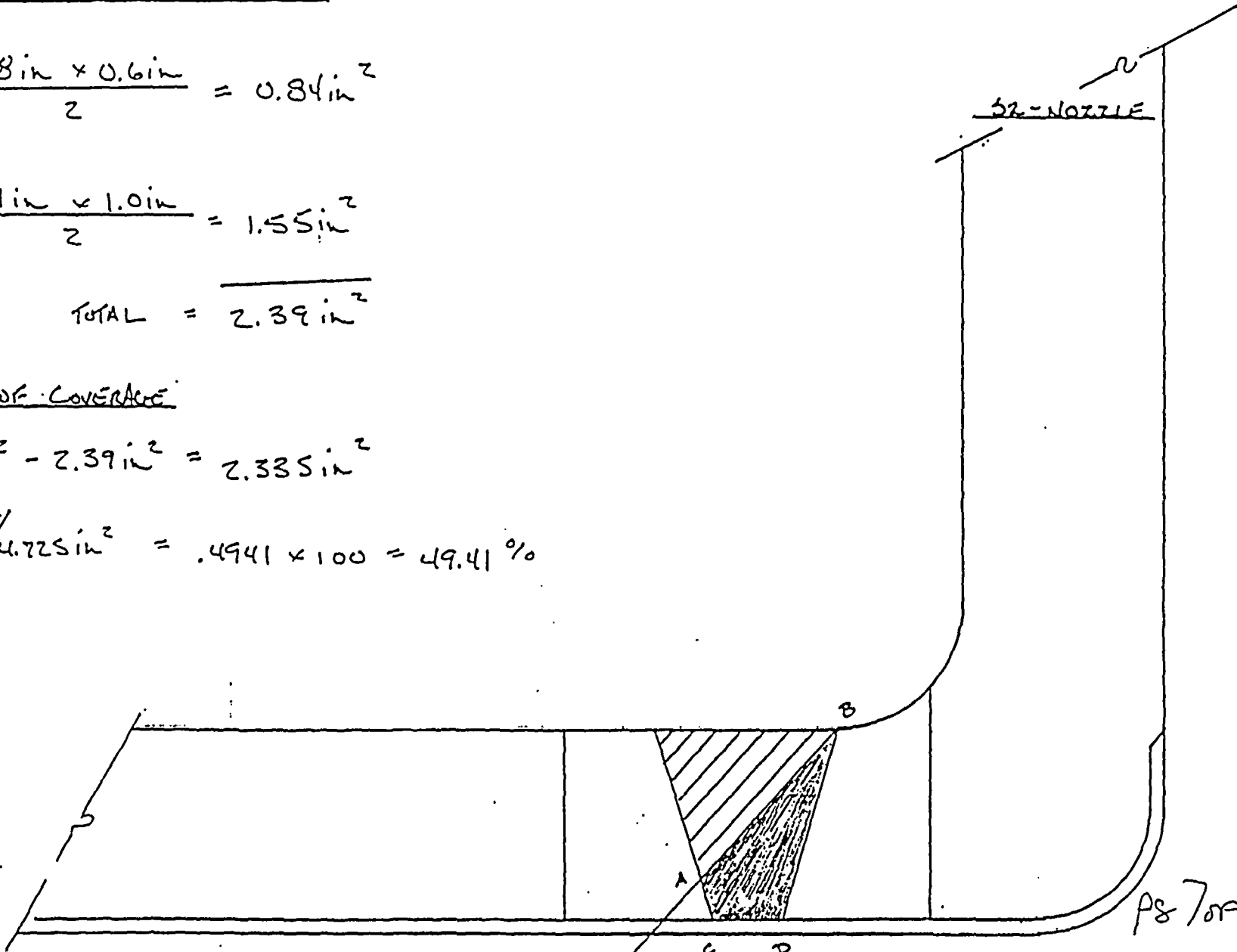
$$4.725 \text{ in}^2 - 2.39 \text{ in}^2 = 2.335 \text{ in}^2$$

$$\frac{2.335 \text{ in}^2}{4.725 \text{ in}^2} = .4941 \times 100 = 49.41 \%$$

S1 - HEAD

SCALE: 1/2" = 1.0"

NOTE: All dimensions taken
directly from drawing



S2 - NOZZLE

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Attachment 3 of 9

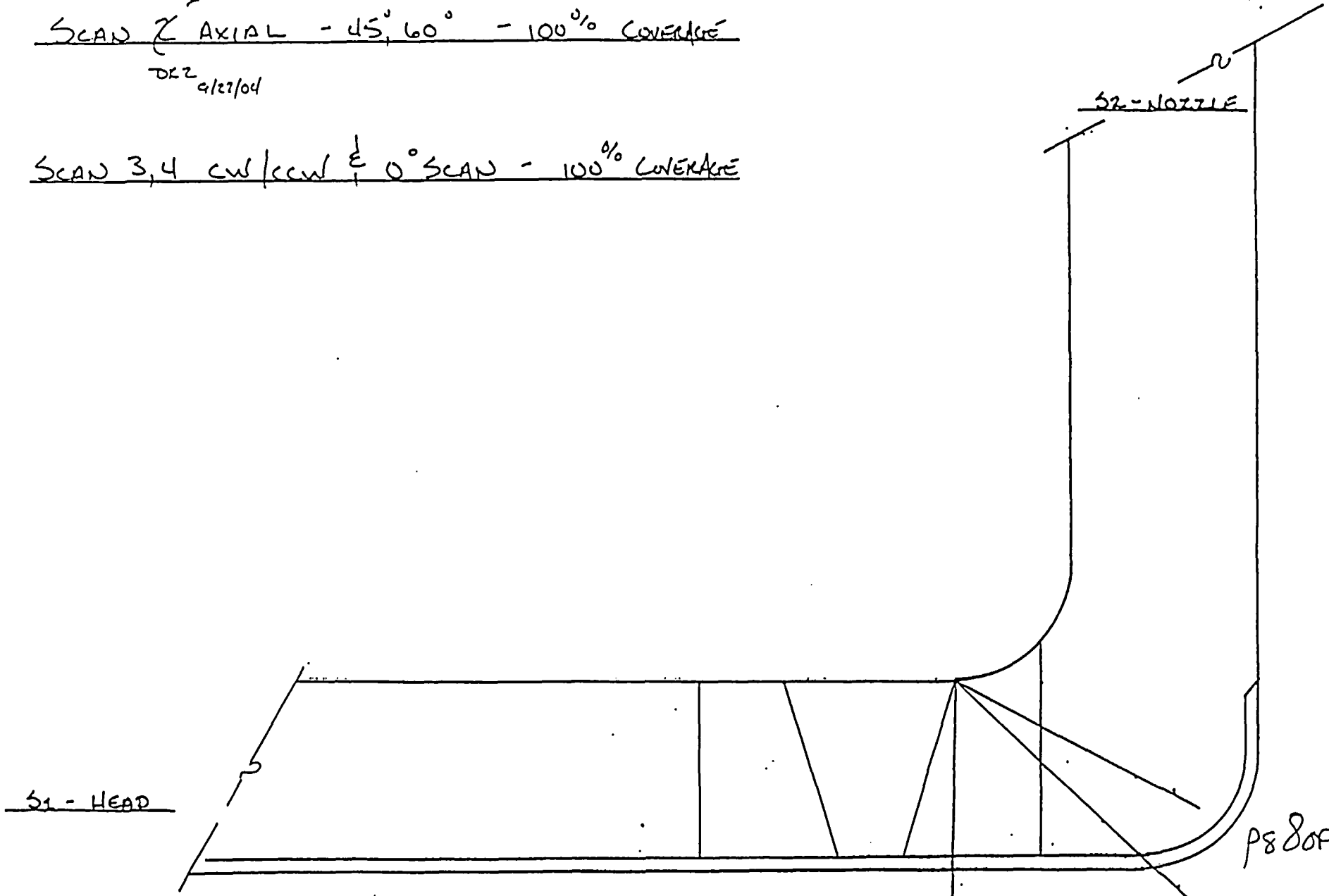
UNIT 1 PPK - NOZZLE / HEAD WELD

ITEM NO. 03.110.005
I.D. NO. 1PZR-W4B
INSP Devk. 3 III
DATE 05/26/05

WELD

SCAN 1 AXIAL - 45°, 60° - 100% COVERAGE
DLZ 9/27/04

SCAN 3, 4 CW/CCW & 0° SCAN - 100% COVERAGE



S1 - HEAD

S2 - NOZZLE

SCALE: 1/2" = 1.0"

NOTE: All dimensions taken directly from drawings

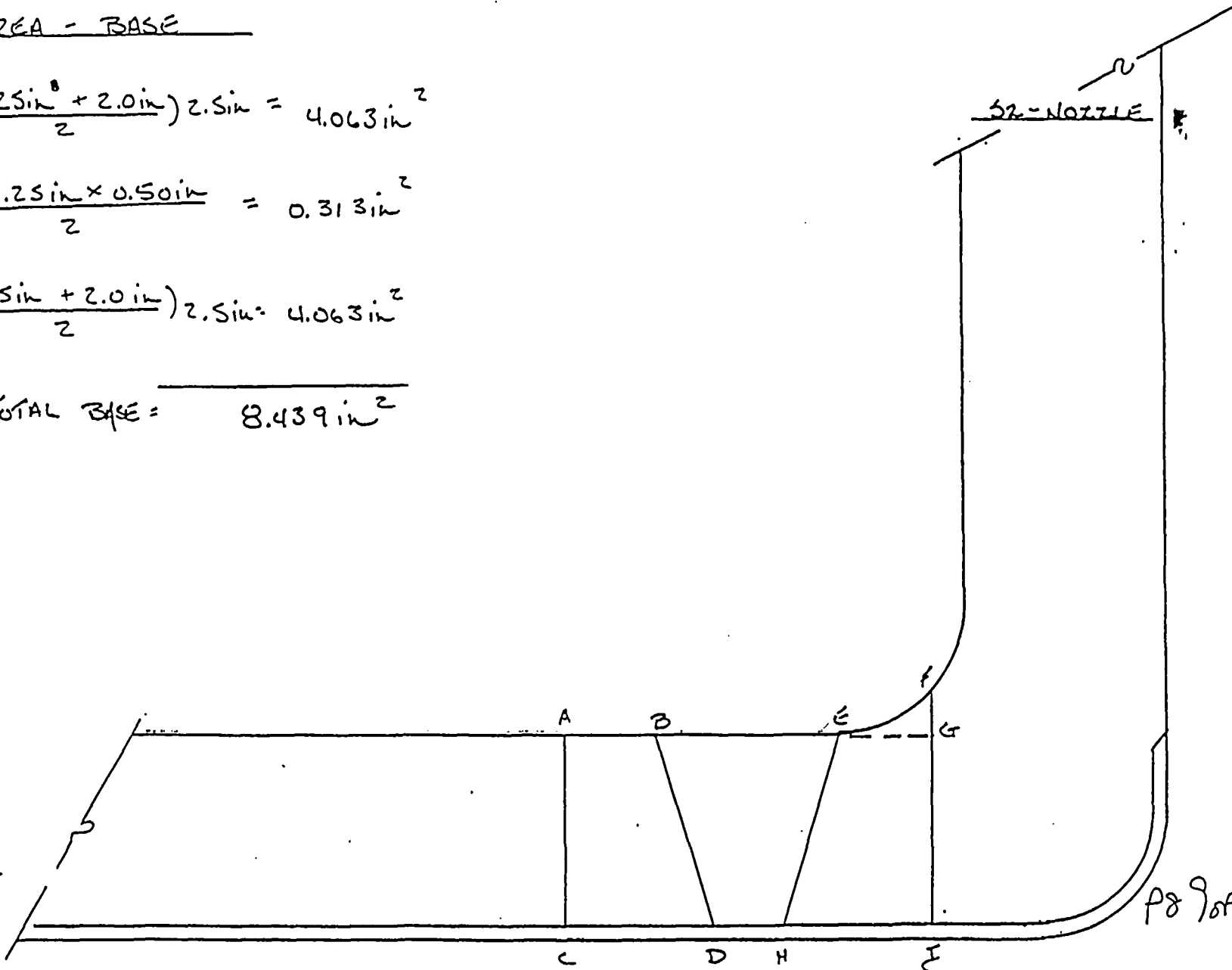
TOTAL AREA - BASE

$$ABCD: \left(\frac{1.25\text{in} + 2.0\text{in}}{2} \right) 2.5\text{in} = 4.063\text{in}^2$$

$$EFG: \frac{1.25\text{in} \times 0.50\text{in}}{2} = 0.313\text{in}^2$$

$$EGHI: \left(\frac{1.25\text{in} + 2.0\text{in}}{2} \right) 2.5\text{in} = 4.063\text{in}^2$$

$$\text{TOTAL BASE} = 8.439\text{in}^2$$



SCALE: $\frac{1}{2} = 1.0"$

NOTE: All dimensions taken
directly from dwg.

Attachment 5 of 9

UNIT 1 PZR - NOZZLE / HEAD WELD

ITEM NO. 303.110.005
I.D. NO. 1PZR-11243
INSP Daulkz - JH
DATE 05/26/05

BASE METAL AXIAL SCAN 1 - (45°, 60°)

60° $ABC: \frac{1.5 \sin \times 1.3 \sin}{2} = 0.975 \sin^2$

60° PERCENT OF COVERAGE

$$8.439 \text{ in}^2 - 0.975 \sin^2 = 7.464 \text{ in}^2$$

$$7.464 \text{ in}^2 / 8.439 \text{ in}^2 = .8845 \times 100 = 88.45 \%$$

45°

$$ABC: \frac{1.5 \sin \times 1.3 \sin}{2} = 0.975 \sin^2$$

$$ACD: \frac{1.5 \sin \times 0.5 \sin}{2} = \frac{0.375 \sin^2}{1.3 \sin^2}$$

45° PERCENT OF COVERAGE

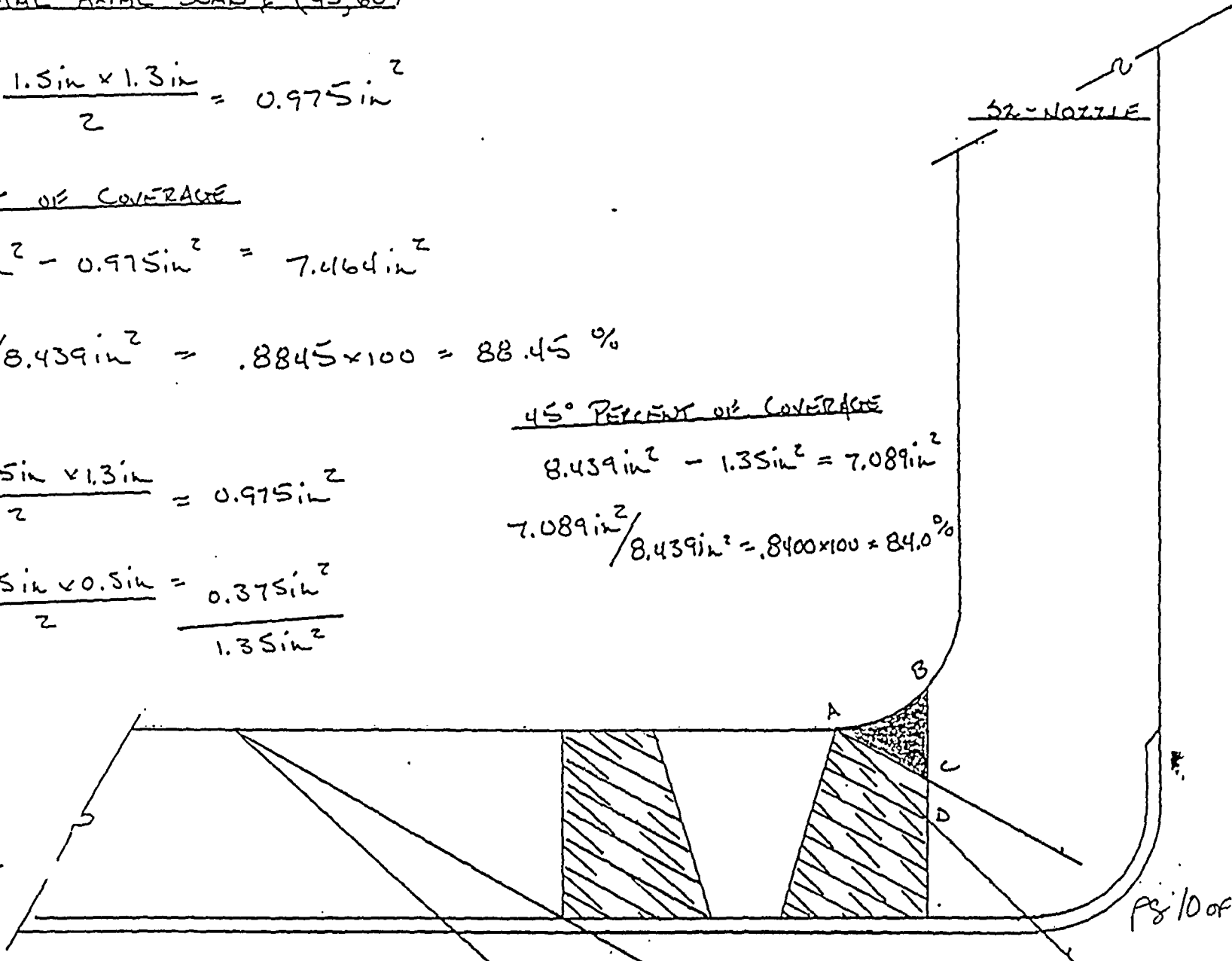
$$8.439 \text{ in}^2 - 1.3 \sin^2 = 7.089 \text{ in}^2$$

$$7.089 \text{ in}^2 / 8.439 \text{ in}^2 = .8400 \times 100 = 84.0 \%$$

S1 - HEAD

SCALE: 1/2" = 1.0" NOTE: All dimensions taken

S2 - NOZZLE



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Attachment 16 of 9

UNIT 1 PZR - NOZZLE LEAD WELD

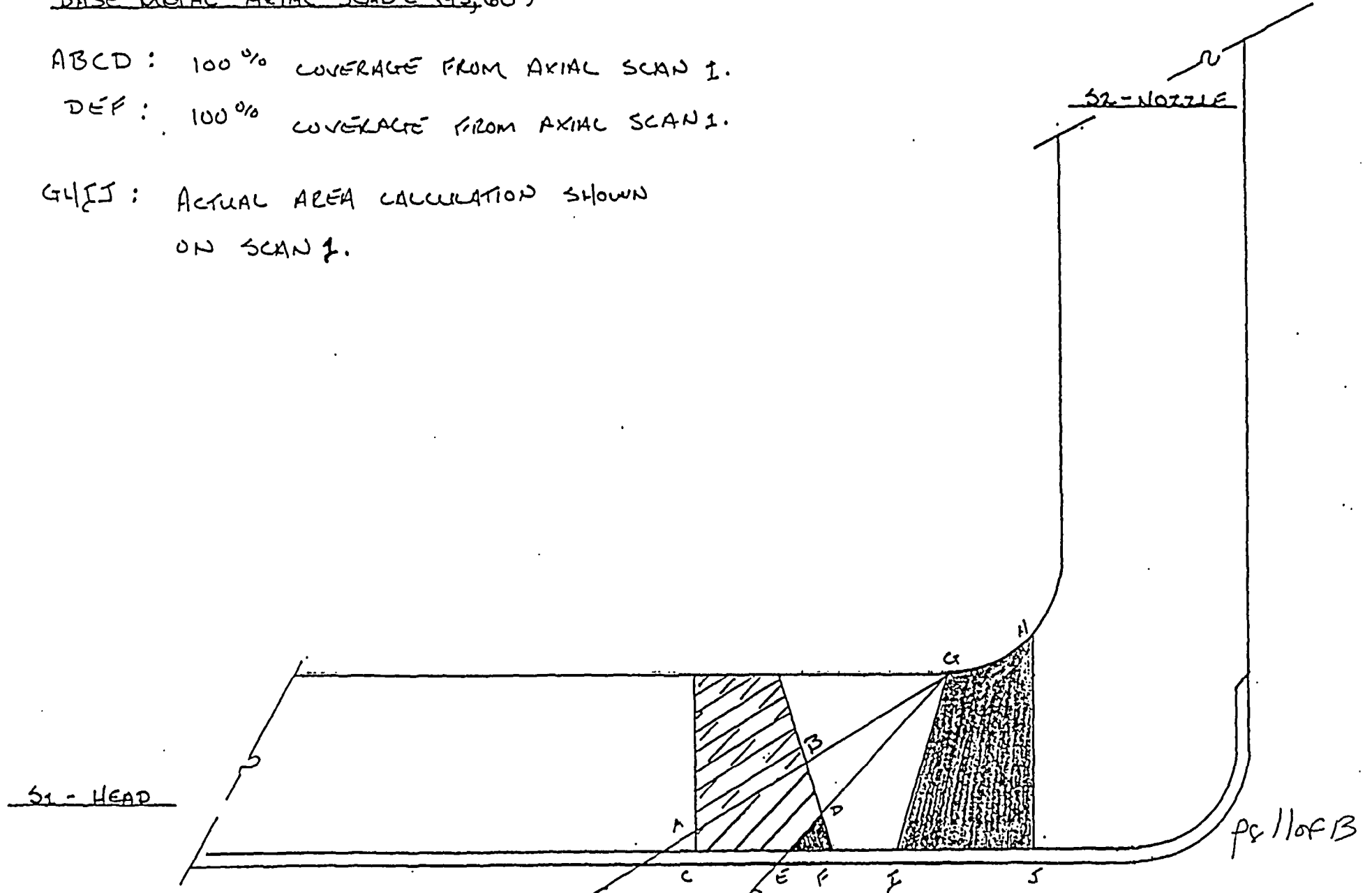
ITEM NO. B03.110.005
I.D. NO. 1PZR-W43
INSP. Daniel K. S. II
DATE 05/26/05

BASE METAL AXIAL SCAN 2 - (45°, 60°)

ABCD : 100% COVERAGE FROM AXIAL SCAN 1.

DEF : 100% COVERAGE FROM AXIAL SCAN 1.

GHIJ : ACTUAL AREA CALCULATION SHOWN
ON SCAN 1.



SCALE: $\frac{1}{2}'' = 1.0''$

NOTE: All dimensions taken
directly from echo.

Attachment 7 of 9

UNIT 1 PZR - NOZZLE / HEAD WELD

ITEM NO. 03.110.005
I.D. NO. 1PZR-104B
INSP: Paul H. B. III
DATE: 05/26/05

BASE - 0° & CW/CCW SCAN (45°, 60°)

$$ABC : \frac{1.25 \text{ in} \times 0.50 \text{ in}}{2} = 0.313 \text{ in}^2$$

$$ACDE : 1.25 \text{ in} \times 2.5 \text{ in} = 3.125 \text{ in}^2$$

$$\frac{3.438 \text{ in}^2}{8.439 \text{ in}^2 - 3.438 \text{ in}^2 = 5.001 \text{ in}^2}$$

$$8.439 \text{ in}^2 - 3.438 \text{ in}^2 = 5.001 \text{ in}^2$$

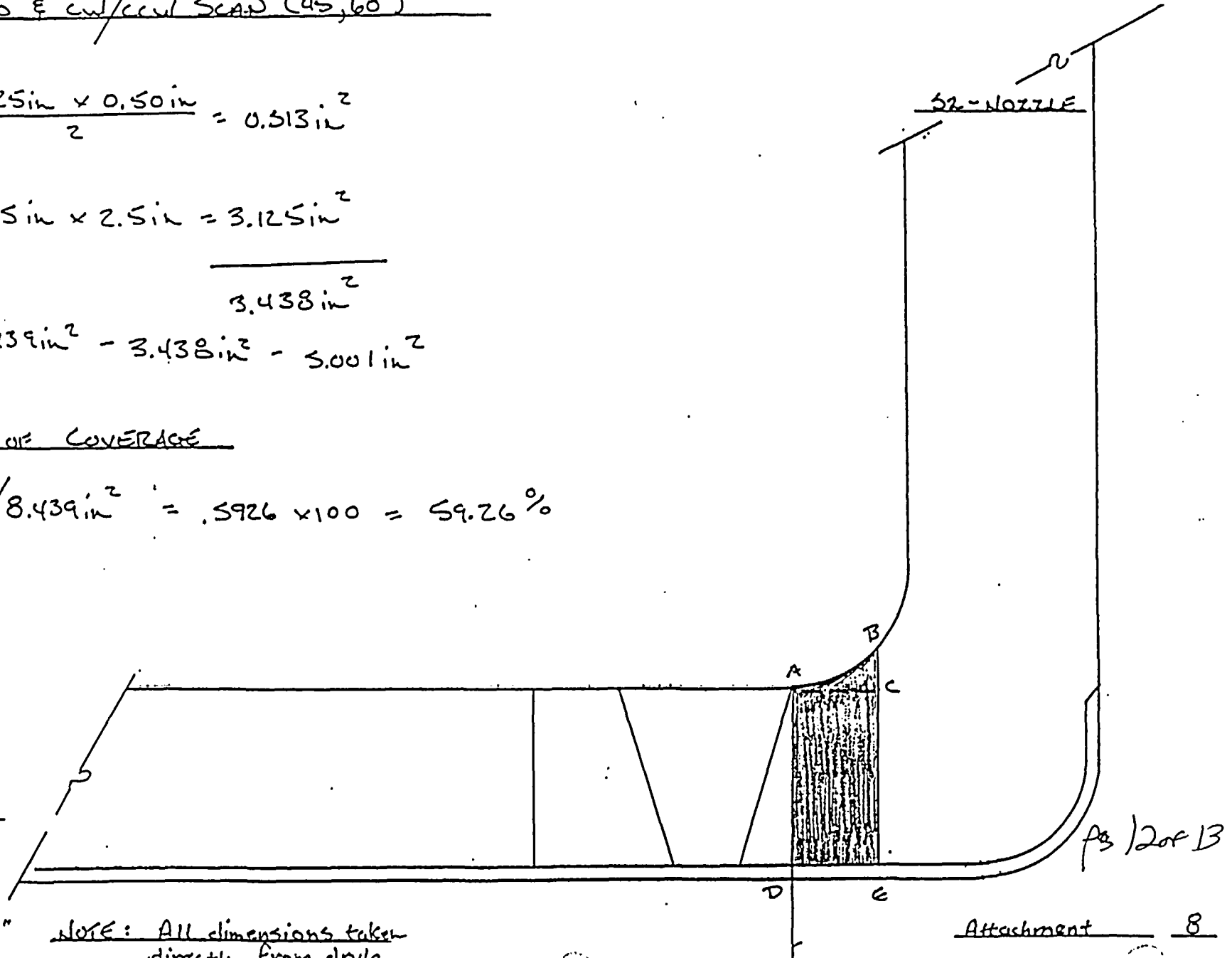
PERCENT OF COVERAGE

$$\frac{5.001 \text{ in}^2}{8.439 \text{ in}^2} = .5926 \times 100 = 59.26\%$$

S1 - HEAD

SCALE: 1/2" = 1.0"

NOTE: All dimensions taken directly from drwg.



Attachment 8 of 9

DUKE POWER COMPANY

ISI LIMITATION REPORT

Component/Weld ID: <u>1PZR-W4B</u> Item No: <u>B03.110.005</u>		remarks: Nozzle Configuration Nozzle Configuration Nozzle Configuration Nozzle Configuration
<input checked="" type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> cw <input checked="" type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 <u>C/L+</u> to <u>Beyond</u> ANGLE: <input checked="" type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input checked="" type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG	<input checked="" type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 <u>C/L+</u> to <u>Beyond</u> ANGLE: <input type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input checked="" type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG	
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG	<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG	
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG	<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG	
Prepared By: David Zimmerman <i>David Zimmerman</i> Level: III Date: 05262005 Attachment Sheet <u>9</u> of <u>9</u>		Sketch(s) attached <input checked="" type="checkbox"/> yes <input type="checkbox"/> No
Reviewed By: <i>DeHouwer</i> Date: <u>5-29-05</u> Authorized Inspector: <i>Robert M. Lill</i> Date: <u>6-8-05</u>		pg 13 of 13



UT Vessel Examination

Site/Unit: Catawba / 1
Summary No.: B03.110.006A
Workscope: ISI

Procedure: NDE-640
Procedure Rev.: 3
Work Order No.: 98688945

Outage No.: CNS1EOC15
Report No.: UT-05-217
Page: 1 of 1

Code: Asme Section XI 1989 Cat./Item: B-D- /B3.110.6A Location: N/A
Drawing No.: CNM 1201.01-175/1 Description: PZR Safety Nozzle to Upper Head
System ID: NC
Component ID: B03.110.006A/1PZR-W4C Size/Length: N/A Thickness/Diameter: 1.9" / 15.0"
Limitations: Yes- See Limitation Report for 820 Exam Start Time: 1211 Finish Time: 1216

Examination Surface: Inside ☐ Outside ☒ Surface Condition: AS GROUND
Lo Location: 9.2.3 Wo Location: Centerline of Weld Couplant: ULTRAGEL II Batch No.: 05125
Temp. Tool Mfg.: D.A.S Serial No.: MCNDE32798 Surface Temp.: 69 °F
Cal. Report No.: CAL-05-228

Angle Used	0	45	45T	60	60T	
Scanning dB	31.5					

Indication(s): Yes ☐ No ☒ Scan Coverage: Upstream ☐ Downstream ☒ CW ☒ CCW ☒

Comments:

Results: Accept ☒ Reject ☐ Info ☐

Percent Of Coverage Obtained > 90%: No - 79.2%

Reviewed Previous Data: Yes

Examiner Level II Leeper, Winfred C.	Signature <i>Winfred C. Leeper</i>	Date 5/26/2005	Reviewer <i>W. E. Hansen</i>	Signature <i>W. E. Hansen</i>	Date 5.29.05
Examiner Level II-N Keene, Douglas L.	Signature <i>Douglas L. Keene</i>	Date 5/26/2005	Site Review N/A	Signature	Date
Other Level II-N Ransom, Greg	Signature <i>Greg Ransom</i>	Date 5/26/2005	ANII Review <i>Robert M. Hill</i>	Signature <i>Robert M. Hill</i>	Date 6.8.05

REF # 05-CN-004 ATTACHMENT F

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UT Vessel Examination

Site/Unit: Catawba / 1
Summary No.: B03.110.006A
Workscope: ISI

Procedure: NDE-820
Procedure Rev.: 2
Work Order No.: 98688945

Outage No.: CNS1EOC15
Report No.: UT-05-220
Page: 1 of 3

Code: Asme Section XI 1989 Cat./Item: B-D- /B3.110.6A Location: N/A
Drawing No.: CNM 1201.01-175/1 Description: PZR Safety Nozzle to Upper Head
System ID: NC
Component ID: B03.110.006A/1PZR-W4C Size/Length: N/A Thickness/Diameter: 1.9" / 15.0"
Limitations: Yes-See Attached Limitation Report Start Time: 1217 Finish Time: 1236

Examination Surface: Inside ☐ Outside ☒ Surface Condition: AS GROUND
Lo Location: 9.2.3 Wo Location: Centerline of Weld Couplant: ULTRAGEL II Batch No.: 05125
Temp. Tool Mfg.: D.A.S Serial No.: MCNDE32798 Surface Temp.: 69 °F
Cal. Report No.: CAL-05-229, CAL-05-230

Angle Used	0	45	45T	60	60T	
Scanning dB		53		67.4		

Indication(s): Yes ☐ No ☒ Scan Coverage: Upstream ☐ Downstream ☒ CW ☒ CCW ☒

Comments:

Results: Accept ☒ Reject ☐ Info ☐

Percent Of Coverage Obtained > 90%: No - 79.2%

Reviewed Previous Data: Yes

Examiner	Level	Signature	Date	Reviewer	Signature	Date
Leeper, Winfred C.	II	<i>Winfred C. Leeper</i>	5/26/2005	<i>DE Houser</i>		5-29-05
Examiner	Level	Signature	Date	Site Review	Signature	Date
Keene, Douglas L.	II-N	<i>Douglas L. Keene</i>	5/26/2005	N/A		
Other	Level	Signature	Date	ANII Review	Signature	Date
Ransom, Greg	II-N	<i>Greg Ransom</i>	5/26/2005	<i>Robert M. Hill</i>		6-8-05

PS 2 of 13



Determination of Percent Coverage for UT Examinations - Vessels

Site/Unit: <u>Catawba / 1</u>	Procedure: <u>NDE-820</u>	Outage No.: <u>CNS1EOC15</u>
Summary No.: <u>B03.110.006A</u>	Procedure Rev.: <u>2</u>	Report No.: <u>UT-05-220</u>
Workscope: <u>ISI</u>	Work Order No.: <u>98688945</u>	Page: <u>2</u> of <u>3</u>

0 deg Planar

Scan 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for 0 deg

45 deg

Scan 1 100.000 % Length X 92.000 % volume of length / 100 = 92.000 % total for Scan 1

Scan 2 100.000 % Length X 66.710 % volume of length / 100 = 66.710 % total for Scan 2

Scan 3 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for Scan 3

Scan 4 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for Scan 4

Add totals and divide by # scans = 79.493 % total for 45 deg

Other deg 60

Scan 1 100.000 % Length X 94.230 % volume of length / 100 = 94.230 % total for Scan 1

Scan 2 100.000 % Length X 60.520 % volume of length / 100 = 60.520 % total for Scan 2

Scan 3 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for Scan 3

Scan 4 100.000 % Length X 79.630 % volume of length / 100 = 79.630 % total for Scan 4

Add totals and divide by # scans = 78.503 % total for 60 deg

Percent complete coverage

Add totals for each angle and scan required and divide by # of angles to determine;

79.208 % Total for complete exam

Note:

Supplemental coverage may be achieved by use of other angles / methods. When used, the coverage for volume not obtained with angles as noted above shall be calculated and added to the total to provide the percent total for the complete examination.

Site Field Supervisor: David H. Z III

Date: 05/26/05

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Limitation Record

Site/Unit:	Catawba / 1	Procedure:	NDE-820	Outage No.:	CNS1EOC15
Summary No.:	B03.110.006A	Procedure Rev.:	2	Report No.:	UT-05-220
Workscope:	ISI	Work Order No.:	98688945	Page:	3 of 3

Description of Limitation:

See Attachment for Limitation Calculations.
Coverage

Aggregate %

Sketch of Limitation:

<u>Δ</u>	<u>SCAN</u>	<u>WELD %</u>	<u>BASE %</u>	<u>AGGREGATE</u>
45°	1	100.00	84.00	92.00
	2	49.41	84.00	66.71
	3	100.00	59.26	79.63
	4	100.00	59.26	79.63
60°	1	100.00	88.45	94.23
	2	37.04	84.00	60.52
	3	100.00	59.26	79.63
	4	100.00	59.26	79.63
0°		100.00	59.26	79.63

Limitations removal requirements:

Radiation field:

Examiner	Level II	Signature	Date	Reviewer	Signature	Date
Leeper, Winfred C.		<i>Winfred C. Leeper</i>	5/26/2005	<i>AE Hansen</i>		5-29-05
Examiner	Level II-N	Signature	Date	Site Review	Signature	Date
Keene, Douglas L.		<i>Douglas L. Keene</i>	5/26/2005	N/A		
Other	Level II-N	Signature	Date	ANII Review	Signature	Date
Ransom, Greg		<i>Greg Ransom</i>	5/26/2005	<i>Robert McMillan</i>		6-8-05

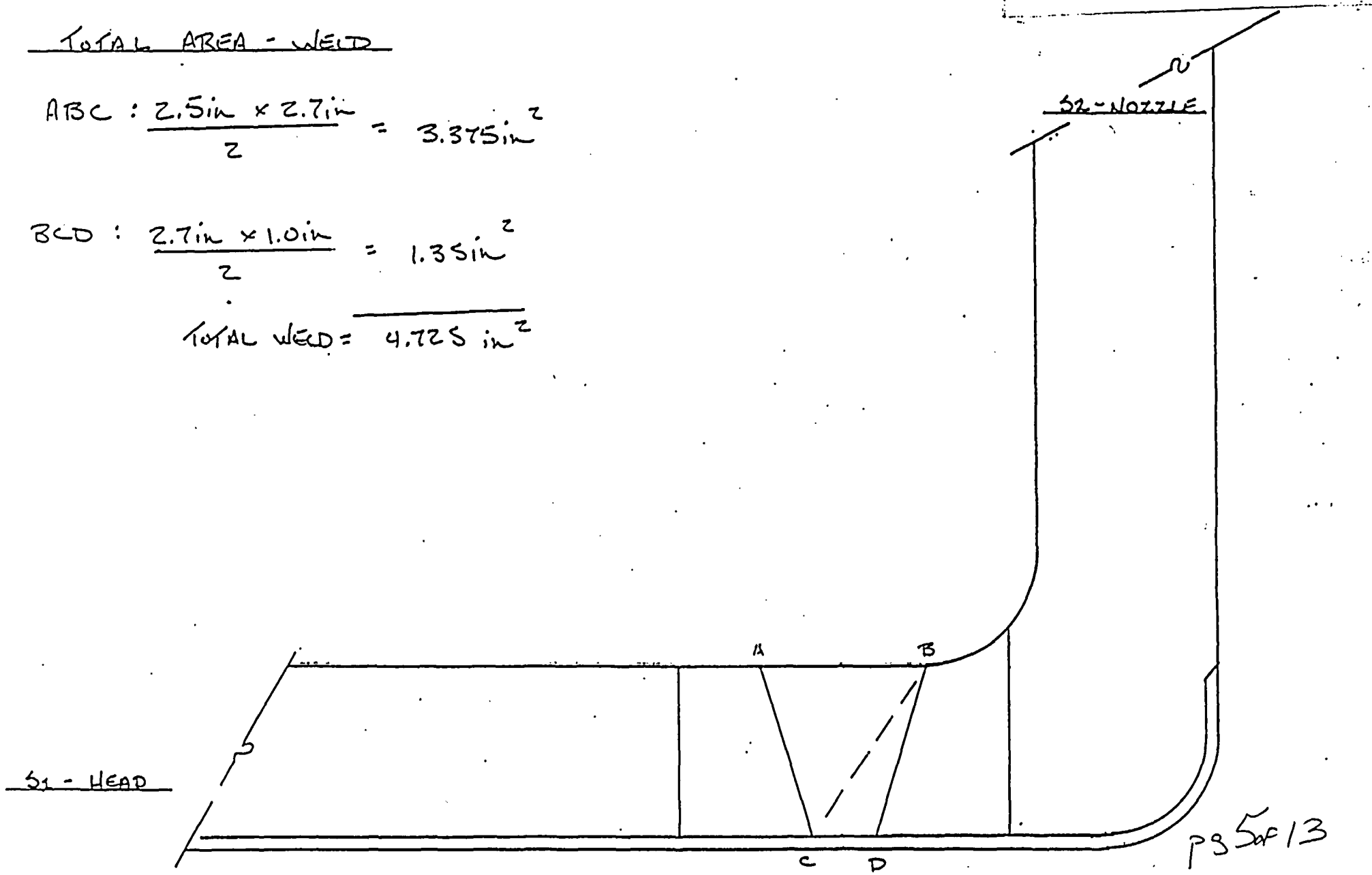
ps 4 of 13

TOTAL AREA - WELD

$$ABC : \frac{2.5in \times 2.7in}{2} = 3.375in^2$$

$$BCD : \frac{2.7in \times 1.0in}{2} = 1.35in^2$$

$$TOTAL WELD = 4.725 in^2$$



SCALE: $\frac{1}{2}'' = 1.0''$

NOTE: All dimensions taken directly from drawings

Attachment 1 of 1

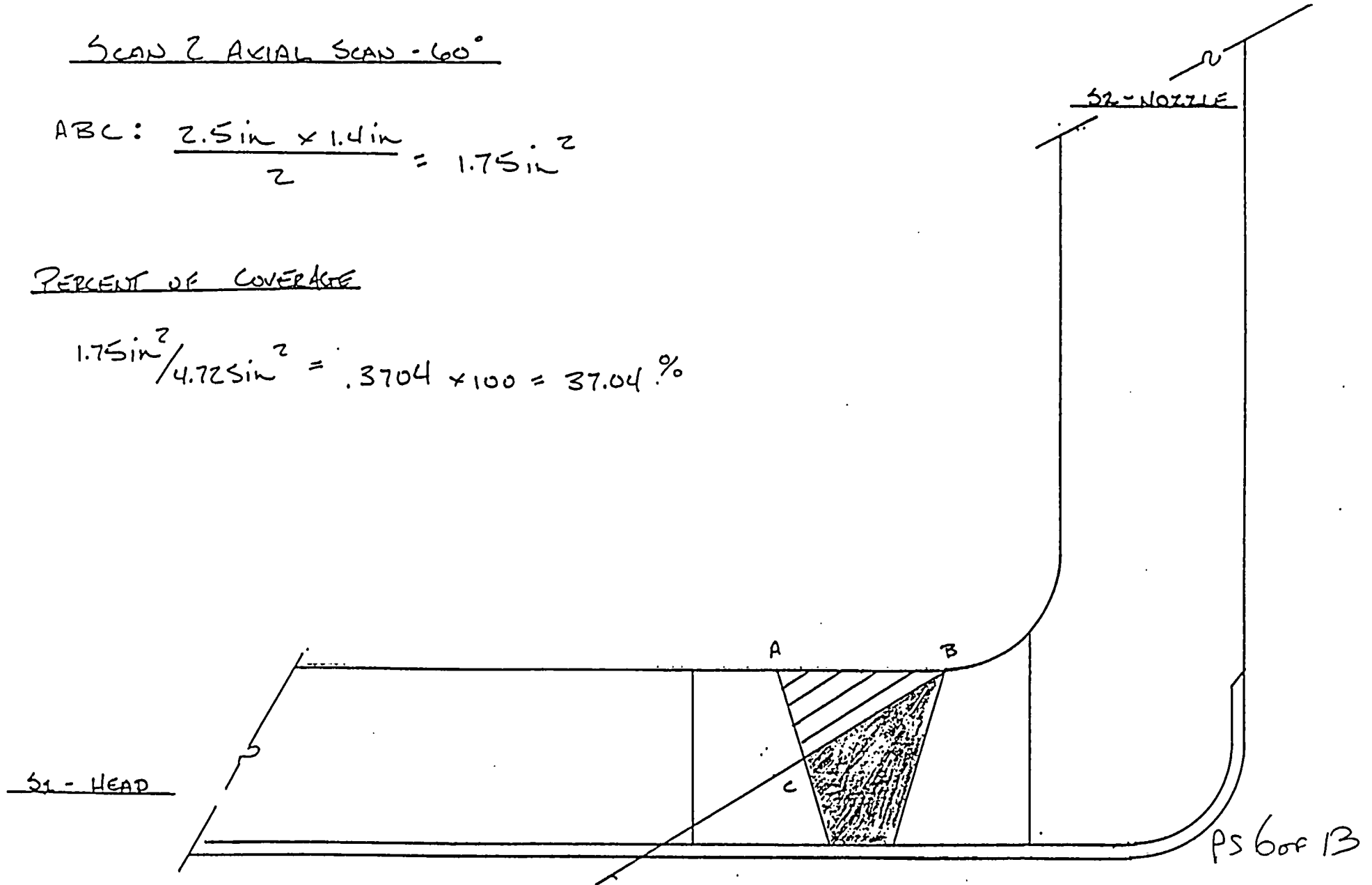
WELD

SCAN 2 AXIAL SCAN - 60°

$$ABC: \frac{2.5 \text{ in} \times 1.4 \text{ in}}{2} = 1.75 \text{ in}^2$$

PERCENT OF COVERAGE

$$\frac{1.75 \text{ in}^2}{4.72 \text{ in}^2} = .3704 \times 100 = 37.04 \%$$



SCALE: 1/2" = 1.0"

NOTE: All dimensions taken
directly from data.

Attachment 2 of 9

WELD

UNIT 1 PZR - NOZZLE / HEAD WELD

ITEM NO. 303.110.006A
I.D. NO. PZR-W4C
INSP David K. III
DATE 05/26/05

SCAN 2 AXIAL SCAN - 45°

$$ABC: \frac{2.8 \text{ in} \times 0.6 \text{ in}}{2} = 0.84 \text{ in}^2$$

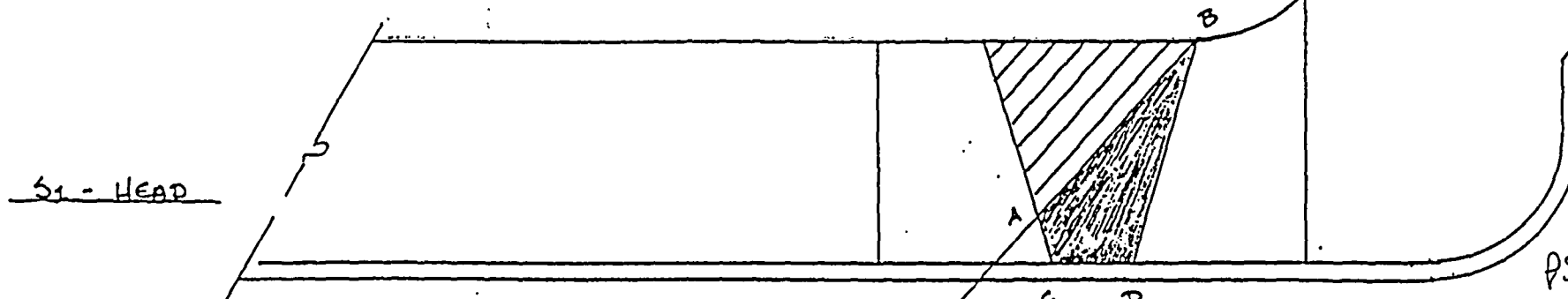
$$BCD: \frac{3.1 \text{ in} \times 1.0 \text{ in}}{2} = 1.55 \text{ in}^2$$

$$\text{TOTAL} = 2.39 \text{ in}^2$$

PERCENT OF COVERAGE

$$4.725 \text{ in}^2 - 2.39 \text{ in}^2 = 2.335 \text{ in}^2$$

$$\frac{2.335 \text{ in}^2}{4.725 \text{ in}^2} = .4941 \times 100 = 49.41 \%$$



SCALE: 1/2" = 1.0"

NOTE: All dimensions taken directly from drawings

Attachment 3 of 9

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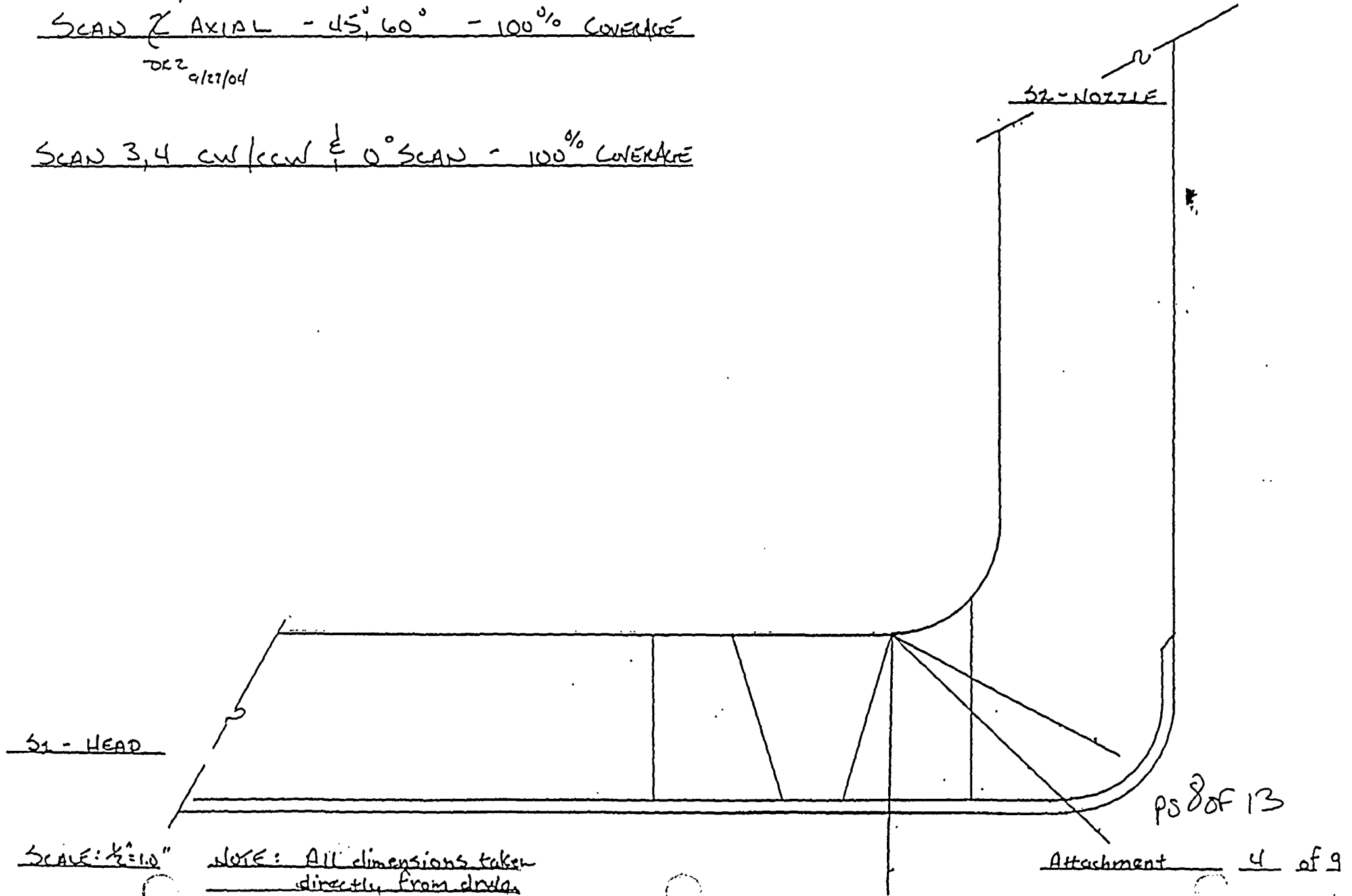
WELD - NOZZLE / HEAD WELD

ITEM NO. 03.110.006A
I.D. NO. IPZR-W4C
INSP David L. Z III
DATE 05/26/05

WELD

SCAN 1 AXIAL - 45°, 60° - 100% COVERAGE
OKZ 9/27/04

SCAN 3, 4 CW/CCW @ 0° SCAN - 100% COVERAGE



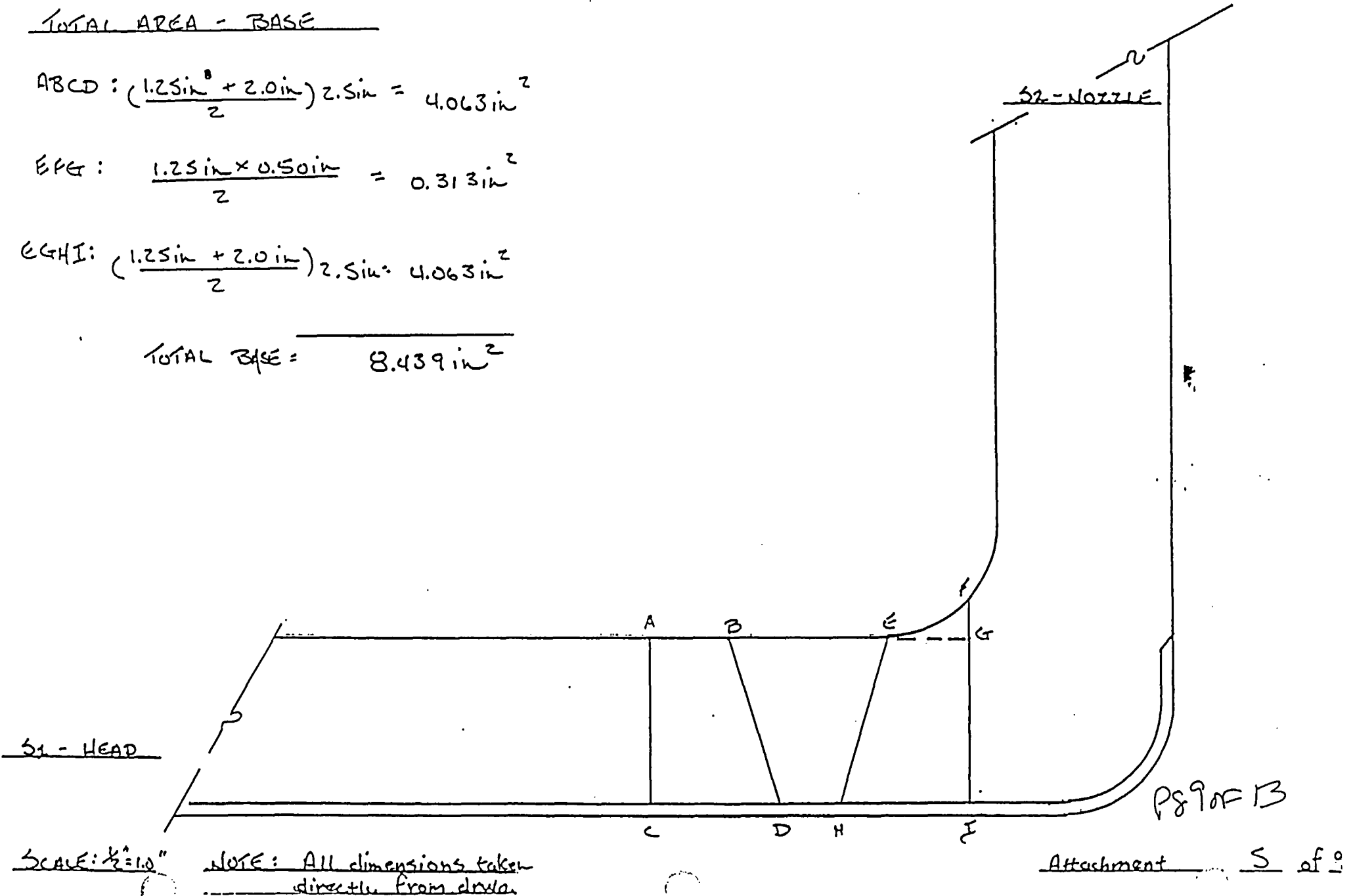
ITEM NO. 303.110.0006A
I.D. NO. 1PZR-W4C
INSP Daniel K. Z. III
DATE 05/26/05

$$ABCD : \left(\frac{1.2 \sin^2 + 2.0 \sin}{2} \right) 2. \sin = 4.063 \sin^2$$

Ex: $\frac{1.25 \text{ in} \times 0.50 \text{ in}}{2} = 0.313 \text{ in}^2$

$$e_{GHI}: \left(\frac{1.25 \text{ in} + 2.0 \text{ in}}{2} \right) 2.5 \text{ in} = 4.063 \text{ in}^2$$

TOTAL BASE = 8.439 in²



UNIT 1 PPR - NOZZLE / HEAD WELD

ITEM NO. 03.110.006A
I.D. NO. PPR-W4C
INSP David B. III
DATE 05/26/05

BASE METAL AXIAL SCAN 1 - (45°, 60°)

$$60^\circ \text{ ABC: } \frac{1.5 \text{ in} \times 1.3 \text{ in}}{2} = 0.975 \text{ in}^2$$

60° PERCENT OF COVERAGE

$$8.439 \text{ in}^2 - 0.975 \text{ in}^2 = 7.464 \text{ in}^2$$

$$7.464 \text{ in}^2 / 8.439 \text{ in}^2 = .8845 \times 100 = 88.45 \%$$

45°

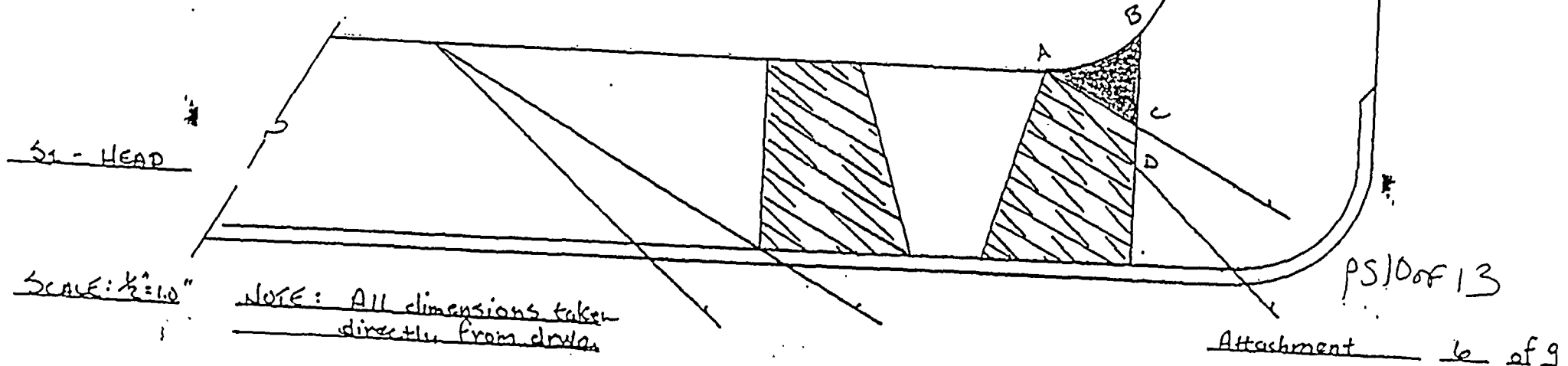
$$\text{ABC: } \frac{1.5 \text{ in} \times 1.3 \text{ in}}{2} = 0.975 \text{ in}^2$$

$$\text{ACD: } \frac{1.5 \text{ in} \times 0.5 \text{ in}}{2} = \frac{0.375 \text{ in}^2}{1.3 \text{ in}^2}$$

45° PERCENT OF COVERAGE

$$8.439 \text{ in}^2 - 1.3 \text{ in}^2 = 7.089 \text{ in}^2$$

$$7.089 \text{ in}^2 / 8.439 \text{ in}^2 = .8400 \times 100 = 84.0 \%$$



UNIT I PZR - NOZZLE LEAD WELD

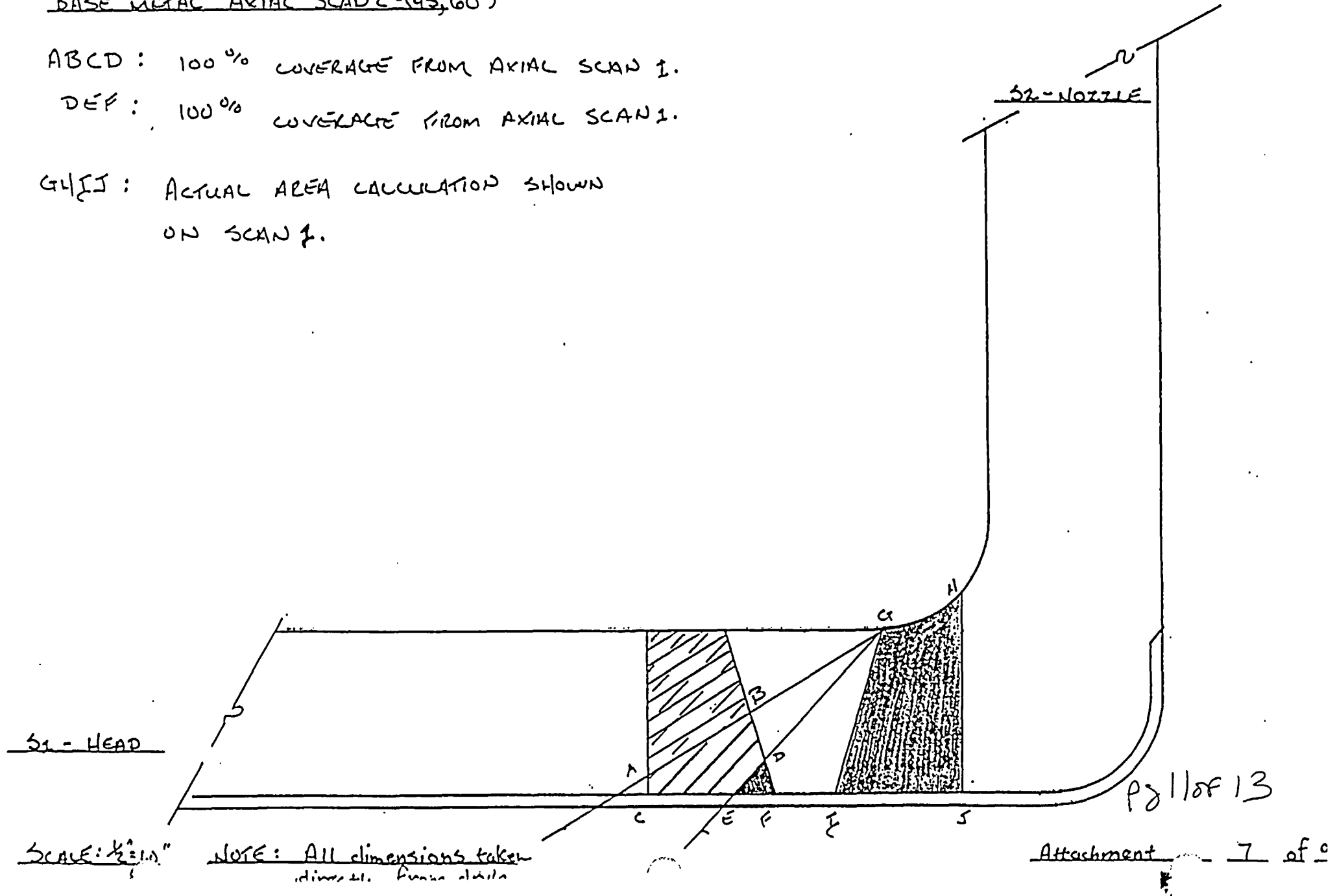
ITEM NO. B03.110.006A
I.D. NO. IPZR-W4C
INSP David R. S. III
DATE 05/26/05

BASE METAL AXIAL SCAN 2 - (45°, 60°)

ABCD: 100% COVERAGE FROM AXIAL SCAN 1.

DEF: 100% COVERAGE FROM AXIAL SCAN 1.

GHIJ: ACTUAL AREA CALCULATION SHOWN
ON SCAN 1.



BASE - 0° & CW/CCW SCAN (45°, 60°)

$$ABC : \frac{1.25\text{in} \times 0.50\text{in}}{2} = 0.313\text{in}^2$$

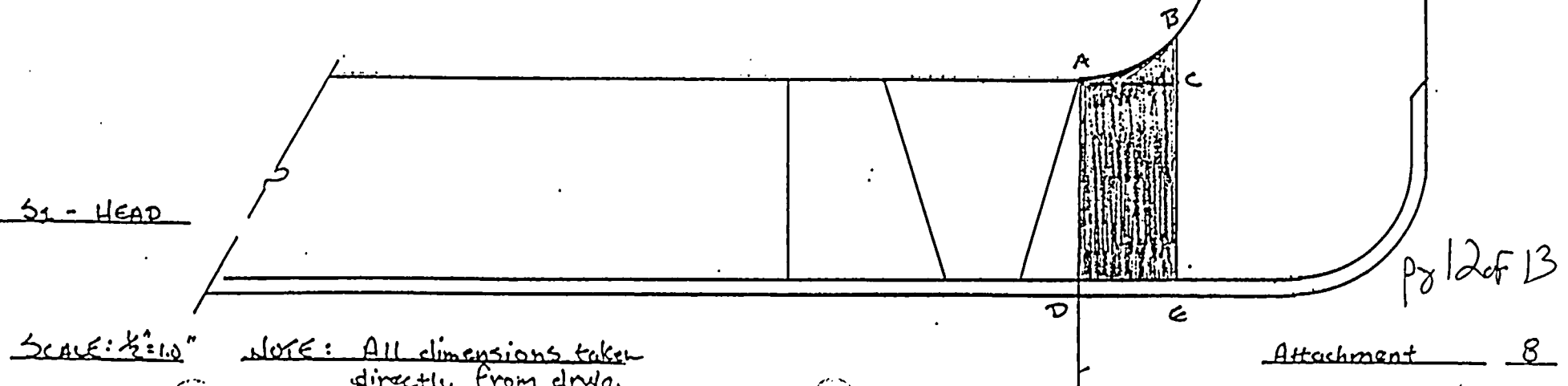
$$ACDE : 1.25\text{in} \times 2.5\text{in} = 3.125\text{in}^2$$

$$\frac{3.438\text{in}^2}{8.439\text{in}^2} = 0.4075$$

$$8.439\text{in}^2 - 3.438\text{in}^2 = 5.001\text{in}^2$$

PERCENT OF COVERAGE

$$\frac{5.001\text{in}^2}{8.439\text{in}^2} = .5926 \times 100 = 59.26\%$$



SCALE: 1/2" = 1.0"

NOTE: All dimensions taken directly from drawings

DUKE POWER COMPANY

ISI LIMITATION REPORT

Component/Weld ID: 1PZR-W4C

Item No: B03.110.006A

remarks:

☒ NO SCAN

SURFACE

BEAM DIRECTION

Nozzle Configuration

☐ LIMITED SCAN

☒ 1

☐ 2

☐ 1

☒ 2

☒ cw

☒ ccw

FROM L _____ to L _____

INCHES FROM W0 C/L+ to Beyond

ANGLE: ☒ 0 ☒ 45 ☒ 60 other _____

FROM 0 DEG to 360 DEG

☒ NO SCAN

SURFACE

BEAM DIRECTION

Nozzle Configuration

☐ LIMITED SCAN

☐ 1

☒ 2

☒ 1

☐ 2

☐ cw

☐ ccw

FROM L _____ to L _____

INCHES FROM W0 C/L+ to Beyond

ANGLE: ☐ 0 ☒ 45 ☒ 60 other _____

FROM 0 DEG to 360 DEG

☐ NO SCAN

SURFACE

BEAM DIRECTION

☐ LIMITED SCAN

☐ 1

☐ 2

☐ 1

☐ 2

☐ cw

☐ ccw

FROM L _____ to L _____

INCHES FROM W0 _____ to _____

ANGLE: ☐ 0 ☐ 45 ☐ 60 other _____

FROM _____ DEG to _____ DEG

☐ NO SCAN

SURFACE

BEAM DIRECTION

☐ LIMITED SCAN

☐ 1

☐ 2

☐ 1

☐ 2

☐ cw

☐ ccw

FROM L _____ to L _____

INCHES FROM W0 _____ to _____

ANGLE: ☐ 0 ☐ 45 ☐ 60 other _____

FROM _____ DEG to _____ DEG

Sketch(s) attached

☒ yes

☐ No

Prepared By: David Zimmerman

Level: III

Date: 05262005

Attachment Sheet 9 of 9

Reviewed By: *DeHaven*

Date: 5-29-05

Authorized Inspector: *Robert M. Smith*

Date: 6-8-05

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CATAWBA UNIT 1

H Scho

Pg. 10F3 LFR # 05-CN-004 ATTACHMENT G

CATAWBA UNIT 1

RPV COVERAGE ESTIMATE BREAKDOWNS

DIRECTION / ORIENTATION

PARALLEL SCANS

CCW/CW

PERP. SCANS

UP/DN

WELD
DESCRIPTION

OUTLET NOZZLE
DM WELD @ 338°

WELD NO.

1RPV-W18-SE AND
1NC23-01

BEAM ANGLES

BEAM DIRECTION	70°L DUAL		ET							
	WELD	VOLUME	WELD	VOLUME	WELD	VOLUME	WELD	VOLUME	WELD	VOLUME
CCW	* 71.1	* 58.69	* 100	* 100						
CW	* 71.1	* 58.69								
IN	100	100								
OUT	100	100								
UT Average = 82.45% COMBINED COVERAGE (UT & ET) = 100%		* CIRC SCANS LIMITED AS PER PROCEDURE PDQS DUE TO ID COUNTERBORE AND ROOT CONFIGURATION. LIMITATION AREA FROM 122.96" TO 123.40" FROM 0° TO 55°; FROM 123.56" TO 124.0" FROM 0° TO 360°; AND FROM 121.76" TO 122.5" FROM 0° TO 360°. ET USED TO SUPPLEMENT EXAM FOR FULL COVERAGE.								



UT Pipe Weld Examination

Site/Unit: Catawba / 1 Procedure: NDE-600 Outage No.: CNS1EOC15
Summary No.: B09.011.048 Procedure Rev.: 16 Report No.: UT-05-168
Workscope: ISI Work Order No.: 98680794 Page: 1 of 3

Code: Asme Section XI 1989 Cat./Item: B-J- /B9.11.48 Location: N/A
Drawing No.: CN-1NC-286 Description: UHI Adapter to Pipe Cap
System ID: NC
Component ID: B09.011.048 /1NC286-1 Size/Length: N/A Thickness/Diameter: .864" / 6"
Limitations: Yes-See Attached Limitation Report Start Time: 1322 Finish Time: 1338

Examination Surface: Inside ☐ Outside ☒ Surface Condition: AS GROUND
Lo Location: RT INT 0 Wo Location: Centerline of Weld Couplant: ULTRAGEL II Batch No.: 05125
Temp. Tool Mfg.: D.A.S Serial No.: MCNDE32797 Surface Temp.: 78 °F
Cal. Report No.: CAL-05-180, CAL-05-181, CAL-05-182

Angle Used	0	45	45T	60	60L	
Scanning dB			41	42	40	

Indication(s): Yes ☐ No ☒ Scan Coverage: Upstream ☐ Downstream ☒ CW ☒ CCW ☒

Comments:

FC 05-08

Results: Accept ☒ Reject ☐ Info ☐

Percent Of Coverage Obtained > 90%: No-37.5%

Reviewed Previous Data: Yes

Examiner Level II Leeper, Winfred C.	Signature <i>Winfred C. Leeper</i>	Date 5/19/2005	Reviewer <i>ME Housen</i>	Signature <i>ME Housen</i>	Date 5-20-05
Examiner Level II Jones, Russel	Signature <i>Russel Jones</i>	Date 5/19/2005	Site Review N/A	Signature	Date
Other Level N/A N/A	Signature <i>Winfred C. Leeper</i>	Date	ANII Review <i>Winfred C. Leeper</i>	Signature <i>Winfred C. Leeper</i>	Date 5/26/05

RFR #05-CN-004 ATTACHMENT H

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Limitation Record

Site/Unit: Catawba / 1
Summary No.: B09.011.048
Workscope: ISI

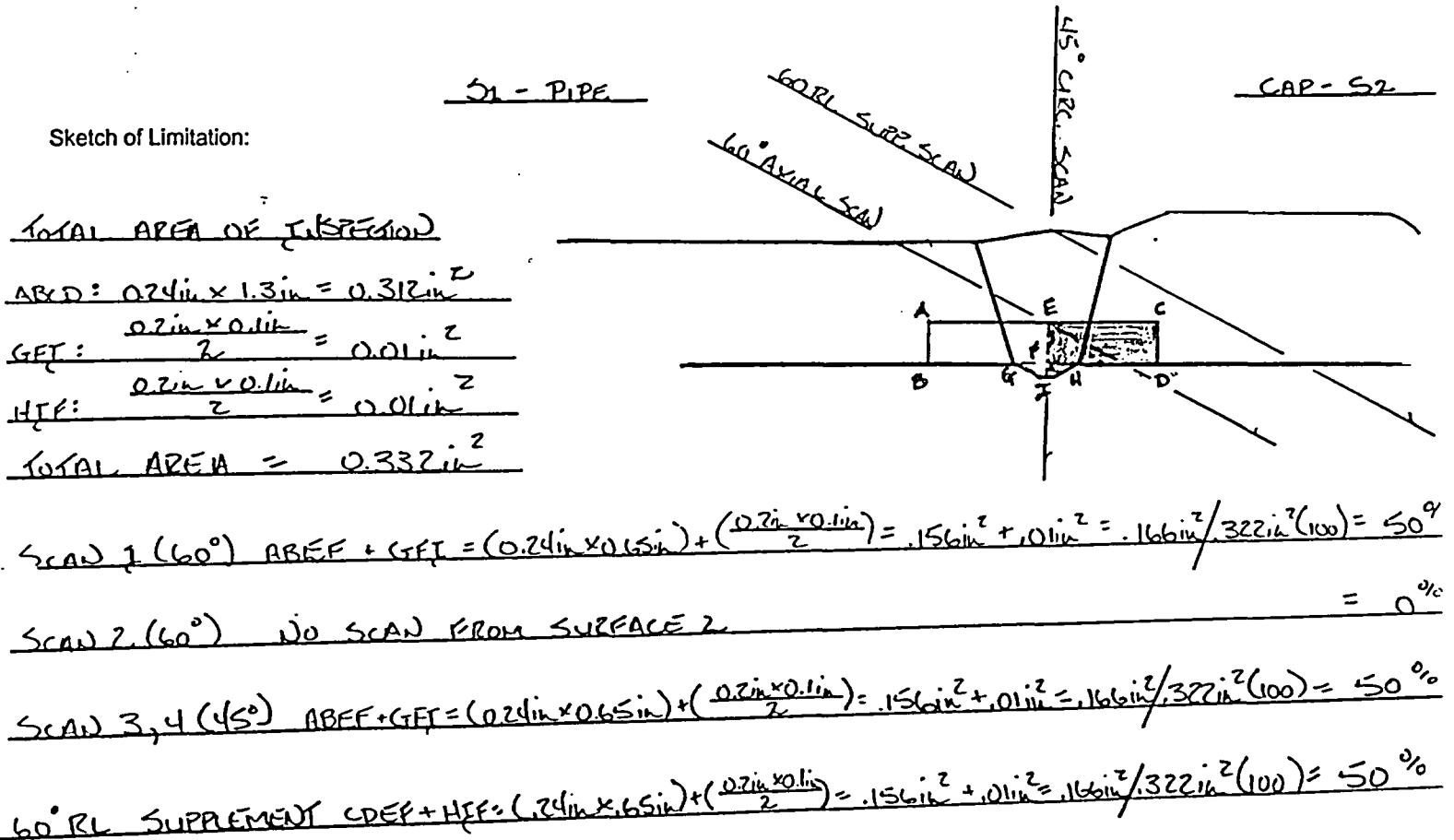
Procedure: NDE-600
Procedure Rev.: 16
Work Order No.: 98680794

Outage No.: CNS1EOC15
Report No.: UT-05-168
Page: 2 of 3

Description of Limitation:

See Attached

Sketch of Limitation:



SCALE: FULL

Limitations removal requirements:

Radiation field:

Examiner	Level II	Signature	Date	Reviewer	Signature	Date
Leeper, Winfred C.		<i>Winfred C. Leeper</i>	5/19/2005	<i>DE Hansen</i>		5.20.05
Examiner	Level II	Signature	Date	Site Review	Signature	Date
Jones, Russel		<i>Russel Jones</i>	5/19/2005	N/A		
Other	Level N/A	Signature	Date	ANII Review	Signature	Date
N/A				<i>Nancy C. Ritchie</i>	<i>Shayla</i>	5/26/05

Pg 2 of 4



Determination of Percent Coverage for UT Examinations - Pipe

Site/Unit:	<u>Catawba / 1</u>	Procedure:	<u>NDE-600</u>	Outage No.:	<u>CNS1EOC15</u>
Summary No.:	<u>B09.011.048</u>	Procedure Rev.:	<u>16</u>	Report No.:	<u>UT-05-168</u>
Workscope:	<u>ISI</u>	Work Order No.:	<u>98680794</u>	Page:	<u>3</u> of <u>3</u>

45 deg

Scan 1	<u> </u>	% Length X	<u> </u>	% volume of length / 100 =	<u> </u>	% total for Scan 1
Scan 2	<u> </u>	% Length X	<u> </u>	% volume of length / 100 =	<u> </u>	% total for Scan 2
Scan 3	<u>100.000</u>	% Length X	<u>50.000</u>	% volume of length / 100 =	<u>50.000</u>	% total for Scan 3
Scan 4	<u>100.000</u>	% Length X	<u>50.000</u>	% volume of length / 100 =	<u>50.000</u>	% total for Scan 4

Add totals and divide by # scans = 50.000 % total for 45 deg

Other deg - 60 (to be used for supplemental scans)

The data to be listed below is for coverage that was not obtained with the 45 deg scans.

Scan 1	<u>100.000</u>	% Length X	<u>50.000</u>	% volume of length / 100 =	<u>50.000</u>	% total for Scan 1
Scan 2	<u>100.000</u>	% Length X	<u>0.000</u>	% volume of length / 100 =	<u>0.000</u>	% total for Scan 2
Scan 3	<u> </u>	% Length X	<u> </u>	% volume of length / 100 =	<u> </u>	% total for Scan 3
Scan 4	<u> </u>	% Length X	<u> </u>	% volume of length / 100 =	<u> </u>	% total for Scan 4

Percent complete coverage

Add totals for each scan required and divide by # of scans to determine;

37.5 % Total for complete exam

Site Field Supervisor:

Durik. J. III

Date:

05/19/05

pg 3 of 4

DUKE POWER COMPANY

ISI LIMITATION REPORT

Component/Weld ID: 1NC286-1

Item No: B09.011.048

remarks:

☐ NO SCAN SURFACE BEAM DIRECTION
☒ LIMITED SCAN ☒ 1 ☐ 2 ☐ 1 ☒ 2 ☐ cw ☐ ccw

FROM L N/A to L N/A INCHES FROM W0 C/L to Beyond
 ANGLE: ☐ 0 ☐ 45 ☒ 60 other _____ FROM 0 DEG to 360 DEG

Cap Conf.

☒ NO SCAN SURFACE BEAM DIRECTION
☐ LIMITED SCAN ☐ 1 ☒ 2 ☐ 1 ☐ 2 ☒ cw ☒ ccw

FROM L N/A to L N/A INCHES FROM W0 C/L to Beyond
 ANGLE: ☐ 0 ☒ 45 ☐ 60 other _____ FROM 0 DEG to 360 DEG

Cap Conf.

☒ NO SCAN SURFACE BEAM DIRECTION
☐ LIMITED SCAN ☐ 1 ☒ 2 ☒ 1 ☐ 2 ☐ cw ☐ ccw

FROM L _____ to L _____ INCHES FROM W0 C/L to Beyond
 ANGLE: ☐ 0 ☐ 45 ☒ 60 other _____ FROM 0 DEG to 360 DEG

Cap Conf.

☐ NO SCAN SURFACE BEAM DIRECTION
☐ LIMITED SCAN ☐ 1 ☐ 2 ☐ 1 ☐ 2 ☐ cw ☐ ccw

FROM L _____ to L _____ INCHES FROM W0 _____ to _____
 ANGLE: ☐ 0 ☐ 45 ☐ 60 other _____ FROM _____ DEG to _____ DEG

Sketch(s) attached

☒ yes ☐ No

Prepared By: David Zimmerman

Level: III

Date: 05/19/05

Attachment Sheet 1 of 1 UT-05-168

Reviewed By: DE Housen

Date: 5-20-05

Authorized Inspector: Nancy C. Ritchie-Slaughter

Date: 5/26/05

pg 4 of 4



UT Vessel Examination

Site/Unit: Catawba / 1

Procedure: NDE-630

Outage No.: CNS1EOC15

Summary No.: B12.040.002D

Procedure Rev.: 2

Report No.: UT-05-211

Workscope: ISI

Work Order No.: 98688919

Page: 1 of 8

Code: Asme Section XI 1989 Cat./Item: B-M-1/B12.40.2D Location: N/A

Drawing No.: CN-1ND-037 Description: Valve Body to Bonnett

System ID: ND

Component ID: B12.040.002D/1ND-37A Size/Length: N/A Thickness/Diameter: 2.043" / 20.0"

Limitations: Yes - See Attached Limitation Report Start Time: 0900 Finish Time: 0936

Examination Surface: Inside ☐ Outside ☒ Surface Condition: AS GROUND

Lo Location: RT INT. #1 Wo Location: Centerline of Weld Couplant: ULTRAGEL II Batch No.: 03125

Temp. Tool Mfg.: D.A.S Serial No.: MCNDE32797 Surface Temp.: 74 °F

Cal. Report No.: CAL-05-220, CAL-05-221, CAL-05-222, CAL-05-223

Angle Used	0	45	45T	60	60T	*
Scanning dB		40.6	46.6	54.7		*

Indication(s): Yes ☐ No ☒ Scan Coverage: Upstream ☒ Downstream ☒ CW ☒ CCW ☒

Comments:

FC 99-02, 03-17, 03-30 * 60°L Scanning Db = 68.8, 45°L = 74.8 Db

Results: Accept ☒ Reject ☐ Info ☐

Percent Of Coverage Obtained > 90%: No - 69.3% Reviewed Previous Data: Yes

Examiner	Level	III	Signature	Date	Reviewer	Signature	Date
Eaton, Jay A.				5/25/2005	DE Hansen		5-30-05
Examiner	Level	I	Signature	Date	Site Review	Signature	Date
Moss, Gary J.				5/25/2005	N/A		
Other	Level	N/A	Signature	Date	ANII Review	Signature	Date
N/A					Robert M. Sullivan		6-8-05

RFR #05-CN-004 ATTACHMENT I

PS/OF9



Determination of Percent Coverage for UT Examinations - Vessels

Site/Unit:	<u>Catawba / 1</u>	Procedure:	<u>NDE-630</u>	Outage No.:	<u>CNS1EOC15</u>
Summary No.:	<u>B12.040.002D</u>	Procedure Rev.:	<u>2</u>	Report No.:	<u>UT-05-211</u>
Workscope:	<u>ISI</u>	Work Order No.:	<u>98688919</u>	Page:	<u>2</u> of <u>8</u>

0 deg Planar

Scan _____ % Length X _____ % volume of length / 100 = _____ % total for 0 deg

45 deg

Scan 1 _____ % Length X _____ % volume of length / 100 = _____ % total for Scan 1

Scan 2 _____ % Length X _____ % volume of length / 100 = _____ % total for Scan 2

Scan 3 _____ % Length X _____ % volume of length / 100 = _____ % total for Scan 3

Scan 4 _____ % Length X _____ % volume of length / 100 = _____ % total for Scan 4

Add totals and divide by # scans = _____ % total for 45 deg

Other deg 45°/60°

Scan 1 100.000 % Length X 36.400 % volume of length / 100 = 36.400 % total for Scan 1

Scan 2 100.000 % Length X 95.220 % volume of length / 100 = 95.220 % total for Scan 2

Scan 3 100.000 % Length X 72.870 % volume of length / 100 = 72.870 % total for Scan 3

Scan 4 100.000 % Length X 72.870 % volume of length / 100 = 72.870 % total for Scan 4

Add totals and divide by # scans = 69.340 % total for 45°/60° deg

Percent complete coverage

Add totals for each angle and scan required and divide by # of angles to determine;

69.340 % Total for complete exam

Note:

Supplemental coverage may be achieved by use of other angles / methods. When used, the coverage for volume not obtained with angles as noted above shall be calculated and added to the total to provide the percent total for the complete examination.

Site Field Supervisor: _____

Date: 05/25/05

PS Jof 9

DUKE POWER COMPANY

ISI LIMITATION REPORT

Component/Weld ID: <u>1ND-37A</u> Item No: <u>B12.040.002D</u>		remarks:
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/A</u> INCHES FROM W0 <u>-.75</u> to <u>Beyond</u> ANGLE: <input type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG		Valve Bonnett Conf.
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/A</u> INCHES FROM W0 <u>+1.9</u> to <u>+3.4</u> ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input checked="" type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG		Valve Body Conf.
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/A</u> INCHES FROM W0 <u>+1.9</u> to <u>+3.2</u> ANGLE: <input type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG		Valve Body Conf.
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG		Sketch(s) attached <input checked="" type="checkbox"/> yes <input type="checkbox"/> No
Prepared By: <u>David Zimmerman</u> Level: <u>III</u> Date: <u>05/25/2005</u> Sheet <u>4</u> of <u>8</u>		
Reviewed By: <u>[Signature]</u> Date: _____ Authorized Inspector: <u>[Signature]</u> Date: <u>6-8-05</u>		

Pg 3 of 9

DUKE POWER COMPANY

ISI LIMITATION REPORT

Component/Weld ID: <u>1ND-37A</u> Item No: <u>B12.040.002D</u>		remarks:
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input checked="" type="checkbox"/> cw <input checked="" type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/A</u> INCHES FROM W0 <u>-.75</u> to <u>Beyond</u> ANGLE: <input type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG		Valve Bonnett Conf.
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG		
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG		
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG		Sketch(s) attached <input checked="" type="checkbox"/> yes <input type="checkbox"/> No
Prepared By: <u>David Zimmerman</u> Level: <u>III</u> Date: <u>05/25/2005</u>		Sheet <u>3</u> of <u>8</u>
Reviewed By: <u>DeHaven</u> Date: _____		Authorized Inspector: <u>Robert McHugh</u> Date: <u>6-8-05</u>

pg 4 of 9

DUKE POWER COMPANY

ISI LIMITATION REPORT

Component/Weld ID: <u>1ND-37A</u> Item No: <u>B12.040.002D</u>		remarks:
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/A</u> INCHES FROM W0 <u>-.75</u> to <u>Beyond</u> ANGLE: <input type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG		Valve Bonnett Conf.
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/A</u> INCHES FROM W0 <u>-.75</u> to <u>Beyond</u> ANGLE: <input type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input checked="" type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG		Valve Bonnett Conf.
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/A</u> INCHES FROM W0 <u>+1.9</u> to <u>+3.4</u> ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input checked="" type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG		Valve Body Conf.
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/A</u> INCHES FROM W0 <u>+1.9</u> to <u>+3.2</u> ANGLE: <input type="checkbox"/> 0 <input checked="" type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG		Valve Body Conf.
		Sketch(s) attached
		<input checked="" type="checkbox"/> yes <input type="checkbox"/> No
Prepared By: <u>David Zimmerman</u>	Level: <u>III</u> Date: <u>05/25/2005</u>	Sheet <u>4</u> of <u>8</u>
Reviewed By: <u>D. F. Houser</u>	Date: <u>5-30-05</u>	Authorized Inspector: <u>Robert M. Sullivan</u> Date: <u>6-8-05</u>

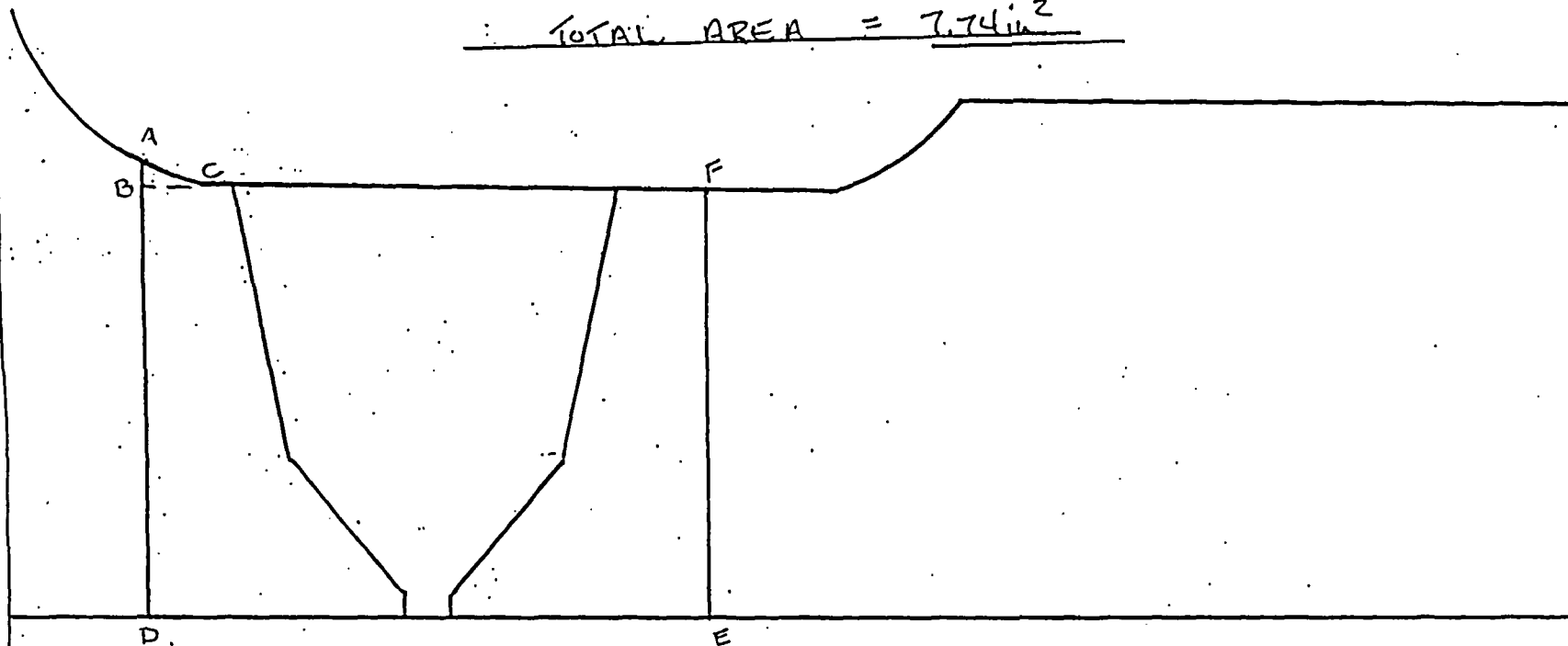
pg 5 of 9

EXAM AREA OF INTEREST




$$ABC = \frac{0.4in \times 0.15in}{2} = 0.06in^2$$

$$BDEF = 2.4in \times 3.2in = 7.68in^2$$

$$\therefore \text{TOTAL AREA} = 7.74in^2$$



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FULL COVERAGE 
 PART. COVERAGE 
 NO COVERAGE 

ITEM NO: B12.040.002.D
 ID NO: IND37A
 INSP: David K. [signature] VE: 05/25/05
 SCALE: FULL ATTACHMENT 5 of 8

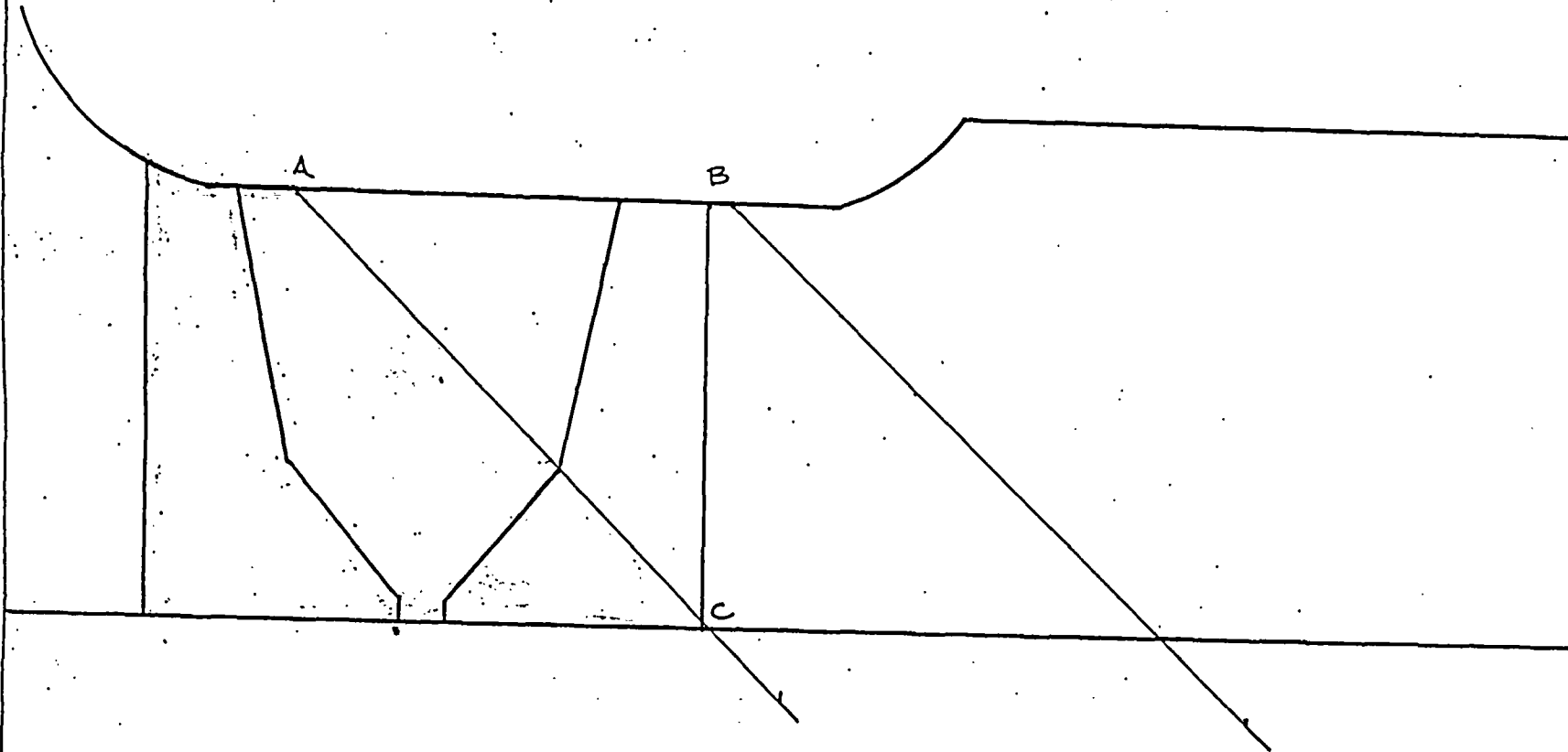
S1-1 E BONNETT

VALS BODY-S2




SCAN 1 - 45° COVERAGE

$$ABC = \frac{2.4in \times 2.35in}{2} = 2.82in^2$$

$$\frac{2.82in^2}{7.74in^2} \times 100 = 36.4\%$$



P27 of 9

FULL COVERAGE 
PART COVERAGE 
NO COVERAGE 

ITEM NO: B12.040.002.D
ID NO: IND37A
INSP: *David K. S.* III. RE: 05/25/05
SCALE: FULL. ATTACHMENT 6 of 8

S1 - VE BONNETT

VAL BODY - S2

SCAN 2 - 45°/60° COVERAGE

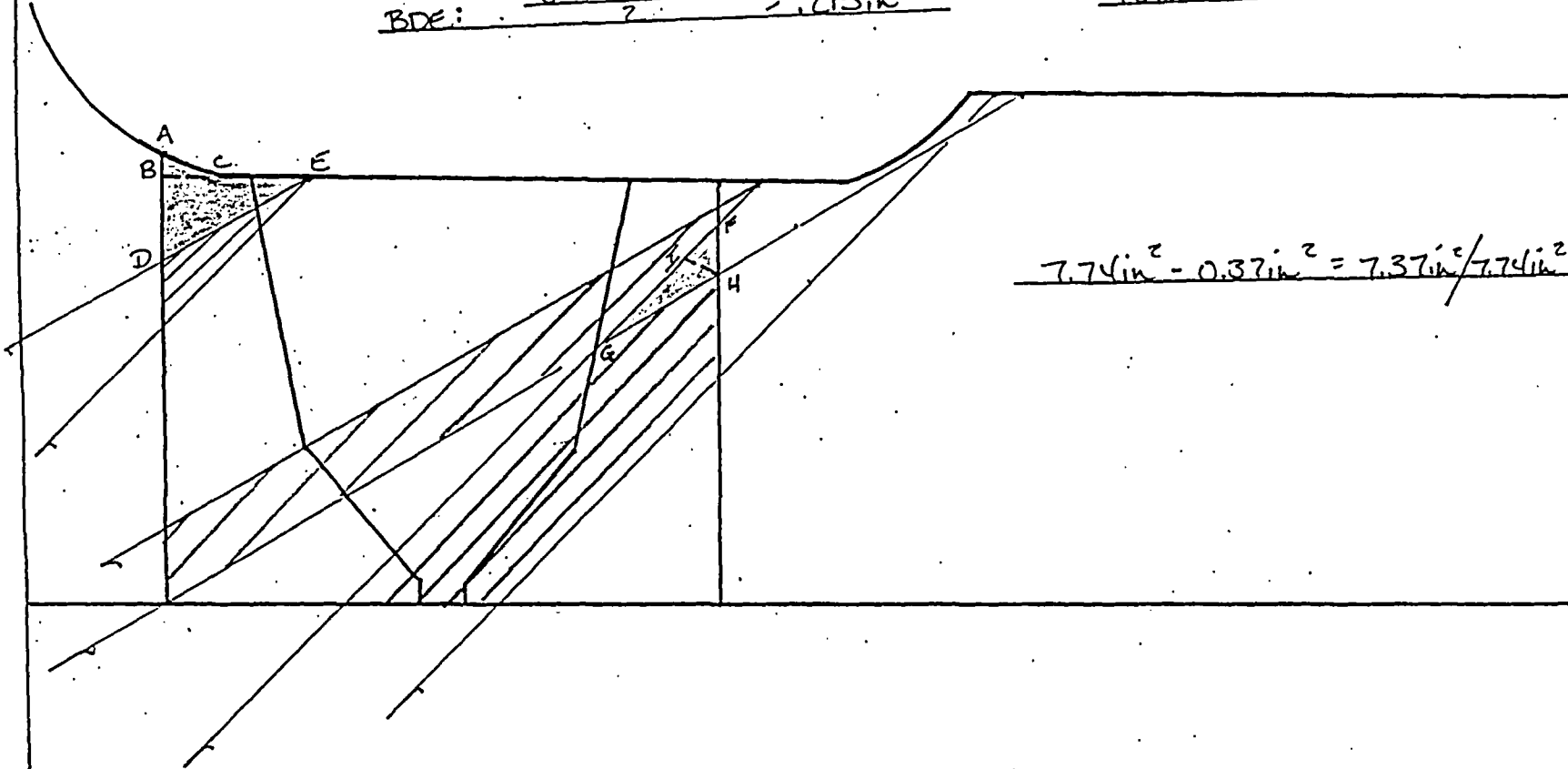
$$ABC: \frac{0.4in \times 0.15in}{2} = 0.06in^2$$

$$BDE: \frac{0.5in \times 0.85in}{2} = 0.213in^2$$

$$FHI: \frac{0.25in \times 0.2in}{2} = 0.025in^2$$

$$GHI: \frac{0.7in \times 0.2in}{2} = 0.07in^2$$

$$TOTAL LOSS = 0.37in^2$$



$$\frac{7.74in^2 - 0.37in^2}{7.74in^2} \times 100 = 95.22\%$$

PS 209

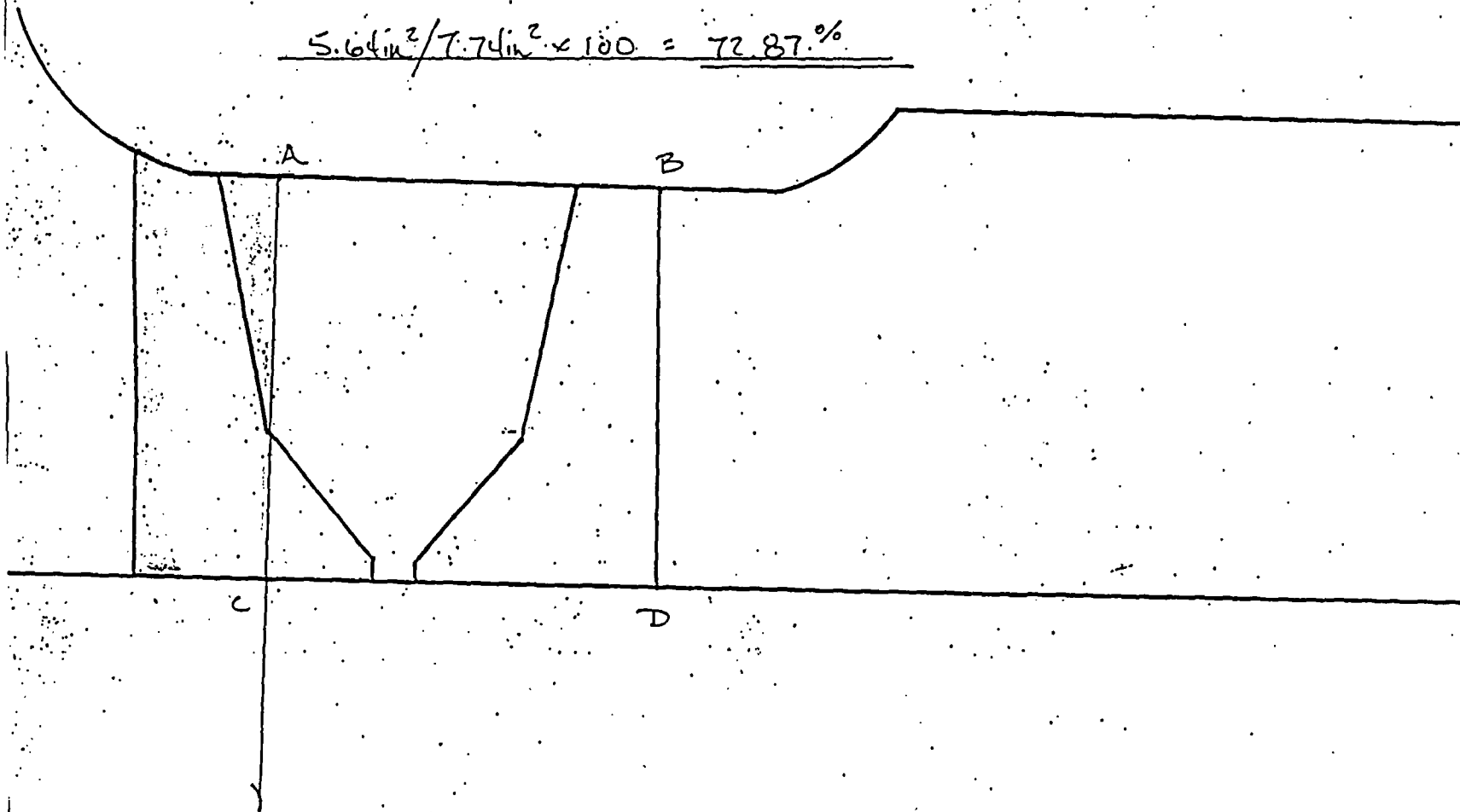
FULL COVERAGE ☐
PART. COVERAGE ☒
NO COVERAGE ☐

ITEM NO: B12.040.002.D
ID NO: IND37A
INSP: *[Signature]* III
SCALE: FULL ATTACHMENT 7 of 8




SCAN 3,4 - 45° COVERAGE

$$ABCD: 2.4in \times 2.35in = 5.64in^2$$

$$5.64in^2 / 7.74in^2 \times 100 = 72.87\%$$



PS 9 of 9

FULL COVERAGE	
PART COVERAGE	
NO COVERAGE	

ITEM NO: B12.040.002.D
ID NO: IND37A
INSP: <u>David K. S.</u> RE: 05/25/05
SCALE: FULL ATTACHMENT B of B



UT Pipe Weld Examination

Site/Unit: Catawba / 1 Procedure: NDE-600 Outage No.: CNS1EOC15
Summary No.: C05.011.049 Procedure Rev.: 16 Report No.: UT-05-169
Workscope: ISI Work Order No.: 98688907 Page: 1 of 25

Code: Asme Section XI 1989 Cat./Item: C-F-1/C5.11.49 Location: N/A 9/5/05
Drawing No.: CN-1ND-39 Description: Valve (1ND2A) to Pipe
System ID: ND
Component ID: C05.011.049 /1ND39-12 Size/Length: N/A Thickness/Diameter: 1.125" / 12"
Limitations: Yes-See Attached Limitation Report Start Time: 1201 Finish Time: 1239

Examination Surface: Inside ☐ Outside ☒ Surface Condition: AS GROUND
Lo Location: 9.1.1.1 Wo Location: Centerline of Weld Couplant: ULTRAGEL II Batch No.: 05125
Temp. Tool Mfg.: D.A.S Serial No.: MCNDE32797 Surface Temp.: 79 °F

Cal. Report No.: CAL-05-183, CAL-05-184, CAL-05-185

Angle Used	0	45	45T	60	60L	
Scanning dB			46.0	46.4	52.3	

Indication(s): Yes ☐ No ☒ Scan Coverage: Upstream ☒ Downstream ☒ CW ☒ CCW ☒

Comments:

FC 05-08

Results: Accept ☒ Reject ☐ Info ☐

Percent Of Coverage Obtained > 90%: No - 76.1%

Reviewed Previous Data: Yes

Examiner Level III Zimmerman, David K.	Signature <i>David K. Zimmerman</i>	Date 5/20/2005	Reviewer <i>[Signature]</i>	Signature <i>[Signature]</i>	Date 5/30/05
Examiner Level II Moss, Gary J.	Signature <i>Gary J. Moss</i>	Date 5/20/2005	Site Review N/A	Signature	Date
Other Level N/A N/A	Signature	Date	ANII Review <i>[Signature]</i>	Signature <i>[Signature]</i>	Date 6-8-05

REF #05-CN-004 ATTACHMENT J

P8 of 25

DUKE POWER COMPANY

ISI LIMITATION REPORT

Component/Weld ID: <u>1ND39-12</u> Item No: <u>C05.011.049</u>		remarks: Valve Configuration
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input checked="" type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input checked="" type="checkbox"/> 2 <input checked="" type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L <u>N/A</u> to L <u>N/A</u> INCHES FROM W0 <u>+1.1"</u> to <u>Beyond</u> ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input checked="" type="checkbox"/> 60 other _____ FROM <u>0</u> DEG to <u>360</u> DEG	 	
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG	 	
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG	 	
<input type="checkbox"/> NO SCAN SURFACE BEAM DIRECTION <input type="checkbox"/> LIMITED SCAN <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> 1 <input type="checkbox"/> 2 <input type="checkbox"/> cw <input type="checkbox"/> ccw FROM L _____ to L _____ INCHES FROM W0 _____ to _____ ANGLE: <input type="checkbox"/> 0 <input type="checkbox"/> 45 <input type="checkbox"/> 60 other _____ FROM _____ DEG to _____ DEG	Sketch(s) attached <input checked="" type="checkbox"/> yes <input type="checkbox"/> No	
Prepared By: <u>David Zimmerman</u> -Level: <u>III</u> Date: <u>05/20/2005</u> Sheet <u>2</u> of <u>35</u> <u>9.5/30/05</u>		
Reviewed By: <u>[Signature]</u> Date: <u>5/30/05</u> Authorized Inspector: <u>[Signature]</u> Date: <u>6-8-05</u>		

PS JofS



Determination of Percent Coverage for UT Examinations - Pipe

Site/Unit:	<u>Catawba / 1</u>	Procedure:	<u>NDE-600</u>	Outage No.:	<u>CNS1EOC15</u>
Summary No.:	<u>C05.011.049</u>	Procedure Rev.:	<u>16</u>	Report No.:	<u>UT-05-169</u>
Workscope:	<u>ISI</u>	Work Order No.:	<u>98688907</u>	Page:	<u>3</u> of <u>3</u>

45 deg

Scan 1	<u> </u>	% Length X	<u> </u>	% volume of length / 100 =	<u> </u>	% total for Scan 1
Scan 2	<u> </u>	% Length X	<u> </u>	% volume of length / 100 =	<u> </u>	% total for Scan 2
Scan 3	<u>100.000</u>	% Length X	<u>100.000</u>	% volume of length / 100 =	<u>100.000</u>	% total for Scan 3
Scan 4	<u>100.000</u>	% Length X	<u>100.000</u>	% volume of length / 100 =	<u>100.000</u>	% total for Scan 4

Add totals and divide by # scans = 100.000 % total for 45 deg

Other deg - 60 (to be used for supplemental scans)

The data to be listed below is for coverage that was not obtained with the 45 deg scans.

Scan 1	<u>100.000</u>	% Length X	<u>52.860</u>	% volume of length / 100 =	<u>52.860</u>	% total for Scan 1
Scan 2	<u>100.000</u>	% Length X	<u>51.430</u>	% volume of length / 100 =	<u>51.430</u>	% total for Scan 2
Scan 3	<u> </u>	% Length X	<u> </u>	% volume of length / 100 =	<u> </u>	% total for Scan 3
Scan 4	<u> </u>	% Length X	<u> </u>	% volume of length / 100 =	<u> </u>	% total for Scan 4

Percent complete coverage

Add totals for each scan required and divide by # of scans to determine;

76.073 % Total for complete exam

Site Field Supervisor:

David K. [Signature]

Date:

05/20/05

NOTE: 60°RL SCAN NOT INCLUDED IN PERCENT COVERAGE DUE TO REQUIREMENTS OF 10CFR 50.55a(b)(2)(xv)(A)(2). BEST EFFORT SCAN WITH 60°RL OBTAINED 47.14% COVERAGE IN ONE AXIAL DIRECTION.

PJ 3 of 5

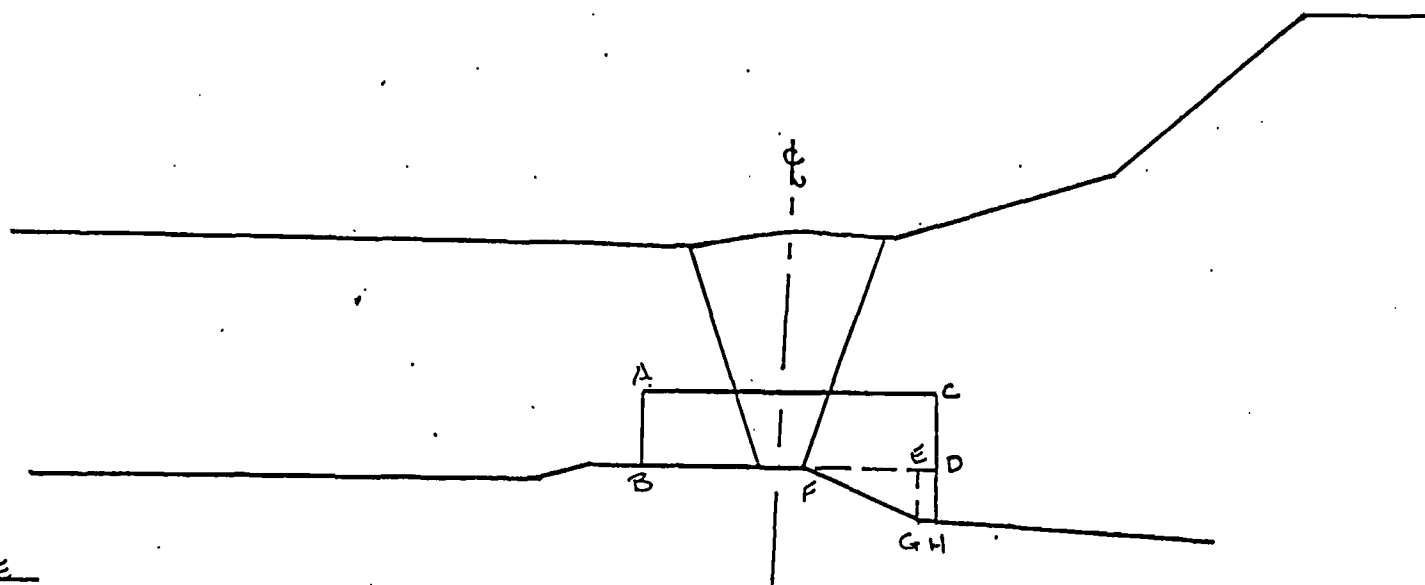
EXAM AREA OF INTEREST

ABCD: $1.55\text{in} \times 0.39\text{in} = 0.61\text{in}^2$

DEGH: $0.1\text{in} \times 0.25\text{in} = 0.03\text{in}^2$

EFG: $\frac{0.25\text{in} \times 0.6\text{in}}{2} = 0.06\text{in}^2$

TOTAL AREA = 0.7in^2



S1 - PIPE

P84r5

VALVE IND2A - S2

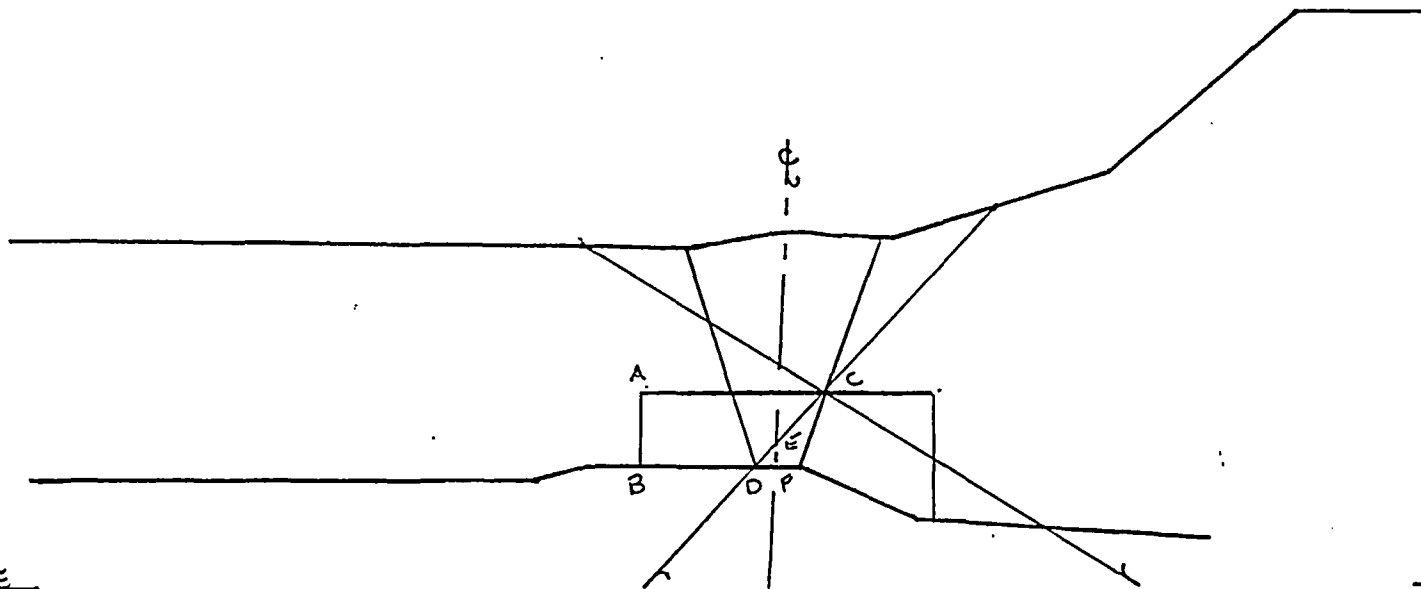
ITEM NO: C05.011.049	
ID NO: IND39-12	UT-05-169
INSP: David K. B.	DATE: 7/20/05
SCALE: FULL	PAGE 4 of 5

EXAM AREA OF COVERAGE

$$\begin{aligned}\text{SCAN 1: } ABCD + DEF &= .39\text{in} \left(\frac{1.0\text{in} + .85\text{in}}{2} \right) \left(\frac{.1\text{in} \times .1\text{in}}{2} \right) \\ &= 0.37\text{in}^2 / .7\text{in}^2 \times 100 = 52.86\%\end{aligned}$$

SCAN 3, 4: 100% (NO LOSS)

$$\begin{aligned}\text{SCAN 2: } ABCD &= .39\text{in} \left(\frac{1.0\text{in} + .85\text{in}}{2} \right) \\ &= .36\text{in}^2 / .7\text{in}^2 \times 100 = 51.43\%\end{aligned}$$



S1 - PIPE

Pg 5 of 5

VALVE IND2A - S2

ITEM NO: C05.011.049		
ID NO: IND 39-12		UT-05-169
INSP: <u>David K. Z</u>	DATE: 05/20/05	
SCALE: FULL	PAGE 5 of 5	



D.M. JAMIL
Vice President

Duke Power
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June 14, 2005

U.S. Nuclear Regulatory Commission
Washington, DC 20555-0001
ATTENTION: Document Control Desk

Subject: Duke Energy Corporation
Catawba Nuclear Station Unit 1
Docket No. 50-413
Response to NRC Bulletin 2004-01: Inspection of
Alloy 82/182/600 Materials Used in the Fabrication
of Pressurizer Penetrations and Steam Space Piping
Connections at Pressurized-Water Reactors

Reference: Letter from Duke Energy Corporation to the NRC,
same subject, dated July 27, 2004

NRC Bulletin 2004-01, "Inspection of Alloy 82/182/600 Materials Used in the Fabrication of Pressurizer Penetrations and Steam Space Piping Connections at Pressurized-Water Reactors," required that within 60 days of plant restart following the next inspection of Alloy 82/182/600 pressurizer penetrations and steam space piping connections, submit to the NRC a statement indicating that the inspections described in the response to item (1)(c) of the bulletin were completed and a description of the as-found condition of the pressurizer shell, any findings of relevant indications of through-wall leakage, followup NDE performed to characterize flaws in leaking penetrations or steam space piping connections, a summary of all relevant indications found by NDE, a summary of the disposition of any findings of boric acid, and any corrective actions taken and/or repairs made as result of the indications found.

During the Catawba Unit 1 Refueling Outage (1EOC15), inspections described in the response to item (1)(c) of the bulletin were completed. A 100% bare metal visual (BMV)



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RFR #05-CN-004 ATTACHMENT K

examination was performed on all Alloy 82/182/600 weld locations on the pressurizer. These BMV inspections were performed by VT-2 qualified inspectors. The inspection scope included the following locations:

- (1) pressurizer surge line nozzle weld
- (3) pressurizer safety valve nozzle welds
- (1) pressurizer spray nozzle weld
- (1) pressurizer PORV nozzle weld
- (1) pressurizer manway

There was no evidence of leakage or boric acid deposits observed at any of these locations. The exterior surfaces are in very good condition with no wastage of the top or bottom heads.

There are no NRC commitments contained in this letter.

Inquiries on this matter should be directed to A. Jones-Young at (803) 831-3051.

Very truly yours,



D.M. Jamil
Site Vice President

D. M. Jamil, being duly sworn, affirms that he is the person who subscribed his name to the foregoing statement, and that all matters and facts set forth herein are true and correct to the best of his knowledge.



D. M. Jamil, Site Vice President

Subscribed and sworn to me: 6-14-05

Michy Handorf, Notary Public

My commission expires: 7-10-2012

SEAL

U.S. NRC
June 14, 2005
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NC Municipal Power Agency No. 1
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T. R. Puryear
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Piedmont Municipal Power Agency
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