

FROM: Northern States Power Company
Minneapolis, Minn. 55401
L.O. Mayer

TO: Dr. Peter A. Moris

CLASSIF: U POST OFFICE
REG. NO:

DESCRIPTION: (Must Be Unclassified)
Ltr reporting supplementary info on
damage to torus baffles w/attach 1-4(Pgs)...

ENCLOSURES:

REMARKS:

1 CY LOCAL PDR MINNEAPOLIS, MINN.
HOLDING 16 CYS FOR ACRS

DATE OF DOCUMENT:

Feb. 15, 1972

DATE RECEIVED:

Feb. 17, 1972

NO.:

LTR.

I

MEMO:

REPORT:

OTHER:

ORIG.:

CC:

OTHER:

3 signed

ACTION NECESSARY ☐

NO ACTION NECESSARY ☐

CONCURRENCE ☐

COMMENT ☐

DATE ANSWERED:

BY:

FILE CODE:

50-263

REFERRED TO

DATE

RECEIVED BY

DATE

Knuth 2-17-72
w/9 cys for ACTION

DISTRIBUTION:

Reg File Cy
AEC PDR

Compliance (2)
Muntzing & Staff

D. Thompson
Morris/Schroeder

Skovholt
Boyd

E.C. Case
DTIE (Laughlin)
NSIC (Buchanan)

DO NOT REMOVE
ACKNOWLEDGED

25

DL

U.S. ATOMIC ENERGY COMMISSION

MAIL CONTROL FORM FORM AEC-3265
(8-60)

NSP

Regulatory

File Cy7

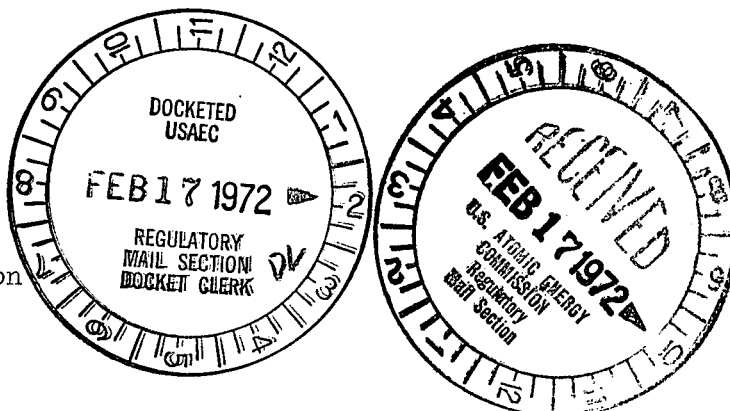
NORTHERN STATES POWER COMPANY

MINNEAPOLIS, MINNESOTA 55401

February 15, 1972

Dr. Peter A Morris, Director
Division of Reactor Licensing
United States Atomic Energy Commission
Washington, D C 20545

Dear Dr. Morris:



MONTICELLO NUCLEAR GENERATING PLANT

Docket No. 50-263 License No. DPR-22
Supplementary Report on Damage to Torus Baffles

A letter reporting the damage to torus baffles and the status of repair work was transmitted on December 15, 1971, in compliance with the 30-day reporting requirement of Section 6.6.C.1 of Appendix A, Technical Specifications of Provisional Operating License DPR-22. The following information supplements the December 15, 1971, letter and summarizes the completion of inspection and repair work.

At the time of the prior report, all torus baffles had been removed. The relief valve discharge lines were being modified as recommended by the General Electric torus design engineers. Repairs were in progress on small lines and catwalk bracing. Consideration was also given for repair of the painted surfaces.

Since the last report, all small lines have been restored to their original condition. Likewise, the structural support bracing for the torus catwalk has been repaired. The modifications to the relief valve discharge lines have been completed as described in the previous report. The lines were extended under the torus water level and terminated with a ram's head type tee as shown on the attached sketches.

Special tests were conducted to assure the integrity of the torus metal. All significant scratches attributed to baffle movement on the torus walls were subjected to a magnetic particle test; the test showed the base metal to be of satisfactory integrity in all cases. Areas where paint was removed by steam discharged from the relief valve lines against the torus wall were magnetic particle tested and found acceptable. In addition, the wall thickness was measured; it was found that no measurable metal erosion had occurred. A group of original pipe connection and structural welds on the inside and outside of the torus were magnetic particle tested. All welds were satisfactory with the exception of two welds connecting each relief valve discharge line brace to the

NORTHERN STATES POWER COMPANY

P A Morris

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torus skin. A small crack was found at the end of each weld which penetrated slightly into the surface of the torus metal. In each case, the weld was repaired in accordance with applicable code requirements. That brace is no longer used. The design modification called for bracing to be connected between two torus ring girders rather than welded to the torus skin. A stress analysis shows that a similar failure is not expected in the modified design.

Paint was earlier reported to be damaged in a number of places. All loose paint was removed and a base primer was applied as necessary. Affected areas were repainted to restore the original quality of metal surface protection.

The Safety Audit Committee reviewed the work completed and plans for additional torus work at the December 15 and 16, 1971, meeting. They discussed final resolution of all work at the January 19 and 20, 1972, meeting. All torus work was essentially completed at this time. The committee saw no safety consideration restraining continued plant operation in light of the removal of the baffles, modifications of the relief valve discharge lines, and other torus repair work.

All quality assurance supervision and documentation was done under the direction and supervision of the Quality Assurance Section of the Northern States Power Company, Plant Engineering and Construction Department.

A detailed report of all torus repair work done including quality assurance documentation is available at the Monticello site for Compliance Inspectors.

Yours very truly,

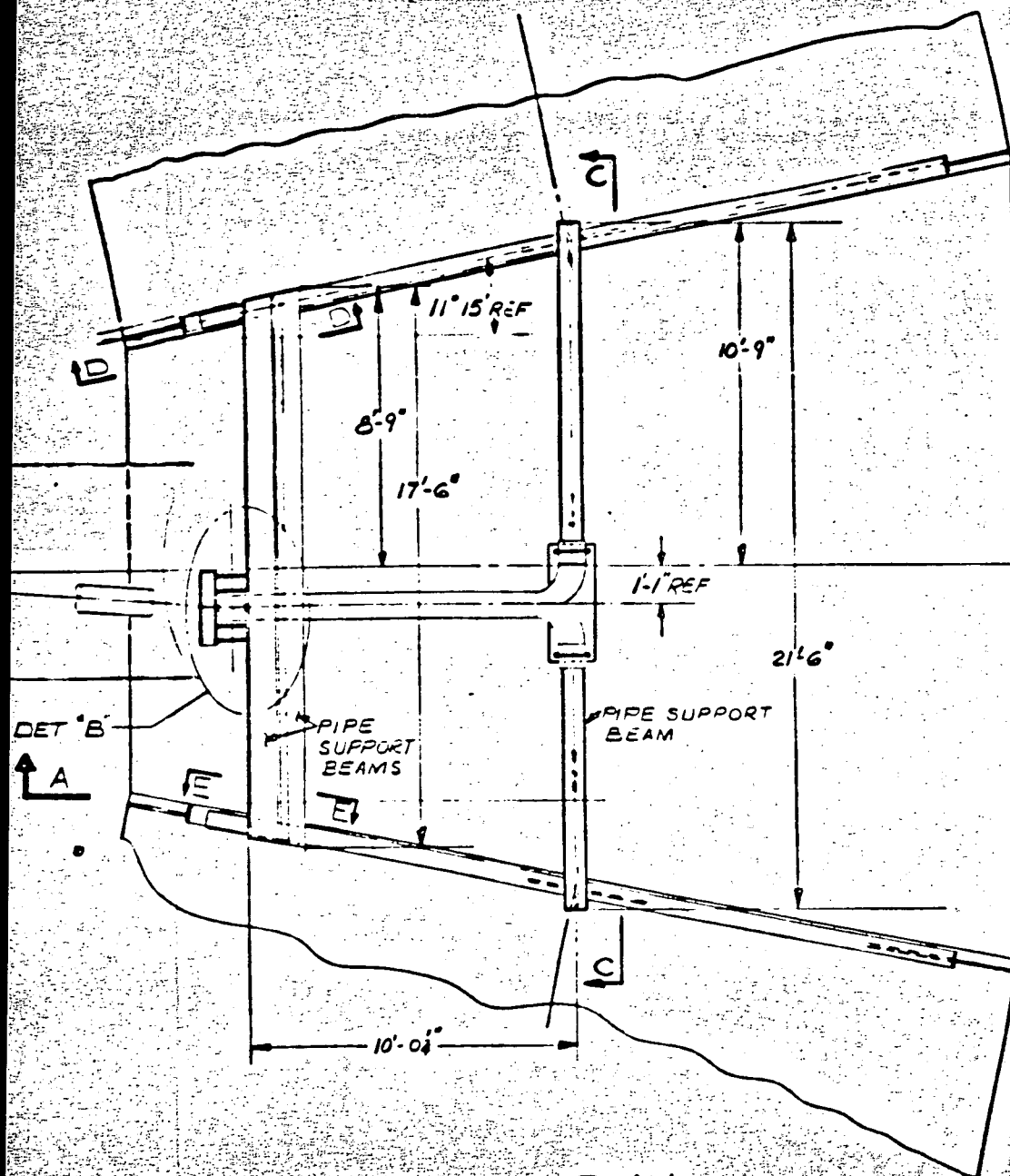


L O Mayer, P.E.
Director-Nuclear Support Services

LOM/MHV/br

cc: B H Grier

Attachments



PLAN

NOTES:

1. EXTEND THE EXISTING FOUR (4) STEAM RELIEF VALVE DISCHARGE PIPES AS SHOWN
2. USE EXISTING BAFFLE BEAMS FOR PIPE SUPPORT BEAMS.
3. CLEAN AND PAINT ALL UNPAINTED MATERIAL WITH ONE (1) COAT OF 5 MILS OF PHENOLINE 363 IN ACCORDANCE WITH MANUFACTURERS (CARBOLINE CO.) RECOMMENDATIONS.

292°-30' AZIMUTH
 67°-30' } SAVE WORK
 157°-30' } TO BE DONE AT
 202°-30' } THESE LOCATIONS

Regulatory File Cy.
 Received 1/15/22 2-15-22

MATERIALS:

PIPE - ASME - SA-106-B CHARPY VEE NOTCH
IMPACT TEST OF 20 FT. LBS AT 0°F
PER ASME SECTION III.

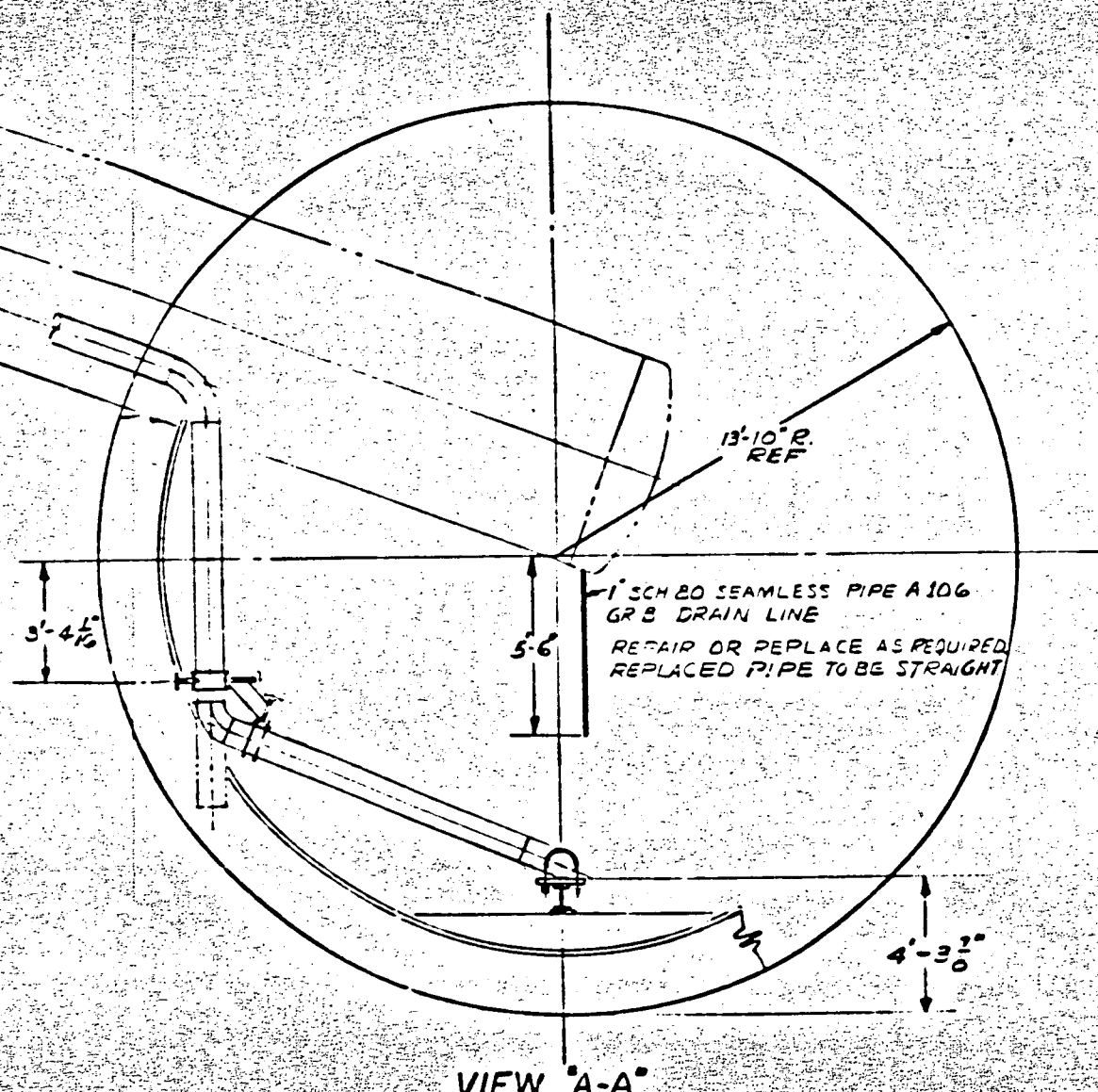
BRACKET GUSSET PLATES:

ASME - SH-516 GR 70
(C-VEE TEST 20 FT. LBS @ 0°F)

BOLTS:

ASTM - A320-L7

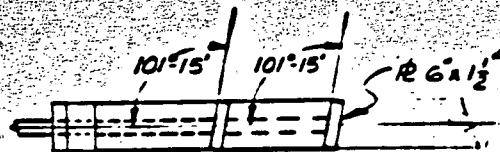
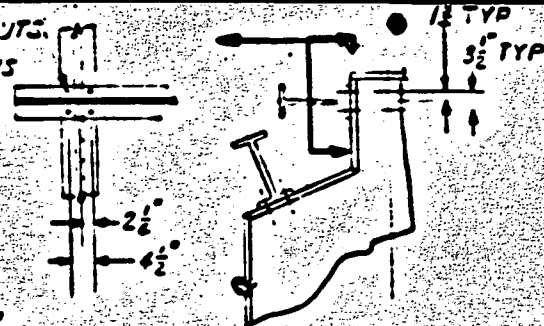
SUPPORT BEAMS - EXISTING 12 WF31 BAFFLES
OF ASTM - A36 FURNISHED
& SPECIFIED UNDER CB&I
CONTRACT NO. 9-6202



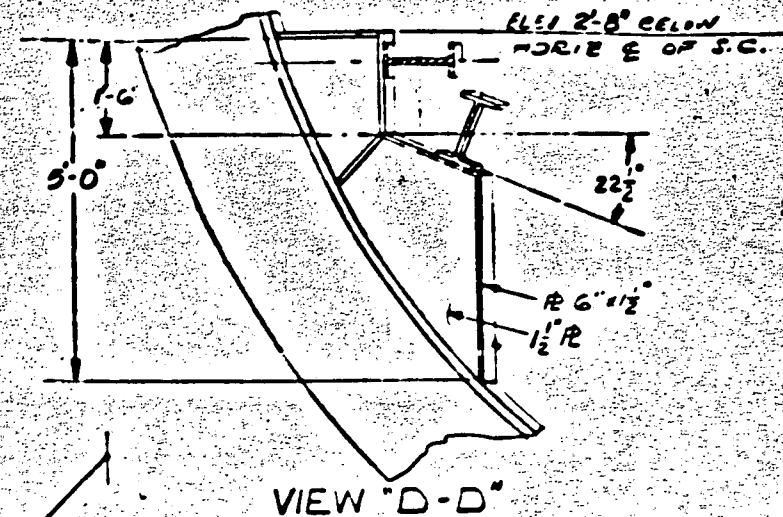
VIEW "A-A"

Regulatory
File Cy.
2/15/72
Receiving

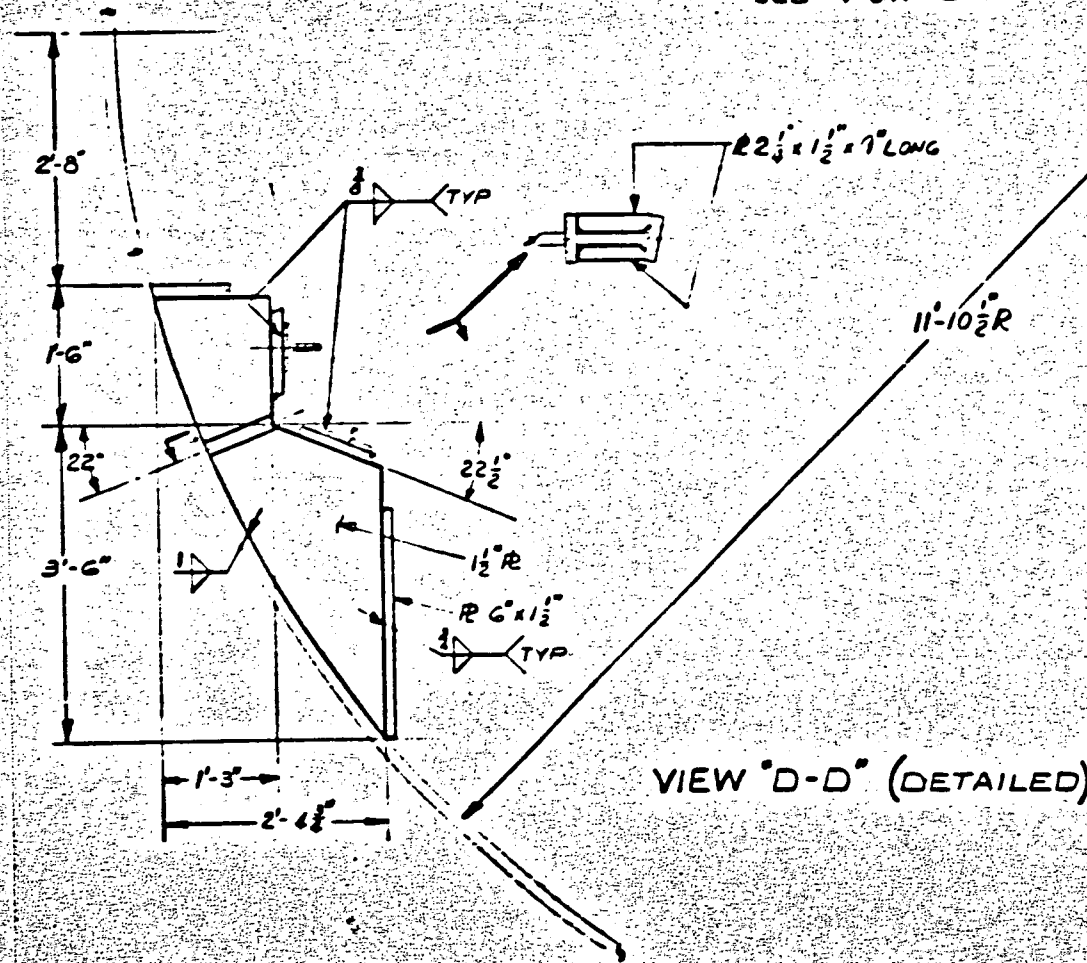
$\frac{3}{4}$ " ϕ BOLTS & NUTS.
TYP FOR BOTH BEAMS



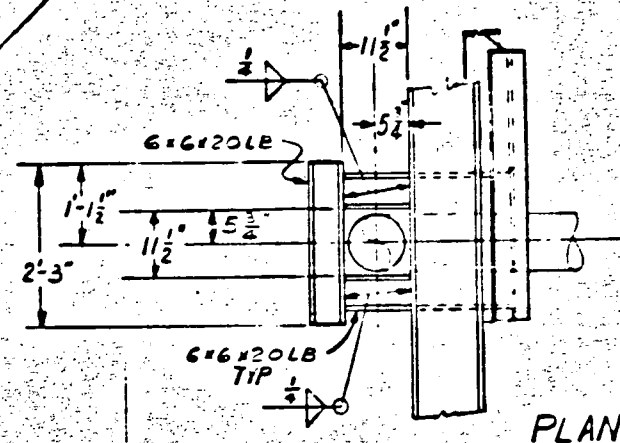
VIEW "E-E"
GPP. HAND FROM "D-D"
FOR OTHER DIMENSIONS
SEE VIEW "D-D"



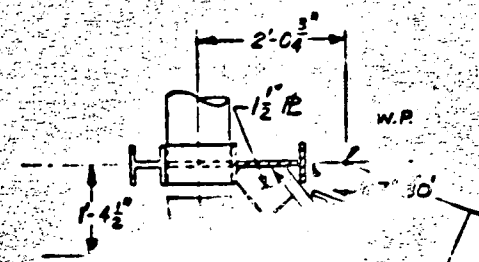
VIEW "D-D"



VIEW "D-D" (DETAILED)



PLAN



DETAIL "B"

$\frac{3}{4}$ " ϕ U BOLT FOR 10" PIPE
(WITH HEX NUTS)

Regulator
File Cy.
2-15-74