

AEC DISTRIBUTION FOR PART 50 DOCKET MATERIAL
(TEMPORARY FORM)

CONTROL NO: 50-263

FROM: Northern States Power Co. Minneapolis, Minn. 55401 L.O. Mayer		DATE OF DOC: 1-12-73	DATE REC'D 1-15-73	LTR X	MEMO	RPT	OTHER
TO: Mr. Donald J. Skovholt		ORIG 1 signed	CC 39	OTHER	SENT AEC PDR ✓ SENT LOCAL PDR ✓		
CLASS: <u>U</u> PROP INFO		INPUT	NO CYS REC'D 40	DOCKET NO: 50-263			
DESCRIPTION: Ltr re our 12-13-72 ltr... furnishing info relating to torus ring header supports re Monticello Plant.....			ENCLOSURES:				
*PLEASE CIRCULATE-INSUFFICIENT CYS FOR FULL DISTRIBUTION			<p align="center">ACKNOWLEDGED DO NOT REMOVE</p>				
PLANT NAMES: Monticello Plant							

FOR ACTION/INFORMATION

DL 1-15-73

BUTLER(L)	SCHWENGER(L)	SCHEMEL(L)	KNIGHTON(E)
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INTERNAL DISTRIBUTION

<u>REG FILE</u>	TECH REVIEW	VOLLMER	HARLESS	WADE	E
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✓OGC, ROOM P-506A	SCHROEDER	GRIMES	F & M	BROWN	E
✓MUNIZING/STAFF	*MACCARY	GAMMILL	SMILEY	G. WILLIAMS	E
CASE	LANGE(2)	KASTNER	NUSSBAUMER	E. GOULBOURNE	L
✓GIAMBUSSO	PAWLICKI	BALLARD		A/T IND	
✓BOYD-L(BWR)	SHAO	SPANGLER	LIC ASST.	BRATTMAN	
DEYOUNG-L(PWR)	*KNUTH		SERVICE L	SALTZMAN	
✓SKOVHOLT-L	STELLO	ENVIRO	MASON L		
P. COLLINS	MOORE	MULLER	WILSON L	PLANS	
	HOUSTON	DICKER	MAIGRET L	MCDONALD	
REG OPR	*TEDESCO	KNIGHTON	SMITH L	DUBE	
✓FILE & REGION (2)	LONG	YOUNGBLOOD	GEARIN L		
MORRIS	LAINAS	PROJ LEADER	DIGGS L	INFO	
✓STELLE	BENAROYA		TEETS L	C. MILES	
		REGAN	LEE L		

EXTERNAL DISTRIBUTION

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✓1-DTIE(ABERNATHY)	(1)(5)(9)-NATIONAL LAB'S	1-PDR-SAN/LA/NY
✓1-NSIC(BUCHANAN)	1-R. CARROLL-OC, GT-B227	1-GERALD LELLOUCHE
1-ASLB-YORE/SAYRE	1-R. CATLIN, E-256-GT	BROOKHAVEN NAT. LAB
✓WOODWARD/H. ST.	1-CONSULANT'S	1-AGMED(WALTER KOESTER,
✓16-CYS ACRS XXXXXX	NEWARK/BLUME/AGABIAN	Rm C-427, GT)
SENT TO LIC. ASST.		1-RD...MULLER...F-309GT
R. DIGGS ON 1-15-73		

NSP

Regulatory

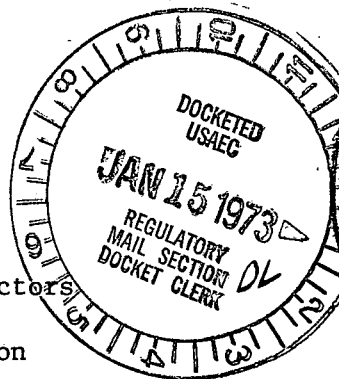
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NORTHERN STATES POWER COMPANY

MINNEAPOLIS, MINNESOTA 55401

January 12, 1973

Mr. Donald J. Skovholt
Assistant Director for Operating Reactors
Directorate of Licensing
United States Atomic Energy Commission
Washington, D. C. 20545



Dear Mr. Skovholt:

MONTICELLO NUCLEAR GENERATING PLANT
Docket No. 50-263 License No. DPR-22
Information Relating to Torus Ring Header Supports

Your letter of December 13, 1972, requested five pieces of information concerning the adequacy of the Monticello torus ring header support design. In the event the specified information could not be obtained within 30 days, a schedule for submitting it to the Commission was to be provided.

Requested Items 1, 2, and 3 will be available in March, 1973 when analyses being conducted by the General Electric Company are scheduled to be completed. A reply will be prepared, including Items 4 and 5, following completion of this investigation.

The General Electric investigation is based on testing conducted in October, 1972 at the Quad Cities Plant. It is intended that conclusions will be reported on a generic basis. Results obtained to date indicate that there is no reason for concern over the design of the Monticello ring header. Indications of possible design deficiencies which may arise during the course of the investigation will be immediately made known to the Commission and the utilities involved. Furthermore, it is our understanding that members of the AEC staff have reviewed the status of this program and the content of the projected report.

Our own experience has indicated that the most likely source of problems experienced with torus ring header supports is improper fabrication and installation. As reported to the Directorate of Regulatory Operations, Region III, by letters of July 5, 1972, and December 6, 1972, the following repairs were necessary at Monticello to correct installation deficiencies in the system:

1. Ungraded, fully threaded bolts were replaced with ASME Grade A325 bolts with no threads in the load bearing region. Bolts were fitted with locking nuts.

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2. All torch-cut bolt holes were filled and replaced with drilled holes.
3. Torus butt plates and padeyes were welded all around with 1/4-inch fillet.
4. All hanger welds were subjected to magnetic particle inspection.
5. Static load analysis was conducted and all hanger loads were balanced.

These repairs restored the torus ring header support system to original design conditions. In addition, the substitution of the higher strength bolt (original design bolt was ASME Grade A307) has resulted in a substantial upgrading of the ability of the system to withstand dynamic loading.

Yours very truly,



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

LOM/DMM/vm

cc B. H. Grier