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AUTH.NAME AUTHOR AFFILIATION
RICKER,J. Northern States Power Co.
RECIP.NAME RECIPIENT AFFILIATION
DOCTOR,S.R. Battelle Memorial Institute, Pacific Northwest Laboratory

SUBJECT: Forwards addl info re accessibility to shell welds from inside vessel w/TRC tool.W/oversize drawing of reactor vessel rollout from inside & overall sketch of vessel, showing active core region in relation to welds.

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Bill Long
Original W/Drawing

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Northern States Power Company

414 Nicollet Mall
Minneapolis, Minnesota 55401-1927
Telephone (612) 330-5500

50-268
TAC 80168

May 1, 1991

Steven R. Doctor, Ph.D
NDE Group Leader
Batelle Northwest Laboratories
Batelle Boulevard
Richland, Washington

Steve,

I'm pleased that you were able to visit the Monticello site to see our reactor vessel shell weld examination in progress. This letter is to forward the additional information you requested regarding accessibility to the shell welds from inside the vessel with the TRC tool.

Attached is a drawing of the reactor vessel rollout viewed from the inside and a overall sketch of the vessel. On the rollout, inaccessible welds are crosshatched. The general sketch shows the where the active core region is in relation to the welds and identifies major items for reference. In In summary, starting at the vessel flange we believe the accessibility to be as follows;

(1) Vessel to flange weld, VCBC-5	90% accessible
(2) 2 Longitudinal welds in shell course 4	85% accessible
(3) Circumferential weld VCBB-4	90% accessible
(4) 2 Longitudinal welds in shell course 3	70% accessible
(5) Circumferential weld, VCBB-3	75% accessible
(6) 2 Longitudinal welds in shell course 2	80% accessible
(7) Circumferential weld VCBA-2 (beltline)	65% accessible
(8) 2 Longitudinal welds in shell course 1	15% accessible

The interferences limiting accessibility, corresponding to the list above are as follows;

(1) Guide rods and probably steam plug hose interference
(2) Dryer separator bracket interference
(3) Guide rods interference
(4) Feedwater and Core Spray piping interference
(5) Feedwater and Core Spray piping interference

DF01 Add: Bill Long
1/1 Original w/Drawing

(6) Jet Pump Riser bracket interference
(7) Feedwater and Core Spray piping interference
(8) Limited by reach of tool

Because the examination is not complete this information is our best estimate. There will also be problems in gathering data from the accessible welds do to cladding surface roughness. We do not know the full extent of those limitations but will after completion of the examination.

Accessibility to the bottom head to shell weld is limited by the Jet Pump Diffuser brackets and close proximity to the Shroud Shelf. We currently examine about 14% of this weld from outside the vessel through openings for the Recirculation Suction nozzles.

If you would like any more information do not hesitate to call me at 612-337-2146.

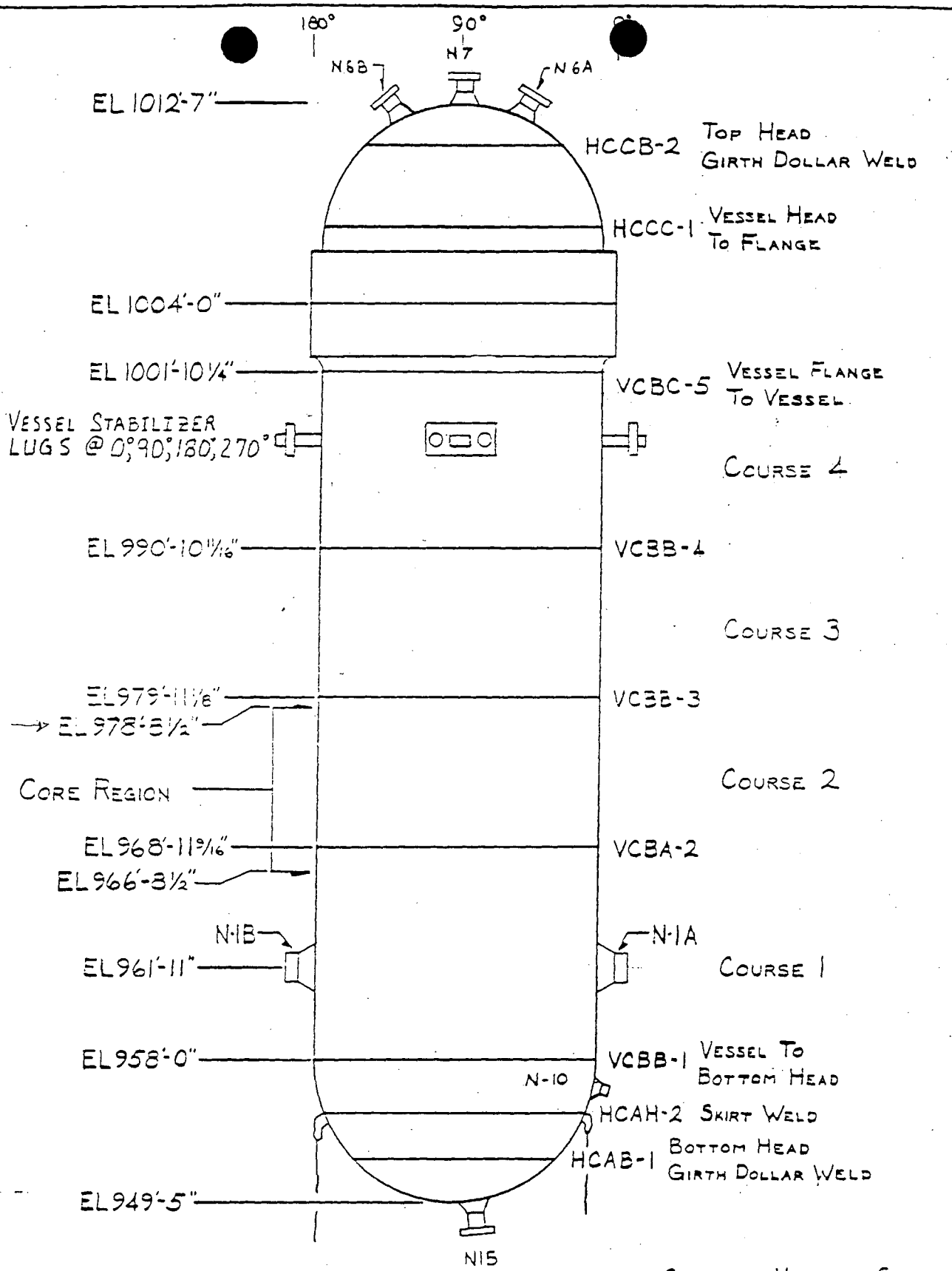
Sincerely,

JL Ricker

Jeff Ricker
Superintendent
Materials & Special Processes

Attachments: TRC Drawing 12560 "Monticello RPV Rollout (ID)", M&SP ISI Sketch Figure 6 rev 2 "Reactor Vessel Circumferential Seam Welds.

cc: J Bridgeman
M Vik
M&SP File

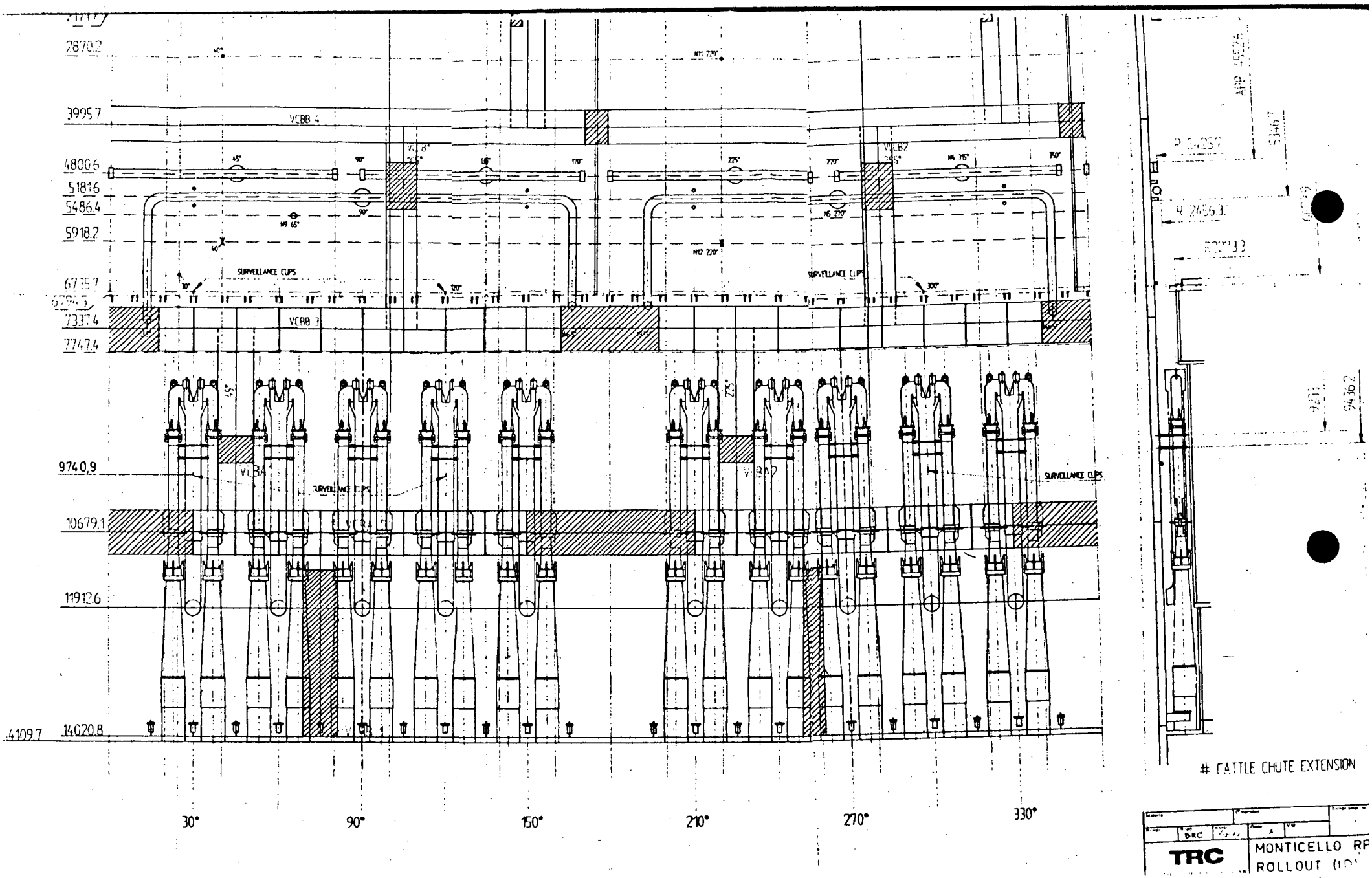


Girth and Vertical Seam Welds 5 5/16" thk., Tp. A533

Reactor Vessel Circumferential Seam Welds

Monticello Unit 1

Dwn: R. Thorne	Figure 6 Rev. 2
Chk'd: DBH (1)	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3995.7
4800.6
5181.6
5486.4
5918.2
6735.7
7337.4
7747.4
9740.9
10679.1
11912.6
14020.8
4109.7
VCBB 4
VCBB 3
VCBA
VCBA2
SURVEILLANCE CLIPS
30°
90°
150°
210°
270°
330°
CATTLE CHUTE EXTENSION
TRC
MONTICELLO RP
ROLLOUT (1D)

ACCELERATED DISTRIBUTION DEMONSTRATION SYSTEM

REGULATORY INFORMATION DISTRIBUTION SYSTEM (RIDS)

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FACIL:50-263 Monticello Nuclear Generating Plant, Northern States 05000263
AUTH.NAME AUTHOR AFFILIATION
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Bill Long 01
Original w/Drawing

2Nd DisT.

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RIDS/ADDS

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414 Nicollet Mall
Minneapolis, Minnesota 55401-1927
Telephone (612) 330-5500

263
50 ~~268~~
TAC 80168

May 1, 1991

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DFO1 Add: Bill Long
1/1 Original w/Drawing

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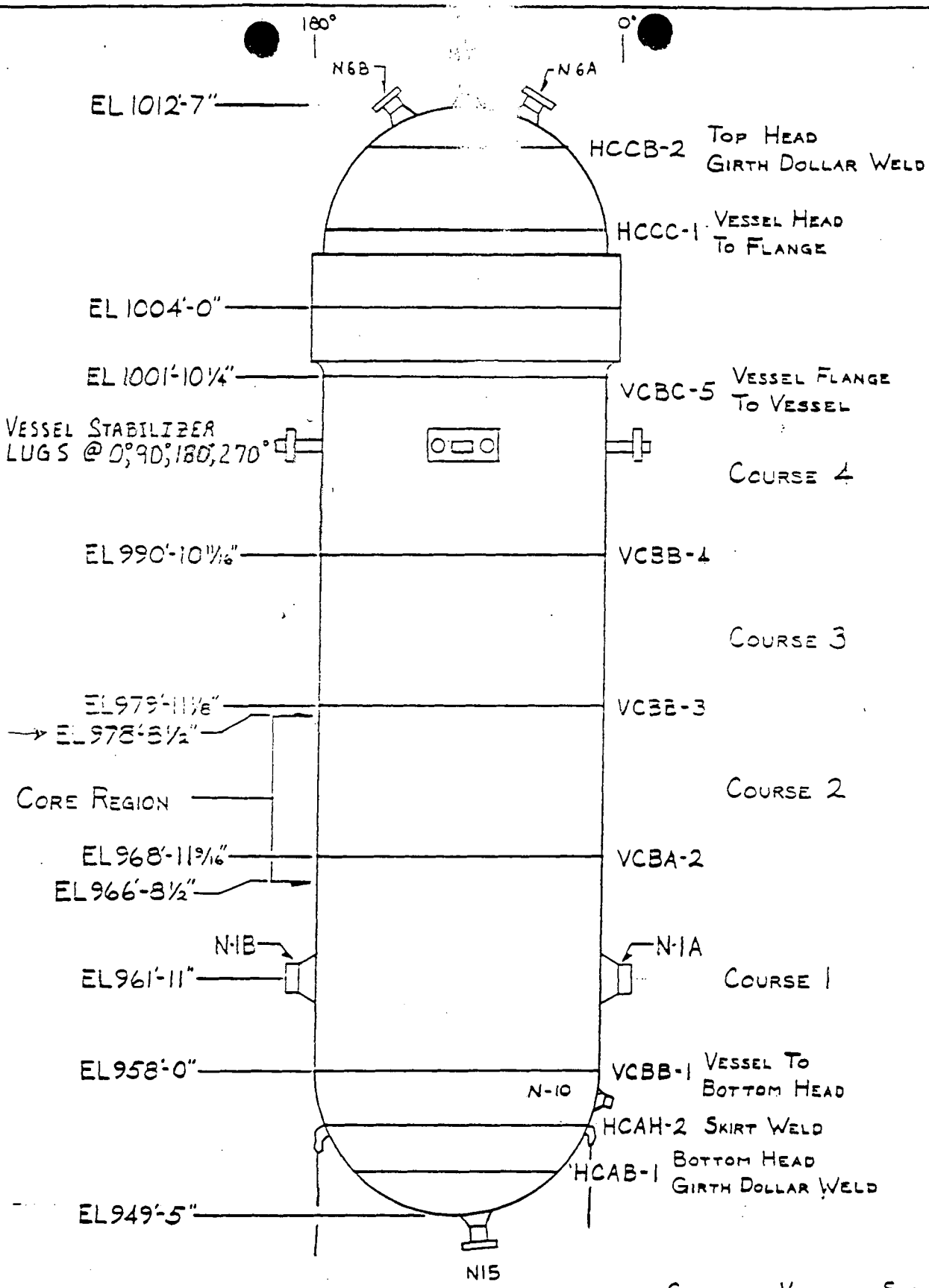

Reactor Vessel
Circumferential Seam Welds

Monticello Unit #1

Dwn: R. Thorne	Figure 6 Rev. 2
Chk'd: DBH (1)	