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 RECIP. NAME RECIPIENT AFFILIATION
 ENGELKEN, R.H. Region 5, San Francisco, Office of the Director ^{MA}

SUBJECT: Final deficiency report re undersized ASME Code welding dimensions for certain socket weld connections, initially submitted 801107. Program to reinspect socket welds in all ASME Section III piping will be completed by 810315.

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 TITLE: Construction Deficiency Report (10CFR50.55E)

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December 16, 1980

Mr. R. H. Engelken, Director
Office of Inspection and Enforcement
U. S. Nuclear Regulatory Commission
Region V
Suite 202, Walnut Creek Plaza
1990 North California Boulevard
Walnut Creek, California 94506

Dear Mr. Engelken:

Subject: Docket Nos. 50-361 and 50-362
San Onofre Nuclear Generating Station, Units 2 and 3

By letter to your office dated November 7, 1980 we transmitted an interim report regarding undersized ASME Code welding dimensions for certain socket weld connections.

Enclosed in accordance with 10CFR50.55(e) are twenty-five (25) copies of a report entitled, "Final Report on Undersized ASME Code Welding Dimensions for Certain Socket Weld Connections - San Onofre Nuclear Generating Station, Units 2 and 3."

If you have any questions regarding this report, we would be pleased to discuss this matter with you at your convenience.

Very truly yours,



cc: Victor Stello (NRC, Director I&E)
R. J. Pate (NRC, San Onofre Units 2 and 3)

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FINAL REPORT ON UNDERSIZED ASME CODE WELDING DIMENSIONS FOR CERTAIN SOCKET WELD CONNECTIONS

San Onofre Nuclear Generating Station, Units 2 and 3

INTRODUCTION

This final report is submitted pursuant to 10CFR50.55(e)(3). It describes a condition found during inspection of small diameter piping socket welds. By letter dated October 8, 1980, Edison confirmed notification to the NRC and on November 7, 1980 Edison submitted an interim report on this condition. That interim report presented background information and measures which had been instituted to resolve the condition. This final report includes a description of the deficiency, an analysis of the safety implications of the condition, and a summary of the corrective action taken or to be taken.

DISCUSSION

The following discussion is responsive to 10CFR50.55(e)(3).

Description of Deficiency

Certain socket weld connections in ASME Code piping in safety related systems with diameters of 2 inches or under exhibit welds which are undersized with respect to the requirements of ASME B&PV Code Section III, Division 1, 1974 Edition, Summer 1974 Addendum, Paragraphs NB/NC/ND-4427.

Analysis of Safety Implications

Generally, the minimum weld sizes specified by the Code are conservative when based on pipe wall thickness rather than actual strength requirements. However, whether failure to meet the minimum weld size requirements of the Code could have resulted in failure of system pressure boundaries was not determined since all undersize ASME Section III socket welds will be reworked to conform to all ASME Section III Code requirements as described in corrective action below.

Corrective Action

A program was initiated to reinspect socket welds in all ASME Section III piping. All undersize socket welds will be reworked to conform to ASME Section III Code requirements. The status of this program as of December 11, 1980 is as follows:

FINAL REPORT ON UNDERSIZED ASME CODE WELDING DIMENSIONS
FOR CERTAIN SOCKET WELD CONNECTIONS - SONGS 2&3

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Unit 2 and Common Systems

Total Number of Socket Welds	7217
Total Number of Socket Welds Inspected	7217
Total Number of Undersized Socket Welds	395
Number of Undersized Socket Welds Reworked	242

Unit 3

Total Number of Socket Welds Completed	2611
Number of Socket Welds Inspected	1150
Number of Undersize Socket Welds	126
Number of Socket Welds Reworked	0

The above program will be completed by March 15, 1981. In addition, all undersized socket welds which were hydrostatically tested previously will be retested after rework is performed.