



Rafael Flores
Senior Vice President
& Chief Nuclear Officer
Rafael.Flores@Luminant.com

Luminant Power
P O Box 1002
6322 North FM 56
Glen Rose, TX 76043

T 254 897 5590
C 817 559 0403
F 254 897 6652

CP-201401035
TXX-14103

Ref. # 10CFR50.55a(g)(5)(iii)

August 27, 2014

U. S. Nuclear Regulatory Commission
ATTN: Document Control Desk
Washington, DC 20555

SUBJECT: COMANCHE PEAK NUCLEAR POWER PLANT
DOCKET NO. 50-446
UNIT 2 RELIEF REQUESTS NOS. B-7, B-12 and B-13 FOR THE SECOND 10-YEAR ISI
INTERVAL (SECOND ISI INTERVAL START DATE: AUGUST 3, 2004; SECOND ISI
INTERVAL END DATE: AUGUST 2, 2014)

Dear Sir or Madam:

Pursuant to 10 CFR 50.55a(g)(5)(iii), Luminant Generation Company LLC (Luminant Power) is submitting Relief Requests B-7, B-12 and B-13 for Comanche Peak Nuclear Power Plant (CPNPP) Unit 2 for the second ten-year inservice inspection interval. A proposed relief is requested from the requirements of the American Society of Mechanical Engineers (ASME) Boiler and Pressure Vessel Code, Section XI 1998 Edition through the 2000 Addenda, for inspection impracticability for Steam Generator Head-to-Tubesheet welds.

The basis and justification for the relief request is attached.

A member of the STARS Alliance

Callaway · Comanche Peak · Diablo Canyon · Palo Verde · Wolf Creek

A047
NRR

This communication contains no new commitments regarding CPNPP Unit 2.

Should you have any questions, please contact Mr. Jack Hicks at (254) 897-6725.

Sincerely,

Luminant Generation Company LLC

Rafael Flores

By: 
Fred W. Madden
Director, External Affairs

Attachments: 1. CPNPP Unit 2 Relief Request Number B-7
 2. CPNPP Unit 2 Relief Request Number B-12
 3. CPNPP Unit 2 Relief Request Number B-13

c - Marc L. Dapas, Region IV
 Balwant K. Singal, NRR
 Resident Inspectors, Comanche Peak
 Jack Ballard, ANII, Comanche Peak

Robert Free
Environmental Monitoring & Emergency Response Manager
Texas Department of State Health Services
Mail Code 1986
P.O. Box 149347
Austin, TX 78714-9347

**10CFR 50.55a REQUEST NUMBER B-7
RELIEF REQUESTED
IN ACCORDANCE WITH 10CFR50.55a(g)(5)(iii)
- INSERVICE INSPECTION IMPRACTICALITY**

1. ASME Code Components Affected:

ASME Code Class: Code Class 1
References: ASME Section XI, Table IWB-2500-1 and IWB-3510
Examination Category: B-B
Item Number: B2.40
Description: Code required examination coverage for the weld volume is impractical
Component: Steam Generator 2-02 Head-to-Tubesheet Weld TCX-1-3100-2-1
Component Number: TCX-RCPCSG-02

2. Applicable Code Edition and Addenda:

ASME Section XI, 1998 Edition through 2000 Addenda.

3. Applicable Code Requirement:

ASME Section XI 1998 Edition through 2000 Addenda, Figure IWB-2500-6 (Design B) requires a minimum volumetric examination of the weld volume extending 1/2t into the base metal on both the head side and tubesheet side of the head-to-tubesheet weld (Code Item B2.40).

Comanche Peak Nuclear Power Plant (CPNPP) Unit 2 second ten-year interval Inservice Inspection Program Plan also implements Code Case N-460, "Alternative Examination Coverage for Class 1 and Class 2 Welds, Section XI, Division 1," which is endorsed by the NRC in Revision 16 of Regulatory Guide 1.147, "Inservice Inspection Code Case Acceptability ASME Section XI, Division 1." Code Case N-460 states, in part, "when the entire examination volume or area cannot be examined due to interference by another component or part geometry, a reduction in examination coverage on any Class 1 or Class 2 weld may be accepted provided the reduction in coverage for that weld is less than 10%."

NRC Information Notice (IN) 98-42, "Implementation of 10CFR50.55a(g) Inservice Inspection Requirements," termed a reduction in coverage of less than 10 percent to be "essentially 100 percent." IN 98-42 states, in part, "The NRC has adopted and further refined the definition of "essentially 100 percent" to mean "greater than 90 percent." This methodology has been applied to all examinations of welds or other areas required by ASME Section XI.

4. Impracticality of Compliance:

The examination of the subject component weld is limited by the presence of four 24"x24" Steam Generator support pads and seventeen 2.5"x2.5" welded pads (See attached sketch). The examinations were conducted in accordance with procedure TX-ISI-210, "Ultrasonic Examination Procedure for Welds in Ferritic Steel Vessels." Straight beam (0°) and angle beam (45° shear and 60° longitudinal) scans were used to achieve the weld volume obtained. As shown on the attached examination data sheets the 0° and 45° exam angles were both limited to 22% not examined, and the 60° exam angle was limited to 31% not examined. Taking the worst case limitation this corresponds to a coverage of 69% of the required examination volume.

**10CFR 50.55a REQUEST NUMBER B-7
RELIEF REQUESTED
IN ACCORDANCE WITH 10CFR50.55a(g)(5)(iii)
- INSERVICE INSPECTION IMPRACTICALITY**

5. Burden Caused by Compliance:

The design configuration restrictions of the subject component makes the Code required examination coverage requirements for the weld volume impractical. Plant modifications or replacements of components designed to allow for complete coverage would be needed to meet the Code requirements. This would cause considerable burden to CPNPP.

6. Proposed Alternative and Basis for Use:

Proposed Alternative:

The following alternatives are proposed in lieu of the required examination coverage of essentially 100 percent:

1. Ultrasonic testing (UT) of the subject component weld was performed to the maximum extent practical during the second ten-year interval.
2. Pressure test VT-2 visual examinations were performed, as required by Code Category B-P, during the second ten-year interval. No evidence of leakage was identified for this component.

Basis for Use:

The basis for use of this alternative is that it provides the best examination coverage practical within the limitations of the current configuration. Based on the percentage of the examination volume completed and the lack of any indications identified, there is a high level of confidence in the continued structural integrity of the weld. CPNPP believes that there is no undue risk to the public health and safety presented by this request.

6. Duration of Proposed Alternative:

The second ten-year ISI interval for Unit 2 began on August 3, 2004 and ends on August 2, 2014.

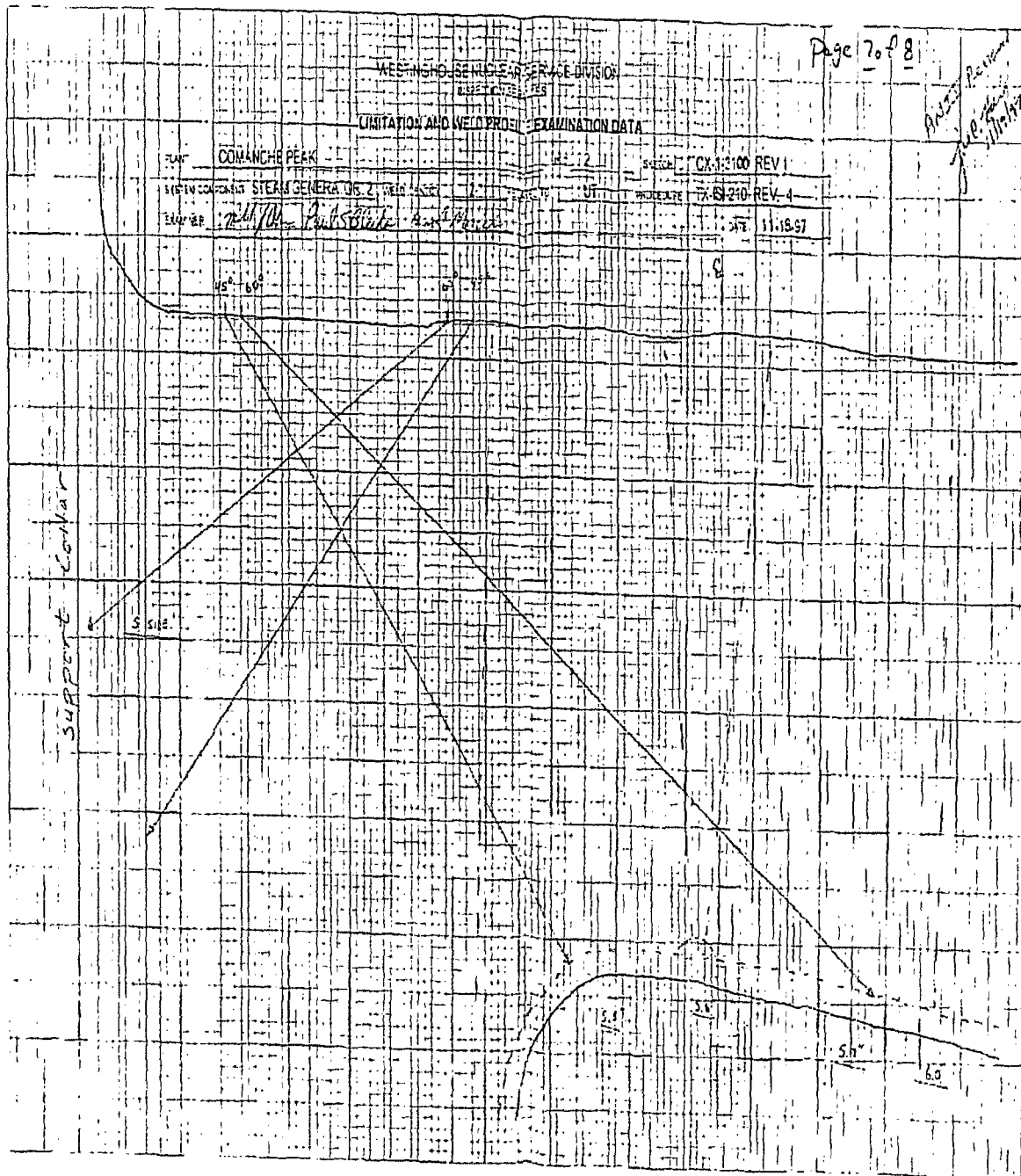
7. Precedents:

Comanche Peak Nuclear Power Plant, Unit 2 First Inspection Interval Relief Request B-5, "Steam Generator Tubesheet-to-Channel Head Welds," as approved by the NRC in ADAMS Accession No. ML012490192

Comanche Peak Nuclear Power Plant, Unit 2 First Inspection Interval Relief Request B-14, "Steam Generator Tubesheet-to-Channel Head Welds," as approved by the NRC in ADAMS Accession No. ML051670284

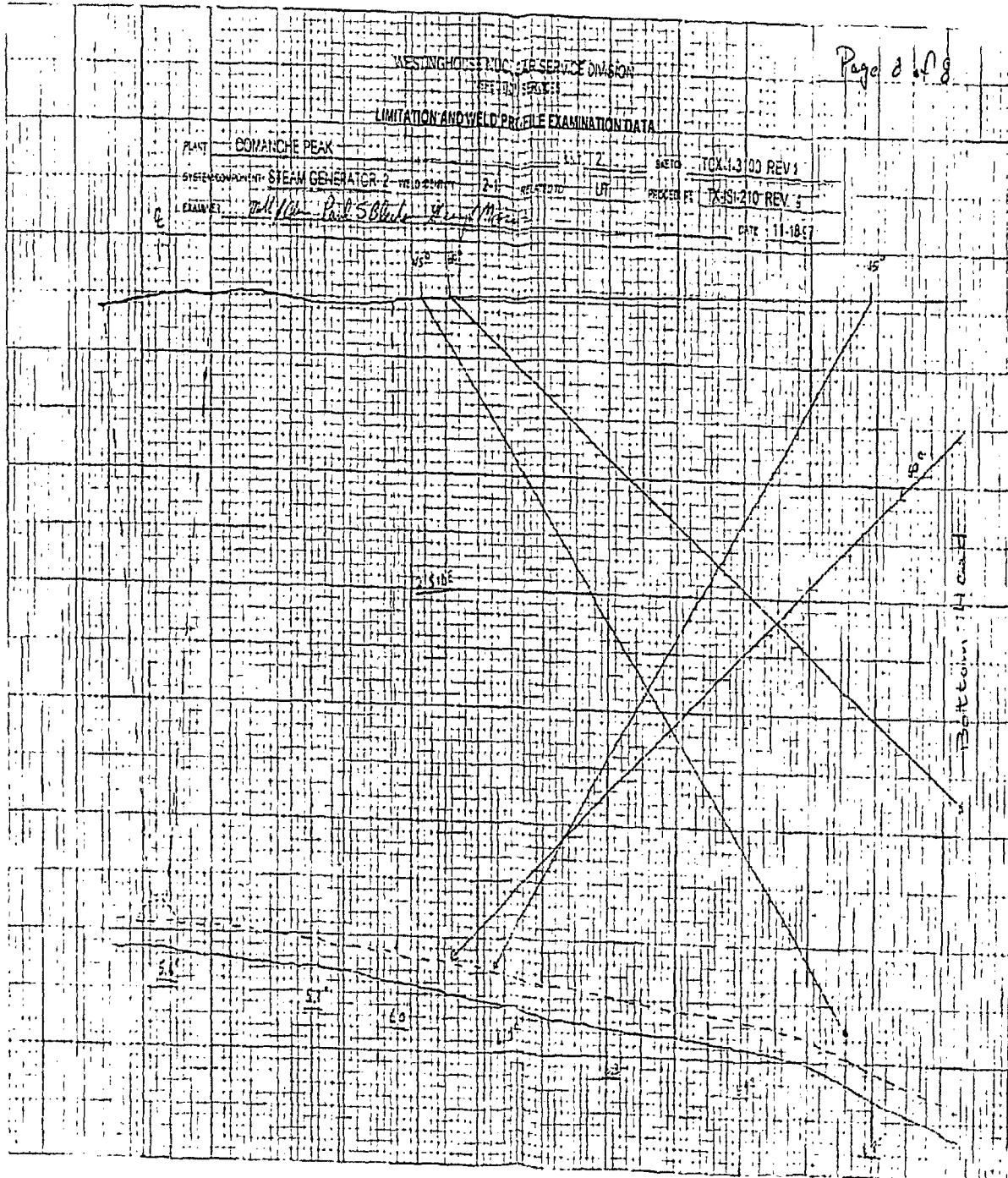
10CFR 50.55a REQUEST NUMBER B-7
RELIEF REQUESTED
IN ACCORDANCE WITH 10CFR50.55a(g)(5)(iii)
- INSERVICE INSPECTION IMPRACTICALITY

Weld Profile Page 1 of 2



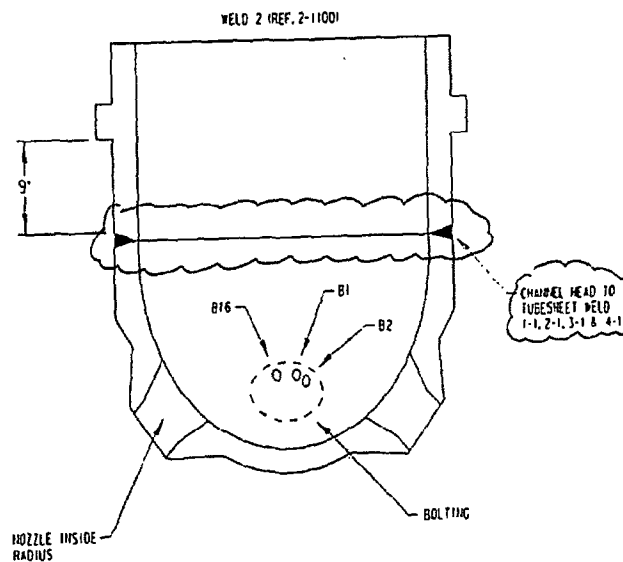
10CFR 50.55a REQUEST NUMBER B-7
RELIEF REQUESTED
IN ACCORDANCE WITH 10CFR50.55a(g)(5)(iii)
- INSERVICE INSPECTION IMPRACTICALITY

Weld Profile Page 2 of 2



10CFR 50.55a REQUEST NUMBER B-7
RELIEF REQUESTED
IN ACCORDANCE WITH 10CFR50.55a(5)(iii)
- INSERVICE INSPECTION IMPRACTICALITY

Exam Report Page 1 of 7



STEAM GENERATOR	WELD	MANWAY	BOLTING	INSIDE RADIUS
1	1-1	HOTSIDE COLD SIDE	1-B1 TO 1-B16 1-B17 TO 1-B32	1A 1B
2	2-1	HOTSIDE COLD SIDE	2-B1 TO 2-B16 2-B17 TO 2-B32	2A 2B
3	3-1	HOTSIDE COLD SIDE	3-B1 TO 3-B16 3-B17 TO 3-B32	3A 3B
4	4-1	HOTSIDE COLD SIDE	4-B1 TO 4-B16 4-B17 TO 4-B32	4A 4B

ILLUSTRATIVE USE ONLY

NOTES:

DESCRIPTION: STEAM GENERATORS 1, 2, 3 & 4
(TUBESIDE) 5.3' / SA-508
(HEADSIDE) 5.3' / SA-216
(BOLTING) 1.875" DIA. / 16.11" LENGTH

TU ELECTRIC
CPSES UNIT 2

INSERVICE INSPECTION
LOCATION ISOMETRIC

APPROVAL: *RB May* *BB May 9-94*

TCX131001.1S1

TCX-1-3100

REV. 1

09-01-94

10CFR 50.55a REQUEST NUMBER B-7
RELIEF REQUESTED
IN ACCORDANCE WITH 10CFR50.55a(g)(5)(iii)
- INSERVICE INSPECTION IMPRACTICALITY

Exam Report Page 2 of 7

PDI		Calibration Data Sheet	
Plant / Unit	COMANCHE PEAK UNIT 2	Data Sheet #	10 UT-18A
Company	WESDYNE	Page	1 of 8
Comp / System	STEAM GENERATOR 2	Cal. Checks	Time
Procedure No.	TX-ISI-210	Initial Calib.	0750
Rev / Chng. No.	6 / N/A	Initial Calib. Date	4/12/08
Cal. Block No.	TBX-28	Intermediate	N/A
Cal. Block Temp	75° Comp. Temp 80°	Intermediate	N/A
Therm S/N:	TU-2261	Final Calib.	1216
Size	N/A	Final Calib. Date	4/12/08
Size	N/A		
Sch.	N/A		
"T"			
<input checked="" type="checkbox"/> Ferritic	<input type="checkbox"/> Austenitic		
Cal. Direction:	Axial Circ. Both	Couplant	
Scan Area:	⊥ to Weld	Type:	ULTRA GEL II
	to Weld	Batch:	06225
		Search Unit #1	
		Manufacture:	KBA
		Serial No.:	01C0X2
		Freq.:	2.25 MHz
		Size:	1.0" Shape: ROUND
		Exam Angle:	0° Model: GAMMA
		Measured Angle:	0°
		Wedge Style:	N/A
		Search Unit Cable	
		Type:	RG 58 A/U
		Length:	20' No. of Connectors 0
		Instrument Settings	
		Make / Model:	KBA / USN 52R
		Serial No.:	102282
		Dis.Delay:	1.227 μs Range: 9.037
		Prb.Delay:	N/A μs Pwidth: N/A
		M'll Cal/Vet:	.2315 μs Pulser SINGLE
		Damping:	1000 Ω Reject: 0%
		Rep. Rate:	AUTOHIGH Freq.: .3 - 4
		Filter:	N/A Mode: N/A
		Voltage:	N/A Rectify: FULLWAVE
		Reference Sensitivity (Sens.)	
		Axial:	13.0 dB Circ: N/A
		SDH Sensitivity:	N/A
		Further Evaluation Required?	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
Examination Area / Weld	Access	Recordable Indications	Exam Sens.
TCX-1-3100 2-1	WELD VOLUME	Yes No Geom	27.0 dB
Remarks / Reason for Incomplete Scan(s)			
22% NOT EXAMINED			
SEE LIMITATION SHEET			
COVERAGE TAKEN FROM PREVIOUS DATA			
Examiners:	WALLACE REID	Level	II Date 4/12/08
Examiners:	N/A	Level	N/A Date N/A

Reviewer / Date

87 Sub 4/15/08

Reviewer / Date

Rail 31 Pauline 4/15/08

Henry Paul M. 4/15/08

Exam Report Page 4 of 7

10CFR 50.55a REQUEST NUMBER B-7
RELIEF REQUESTED
IN ACCORDANCE WITH 10CFR50.55a(g)(5)(iii)
- INSERVICE INSPECTION IMPRACTICALITY

WESTINGHOUSE NUCLEAR SERVICE DIVISION									
INSPECTION SERVICES									
BEAM SPREADS									
PLANT	COMANCHE PEAK			UNIT	II		PROCEDURE	TX-ISI-210, REV. 6	
TRANSDUCER S/N	01BXVB	ANGLE	45°	SIZE	.5" X 1"	FREQUENCY	2.25 MHz	CAL. BLOCK	TBX-28
								THICKNESS	5.45"
EXAMINER	JACK REISEWITZ <i>Jack Reiserwitz</i>			DATE			04/11/08		

47°
45°
41°
48°
45°
40°
49°
45°
42°

SURFACE DIST.	FORWARD	MAX	BACKWARD
1/4 T	1.15	1.35	1.55
1/2 T	2.35	2.70	3.00
3/4 T	3.55	4.00	4.40

Exam Report Page 5 of 7

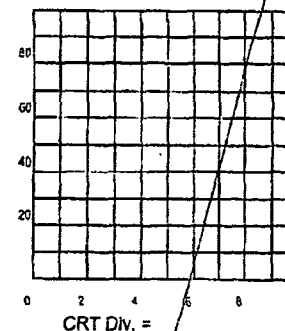
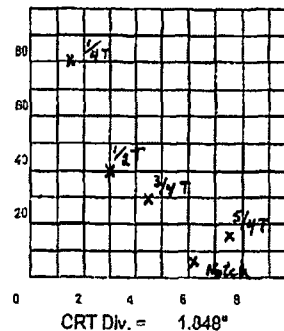
10CFR 50.55a REQUEST NUMBER B-7
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IN ACCORDANCE WITH 10CFR50.55a(5)(iii)
- INSERVICE INSPECTION IMPRACTICALITY

PDI

Calibration Data Sheet

Plant / Unit COMANCHE PEAK UNIT 2
Company WESDYNE
Comp / System STEAM GENERATOR 2
Procedure No. TX-ISI-210
Rev / Chng. No. 6 / N/A
Cal. Block No. TBX-28
Cal. Block Temp 75° Comp. Temp 80°
Therm S/N: TU-2261
Size N/A Sch. N/A "T"
☒ Ferritic ☐ Austenitic

Data Sheet # 10 UT-18C
Page 4 of 8
Cal. Checks
Initial Calib. 0800
Initial Calib. Date 4/12/08
Intermediate N/A
Intermediate N/A
Final Calib. 1230
Final Calib. Date 4/12/08



Cal. Direction: Axial Circ. X Both Couplant

Scan Area: ⊥ to Weld
⊥ to Weld

Type: ULTRA GEL II
Batch: 06225

Search Unit #1
Manufacture: KBA
Serial No.: 018XVB Freq.: 2.25 MHz
Size: .5" X 1.0" Shape: RECTANGLE
Exam Angle 80° Model: GAMMA
Measured Angle: 60°
Wedge Style: SWS

Search Unit #2
Manufacture: N/A
Serial No.: N/A Freq.: N/A
Size: N/A Shape: N/A
Exam Angle N/A Model: N/A
Measured Angle: N/A
Wedge Style: N/A

Search Unit Cable
Type: RG 58 A/U
Length: 20' No. of Connectors 0

Search Unit Cable
Type: N/A
Length: N/A No. of Connectors N/A

Instrument Settings
Make / Model: KBA / USN 60 SW
Serial No.: 105420
Dis.Delay: .335 μ s Range: 18.48
Prb.Delay: 14.8894 μ s Pwidth: 220 ns
M/I Cal/Vet: .1270 μ s Pulser SQUARE
Damping: 500 Ω Reject: 0%
Rep. Rate: AUTOHIGH Freq.: 2.25 MHz
Filter: N/A Mode: SINGLE
Voltage: 450 Rectify: FULLWAVE

Instrument Settings
Make / Model: N/A
Serial No.: N/A
Dis.Delay: N/A μ s Range: N/A
Prb.Delay: N/A μ s Pwidth: N/A
M/I Cal/Vet: N/A μ s Pulser N/A
Damping: N/A Ω Reject: N/A
Rep. Rate: AUTOHIGH Freq.: N/A
Filter: N/A Mode: N/A
Voltage: N/A Rectify: FULLWAVE

Examination Area / Weld	Access	Recordable indications	Exam Sens.
		Yes No Geom	
TCX-1-3100	2-1 2-SIDED	X	59.0 dB

Remarks / Reason for Incomplete Scan(s)
OK 4/24/13
27% NOT EXAMINED
SEE LIMITATION SHEET
COVERAGE TAKEN FROM PREVIOUS DATA

Examiners: CAREY LASOYA Level II Date 4/12/08

Examiners: N/A Level N/A Date N/A

Reviewer / Date SAS 4/15/08

Reference Sensitivity (Sens.)
Axial: 45.0 dB Circ: 45.0 dB

SDH Sensitivity: N/A

Further Evaluation Required? ☐ Yes ☒ No

Reviewer / Date Paul M. Bessinger 4/14/08 Jeffrey M. Bessinger 4/15/08

10CFR 50.55a REQUEST NUMBER B-7
RELIEF REQUESTED
IN ACCORDANCE WITH 10CFR50.55a(g)(5)(iii)
- INSERVICE INSPECTION IMPRACTICALITY

Exam Report Page 6 of 7

WESTINGHOUSE NUCLEAR SERVICE DIVISION											
INSPECTION SERVICES											
BEAM SPREADS											
PLANT	COMANCHE PEAK			UNIT	II	PROCEDURE	TX-ISI-210, REV. 6				
TRANSDUCER S/N	01BXVB	ANGLE	60°	SIZE	.5" X 1"	FREQUENCY	2.25 MHz	CAL. BLOCK	TBX-28	THICKNESS	5.45"
EXAMINER	CAREY LASOYA <i>Carey Lasoya</i>					DATE	04/11/08				

64°
61°
56°
65°
61°
56°
64°
61°
57°

SURFACE DIST.	FORWARD	MAX	BACKWARD
1/4 T	2.00	2.45	2.90
1/2 T	4.20	4.90	5.80
3/4 T	6.50	7.40	8.45

10CFR 50.55a REQUEST NUMBER B-7
RELIEF REQUESTED
IN ACCORDANCE WITH 10CFR50.55a(g)(5)(iii)
- INSERVICE INSPECTION IMPRACTICALITY

Exam Report Page 7 of 7

WESTINGHOUSE NUCLEAR SERVICES DIVISION		Page 6 of 8
LIMITATION TO EXAMINATION		
PLANT	COMANCHE PEAK	UNIT 2 SKETCH TCX-1-3100 REV 1
SYST./COMP.	STEAM GENERATOR 2	PROCEDURE TX-ISI-210 REV. 4
EXAMINER	DATE 11-18-97	
RELATED TO:	UT <input checked="" type="checkbox"/> PT <input type="checkbox"/> MT <input type="checkbox"/> VT <input type="checkbox"/>	IDENT. NO. 2-1
PROVIDE GENERAL INFORMATION TO DESCRIBE APPROXIMATE SIZE, LOCATION AND TYPE OF LIMITATION.		
<div style="border: 1px solid black; padding: 10px; margin: 10px auto; width: 80%;"><p style="text-align: center;">S SIDE</p><div style="text-align: center; border-bottom: 1px solid black; padding-bottom: 5px;">SUPPORT COLLAR</div><div style="display: flex; justify-content: space-around; align-items: flex-end;"><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 445"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 275"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 193"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 86"</div></div></div><div style="display: flex; justify-content: space-around; align-items: flex-end;"><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 305"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 205"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 106"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 21"</div></div></div><div style="display: flex; justify-content: space-around; align-items: flex-end;"><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 323"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 235"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 128"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 46"</div></div></div><div style="display: flex; justify-content: space-around; align-items: flex-end;"><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 342"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 251"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 151"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 48"</div></div></div><div style="display: flex; justify-content: space-around; align-items: flex-end;"><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 364"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 261"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 155"</div></div><div style="text-align: center;"><div style="border: 1px solid black; width: 60px; height: 40px; margin: 0 auto;"></div><div style="margin-top: 5px;">← 48"</div></div></div></div> <div style="text-align: center; padding-top: 5px;">2 SIDE</div>		

**10CFR 50.55a Request Number B-12
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticality -**

1. ASME Code Components Affected:

ASME Code Class: Code Class 1
References: ASME Section XI, Table IWB-2500-1 and IWB-3510
Examination Category: B-B
Item Number: B2.40
Description: Code required examination coverage for the weld volume is impractical
Component: Steam Generator 2-01 Head-to-Tubesheet Weld TCX-1-3100-1-1
Component Number: TCX-RCPCSG-01

2. Applicable Code Edition and Addenda:

ASME Section XI, 1998 Edition through 2000 Addenda.

3. Applicable Code Requirement:

ASME Section XI 1998 Edition through 2000 Addenda, Figure IWB-2500-6 (Design B) requires a minimum volumetric examination of the weld volume extending 1/2t into the base metal on both the head side and tubesheet side of the head-to-tubesheet weld (Code Item B2.40).

Comanche Peak Nuclear Power Plant (CPNPP) Unit 2 second ten-year interval Inservice Inspection Program Plan also implements Code Case N-460, "Alternative Examination Coverage for Class 1 and Class 2 Welds, Section XI, Division 1," which is endorsed by the NRC in Revision 16 of Regulatory Guide 1.147, "Inservice Inspection Code Case Acceptability ASME Section XI, Division 1." Code Case N-460 states, in part, "when the entire examination volume or area cannot be examined due to interference by another component or part geometry, a reduction in examination coverage on any Class 1 or Class 2 weld may be accepted provided the reduction in coverage for that weld is less than 10%."

NRC Information Notice (IN) 98-42, "Implementation of 10CFR50.55a(g) Inservice Inspection Requirements," termed a reduction in coverage of less than 10 percent to be "essentially 100 percent." IN 98-42 states, in part, "The NRC has adopted and further refined the definition of "essentially 100 percent" to mean "greater than 90 percent." This methodology has been applied to all examinations of welds or other areas required by ASME Section XI.

10CFR 50.55a Request Number B-12
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

4. Impracticability of Compliance:

The examination of the subject component weld is limited by the presence of four 24"x24" Steam Generator support pads and seventeen 2.5"x2.5" welded pads (See attached sketch). The examinations were conducted in accordance with procedure TX-ISI-210, "Ultrasonic Examination Procedure for Welds in Ferritic Steel Vessels." Straight beam (0°) and angle beam (45° shear and 60° longitudinal) scans were used to achieve the weld volume obtained. As shown on the attached examination data sheets the 0° and 45° exam angles achieved 78% examination coverage, and the 60° exam angle achieved 69% examination coverage. Taking the worst case limitation this corresponds to a coverage of 69% of the required examination volume.

5. Burden Caused by Compliance:

The design configuration restrictions of the subject component makes the Code required examination coverage requirements for the weld volume impractical. Plant modifications or replacements of components designed to allow for complete coverage would be needed to meet the Code requirements. This would cause considerable burden to CPNPP.

6. Proposed Alternative and Basis for Use:

Proposed Alternative:

The following alternatives are proposed in lieu of the required examination coverage of essentially 100 percent:

3. Ultrasonic testing (UT) of the subject component weld was performed to the maximum extent practical during the second ten-year interval.
4. Pressure test VT-2 visual examinations were performed, as required by Code Category B-P, during the second ten-year interval. No evidence of leakage was identified for this component.

Basis for Use:

The basis for use of this alternative is that it provides the best examination coverage practical within the limitations of the current configuration. Based on the percentage of the examination volume completed and the lack of any indications identified, there is a high level of confidence in the continued structural integrity of the weld. CPNPP believes that there is no undue risk to the public health and safety presented by this request.

10CFR 50.55a Request Number B-12
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticality –

6. Duration of Proposed Alternative:

The second ten-year ISI interval for Unit 2 began on August 3, 2004 and ends on August 2, 2014.

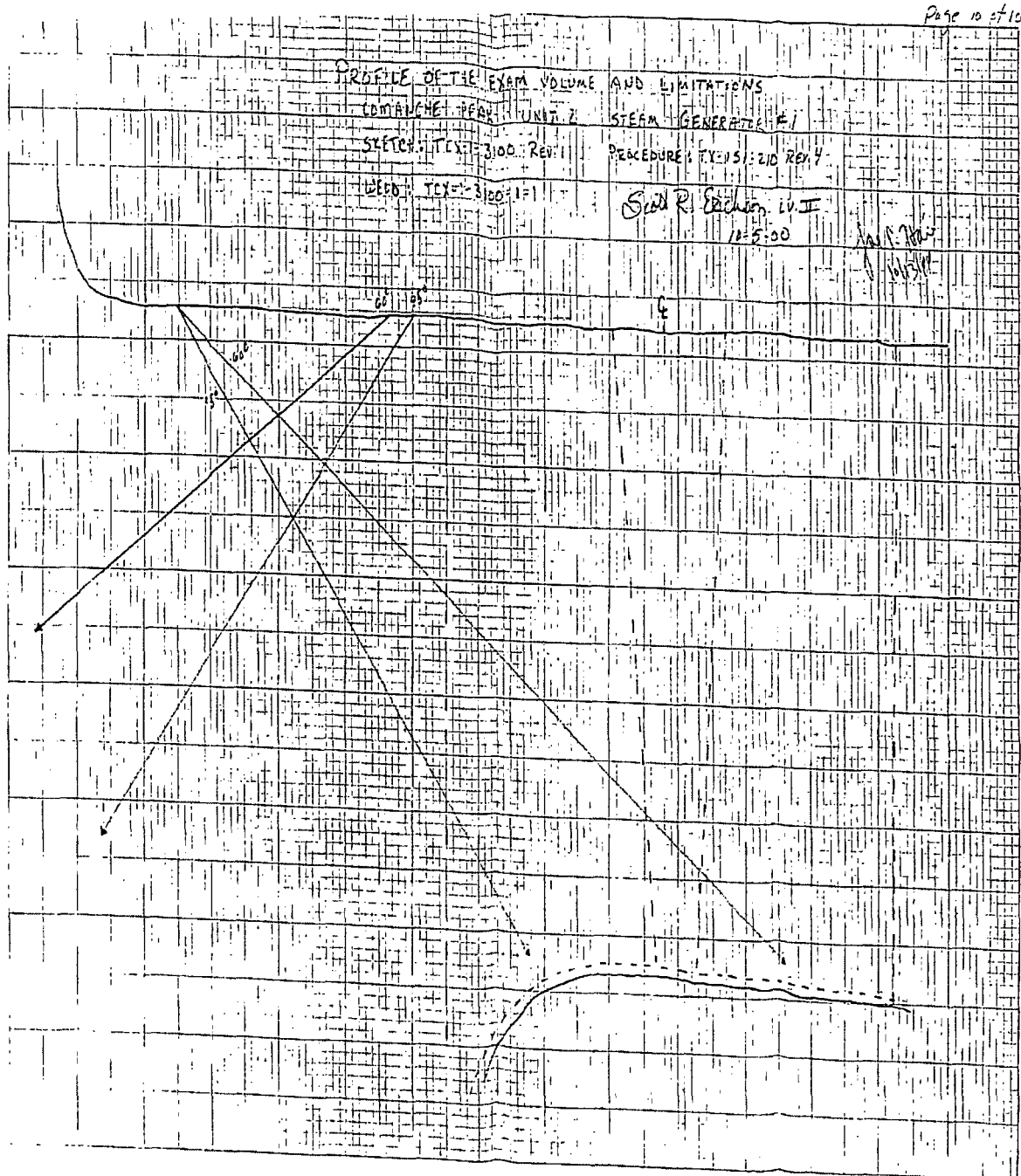
7. Precedents:

Comanche Peak Nuclear Power Plant, Unit 2 First Inspection Interval Relief Request B-5, "Steam Generator Tubesheet-to-Channel Head Welds," as approved by the NRC in ADAMS Accession No. ML012490192

Comanche Peak Nuclear Power Plant, Unit 2 First Inspection Interval Relief Request B-14, "Steam Generator Tubesheet-to-Channel Head Welds," as approved by the NRC in ADAMS Accession No. ML051670284

10CFR 50.55a Request Number B-12
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

Weld Profile Page 1 of 1



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10CFR 50.55a Request Number B-12
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

STEAM GENERATOR	WELD	MANWAY	BOLTING	INSIDE RADIUS
1	1-1	HOTSIDE COLD SIDE	1-B1 TO 1-B16 1-B17 TO 1-B32	1A 1B
2	2-1	HOTSIDE COLD SIDE	2-B1 TO 2-B16 2-B17 TO 2-B32	2A 2B
3	3-1	HOTSIDE COLD SIDE	3-B1 TO 3-B16 3-B17 TO 3-B32	3A 3B
4	4-1	HOTSIDE COLD SIDE	4-B1 TO 4-B16 4-B17 TO 4-B32	4A 4B

ILLUSTRATIVE USE ONLY

NOTES:	DESCRIPTION: STEAM GENERATORS 1, 2, 3 & 4 (TUBESIDE) 5.3' SA-508 (HEADSIDE) 5.3' SA-216 (BOLTING) 1.875" DIA./16.11" LENGTH	TU ELECTRIC CPSES UNIT 2	
		INSERVICE INSPECTION LOCATION ISOMETRIC	
APPROVAL: <i>RBMay, DBMay 9-94</i>		TCX-1-3100	REV. 1 09-01-94

TCX-1-3100-1-1

Weld Exam Report Page 2 of 10

10CFR 50.55a Request Number B-12
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WESDYNE A Westinghouse Electric Company		Calibration Data Sheet																																																																												
Plant / Unit	COMANCHE PEAK UNIT 2		Data Sheet #	12 UT-017A																																																																										
Company	WesDyne International		Page	1 of 10																																																																										
Comp / System	STEAM GENERATOR																																																																													
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Remarks / Reason for Incomplete Scan(s): COMPONENT TEMP: 95°F 69% EXAMINATION COVERAGE ACHIEVED			Reference Sensitivity (Sens.) Axial: 63.5 dB Circ: N/A SDH Sensitivity: 47.6 dB CRT Div./SDH: 1.1																																																																											
Examiners: TOMAZ VIDRIH Level II Date 04/08/11 N/A Level N/A Date N/A			Reviewers: <i>[Signature]</i> Further Evaluation Required? <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No REVIEWER / DATE: <i>[Signature]</i> 4-9-11 REVIEWER / DATE: <i>[Signature]</i> 4/20/11																																																																											

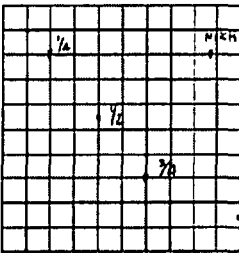
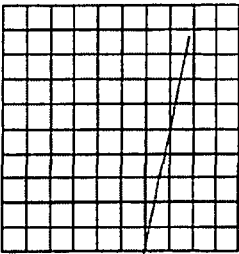
10CFR 50.55a Request Number B-12
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WESDYNE <small>ANALYTICAL SERVICES</small>		Calibration Data Sheet			
Plant / Unit: <u>COMANCHE PEAK UNIT 2</u>		Data Sheet # <u>12 UT-017B</u>			
Company: <u>WesDyne International</u>		Page <u>2</u> of <u>10</u>			
Comp / System: <u>STEAM GENERATOR</u>					
Procedure No: <u>TX-IS-210</u>					
Rev / Chng No: <u>770</u>					
Cal Block No: <u>7BX28</u>					
Cal Block Temp: <u>83 °F</u>					
Thermometer S/N: <u>IC-1454</u>					
Size: <u>19 LX 6 W X 5.45 T</u> Sch: <u>N/A</u>					
<input checked="" type="checkbox"/> Ferritic <input type="checkbox"/> Austenitic					
Each Major CRT Div = <u>.9633"</u>					
Cal Direction: <input checked="" type="checkbox"/> Axial <input type="checkbox"/> Circ <input type="checkbox"/> Both					
Scan Area: <u>11</u> to We'd <input checked="" type="checkbox"/> <u>11</u> to We'd <input checked="" type="checkbox"/>					
Calibration Reference Check: <u>104874</u> Ref Reflector: <u>SDH</u> Type: <u>ULTRAGEL II</u> Batch: <u>06225</u>					
		Cal. Checks		Time	
		Initial Calib		0811	
		Initial Calib Date		04/08/11	
		Intermediate		1300	
		Intermediate		N/A	
		Final Calib		1655	
		Final Calib Date		04/08/11	
		Couplant			
		Type: <u>ULTRAGEL II</u>			
		Batch: <u>06225</u>			
		Search Unit #1		Search Unit #2	
		Manufacture: <u>KRAUTKRAMER</u>		Manufacture: <u>N/A</u>	
		Serial No.: <u>01BXV7</u>		Serial No.: <u>N/A</u>	
		No. of Elements: <u>1</u>		No. of Elements: <u>N/A</u>	
		Size: <u>1 X .50"</u> Shape: <u>RECT.</u>		Size: <u>N/A</u> Shape: <u>N/A</u>	
		Freq: <u>2.25 MHz</u> Style: <u>GAMMA</u>		Freq: <u>N/A</u> Style: <u>N/A</u>	
		Exam Angle: <u>45°</u> Mode: <u>SEAR</u>		Exam Angle: <u>N/A</u> Mode: <u>N/A</u>	
		Measured Angle: <u>45°</u>		Measured Angle: <u>N/A</u>	
		Wedge Style: <u>NON INTEGRAL</u>		Wedge Style: <u>N/A</u>	
		Search Unit Cable		Search Unit Cable	
		Type: <u>BNC / BNC</u>		Type: <u>RG 174</u>	
		Length: <u>12'</u> No. of Con.: <u>0</u>		Length: <u>N/A</u> No. of Con.: <u>N/A</u>	
		Instrument Settings		Instrument Settings	
		Make / Model: <u>KRAUTKRAMER USH 58L</u>		Make / Model: <u>KRAUTKRAMER USH 60SW</u>	
		Serial No.: <u>SAP 10439</u>		Serial No.: <u>N/A</u>	
		Probe Delay: <u>12.2712</u> Range: <u>9.633</u>		Probe Delay: <u>N/A</u> Range: <u>N/A</u>	
		M'U Cal / Vel: <u>.1262</u> Pulser: <u>SQUARE</u>		M'U Cal / Vel: <u>N/A</u> Pulser: <u>N/A</u>	
		Damping: <u>500</u> Reject: <u>C%</u>		Damping: <u>N/A</u> Reject: <u>N/A</u>	
		PRF: <u>AUTOHIGH</u> Freq: <u>2.25 MHz</u>		PRF: <u>AUTOHIGH</u> Freq: <u>N/A</u>	
		Filter: <u>FIXED</u> Mode: <u>PIE</u>		Filter: <u>N/A</u> Mode: <u>PIE</u>	
		Rectify: <u>FULLWAVE</u> Voltage: <u>450</u>		Rectify: <u>N/A</u> Voltage: <u>N/A</u>	
		Pulse Width: <u>220ns</u>		Pulse Width: <u>N/A</u>	
		Reference Sensitivity (Sens): <u>56 dB</u> Circ: <u>N/A</u>		Reference Sensitivity (Sens): <u>N/A</u> Circ: <u>N/A</u>	
		SDH Sensitivity: <u>40 dB</u>		SDH Sensitivity: <u>N/A</u>	
		CRT Div./SDH: <u>1.1</u>		CRT Div./SDH: <u>N/A</u>	
Examiners: <u>JEROME JERMAN</u> Level: <u>II</u> Date: <u>04/08/11</u>		Level: <u>N/A</u> Date: <u>N/A</u>			
Reviews: <u>N/A</u>		Further Evaluation Required? <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No			
REVIEWER / DATE: <u>JSole 4-9-11</u>		REVIEWER / DATE: <u>Hand on 4/20/11</u>			
		<u>Hand on 4-20-11</u>			

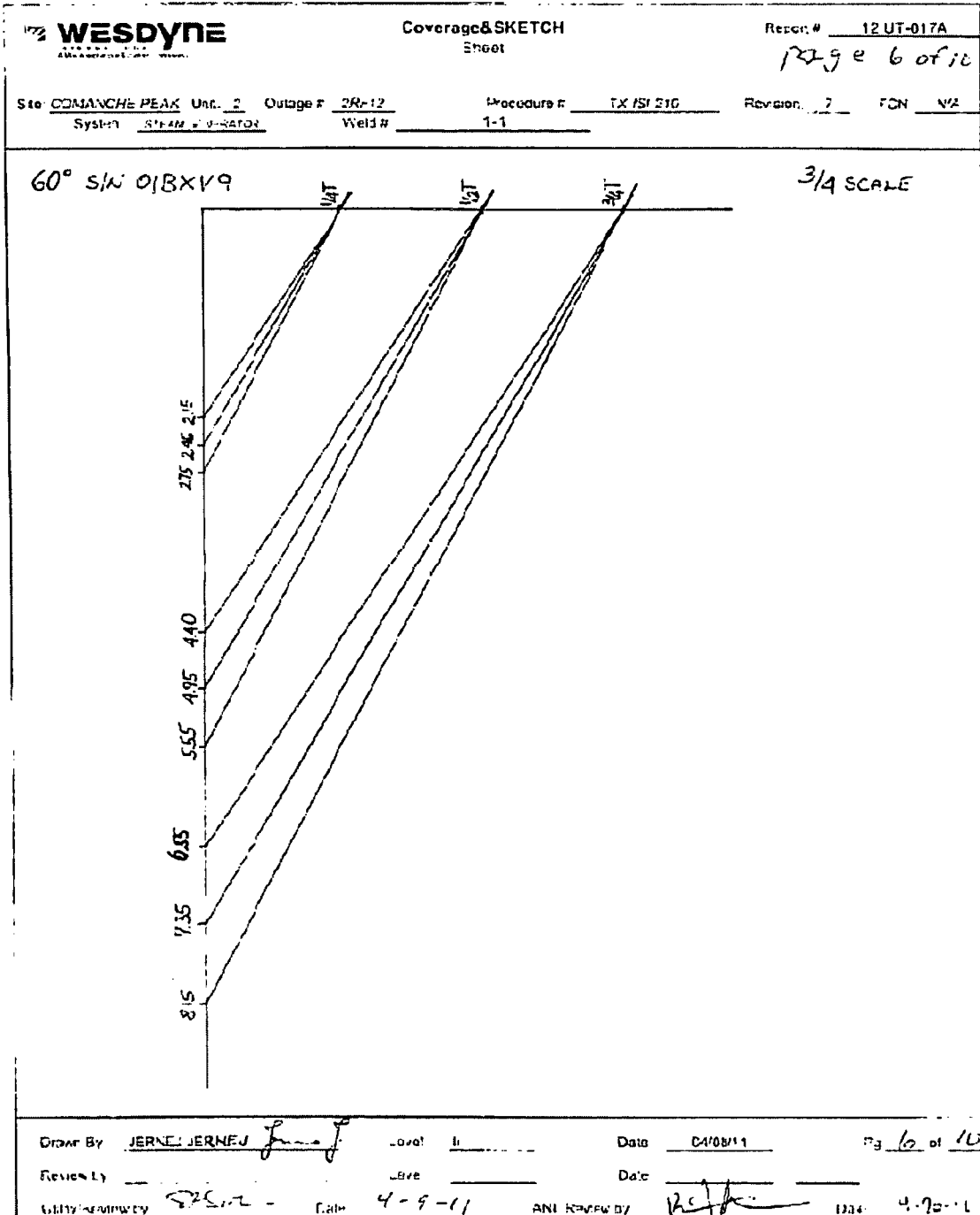
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WESDYNE <small>INTERNATIONAL</small>		Calibration Data Sheet																																				
Part / Unit <u>COMANCHE PEAK UNIT 2</u>		Data Sheet # <u>12 UT 017C</u>																																				
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Calibration Reference Check Rompas Back = <u>104874</u> Ref. Reflector <u>SDH</u> Type: <u>ULTRAGEL II</u> Batch: <u>06225</u>		Search Unit #2 Manufacture: _____ Serial No. _____ No. of Elements: _____ Size: _____ Shape: _____ Freq. _____ Style: _____ Exam Angle: _____ Mode: _____ Measured Angle: _____ Wedge Style: _____		Search Unit Cable Type: <u>BNC</u> Length: <u>12'</u> No. of Con.: <u>0</u>																																		
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		Yes	No	Geom																																		
ICX-1-3103 1-1"	BOTH		X		67.4 dB																																	
Remarks: Reason for Incomplete Scan(s) <u>*135° TO 315° SCANNED</u> <u>78% EXAMINATION COVERAGE ACHIEVED</u>		COMPONENT TEMP: <u>95°F</u>																																				
Examiners: <u>JOHN BELL</u> <u>John Bell</u> Level <u>II</u> Date <u>04/08/11</u> <u>N/A</u> Level <u>N/A</u> Date <u>N/A</u>		Further Evaluation Required? <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No																																				
RBV GACTS REVIEWER / DATE: <u>878</u> <u>4-9-11</u>		REVIEWER / DATE: <u>Paul M. Boudry</u> <u>4/12/11</u> <u>11/11</u>																																				

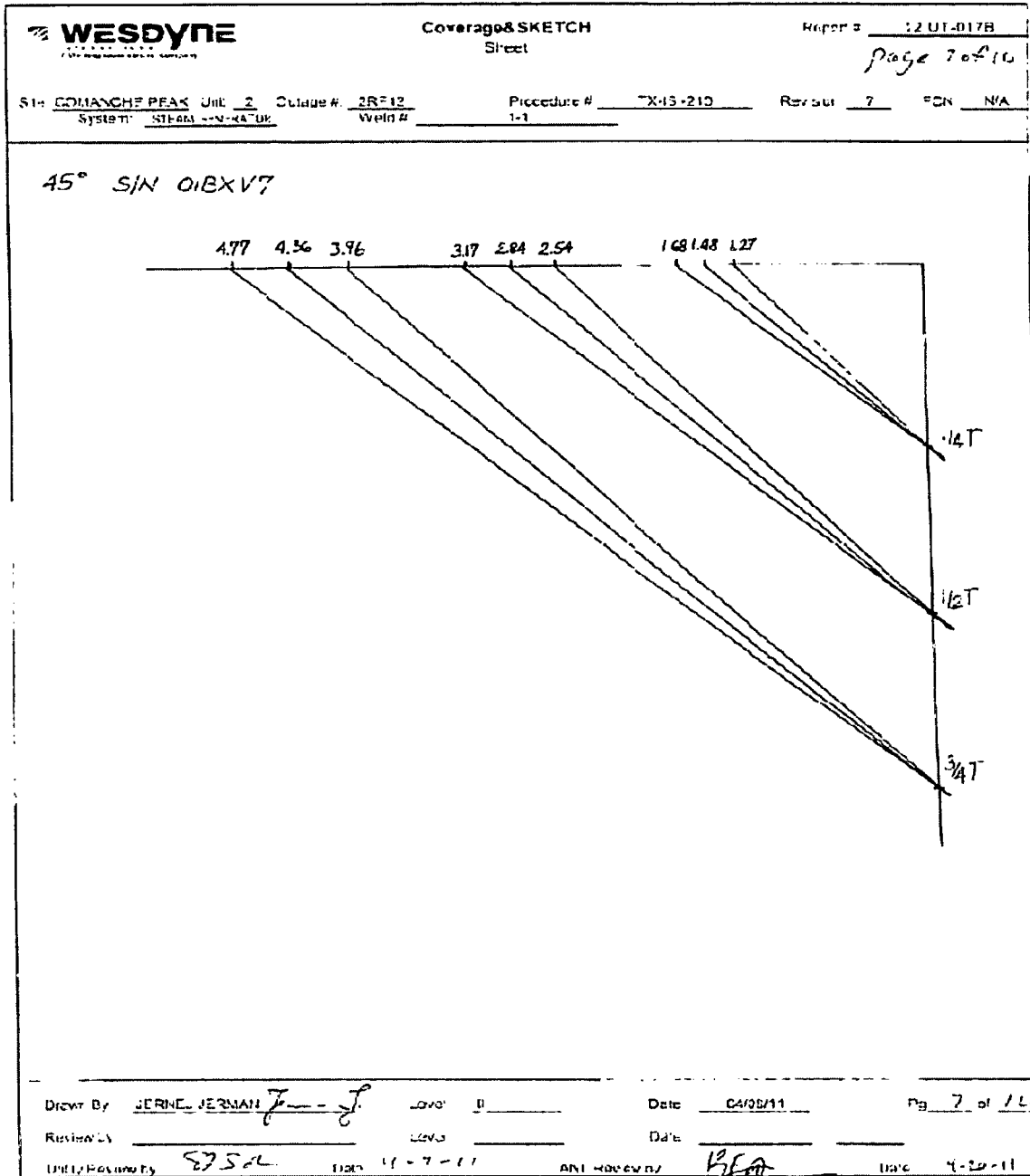
10CFR 50.55a Request Number B-12
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

Weld Exam Report Page 7 of 10




10CFR 50.55a Request Number B-12
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

Weld Exam Report Page 8 of 10

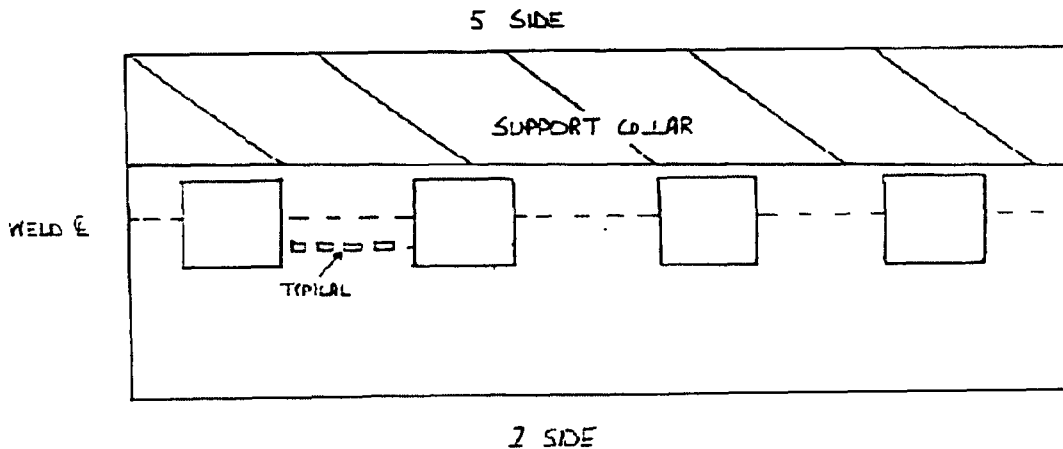


10CFR 50.55a Request Number B-12
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticality -

Weld Exam Report Page 10 of 10

	WESTINGHOUSE NUCLEAR SERVICES DIVISION				REPORT NO	UT-00-021
	LIMITATION TO EXAMINATION				PAGE	9 OF 10 44-11
PLANT	<u>Comanche Peak</u>	UNIT	<u>2</u>	SKETCH	<u>TCX-1-2100</u>	
SYST/COMP	<u>REACTOR COOLANT</u>			PROCEDURE	<u>TX-ISI-210 Rev 4 FC N/A</u>	
EXAMINER	<u>Mason, W. Andrew</u> <i>W. Mason</i>	LEVEL	<u>II</u>	DATE	<u>10/5/2000</u>	
EXAMINER	<u>Holasek, Wade</u> <i>W. Holasek</i>	LEVEL	<u>II</u>	DATE	<u>10/5/2000</u>	
COMPONENT ID <u>TCX-1-2100-1-1</u>						
RELATED TO	<u>MT</u>	<u>PT</u>	<input checked="" type="radio"/> <u>JT</u>	<u>VT</u>		
PROVIDE SUFFICIENT INFORMATION TO DESCRIBE SIZE LOCATION AND TYPE OF LIMITATION						
<u>COMMENTS/SKETCH/DETAILS</u>						

Four 24"X24" Support pads restricts all scan for 22%. Seventeen 2.5"X2.5" welded pads approx. 7" from CL limits 60" scan. 0" -22% not examined. 46" -22% not examined. 60" -31% not examined. 31% of required exam volume not examined.



NUCLEAR REVIEW / DATE	NUCLEAR LEVEL III REVIEW / DATE	API REVIEW / DATE
<i>Frank D. Buehler</i> 10/4/00	<i>J. Ragam</i> 10/12/00	<i>Joe C. Hair</i> 10/13/00

**10CFR 50.55a Request Number B-13
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticality –**

1. ASME Code Components Affected:

ASME Code Class: Code Class 1
References: ASME Section XI, Table IWB-2500-1 and IWB-3510
Examination Category: B-B
Item Number: B2.40
Description: Code required examination coverage for the weld volume is impractical
Component: Steam Generator 2-04 Head-to-Tubesheet Weld TCX-1-3100-4-1
Component Number: TCX-RCPCSG-04

2. Applicable Code Edition and Addenda:

ASME Section XI, 1998 Edition through 2000 Addenda.

3. Applicable Code Requirement:

ASME Section XI 1998 Edition through 2000 Addenda, Figure IWB-2500-6 (Design B) requires a minimum volumetric examination of the weld volume extending 1/2t into the base metal on both the head side and tubesheet side of the head-to-tubesheet weld (Code Item B2.40).

Comanche Peak Nuclear Power Plant (CPNPP) Unit 2 second ten-year interval Inservice Inspection Program Plan also implements Code Case N-460, "Alternative Examination Coverage for Class 1 and Class 2 Welds, Section XI, Division 1," which is endorsed by the NRC in Revision 16 of Regulatory Guide 1.147, "Inservice Inspection Code Case Acceptability ASME Section XI, Division 1." Code Case N-460 states, in part, "when the entire examination volume or area cannot be examined due to interference by another component or part geometry, a reduction in examination coverage on any Class 1 or Class 2 weld may be accepted provided the reduction in coverage for that weld is less than 10%."

NRC Information Notice (IN) 98-42, "Implementation of 10CFR50.55a(g) Inservice Inspection Requirements," termed a reduction in coverage of less than 10 percent to be "essentially 100 percent." IN 98-42 states, in part, "The NRC has adopted and further refined the definition of "essentially 100 percent" to mean "greater than 90 percent." This methodology has been applied to all examinations of welds or other areas required by ASME Section XI.

4. Impracticality of Compliance:

10CFR 50.55a Request Number B-13
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

The examination of the subject component weld is limited by the presence of four 24"x24" Steam Generator support pads and nineteen 2.5"x2.5" welded pads (See attached sketch). The examinations were conducted in accordance with procedure TX-ISI-210, "Ultrasonic Examination Procedure for Welds in Ferritic Steel Vessels." Straight beam (0°) and angle beam (45° shear and 60° longitudinal) scans were used to achieve the weld volume obtained. As shown on the attached examination data sheets the 0°, 45°, and 60° exam angles all achieved 77.5% examined. Therefore, this corresponds to a cumulative exam coverage of 77.5% of the required examination volume.

5. Burden Caused by Compliance:

The design configuration restrictions of the subject component makes the Code required examination coverage requirements for the weld volume impractical. Plant modifications or replacements of components designed to allow for complete coverage would be needed to meet the Code requirements. This would cause considerable burden to CPNPP.

6. Proposed Alternative and Basis for Use:

Proposed Alternative:

The following alternatives are proposed in lieu of the required examination coverage of essentially 100 percent:

1. Ultrasonic testing (UT) of the subject component weld was performed to the maximum extent practical during the second ten-year interval.
2. Pressure test VT-2 visual examinations were performed, as required by Code Category B-P, during the second ten-year interval. No evidence of leakage was identified for this component.

Basis for Use:

The basis for use of this alternative is that it provides the best examination coverage practical within the limitations of the current configuration. Based on the percentage of the examination volume completed and the lack of any indications identified, there is a high level of confidence in the continued structural integrity of the weld. CPNPP believes that there is no undue risk to the public health and safety presented by this request.

6. Duration of Proposed Alternative:

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The second ten-year ISI interval for Unit 2 began on August 3, 2004 and ends on August 2, 2014.

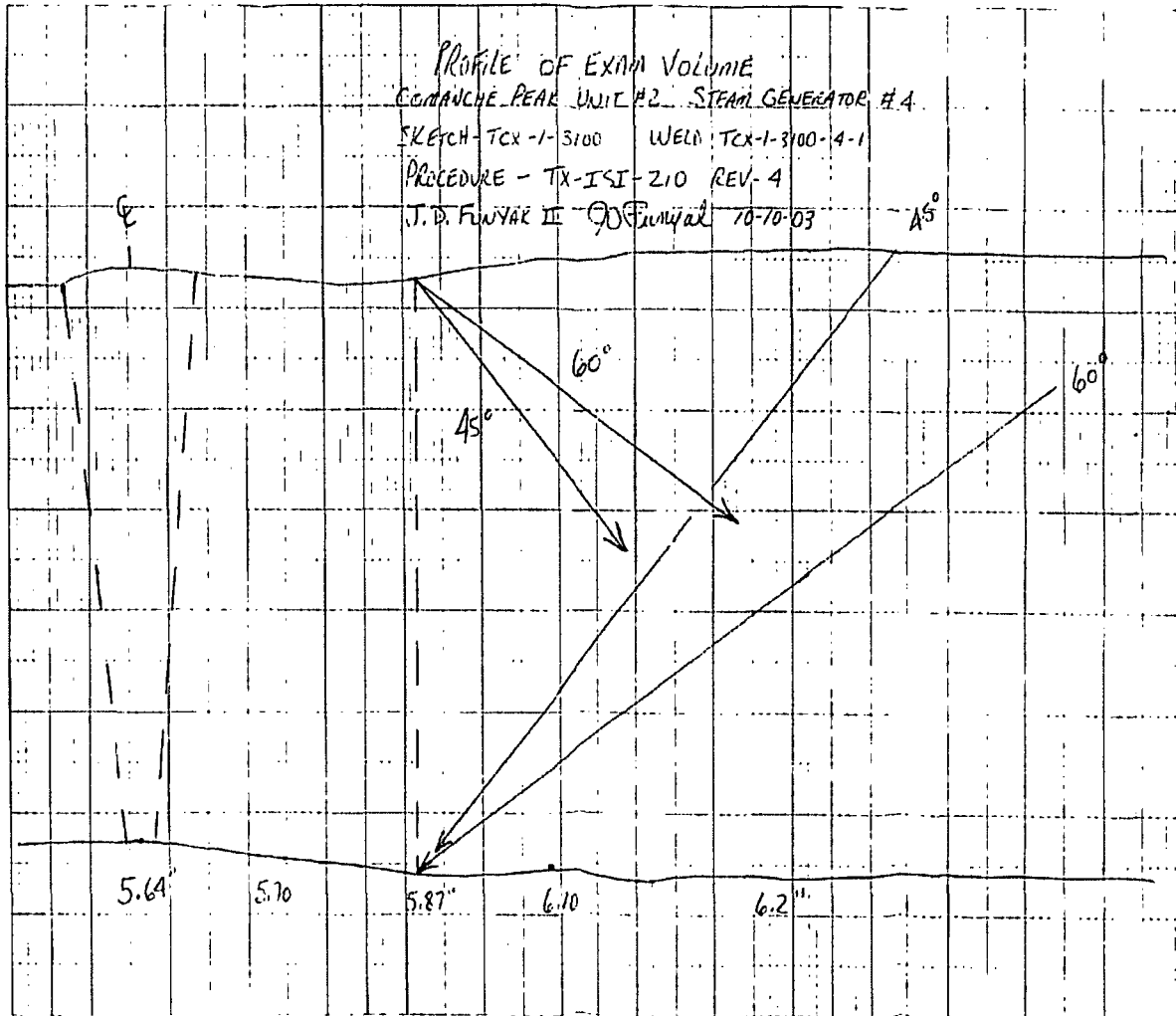
7. Precedents:

Comanche Peak Nuclear Power Plant, Unit 2 First Inspection Interval Relief Request B-5,
“Steam Generator Tubesheet-to-Channel Head Welds,” as approved by the NRC in ADAMS
Accession No. ML012490192

Comanche Peak Nuclear Power Plant, Unit 2 First Inspection Interval Relief Request B-14,
“Steam Generator Tubesheet-to-Channel Head Welds,” as approved by the NRC in ADAMS
Accession No. ML051670284

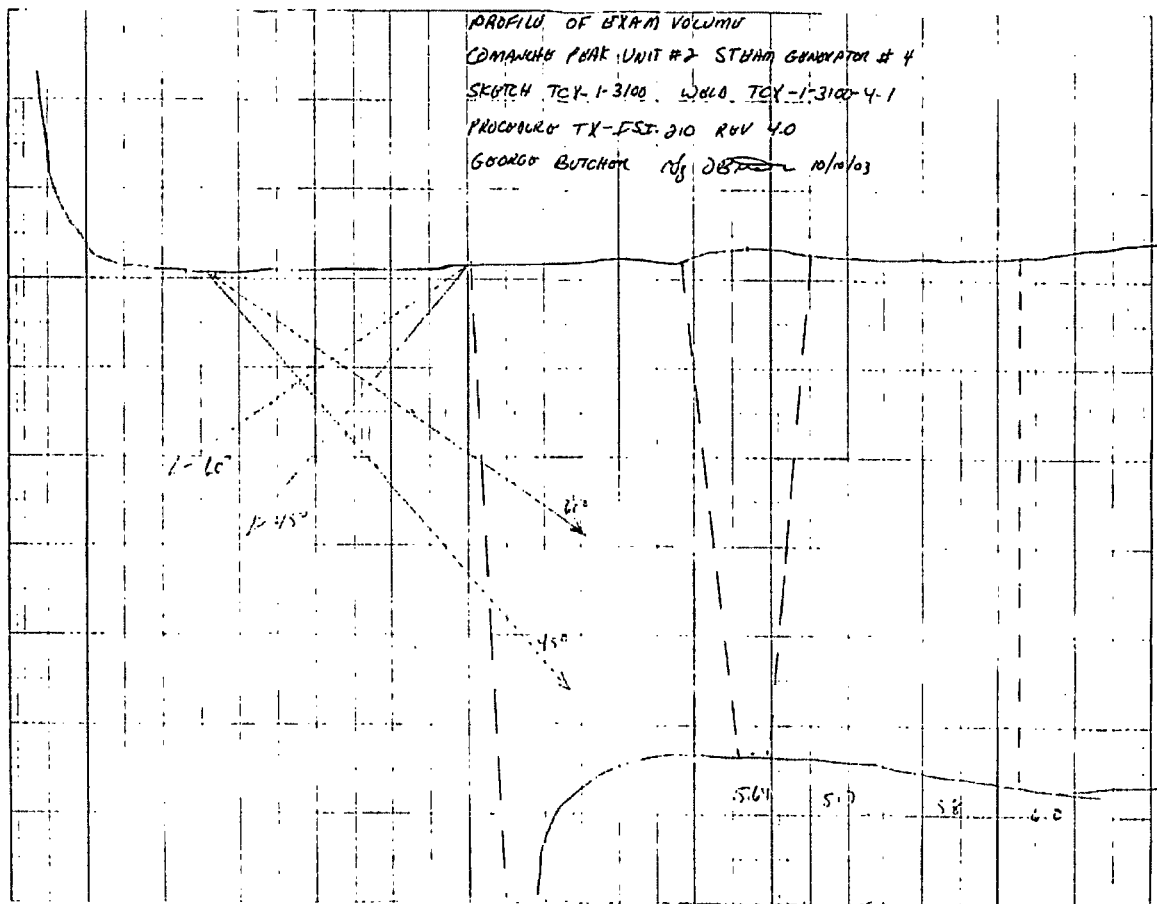
10CFR 50.55a Request Number B-13
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

Weld Profile Page 1 of 2



10CFR 50.55a Request Number B-13
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

Weld Profile Page 2 of 2



10CFR 50.55a Request Number B-13
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- Inservice Inspection Impracticability -

Weld Exam Page 1 of 9

STEAM GENERATOR	REL	MANUAL	BOLTING	INSIDE RADIUS
1	1-	WETSIDE COLD SIDE	1-B: TO 1-B16 1-B17 TO 1-B32	1A 1B
2	2-	WETSIDE COLD SIDE	2-B1 TO 2-B16 2-B17 TO 2-B32	2A 2B
3	3-	WETSIDE COLD SIDE	3-B1 TO 3-B16 3-B17 TO 3-B32	3A 3B
4	4-	WETSIDE COLD SIDE	4-B1 TO 4-B16 4-B17 TO 4-B32	4A 4B

ILLUSTRATIVE USE ONLY

NOTES:	DESCRIPTION: STEAM GENERATORS 1, 2, 3 & 4 (TUBESIDE) 5.3"/SA-508 (HEADSIDE) 5.1"/SA-216 (BOLTING) 1.875" DIA./16.11" LENGTH	TU ELECTRIC CPSES UNIT 2	
	APPROVAL: <i>RR May</i> <i>BS May</i> 5-1-94	INSERVICE INSPECTION LOCATION ISOMETRIC	
		TO: 1-3100	REV. 1 12-01-93

10CFR 50.55a Request Number B-13
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticality -

Weld Exam Page2 of 9

UT Calibrat. Lamination

Site/Unit		CPNPP	/	2	Procedure		TX-ISI-210	Outage No		2RF13
Summary No		011700			Procedure Rev		7	Report No		UT-2012-055
Workscope		ISI			Work Order No		4181105	Page		1 of 8

Code	ASME Sec. XI 1998 Ed./2000 Add.	Cat./Item	B-B/B2.40	Location	2-154L, RB, 812
Drawing No	TCX-1-3100	Description	SG4 CHANNEL HEAD TO TUBESHEET WELD		
System ID:	RC				
Component ID	TCX-1-3100-4-1	Size/Length	1.5" / 426"	Thickness/Diameter	5.3" / 135.6"
Limitations	SEE DRAWING	Start Time	1038	Finish Time	1229

Instrument Settings				Search Unit				Cal. Checks			Axial Orientated Search Unit										
Serial No	104765			Serial No	01C0X1			Time	10/16/2012		Calibration Reflector	Signal Amplitude %	Sweep Division	Sound Path							
Manufacturer	GEIT			Manufacturer	KBA			Initial Cal.	0900		1/4 T	82	1.5	1.36							
Model	USN 58LSW	Linearity	L-2012-004	Size	1.0" Dia			Inter Cal.	1037		1/2 T	81	3.0	2.72							
Delay	0	Range	9.09	Freq	2.25 MHz	Center Freq	1.97 MHz	Inter Cal.			3/4 T	70	4.5	4.07							
Mit Cal/Vel	0.2319	Pulse Type	Square	Exam Angle	0	Squint Angle	N/A	Final Cal.	1308		N/A										
Damping	500 Ohms	Reject	0%	Measured Angle	0	Mode	Shear	Couplant				Circumferential Orientated Search Unit									
PRF	Auto High	SU Freq	2.25 MHz	Ext. Point	N/A	# of Elements	1	Cal. Batch	07225		Calibration Reflector	Signal Amplitude %	Sweep Division	Sound Path							
Frequency	2.25 MHz	Rectify	Fullwave	Config	SINGLE	Focus	N/A	Type	Ultralog II		N/A										
Voltage	450	Pulse Width	220	Shape	Round	Contour	N/A	Mfg	Sonotech		N/A										
				Wedge Style	N/A			Exam Batch	07225		N/A										
				Search Unit Cable				Type	Ultralog II		N/A										
				Type	RG-174	Length	12'	No. Conn.	0		Mfg.	Sonotech		N/A							
				Scan Coverage				Reference Block				Reference/Simulator Block									
Calibration Block				Upstream	<input checked="" type="checkbox"/>	Downstream	<input checked="" type="checkbox"/>	Scan dB	18.7		Serial No	104878		Gain dB	Reflector	Signal Amplitude %	Sweep Division	Sound Path			
Cal. Block No				TBX-28		CW	<input checked="" type="checkbox"/>	CCW	<input type="checkbox"/>		Type	Rompas Block C/S		8.9	SDH	\$4	0.9	.849			
Thickness				5.45		Da	0														
Cal. Bk Temp				95		Temp Too	RF2425		Exam Surface		OD										
Comp Temp				97		Temp Too	RF2425		Surface Condition		Flush										
Recordable Indication(s):																Yes <input type="checkbox"/> No <input checked="" type="checkbox"/> (If Yes Ref Attached Ultrasonic Indication Report.)		Comments		77.5% CODE COVERAGE ACHIEVED	
Results: Accept <input checked="" type="checkbox"/> Reject <input type="checkbox"/> Info <input type="checkbox"/>																					
Percent Of Coverage Obtained > 90%: NO - 77.5																Reviewed Previous Data		Yes			

Examiner	Level	II	Signature	Date	10/16/2012	Reviewer	Sabo, Steve	Signature	Date	10/22/12
Fang, Chia Wei	Level	N/A	Signature	Date		Site Review	ISI Engineer	Signature	Date	10/24/12
Other	Level	N/A	Signature	Date		ANII Review	Ballard, Jack ANII	Signature	Date	10/24/12
N/A	Level	N/A	Signature	Date				Signature	Date	

10CFR 50.55a Request Number B-13
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

Weld Exam Page 3 of 9

UT Calibration Examination

Site/Unit	CPNPP / 2	Procedure	TX-ISI-210	Outage No.	2RF13
Summary No	011700	Procedure Rev	7	Report No	UT-2012-055
Workscope	ISI	Work Order No	4181105	Page	2 of 8
Code	ASME Sec. XI 1998 Ed./2000 Add.	Cal Item	B-B/B2.40	Location	2-154L, RB, 812
Drawing No	TCX-1-3100	Description	SG4 CHANNEL HEAD TO TUBESHEET WELD		
System ID	RC				
Component ID	TCX-1-3100-4-1	Size/Length	1.5" / 426"	Thickness/Diameter	5.3" / 35.6"
Limitations	SEE DRAWING	Start Time	1038	Finish Time	1229

Instrument Settings				Search Unit				Cal Checks		Time	Date	Axial Orientated Search Unit							
Serial No	105421			Serial No	01BXVF			Initial Cal.	0920	10/16/2012		Calibration Reflector	Signal Amplitude %	Sweep Division	Sound Path				
Manufacturer	GEIT			Manufacturer	KBA			Inter. Cal.	1050	10/16/2012		1/4 T	80	1.5	1.94				
Model	USN 60 SW	Linearity	L-2012-003	Size	0.50" X 1.0"		Model	SWVS	Inter. Cal.			1/2 T	45	3.0	1.88				
Delay	11.085	Range	12.95	Freq	2.25 MHz		Center Freq	2.29 MHz	Inter. Cal.			3/4 T	30	4.5	1.83				
Mt Cal/Vol	0.1261	Pulse Type	Square	Exam Angle	45		Squat Angle	N/A	Final Cal.	1309	10/16/2012	NOTCH	12	6.8	1.80				
Damping	500 Ohms	Recd	0%	Measured Angle	45		Mode	Shear				1 1/4 T	9	10.0	12.95				
PRF	Auto High	SC Freq	2.25 MHz	Ext Point	0.65		# of Elements	1	Couplant			Circumferential Orientated Search Unit							
Frequency	2.25 MHz	Rectify	Fullwave	Corfig	Single		Focus	N/A	Cal Batch	07225		Calibration Reflector	Signal Amplitude %	Sweep Division	Sound Path				
Voltage	450	Pulse Width	220	Shape	RECT		Contour	N/A	Type	Ultragel II		N/A							
				Wedge Style	Non-integral				Mfg	Sonotech		N/A							
Ax Gain (dB)	39			Circ Gain (dB)	N/A				Exam Batch	07225		N/A							
1 Maj Screen Cvt	1.295' in of Sound Path			Type	RG-174			Length	12	No Conn	0	N/A							
Calibration Block				Scan Coverage				Reference Block				Reference/Simulator Block							
Cal Block No	TBX-28			Upstream	<input checked="" type="checkbox"/>		Downstream	<input checked="" type="checkbox"/>	Scan dB	64.9		Gain dB	Reflector	Signal Amplitude %	Sweep Division	Sound Path			
Thickness	5.45			Dia	0			CW	<input checked="" type="checkbox"/>	CCW	<input checked="" type="checkbox"/>	Scan dB	64.9		39	SDH	52	1.0	1.29
Ca Blk Temp	95			Temp Tool	RF2425			Exam Surface	OD			Type	Rompas Block C/S						
Comp Temp	97			Temp Tool	RF2425			Surface Condition	Flush										
Recordable Indication(s):	Yes <input type="checkbox"/> No <input checked="" type="checkbox"/>			(If Yes, Ref Attached Ultrasonic Indication Report.)															
Results	Accept <input checked="" type="checkbox"/> Reject <input type="checkbox"/> Info <input type="checkbox"/>			Comments: 77.5% CODE COVERAGE ACHIEVED															

Percent Of Coverage Obtained > 90% NO - 77.5 Reviewed Previous Data Yes

Examiner	Level	II-PDI	Signature	Date	Reviewer	Signature	Date
Williams, Stephen T.			<i>Stephen T. Williams</i>	10/16/2012	Sabo, Steve	<i>Steve Sabo</i>	10/22/12
Examiner	Level	N/A	Signature	Date	Site Review	Signature	Date
N/A					ISI Engineer	<i>Jack Ballard</i>	10/24/12
Other	Level	N/A	Signature	Date	ANII Review	Signature	Date
N/A					Ballard, Jack ANII	<i>Jack Ballard</i>	10/24/12

10CFR 50.55a Request Number B-13
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

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UT Calibrat . Amination

Site/Unit		CPNPP	2	Procedure		TX-ISI-210	Outage No.		2RF13
Summary No.		011700		Procedure Rev.		7	Report No.		UT-2012-055
Workscope		ISI		Work Order No.		4181105	Page.		3 of 8

Code	ASME Sec. XI 1998 Ed./2000 Add.	Cal Item	B-B/B2.40	Location	2-154L, RB, 812
Drawing No	TCX-1-3100	Description	SG4 CHANNEL HEAD TO TUBESHEET WELD		
System ID	RC				
Component ID	TCX-1-3100-4-1	Size/Length	1.5" / 426"	Thickness/Diameter	5.3" / 135.6"
Limitations	SEE DRAWING	Start Time	1038	Finish Time	1229

Instrument Settings				Search Unit				Cal. Checks			Axial Orientated Search Unit								
Serial No	105208	Serial No	01BXV9	Cal. Checks	Time	Date	Calibration	Signal	Sweep	Sound Path									
Manufacturer	GEIT	Manufacturer	KBA	Initial Cal.	0915	10/16/2012	Reflector	Amplitude %	Division										
Model	USN 60 SW	Linearity	L-2012-001	Size	0.50" X 1.0"	Model	SWS	Inter. Cal.	1035	10/16/2012	1/4 T	80	1.5	2.778					
Delay	15.7069	Range	18.52"	Freq	2.25 MHz	Center Freq	2.27 MHz	Inter. Cal.			1/2 T	18	3.1	5.7412					
Mt Cal/Vel	0.1274	Pulse Type	Square	Exam Angle	60	Squint Angle	N/A	Inter. Cal.			3/4 T	25	4.5	8.334					
Damping	500 Ohms	Reject	0%	Measured Angle	60	Mode	Shear	Final Cal.	1305	10/16/2012	Notch	53	5.8	11.55					
PRF	Auto High	SU Freq	2.25 MHz	Ext. Fmt	0.7	# of Elements	1	Couplant			5/4 T	12	7.2	14.766					
Frequency	2.25 MHz	Rctly	Fullwave	Config.	Single	Focus	N/A	Cal. Batch	07225	Circumferential Orientated Search Unit:									
Voltage	450	Pulse Width	220	Shape	Round	Contour	N/A	Type	Ultrage II	Calibration	Signal	Sweep	Sound Path						
				Wedge Style	Non-Integral			Mfg	Sonotech	Reflector	Amplitude %	Division							
Ax. Gain (dB) 45.8				Circ Gain (dB) 0	Search Unit Cable			Exam Batch	07225	Reference/Simulator Block									
1.5 Screen Div = 2.778				n of Sound Path	Type	RG-174	Length	6'	No. Conn.	0	Gain	Reflector	Signal	Sweep	Sound Path				
Calibration Block				Scan Coverage				Reference Block											
Cal Block No	TBX-28	Upstream	<input checked="" type="checkbox"/>	Downstream	<input checked="" type="checkbox"/>	Scan dB	69.8	Serial No	104879	Gain	45.8	Reflector	SDH	Signal	90	Sweep	.4	Sound Path	0.7408
Thickness	5.45	Dia	0	CW	<input checked="" type="checkbox"/>	CCW	<input checked="" type="checkbox"/>	Scan dB	69.8	Type	Rompas Block C/S								
Cal Block Temp	95	Temp Tool	RF2425	Exam Surface	OD														
Comp Temp	97	Temp Tool	RF2425	Surface Condition	Flush														
Recordable Indication(s):				Yes	No	(If Yes, Ref Attached Ultrasonic Indication Report)													
Results				Accept	<input checked="" type="checkbox"/>	Reject	<input type="checkbox"/>	Info	<input type="checkbox"/>	Comments 77.5% CODE COVERAGE ACHIEVED									
Percent Of Coverage Obtained > 90%:				NO - 77.5		Reviewed Previous Data:				Yes									

Examiner	Level	II-PDI	Signature	Date	Reviewer	Signature	Date
Vidrih, Tomaz				10/16/2012	Sabo, Steve		10/22/12
Examiner	Level	N/A	Signature	Date	Site Review	Signature	Date
N/A					ISI Engineer		10/24/12
Other	Level	N/A	Signature	Date	ANII Review	Signature	Date
N/A					Baillard, Jack ANII		10/24/12

10CFR 50.55a Request Number B-13
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticality -

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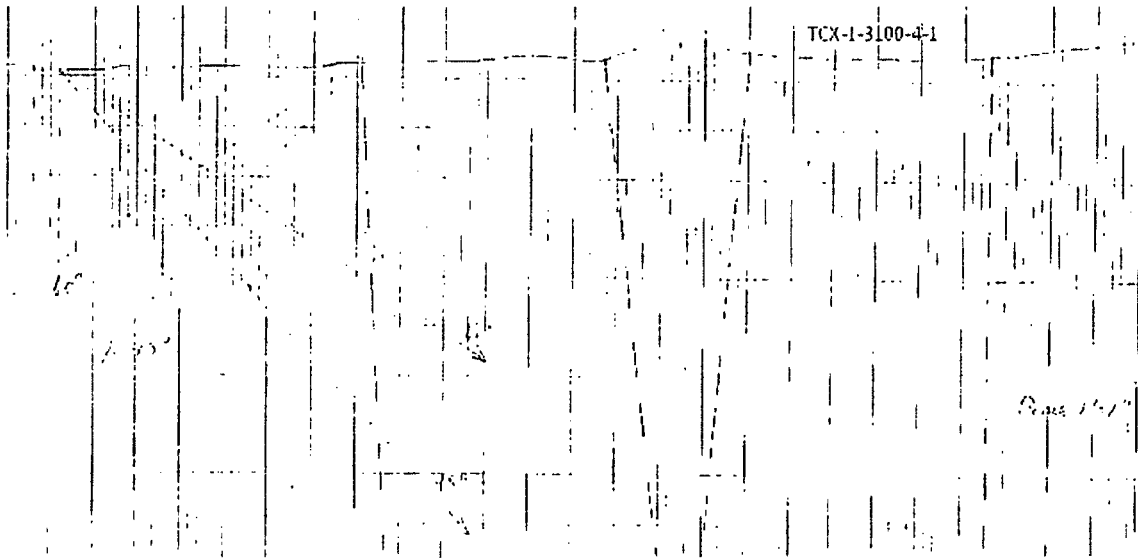
Supplemental Report

Report No. UT-2012-055

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Summary No. 011700

Sketch or Photo: Q:\SH2R\13 DataSheet\Sens\TCX-1 3100-4-1 PROFILE B.jpg



* See Attached Original Weld Profile
from 2RF07 for Better Quality *

**10CFR 50.55a Request Number B-13
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticality -**

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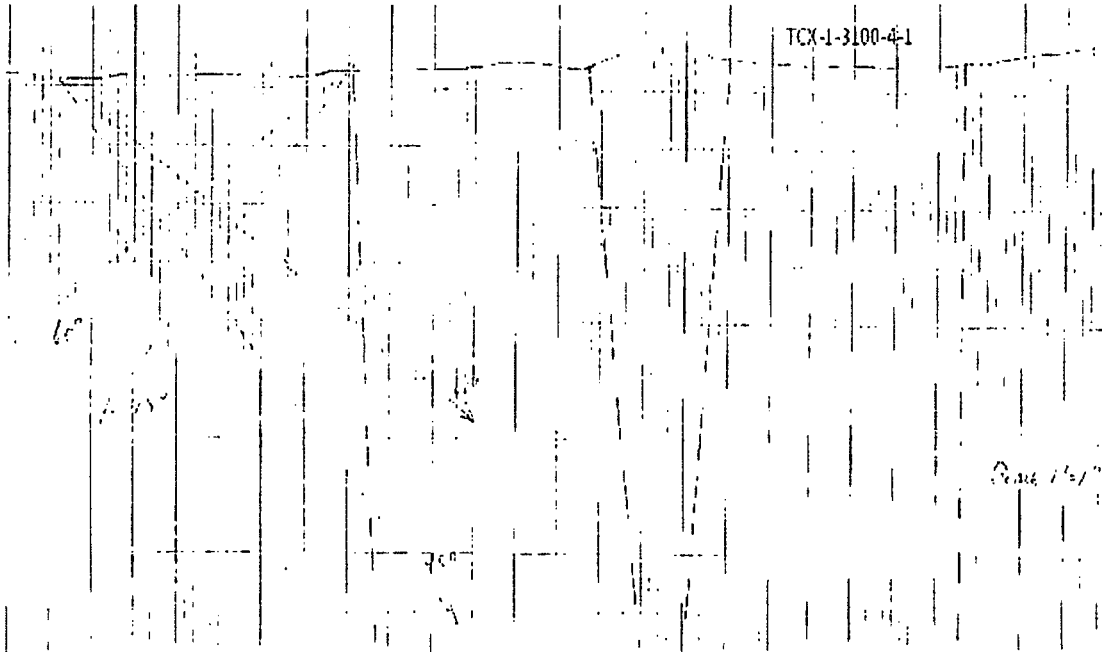
Supplemental Report

Report No. UT-2012-055

Page: 5 of 8

Summary No. 011700

Sketch or Photo: O:\SF2RF13 DataSheet Scans\TCX-1-3100-4-1 PROFILE B.jpg



* See Attached Original Weld Profile
from 2RF07 for Better Quality *

10CFR 50.55a Request Number B-13
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

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Supplement Report

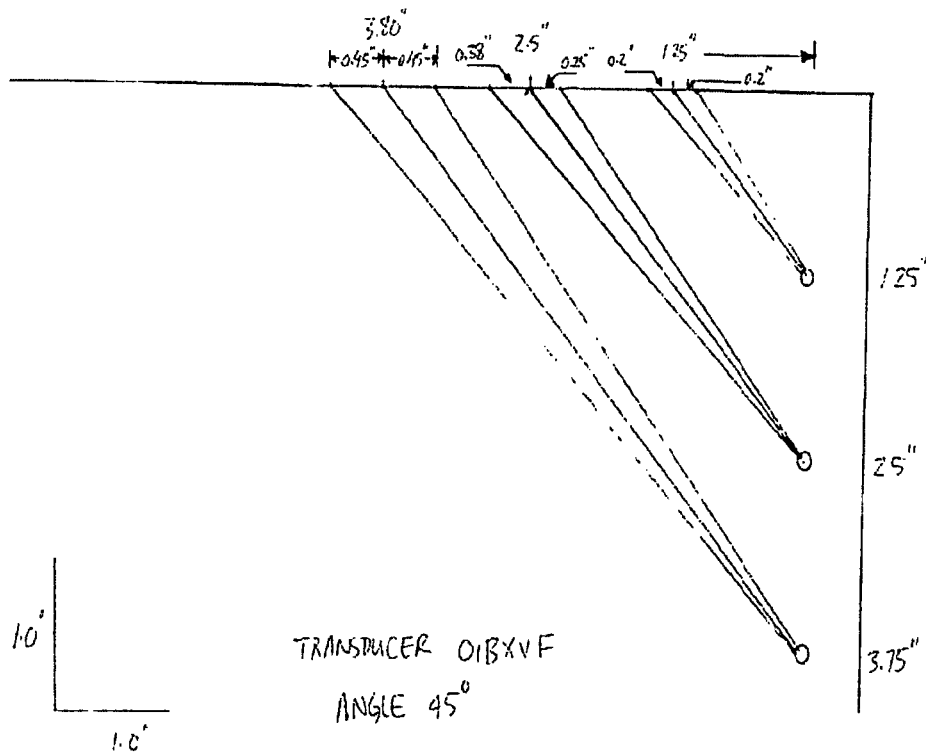
Report No. UT-2012-055

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Summary No. 011700

Sketch or Photo O:\S\2PF13 Data\Sheet Scans\TCX-1-3100-4-1 Beam Spread 45.jpg

TCX-1-3100-4-1



10CFR 50.55a Request Number B-13
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

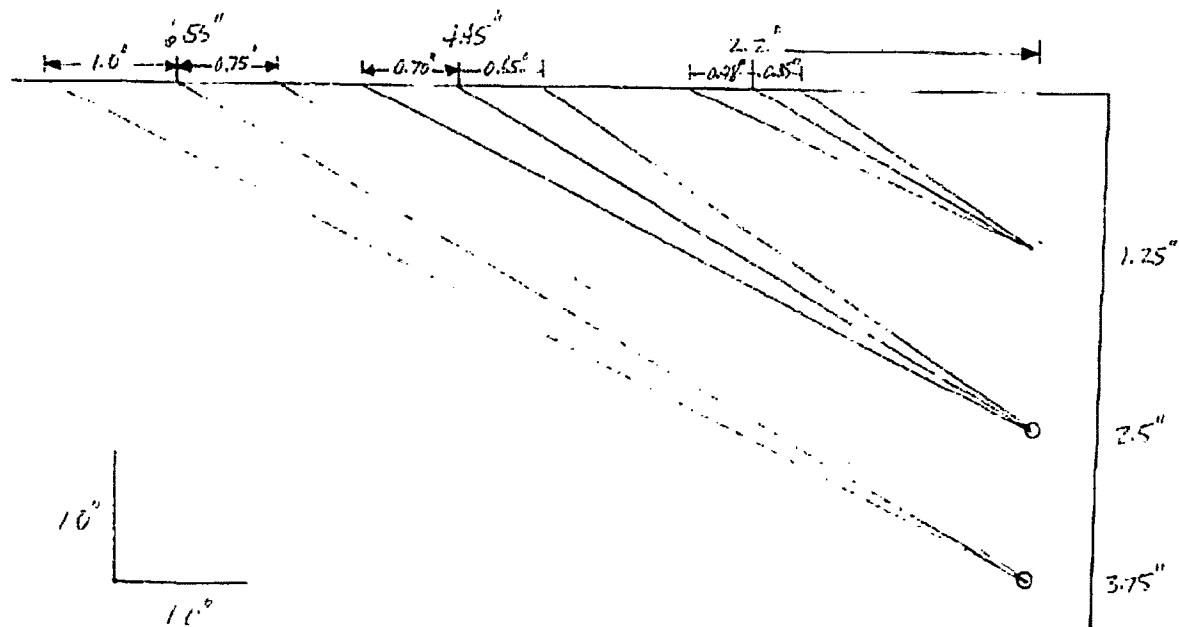
Report No. UT-2012-055
Page: 7 of 8

Supplemer. port

Summary No. 011700

Sketch or Photo: 01502RF-13 DZashree: Scans\TCX-1-3100-4-1 Beam Spread 60.jpg

TCX-1-3100-4-1



TRANSDUCER 01BXV9
ANGLE 60°

10CFR 50.55a Request Number B-13
Relief Requested
In Accordance with 10CFR50.55a(g)(5)(iii)
- Inservice Inspection Impracticability -

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Limitation Record

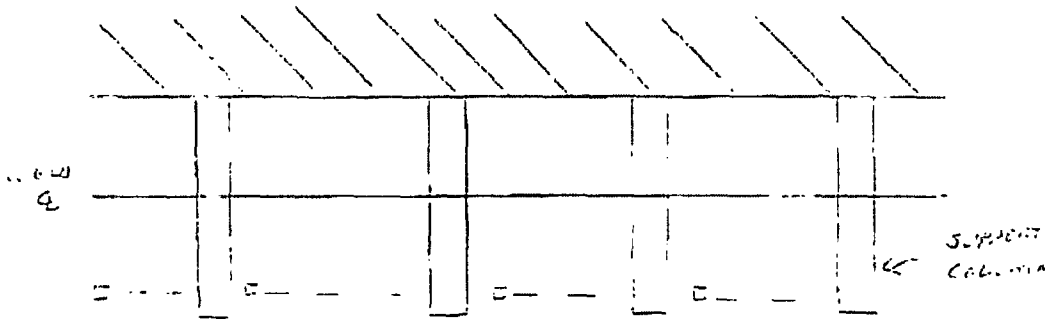
Site/Unit	CPNPP / 2	Procedure	TX-ISI-210	Outage No	2RF13
Primary No	011700	Procedure Rev	7	Report No	UT-2012-055
Workscope	ISI	Work Order No	4181105	Page	8 of 8

Location of Limitation:

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PLATE

TCX-1-3100-4-1



10 TOTAL 24' 24' SURFACED AREAS
4 TOTAL 24' 24' SURFACED COLUMNS
20 5' OF AREA NOT EXAMINED
WELD LENGTH 426 OBSTRUCTED LENGTH 96'

Limitations removal requirements

Radiation field

Examiner	Level II	Signature	Date	Reviewer	Signature	Date
Fang, Chia Wei			10/16/2012	Sabo, Steve		10/24/12
Examiner	Level N/A	Signature	Date	Site Review	Signature	Date
N/A				ISI Engineer		10/24/12
Other	Level N/A	Signature	Date	ANI Review	Signature	Date
N/A				Ballard, Jack ANII		10/24/12