



**UNITED STATES  
NUCLEAR REGULATORY COMMISSION**  
REGION III  
2443 WARRENVILLE RD. SUITE 210  
LISLE, IL 60532-4352

May 1, 2015

Mr. Anthony Vitale  
Vice President, Operations  
Entergy Nuclear Operations, Inc.  
Palisades Nuclear Plant  
27780 Blue Star Memorial Highway  
Covert, MI 49043-9530

**SUBJECT: PALISADES NUCLEAR PLANT - NOTIFICATION OF NRC INSPECTION AND  
REQUEST FOR INFORMATION**

Dear Mr. Vitale:

On September 21, 2015, the U.S. Nuclear Regulatory Commission (NRC) will begin the Baseline Inservice Inspection (Procedure 71111.08). This on-site inspection is scheduled to be performed September 21, 2015, through October 7, 2015.

Experience has shown that this inspection is resource intensive both for the NRC inspector and your staff. In order to minimize the impact to your on-site resources, and to ensure a productive inspection for both sides, we have enclosed a request for documents needed for this inspection. These documents have been divided into two groups.

The first group identifies information necessary to ensure that the inspector is adequately prepared. The second group identifies the information the inspector will need upon arrival at the site. It is important that all of these documents are up-to-date, and complete, in order to minimize the number of additional documents requested during the preparation and/or the on-site portions of the inspection.

We have discussed the schedule for inspection activities with your staff and understand that our regulatory contact for this inspection will be Ms. B. Dotson, of your organization. If there are any questions about this inspection or the material requested, please contact the lead inspector Mr. M. Holmberg at 630 829-9748 or via e-mail at [Mel.Holmberg@nrc.gov](mailto:Mel.Holmberg@nrc.gov).

This letter does not contain new or amended information collection requirements subject to the Paperwork Reduction Act of 1995 (44 U.S.C. 3501 et seq.). Existing information collection requirements were approved by the Office of Management and Budget, Control Number 3150-0011. The NRC may not conduct or sponsor, and a person is not required to respond to, a request for information or an information collection requirement unless the requesting document displays a currently valid Office of Management and Budget Control Number.

A. Vitale

-2-

In accordance with Title 10 of the *Code of Federal Regulations* (10 CFR) 2.390, "Public Inspections, Exemptions, Requests for Withholding," of the NRC's "Rules of Practice," a copy of this letter, its enclosure, and your response (if any) will be available electronically for public inspection in the NRC's Public Document Room or from the Publicly Available Records (PARS) component of the NRC's Agencywide Documents Access and Management System (ADAMS). ADAMS is accessible from the NRC Web site at <http://www.nrc.gov/reading-rm/adams.html> (the Public Electronic Reading Room).

Sincerely,

**/RA/**

David E. Hills, Chief  
Engineering Branch 1  
Division of Reactor Safety

Docket No. 50-255  
License No. DPR-20

Enclosure:  
Inservice Inspection Document Request

cc w/encl: Distribution via LISTSERV®

## INSERVICE INSPECTION DOCUMENT REQUEST

**Inspection Dates:** September 21, 2015, through October 7, 2015

**Inspection Procedures:** IP 71111-08, "Inservice Inspection"

**Lead Inspector:** Mel Holmberg, DRS  
(630) 829-9748  
[Mel.Holmberg@nrc.gov](mailto:Mel.Holmberg@nrc.gov)

### **A. *Information for the In-Office Preparation Week***

The following information is requested as an (electronic copy CD-ROM if possible) by August 28, 2015, to facilitate the selection of specific items that will be reviewed during the on-site inspection week. The inspector will select specific items from the information requested below and a list of additional documents needed on-site from your staff. We request that the specific items selected from the lists be available and ready for review on the first day of inspection. If you have any questions regarding this information, please call the inspector as soon as possible.

1. For the upcoming outage, a detailed schedule and description of:
  - a. Non-Destructive Examinations (NDEs) planned for Class 1 and 2 Systems and containment, performed as part of your ASME Code Inservice Inspection (ISI) Program (include edition and addenda of Code committed to), and NDE examinations planned for other systems performed as part of a Risk-Informed (RI)-ISI Program, or other augmented inspection programs (e.g., ASME Code Case N-770-1 examination of dissimilar metal welds and examinations to meet an industry initiative). For each weld examination, include the weld identification number, description of weld (component name), category, class, type of exam and procedure number, and date of examination;
  - b. Reactor vessel upper head examinations required by 10 CFR 50.55a(g)(6)(ii)(D) and Code Case N-729-1;
  - c. Steam generator (SG) tube inspection and repair activities for the upcoming outage or SG secondary side examinations<sup>1</sup>; and
  - d. Welding on Code Class 1, 2, or 3 components (including contingency repair welding for dissimilar metal welds).
2. A copy of the NDE procedures and welding procedures (including contingency weld repair procedures for dissimilar metal weld repairs) used to perform the activities identified in Item A.1 (including NDE calibration and flaw characterization/sizing procedures and Welding Procedure Qualification Records). For ultrasonic examination procedures qualified in accordance with Appendix VIII, of Section XI

---

<sup>1</sup> Note 1- If no SG examinations are planned for this outage, please confirm when the next SG examination will occur and no further information is required for the items identified above requesting SG related information.

Enclosure

## INSERVICE INSPECTION DOCUMENT REQUEST

of the ASME Code, provide documentation supporting the procedure qualification (e.g., the EPRI performance demonstration qualification summary sheets).

3. A copy of ASME Section XI, Code Relief Requests applicable to the examinations identified in Item A.1. This would include the NRC approved Relief Request for implementing a RI-ISI Program (if applicable).
4. A copy of the 10-year ISI Program showing those required exams scheduled to be performed this outage, and those which have been completed.
5. A list identifying NDE reports (ultrasonic, radiography, magnetic particle, or dye penetrant), which have identified relevant indications on Code Class 1 and 2 Systems since the beginning of the last refueling outage.
6. List with short description of the welds in Code Class 1 and 2 Systems, which have been fabricated due to component repair/replacement activities since the beginning of the last refueling outage and identify the system, weld number, and reference applicable documentation (e.g., NIS-2 forms with definitions of system and component acronyms).
7. If reactor vessel weld examinations required by the ASME Code are scheduled to occur during the inspection period, provide a detailed description of the welds to be examined, and the extent of the planned examination.
8. List with description of ISI and SG related issues such as piping or SG tube degradation or damage (e.g., cracks, wall thinning, wear, MIC) or errors identified during piping/SG tube examinations that have been entered into your corrective action system since the beginning of the last refueling outage. Also, include a list of corrective action records associated with foreign material introduced/identified in the reactor vessel, primary coolant system, steam generator or feed systems since the beginning of the last refueling outage.
9. Copy of any 10 CFR Part 21 reports applicable to your structures systems or components within the scope of Section XI of the ASME Code that have been identified since the beginning of the last refueling outage.
10. Copy of SG history documentation given to vendors performing eddy current (ET) testing of the SGs during the upcoming outage.<sup>1</sup>
11. Copy of procedure containing screening criteria used for selecting tubes for in-situ pressure testing and the procedure to be used for in-situ pressure testing.<sup>1</sup>
12. Copy of previous outage SG tube operational assessment completed following ET of the SGs.<sup>1</sup>
13. Copy of the document defining the planned SG ET scope (e.g., 100 percent of unrepaired tubes with bobbin probe and 20 percent sample of hot leg expansion transition regions with rotating probe), and identify the scope expansion criteria,

---

<sup>1</sup> Note 1- If no SG examinations are planned for this outage, please confirm when the next SG examination will occur and no further information is required for the items identified above requesting SG related information.

## INSERVICE INSPECTION DOCUMENT REQUEST

which will be applied. Also identify and describe any deviations in this scope or expansion criteria from the EPRI Guidelines.<sup>1</sup>

14. Copy of the document describing the ET acquisition equipment to be applied including ET probe types. Also identify the extent of planned tube examination coverage with each probe type (e.g., rotating probe - 0.080 inches, 0.115 inches pancake coils and mid-range + point coil applied at the top-of-tube-sheet plus 3 inches to minus 12 inches).
15. Provide procedures with guidance/instructions for identifying (e.g. physically locating the tubes that require repair), and plugging SG tubes.<sup>1</sup>
16. Identify and quantify any SG tube leakage experienced during the previous operating cycle. Also provide documentation identifying which SG was leaking and corrective actions completed or planned for this condition.
17. Copy of current calculations for EDY, and RIY as defined in Code Case N-729-1 that establish the volumetric and visual examination frequency for the reactor vessel head and J-groove welds.
18. Copy of site documents (or vendor reports) that determined the cause for the primary coolant leak identified at control rod drive (CRD) -24 housing in August of 2012. Specifically, provide documents that assessed:
  - a. The rub/wear marks on the internal alignment pad (e.g. weld buildup pad) to determine if this contributed to the cause.
  - b. Binding force exerted on the interior of the housings to determine if sufficient stresses were induced to initiate and propagate a crack, absent the existence of a weld.
19. Point of contact information (name and site number) for the following activities:
  - a. Inservice Inspection - Site and vendor leads;
  - b. Boric Acid Inspections and Evaluations;
  - c. Reactor Vessel Head Inspection - Site and vendor leads; and
  - d. SG Inspection - Site and vendor leads.

**B. On-Site Information to be Provided to the Inspector on the First Day of the Inspection (e.g., Following the Entrance Meeting). Please Provide Hard Copies (e.g., Paper Records) of the Following Documents.**

1. For welds selected by the inspector from Item A.1.d and A.6 above, provide copies of the following documents:
  - a. Document of the weld number and location (e.g., system, train, branch);

---

<sup>1</sup> Note 1- If no SG examinations are planned for this outage, please confirm when the next SG examination will occur and no further information is required for the items identified above requesting SG related information.

## INSERVICE INSPECTION DOCUMENT REQUEST

- b. Document with a detail of the weld construction (e.g., drawing);
  - c. Applicable Code Edition and Addenda for construction of the weldment (e.g., B31.1 or ASME Section III);
  - d. Applicable Code Edition and Addenda for weld procedure qualification;
  - e. Applicable weld procedures (WPS) used to fabricate the welds;
  - f. Copies of procedure qualification records (PQRs) supporting the WPS;
  - g. Copies of welders' performance qualification records (WPQ);
  - h. Copies of mechanical test reports identified in the PQRs above;
  - i. Copies of the nonconformance reports for the selected welds;
  - j. Access to radiographs and equipment to view radiographs of the selected welds; and
  - k. Copies of the pre-service examination records for the selected welds.
- 2. For the ISI related corrective action issues selected by the inspector from Item A.8 above, provide a copy of the corrective actions and supporting documentation.
  - 3. For the non-destructive examination reports with relevant indications on Code Class 1 and 2 Systems selected by the inspector from Item A.5 above, provide a copy of the examination records, and associated corrective action documents. Updated schedules for Item A.1 (including schedule showing contingency repair plans if available).
  - 4. Copy of the procedures which govern the scope, equipment used, and implementation of the inspections required to identify boric acid leakage from systems and components above the vessel head.
  - 5. Copy of:
    - a. Engineering evaluations/assessments of boric acid related deposits and associated wastage or corrosion for safety significant components (since beginning of last refueling outage); and
    - b. Corrective action records for coolant leakage including boric acid deposits on safety-related components identified since the beginning of the last refueling outage.
  - 6. Copy of the plant procedures used to perform inspections to identify reactor coolant system leaks or boric acid deposits and the procedures for resolution of leaks or boric acid deposits.
  - 7. Fabrication Drawings (D size) of the reactor vessel welds (including vessel head J-groove welds) if any are to be examined during the outage. Also provide any drawings used by NDE vendors to locate these welds.

## INSERVICE INSPECTION DOCUMENT REQUEST

8. Copy of the documents which demonstrate that the procedures to be used for volumetric examination of the reactor vessel head penetration J-groove welds were qualified by a blind demonstration test in accordance with 10 CFR 50.55a(g)(6)(ii)(D).
9. Copy of volumetric, surface and visual examination records for the prior inspection of the reactor vessel head and head penetration J-groove welds.
10. Provide a copy of the EPRI Examination Technique Specification Sheets and vendor documents, which support qualification of the ET probes to be used during the upcoming SG tube inspections.<sup>1</sup>
11. Provide a copy of the guidance to be followed if a loose part or foreign material is identified in the SGs.<sup>1</sup>
12. Identify the types of SG tube repair processes which will be implemented for defective SG tubes (including any NRC reviews/evaluation/approval of this repair process). Provide the flaw depth sizing criteria to be applied for ET indications identified in the SG tubes.<sup>1</sup>
13. Copy of document describing actions to be taken if a new SG tube degradation mechanism is identified.<sup>1</sup>
14. Provide document which defines the scope of SG secondary side examinations (if any are planned) and identify site specific operational history related to degradation of SG secondary side components (if any).
15. Provide procedures with guidance/instructions for identifying (e.g., physically locating the tubes that require repair) and plugging SG tubes.<sup>1</sup>
16. Provide copies of the following standards at the on-site NRC inspection location for the duration of the inspection:
  - a. Sections V, IX, and XI of the ASME Code with Editions applicable to the inservice inspection program and the repair/replacement program;
  - b. Copy of the performance demonstration initiative (PDI) generic procedures with the latest applicable revisions that support site qualified ultrasonic examination of piping welds and components (e.g., PDI-UT-1, PDI-UT-2, PDI-UT-3, PDI-UT-10 etc.);
  - c. EPRI and industry standards referenced in the site procedures used to perform the SG tube eddy current examination, which includes EPRI documents: TR-107621-R1, "Steam Generator Integrity Assessment Guidelines," TR-107620-R1, "Steam Generator In-Situ Pressure Test Guidelines," Steam Generator Management Program: Steam Generator Integrity Assessment Guidelines, Part 10, and 1003138, "Pressurized Water Reactor Steam Generator Examination Guidelines"<sup>1</sup>; and

---

<sup>1</sup> Note 1- If no SG examinations are planned for this outage, please confirm when the next SG examination will occur and no further information is required for the items identified above requesting SG related information.

## **INSERVICE INSPECTION DOCUMENT REQUEST**

- d. Boric Acid Corrosion Guidebook Revision 1 - EPRI Technical Report 1000975.
- 17. Provide training (e.g., Scaffolding, Fall Protection, FME) if required to access the NDEs selected by the inspector for observation.

If you have questions regarding the information requested, please contact the lead inspector.



A. Vitale

-2-

In accordance with Title 10 of the *Code of Federal Regulations* (10 CFR) 2.390, "Public Inspections, Exemptions, Requests for Withholding," of the NRC's "Rules of Practice," a copy of this letter, its enclosure, and your response (if any) will be available electronically for public inspection in the NRC's Public Document Room or from the Publicly Available Records (PARS) component of the NRC's Agencywide Documents Access and Management System (ADAMS). ADAMS is accessible from the NRC Web site at <http://www.nrc.gov/reading-rm/adams.html> (the Public Electronic Reading Room).

Sincerely,

/RA/

David E. Hills, Chief  
Engineering Branch 1  
Division of Reactor Safety

Docket No. 50-255  
License No. DPR-20

Enclosure:  
Inservice Inspection Document Request

cc w/encl: Distribution via LISTSERV®

**DISTRIBUTION:**

Kimyata MorganButler  
RidsNrrPMPalisades Resource  
RidsNrrDorLpl3-1 Resource  
RidsNrrDirslrib Resource  
Cynthia Pederson  
Darrell Roberts  
Richard Skokowski  
Allan Barker  
Carole Ariano  
Linda Linn  
DRPIII  
DRSIII  
Jim Clay  
Carmen Olteanu

ADAMS Accession Number ML15124A927

☒ Publicly Available      ☐ Non-Publicly Available      ☐ Sensitive      ☒ Non-Sensitive

To receive a copy of this document, indicate in the concurrence box "C" = Copy without attach/encl "E" = Copy with attach/encl "N" = No copy

OFFICE	RIII		RIII						
NAME	MHolmberg:cl		DHills						
DATE	04/30/15		05/01/15						

**OFFICIAL RECORD COPY**