

CATEGORY 1

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 Document Control Branch (Document Control Desk)

SUBJECT: Forwards info which DPC provided to NRC via FAX on 960423.
 Encl info summarizes scope of testing program being applied
 to upgraded high pressure injection piping per Request for
 Relief 95-01.

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DUKE POWER

June 5, 1996

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

Subject: Duke Power Company
Oconee Nuclear Station, Units 1, 2, and 3
Docket No. 50-269, 50-270, 50-287
Request for Relief No. 95-01
Supplemental Information

Gentlemen:

Please find attached the information which Duke Power provided to your staff via FAX on April 23, 1996. The attached information summarizes the scope of the testing program which is being applied to upgraded High Pressure Injection piping per Request for Relief 95-01. If there are any questions or further information is needed you may contact D. A. Nix at (864) 885-3634.

Very truly yours,

J. W. Hampton
Site Vice President

Attachment

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U. S. Nuclear Regulatory Commission
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xc (w/attchs): Mr. D. E. LaBarge
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Attachment

Notes:

1. "System 51A" pertains to the existing population of High Pressure Injection (HPI) System welds which were in the ISI program prior to the HPI System upgrade as described in Request for Relief 95-01.
2. "System 51B" pertains to the added population of welds as a result of the HPI System upgrade as described in Request for Relief 95-01.

HPI Upgrade for Units 1, 2, & 3 at Oconee Nuclear Station

The HPI System falls under the jurisdiction of ASME Section XI. The requirements met for ISI inspections were found in the 1989 Section XI manual, Subsection IWC. The HPI system requirements were taken from Table IWC-2500-1, Examination Category C-F-1 (Pressure Retaining Welds in Austenitic Stainless Steel or High Alloy Piping). Table IWC-2500-1 Note 2 reads as follows; **“The welds selected for examination shall include 7.5%, but not less than 28 welds, of all austenitic stainless steel or high alloy welds not exempted by IWC-1220. (Some welds not exempted by IWC-1220 are not required to be nondestructively examined per Examination Category C-F-1. These welds however, shall be included in the total weld count to which the 7.5% sampling rate is applied)”**. The remaining part of note 2 gives you a breakdown of which welds of the total population will be selected for the 7.5% to be examined.

The welds selected from Units 1, 2, & 3 HPI systems were selected in accordance with Table IWC-2500-1 Note 2. The following data will give you a total population of welds for HPI systems in all three Units. It will also give you the figures that meet the 7.5% requirements to be examined.

Unit 1

ITEM Number	System 51A Total Population of Welds	System 51A welds selected to be examined (7.5% of total population)	System 51B Total Population of Welds	System 51B welds selected to be examined (7.5% of total population)
C05.011. Piping welds $\geq \frac{3}{8}$ " wall thickness for piping $>$ NPS 4			8 * (see note)	1 Borrowed from sys 53A *(see note)
C05.021. Piping welds $> \frac{1}{5}$ " wall thickness for piping \geq NPS 2 and \leq NPS 4	487	37	341 **(see note)	26 Borrowed from sys 51A **(see note)
C05.030. Socket Welds	7	1	29	3
C05.041. Pipe Branch Connections of Branch Piping \geq NPS 2	2	1	1	1

* These 8 welds had a wall thickness $< \frac{3}{8}$ " and did not require nondestructive testing (see note 2 in table IWC-2500-1). These welds were counted in the total population of system 51B and 1 C05.011 weld from system 53A was borrowed to meet the percentage requirements (7.5%) for welds to be inspected. In addition to the 1 weld borrowed from system 53A to be inspected to meet the 7.5% requirement, we are doing a surface inspection (PT) on 5% of the thin wall piping in system 51B from the C05.011 category. These inspections were done as augmented inspections under a G09.001 item number. (8 X 5% = .4) 1 Weld from the C05.011. category in system 51B was selected to be inspected under a G09.001 item number.

Unit 1 *continued*

****** These 341 welds had a wall thickness $\leq \frac{1}{5}$ " and did not require nondestructive testing (see note 2 in table IWC-2500-1). These welds were counted in the total population of system 51B and 26 C05.021 welds from system 51A were borrowed to meet the percentage requirements (7.5%) for welds to be inspected. In addition to the 26 welds borrowed from system 51A to be inspected to meet the 7.5% requirement, we are doing a surface inspection (PT) on 5% of the thin wall piping in system 51B from the C05.021 category. These inspections were done as augmented inspections under G12.001 item numbers. (341 X 5% = 17.05) 19 welds from the C05.021 category in system 51B were selected for inspection and are listed under G12.001 item numbers.

Unit 2

ITEM Number	System 51A Total Population of Welds	System 51A welds selected to be examined (7.5% of total population)	System 51B Total Population of Welds	System 51B welds selected to be examined (7.5% of total population)
C05.011. Piping welds $\geq \frac{3}{8}$ " wall thickness for piping $>$ NPS 4	55	5 Borrowed from sys 53A	6 * (see note)	1 Borrowed from sys 51A *(see note)
C05.021. Piping welds $> \frac{1}{5}$ " wall thickness for piping \geq NPS 2 and \leq NPS 4	432	34	311 **(see note)	24 Borrowed from sys 51A **(see note)
C05.030. Socket Welds	1	1	63	5
C05.041. Pipe Branch Connections of Branch Piping \geq NPS 2	1	1	2	1

***** These 6 welds had a wall thickness $< \frac{3}{8}$ " and did not require nondestructive testing (see note 2 in table IWC-2500-1). These welds were counted in the total population of system 51B and 1 C05.021 weld from system 51A was borrowed to meet the percentage requirements (7.5%) for welds to be inspected. In addition to the 1 weld borrowed from system 51A to be inspected to meet the 7.5% requirement, we are doing a surface inspection (PT) on 5% of the thin wall piping in system 51B from the C05.011 category. These inspections were done as augmented inspections under a G09.001 item number. (6 X 5% = .3) 1 Weld from the C05.011 category in system 51B was selected to be inspected under a G09.001 item number.

****** These 311 welds had a wall thickness $\leq \frac{1}{5}$ " and did not require nondestructive testing (see note 2 in table IWC-2500-1). These welds were counted in the total population of system 51B and 24 C05.021 welds from system 51A were borrowed to meet the percentage requirements (7.5%) for welds to be inspected. In addition to the 24 welds borrowed from system 51A to be inspected to meet the 7.5% requirement, we are doing a surface inspection (PT) on 5% of the thin wall piping in system 51B from the C05.021 category. These inspections were done as augmented inspections under G12.001 item numbers. (311 X 5% = 15.55) 16 welds from the C05.021 category in system 51B were selected for inspection and are listed under G12.001 item numbers.

Unit 3

ITEM Number	System 51A Total Population of Welds	System 51A welds selected to be examined (7.5% of total population)	System 51B Total Population of Welds	System 51B welds selected to be examined (7.5% of total population)
C05.011. Piping welds $\geq \frac{3}{8}$ " wall thickness for piping $>$ NPS 4	53	4 Borrowed from sys 51A C05.021 welds	10 * (see note)	1 Borrowed from sys 51A *(see note)
C05.021. Piping welds $> \frac{1}{5}$ " wall thickness for piping \geq NPS 2 and \leq NPS 4	378	29	333 **(see note)	26 Borrowed from sys 51A **(see note)
C05.030. Socket Welds	1	1	48	4
C05.041. Pipe Branch Connections of Branch Piping \geq NPS 2			1	1

* These 10 welds had a wall thickness $< \frac{3}{8}$ " and did not require nondestructive testing (see note 2 in table IWC-2500-1). These welds were counted in the total population of system 51B and 1 C05.021 weld from system 51A was borrowed to meet the percentage requirements (7.5%) for welds to be inspected.

In addition to the 1 weld borrowed from system 51A to be inspected to meet the 7.5% requirement, we are doing a surface inspection (PT) on 5% of the thin wall piping in system 51B from the C05.011 category. These inspections were done as augmented inspections under a G09.001 item number. ($10 \times 5\% = .5$) 1 Weld from the C05.011 category in system 51B was selected to be inspected under a G09.001 item number.

** These 333 welds had a wall thickness $\leq \frac{1}{5}$ " and did not require nondestructive testing (see note 2 in table IWC-2500-1). These welds were counted in the total population of system 51B and 26 C05.021 welds from system 51A were borrowed to meet the percentage requirements (7.5%) for welds to be inspected.

In addition to the 26 welds borrowed from system 51A to be inspected to meet the 7.5% requirement, we are doing a surface inspection (PT) on 5% of the thin wall piping in system 51B from the C05.021 category. These inspections were done as augmented inspections under G12.001 item numbers. ($333 \times 5\% = 16.65$) 17 welds from the C05.021 category in system 51B were selected for inspection and are listed under G12.001 item numbers.

HPI SYSTEM UPGRADE

Listed below is a breakdown by pipe size and diameter of all of the piping involved in the HPI upgrade.

	6" x .134"	4" x .120"	3" x .120"	2 1/2" x .120"	2" pipe	Total
Oconee 1	8	118	25	198	30	379
Oconee 2	6	132	29	149	66	382
Oconee 3	10	139	27	161	55	392
Total	24	389	81	508	151	1153