



ROCHESTER GAS AND ELECTRIC CORPORATION • 89 EAST AVENUE, ROCHESTER, N.Y. 14649

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CENTRAL FILES



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August 5, 1980

Mr. Boyce H. Grier, Director  
U. S. Nuclear Regulatory Commission  
Office of Inspection and Enforcement  
Region I  
631 Park Avenue  
King of Prussia, Pennsylvania 19406

Subject: IE Bulletin No. 79-03A, Longitudinal Weld Defects in ASME  
SA-312, Type 304 Stainless Steel Pipe  
R. E. Ginna Nuclear Power Plant, Unit #1  
Docket (No. 50-244)

Dear Mr. Grier:

As stated in our response to NRC IE Bulletin 79-03 dated April 6, 1979, Ginna Station does not utilize ASME SA-312 Type 304 Stainless Steel Pipe with longitudinal seam welds manufactured by Youngstown Welding and Engineering Company nor by any other piping manufacturers. Ginna Station's Class 2 piping was originally designed to ASA-B36.19 and B36.10 with reference to ASTM A-312 Type 304 Stainless Steel Seamless Pipe.

Due to the NRC's concern that the CLP (centerline lack of penetration) problem is a significant deficiency which could result in repair or replacement of pipe and/or fittings, a further review of our safety-related stainless steel system has been completed. One fitting with longitudinal seam welds has been identified in our plant. The following information regards the fitting identified:

- |   |                                    |
|---|------------------------------------|
| 1. System   | Residual Heat Removal              |
| 2. Location   | Containment Vessel Basement        |
| 3. Code   | USAS B31.1.0-1967                  |
| 4. Design Pressure  | 2485 psig                          |
| 5. Design Temperature                                       | 650 F                              |
| 6. Nominal Size   | 10 inch                            |
| 7. Nominal Wall   | 1.000 inches                       |
| 8. Material   | A403 WP 316 (automatically welded) |
| 9. Allowable Stress   | 16,000 psi                         |
| 10. Calculated minimum wall thickness for internal pressure | 0.898 inches                       |

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TO Mr. Boyce H. Grier, Director

- 11. Actual wall thickness 1.10 inches
- 12. Manufacturer Flowline Corporation

The elbow in question received 100% radiography of the longitudinal weld joint during original fabrication. Therefore, a weld joint efficiency factor of 1.0 can be used rather than 0.85. For this reason, the calculated minimum wall thickness shown is based on 100% of the code allowable stress. The calculation did include a factor of 0.875 to account for manufacturing tolerance.

In 1971 Inservice Inspection utilizing the ultrasonic method in accordance with ASME Code Section XI was performed on these longitudinal seam welds with no recordable indications. Please note that this elbow is isolated from the Reactor Coolant System during normal operation and only operates at 400 psig and 350°F during RHR System operation.

Very truly yours,



L. D. White, Jr.

cc: U. S. Nuclear Regulatory Commission  
Office of Inspection and Enforcement  
Division of Reactor Construction Inspection  
Washington, D. C. 20555

