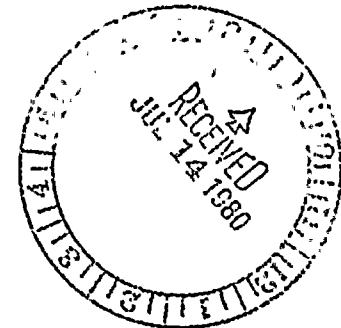


Washington Public Power Supply System
A JOINT OPERATING AGENCY

P. O. Box 968 3000 GEO. WASHINGTON WAY RICHLAND, WASHINGTON 99352 PHONE (509) 375-5000

July 10, 1980.
602-80-145



Docket No. 50-397

U. S. Nuclear Regulatory Commission
NRC Region V
Suite 202, Walnut Creek Plaza
1990 N. California Blvd.
Walnut Creek, California 94596

Attention: Mr. R. H. Engelken, Director

Subject: WPPSS NUCLEAR PROJECT NO. 2
IE BULLETIN NO. 80-08

Dear Mr. Engelken:

The subject bulletin requested information on non-destructive examinations of the containment boundary welds and weld joint details of flued head fittings at the containment penetration interface.

The following is in response to this bulletin.

Item 1

Flued head fittings are used on WNP-2 as indicated on attachment 1.

Item 2a

Flued heads are installed under two contracts. The containment contractor furnished and installed all the flued head fittings indicated on attachment 1, except as indicated below. This work is covered by the 1971 ASME code, Summer 1972 addenda.

Four flued heads on the main steam line (X-18 a, b, c, d) are provided by the NSSS supplier, and installed by the general piping and mechanical installation contractor. In addition to the flued head to penetration containment boundary weld, these flued heads were welded to the process piping with a containment penetration boundary weld by the supplier. These are covered by the 1971 ASME code, Winter 1973 addenda.

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Item 2b

Liquid Penetrant, Magnetic Particle, Visual Examination and Radiography were used on the subject welds.

All completed welds were examined radiographically.

Item 2c

All PDM supplied flued heads were joined with a single u-butt joint. The General Electric supplied flued heads used double-u and single-v butt joints.

The remainder of this item is summarized on attachment 1.

Item 2d

Results of Non-Destructive Examinations

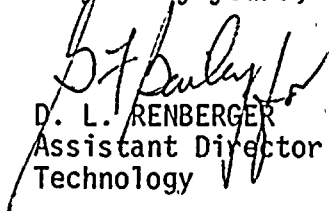
There were weld defects that had to be ground out and repaired. These defects included incomplete fusion, slag, surface defects and porosity.

The flued heads on the Main Steam were inadvertently installed with split backing bars. The weld area in the vicinity of the split was ground out and the backing bar ends welded to make it continuous. The ground area was rewelded and radiographed.

Item 3

This item does not apply as all welds have been radiographed and are acceptable.

Very truly yours,


D. L. RENBERGER
Assistant Director
Technology

DLR:LV:cph
attachment

cc w/att: RE Snaith - B&R
JJ Verderber - B&R
JR Lewis - BPA
B. Wood - NUS
WNP-2 Files



FLUED HEAD CONTAINMENT PENETRATION WELDS

Penetration Number	Material		Size (in.)		Backing Bar
	Flued Head	Pipe	Diameter	Thick	
X-2	SA 333	SA 350 LF 1 or 2	16	.843	No
X-4	SA 155 KCF 70	SA 350 LF 1 or 2	24	.375	No
X-6	SA 155 KCF 70	SA 350 LF 1 or 2	28	.75	No
X-7	SA 155 KCF 70	SA 350 LF 1 or 2	12	.688	No
X-8	SA 155 KCF 70	SA 350 LF 1 or 2	28	.75	No
X-12A	SA 155 KCF 70	SA 350 LF 1 or 2	28	.75	No
X-12B	SA 155 KCF 70	SA 350 LF 1 or 2	28	.75	No
X-12C	SA 155 KCF 70	SA 350 LF 1 or 2	28	.75	No
X-13	SA 106 Gr. B	SA 350 LF 1 or 2	10	.593	No
X-14	SA 155 KCF Gr 70	SA 350 LF 1 or 2	22	.50	No
X-17A	SA 155 KCF Gr 70	SA 350 LF 1 or 2	42	2.000	No
X-17B	SA 155 KCF Gr 70	SA 350 LF 1 or 2	42	2.000	No
X-18A	SA 105	SA 106 Gr. B	44	1.250	Yes
X-18B	SA 105	SA 106 Gr. B	44	1.250	Yes
X-18C	SA 105	SA 106 Gr. B	44	1.250	Yes
X-18D	SA 105	SA 106 Gr. B	44	1.250	Yes
X-19A	SA 155 KCF Gr 70	SA 350 LF 1 or 2	28	.75	No
X-19B	SA 155 KCF Gr 70	SA 350 LF 1 or 2	28	.75	No
X-20	SA 155 KCF Gr 70	SA 350 LF 1 or 2	36	1.25	No
X-21	SA 155 KCF Gr 70	SA 350 LF 1 or 2	26	.50	No
X-22	SA 333 Gr 1	SA 350 LF 1 or 2	12	.668	No
X-45	SA 333 Gr 1	SA 350 LF 1 or 2	16	.844	No
X-116	SA 155 KCF Gr 70	SA 350 LF 1 or 2	12	.688	No