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 FACIL: 50-251 Turkey Point Plant, Unit 4, Florida Power and Light C 05000251
 AUTH. NAME: AUTHOR AFFILIATION
 PLUNKETT, T.F. Florida Power & Light Co.
 RECIP. NAME: RECIPIENT AFFILIATION
 EBNETER, S.D. Region 2 (Post 820201)

SUBJECT: Special rept: on 921106 & 12,20th yr tendon insp determined
 that lift-off value for hoop tendon 13H54 & dome tendon
 1D40 below min design prestress force. Tendons restored to
 required level. Addl rept to be submitted by 930129.

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 TITLE: General (50 Dkt)-Insp Rept/Notice of Violation Response

NOTES: NRR RAGHAVAN, L

05000251 /

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EXTERNAL:	EG&G/BRYCE, J.H.	1 1	NRC PDR	1 1
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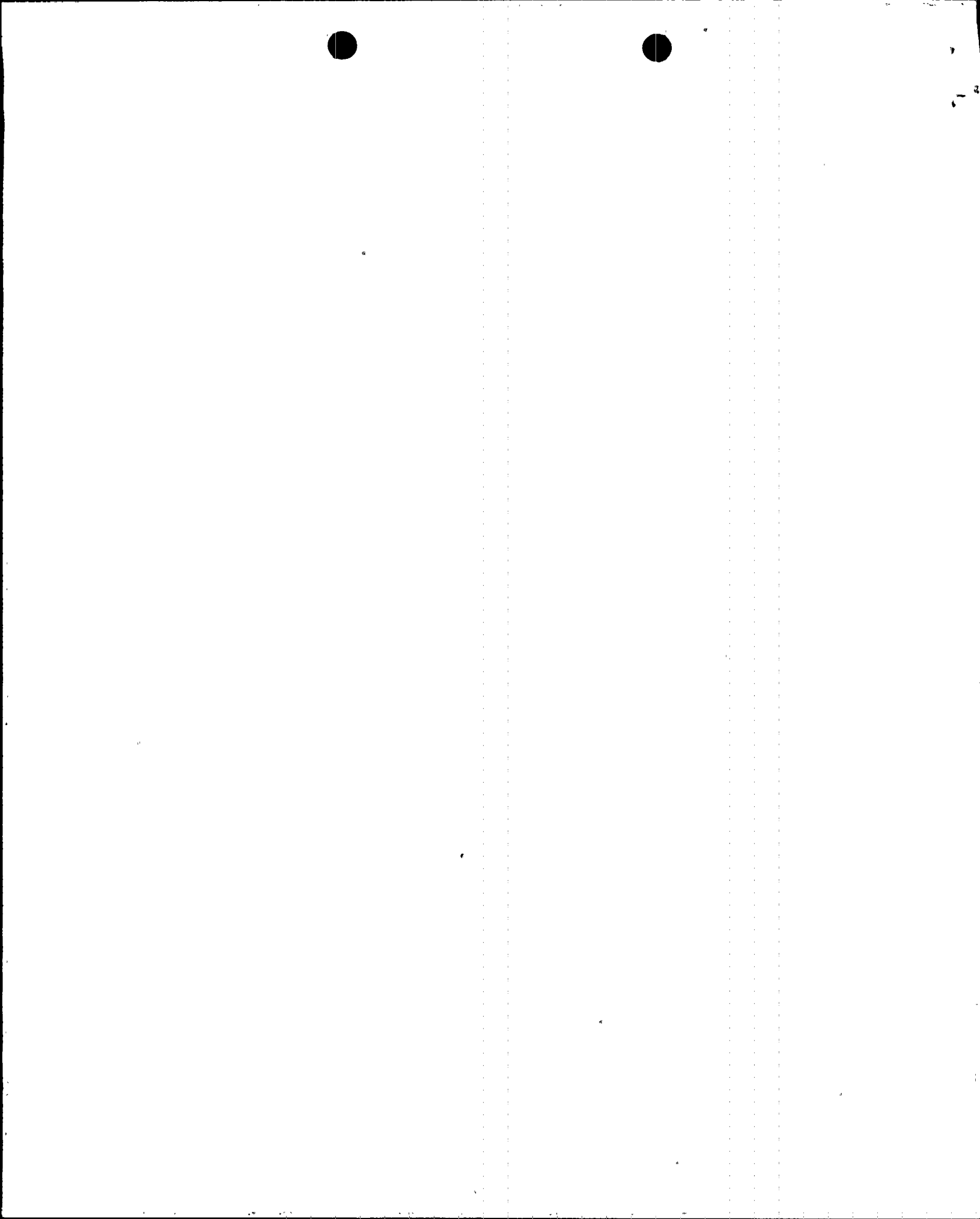
NOTES: 1 1

NOTE TO ALL "RIDS" RECIPIENTS:

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DEC 04 1992

L-92-330
10 CFR 50.36

Stewart D. Ebnetter
Regional Administrator
U. S. Nuclear Regulatory Commission
101 Marietta Street, N.W., Suite 2900
Atlanta, Georgia 30323

Dear Mr. Ebnetter:

Re: Turkey Point Unit 4
Docket No. 50-251
Special Report - Twentieth Year Tendon Inspection
Low Lift-Off Force

In accordance with Florida Power and Light Company (FPL) Turkey Point Units 3 and 4 Technical Specification 3.6.1.6 a., the enclosed Special Report is provided. This report summarizes the low lift-off force inspection results for hoop tendon 13H54 and dome tendon 1D40.

As discussed with the staff on November 30, 1992, a second hoop tendon 35H38 measured a lift-off value below the minimum design prestress force and in accordance with Technical Specification 3.6.1.6 a., tendon 35H38 will be addressed in a separate Special Report to be submitted to the NRC by December 18, 1992.

An additional report will be transmitted to the NRC by January 29, 1993, summarizing the surveillance testing of all hoop and dome tendons inspected during the Unit 4 twentieth year inspection.

Should there be any questions, please contact us.

Very truly yours,

T. F. Plunkett by S. W. Pearce

T. F. Plunkett
Vice President
Turkey Point Nuclear

TFP/RJT/rt

Enclosure

cc: USNRC, Document Control Desk, Washington, D.C.
Senior Resident Inspector, USNRC, Turkey Point Plant

100009

9212100117 921204
PDR ADDCK 05000251
S PDR

an FPL Group company

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Enclosure

NRC Special Report

Turkey Point Unit 4
Twentieth Year Tendon Inspection
Low Lift-Off Force on
Hoop Tendons 13H54 and Dome Tendon 1D40

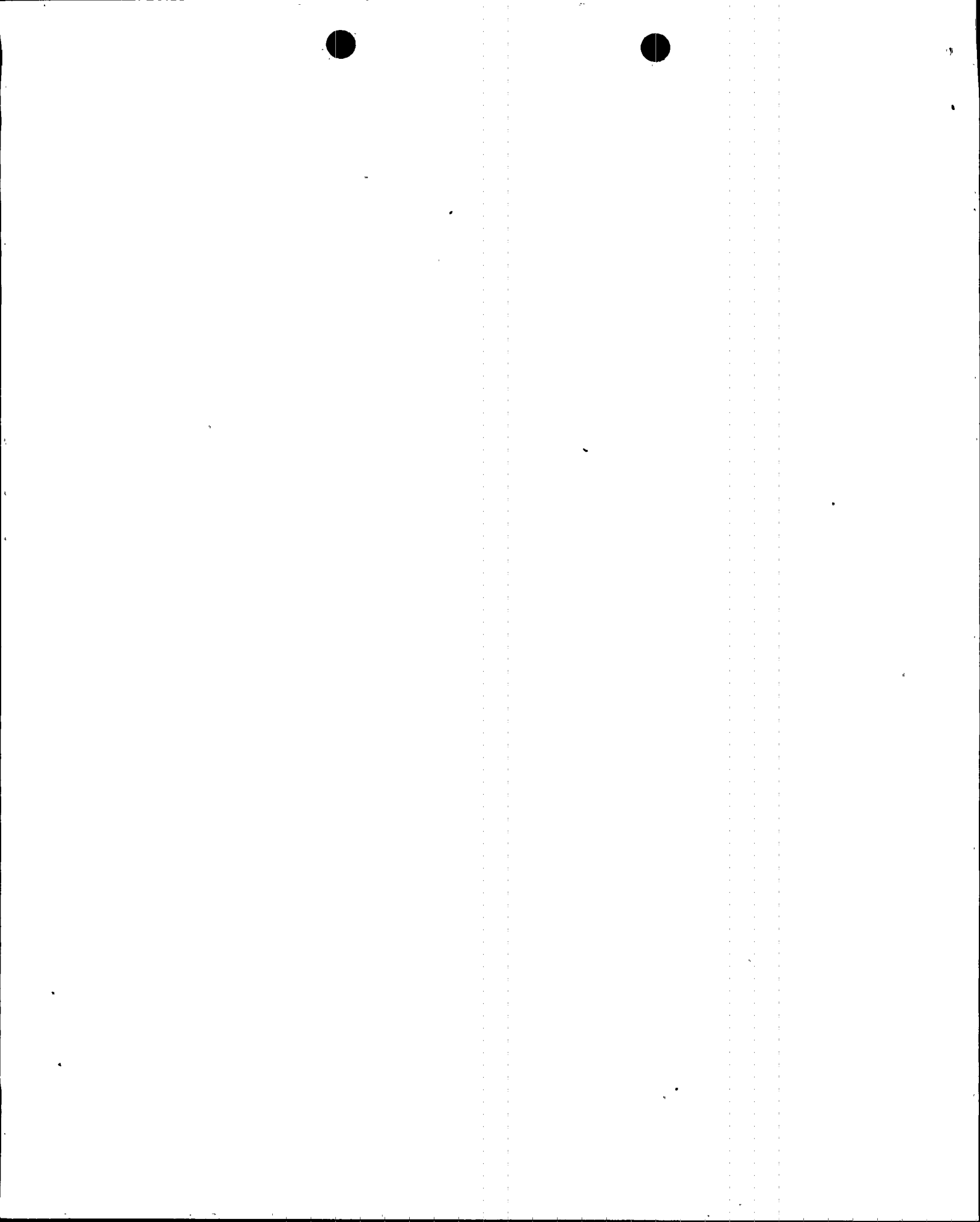


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4.0	CORRECTIVE ACTIONS
5.0	REFERENCES



1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466	467	468	469	470	471	472	473	474	475	476	477	478	479	480	481	482	483	484	485	486	487	488	489	490	491	492	493	494	495	496	497	498	499	500	501	502	503	504	505	506	507	508	509	510	511	512	513	514	515	516	517	518	519	520	521	522	523	524	525	526	527	528	529	530	531	532	533	534	535	536	537	538	539	540	541	542	543	544	545	546	547	548	549	550	551	552	553	554	555	556	557	558	559	560	561	562	563	564	565	566	567	568	569	570	571	572	573	574	575	576	577	578	579	580	581	582	583	584	585	586	587	588	589	590	591	592	593	594	595	596	597	598	599	600	601	602	603	604	605	606	607	608	609	610	611	612	613	614	615	616	617	618	619	620	621	622	623	624	625	626	627	628	629	630	631	632	633	634	635	636	637	638	639	640	641	642	643	644	645	646	647	648	649	650	651	652	653	654	655	656	657	658	659	660	661	662	663	664	665	666	667	668	669	670	671	672	673	674	675	676	677	678	679	680	681	682	683	684	685	686	687	688	689	690	691	692	693	694	695	696	697	698	699	700	701	702	703	704	705	706	707	708	709	710	711	712	713	714	715	716	717	718	719	720	721	722	723	724	725	726	727	728	729	730	731	732	733	734	735	736	737	738	739	740	741	742	743	744	745	746	747	748	749	750	751	752	753	754	755	756	757	758	759	760	761	762	763	764	765	766	767	768	769	770	771	772	773	774	775	776	777	778	779	780	781	782	783	784	785	786	787	788	789	790	791	792	793	794	795	796	797	798	799	800	801	802	803	804	805	806	807	808	809	810	811	812	813	814	815	816	817	818	819	820	821	822	823	824	825	826	827	828	829	830	831	832	833	834	835	836	837	838	839	840	841	842	843	844	845	846	847	848	849	850	851	852	853	854	855	856	857	858	859	860	861	862	863	864	865	866	867	868	869	870	871	872	873	874	875	876	877	878	879	880	881	882	883	884	885	886	887	888	889	890	891	892	893	894	895	896	897	898	899	900	901	902	903	904	905	906	907	908	909	910	911	912	913	914	915	916	917	918	919	920	921	922	923	924	925	926	927	928	929	930	931	932	933	934	935	936	937	938	939	940	941	942	943	944	945	946	947	948	949	950	951	952	953	954	955	956	957	958	959	960	961	962	963	964	965	966	967	968	969	970	971	972	973	974	975	976	977	978	979	980	981	982	983	984	985	986	987	988	989	990	991	992	993	994	995	996	997	998	999	1000	1001	1002	1003	1004	1005	1006	1007	1008	1009	1010	1011	1012	1013	1014	1015	1016	1017	1018	1019	1020	1021	1022	1023	1024	1025	1026	1027	1028	1029	1030	1031	1032	1033	1034	1035	1036	1037	1038	1039	1040	1041	1042	1043	1044	1045	1046	1047	1048	1049	1050	1051	1052	1053	1054	1055	1056	1057	1058	1059	1060	1061	1062	1063	1064	1065	1066	1067	1068	1069	1070	1071	1072	1073	1074	1075	1076	1077	1078	1079	1080	1081	1082	1083	1084	1085	1086	1087	1088	1089	1090	1091	1092	1093	1094	1095	1096	1097	1098	1099	1100	1101	1102	1103	1104	1105	1106	1107	1108	1109	1110	1111	1112	1113	1114	1115	1116	1117	1118	1119	1120	1121	1122	1123	1124	1125	1126	1127	1128	1129	1130	1131	1132	1133	1134	1135	1136	1137	1138	1139	1140	1141	1142	1143	1144	1145	1146	1147	1148	1149	1150	1151	1152	1153	1154	1155	1156	1157	1158	1159	1160	1161	1162	1163	1164	1165	1166	1167	1168	1169	1170	1171	1172	1173	1174	1175	1176	1177	1178	1179	1180	1181	1182	1183	1184	1185	1186	1187	1188	1189	1190	1191	1192	1193	1194	1195	1196	1197	1198	1199	1200	1201	1202	1203	1204	1205	1206	1207	1208	1209	1210	1211	1212	1213	1214	1215	1216	1217	1218	1219	1220	1221	12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1.0 Purpose/Scope

During the performance of the twentieth year tendon surveillance of the Turkey Point Unit 4 containment post-tensioning system, two surveillance tendons, 13H54 (inspected on November 6, 1992) of the hoop tendon group and 1D40 (inspected on November 12, 1992) of the dome tendon group were found to have a measured normalized lift-off force below the predicted lower limit (References 5.4 and 5.5). Consequently, in accordance with the requirements of the Turkey Point Plant Technical Specifications 4.6.1.6.1 (a), additional lift-off measurements on the adjacent tendons (13H53 and 13H55, inspected on November 6, 1992 and 1D38 and 1D41 inspected on November 13, 1992) were taken for each of the applicable surveillance tendons. In each case, since the measured normalized lift-off force in at least one of these adjacent tendons was between the predicted lower limit and 90% of the predicted lower limit, Turkey Point Unit 4 entered a 15 day ACTION statement to the LIMITING CONDITION OF OPERATION (Technical Specification 3.6.1.6). This ACTION statement required restoration of the tendon(s) to the required level of integrity within 15 days and performance of an engineering evaluation of the containment, and the submittal of a Special Report to the NRC within 30 days.

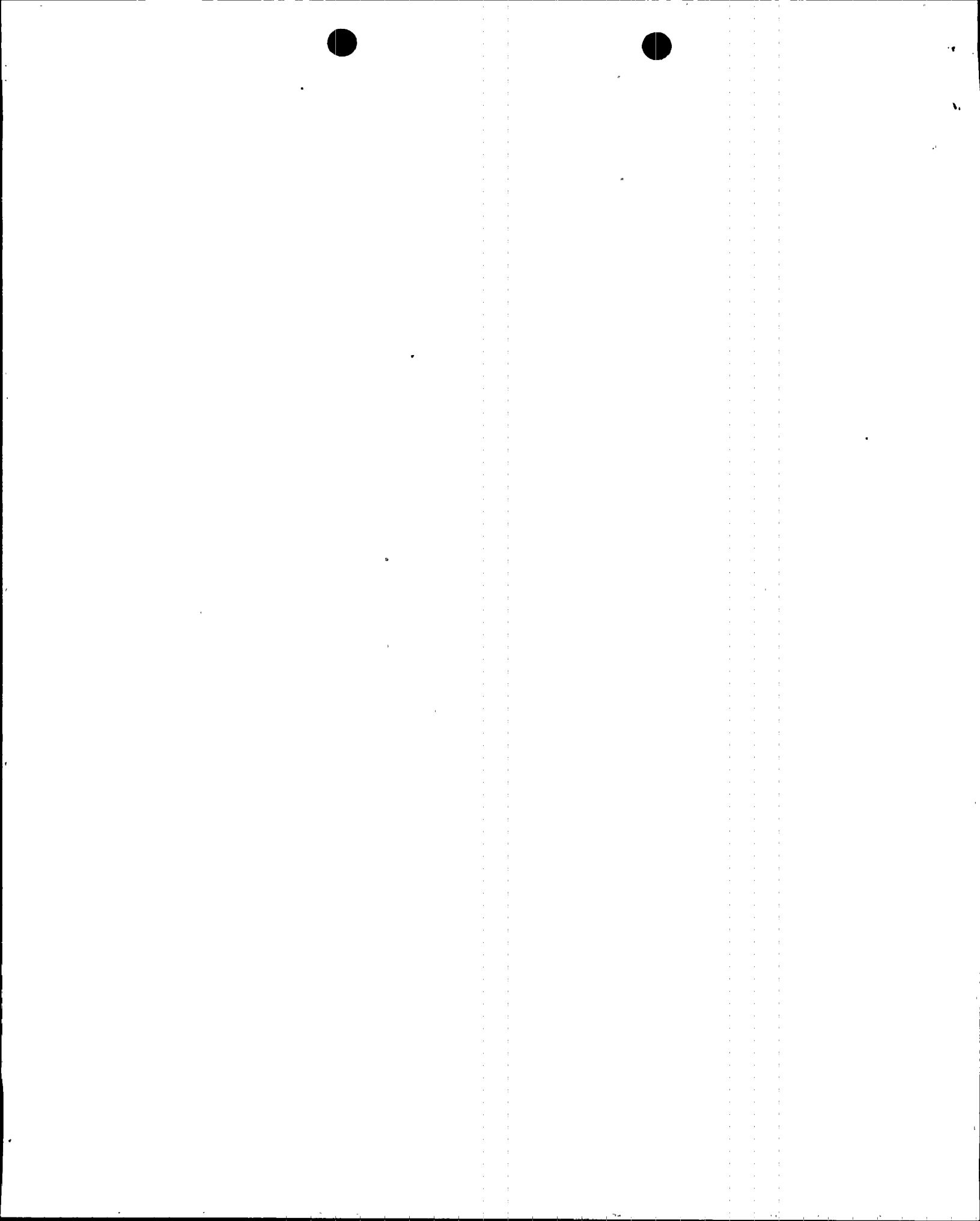
The evaluation of the structural integrity of the containment post-tensioning system is included in this engineering evaluation.

2.0 Engineering Evaluation

The Turkey Point Unit 4 containment is a post-tensioned, reinforced concrete structure comprised of a vertical cylinder with a shallow dome and supported on a conventional reinforced concrete foundation base slab. The vertical cylinder wall is provided with a system of vertical and hoop tendons. Vertical tendons are anchored at the top surface of the ring girder and at the bottom of the base slab. Each hoop tendon is anchored at alternate vertical buttresses nominally 120 degrees apart. Tendons in the dome consist of three groups of tendons oriented at 120 degrees with respect to each other and are anchored at the vertical face of the dome ring girder.

The tendon surveillance program for the Turkey Point Nuclear Plant Unit 4 containment structure post-tensioning system has been performed at one, three and five years after the containment Initial Structural Integrity Test (ISIT), and every five years thereafter. Three dome, five hoop, and four vertical tendons were selected for the twentieth year tendon surveillance on a random basis, excluding those tendons which were previously inspected for earlier surveillances. The Turkey Point Unit 4 twentieth year tendon surveillance is performed in accordance with the requirements of References 5.6 and 5.9.

A wire has been removed for inspection from dome tendon 1D40. In addition, grease samples have been removed for each surveillance tendon inspected to date. The visual inspection of the tendon wire and sheath filler samples have revealed no abnormal wire corrosion or grease discoloration.



Also, the concrete at the tendon anchorage area adjacent to the bearing plates for all hoop tendons has been inspected. This inspection has revealed that no cracks were found which exceed the acceptance width of 0.01 inches noted in reference 5.8, Section IWL-3221.3(d).

For tendons 1D40 and 1D41, the bearing plates are located in the vicinity of a horizontal construction joint located at approximately mid-height of the ring girder. Some concrete spalling/cavities were observed at this horizontal construction joint during the Unit 3 third year tendon surveillance. The spalling was inspected and evaluated in reference 5.11, which concluded that the structural integrity of the containment is not affected. While inspecting the concrete surface in the vicinity of the bearing plates for tendons 1D40 and 1D41 during the Unit 4 twentieth year surveillance, a similar spalling/cavity was observed at this joint. The subject areas were inspected, and it was concluded that the spalling observed during the Unit 4 twentieth year surveillance is similar to the condition evaluated in reference 5.11 and there will be no adverse effects on the containment structural integrity. The appropriate corrective actions will be specified in the Unit 4 final surveillance report to repair the spalled areas to mitigate any potential corrosion path to the main reinforcing steel.

The following are the predicted lower limit (PLL) and the minimum design prestress force at the anchorage for hoop and dome tendons:

Twentieth Year Predicted Lower Limit = 6.63 kips/wire
for Hoop and Dome Tendons
(Reference 5.6)

Minimum Design Prestress Force = 6.29 kips/wire
(Based on Original Design)
at Anchorage for Hoop Tendons
(Reference 5.3)

Minimum Design Prestress Force = 6.55 kips/wire
(Based on Original Design)
at Anchorage for Dome Tendons
(Reference 5.3)

The lift-off forces which are below the predicted lower limit occurred in one of the hoop surveillance tendons (13H54) and its adjacent tendons (13H53 and 13H55) and in one of the dome surveillance tendons (1D40) and one of its adjacent tendons (1D41).

From references 5.4 and 5.5, the results of the surveillance on hoop and dome tendons are as follows:

<u>Tendon</u>	<u>Measured Normalized Lift-Off Force (kips/wire)</u>	<u>Percentage of PLL</u>
13H53	6.27	94.6%
13H54	6.37	96.1%
13H55	6.26	94.4%
Average	6.30 kips/wire	95.0%



<u>Tendon</u>	<u>Measured Normalized Lift-Off Force (kips/wire)</u>	<u>Percentage of PLL</u>
1D38	6.84	103.2%
1D40	6.54	98.6%
1D41	6.29	94.9%
Average	6.56 kips/wire	98.9%

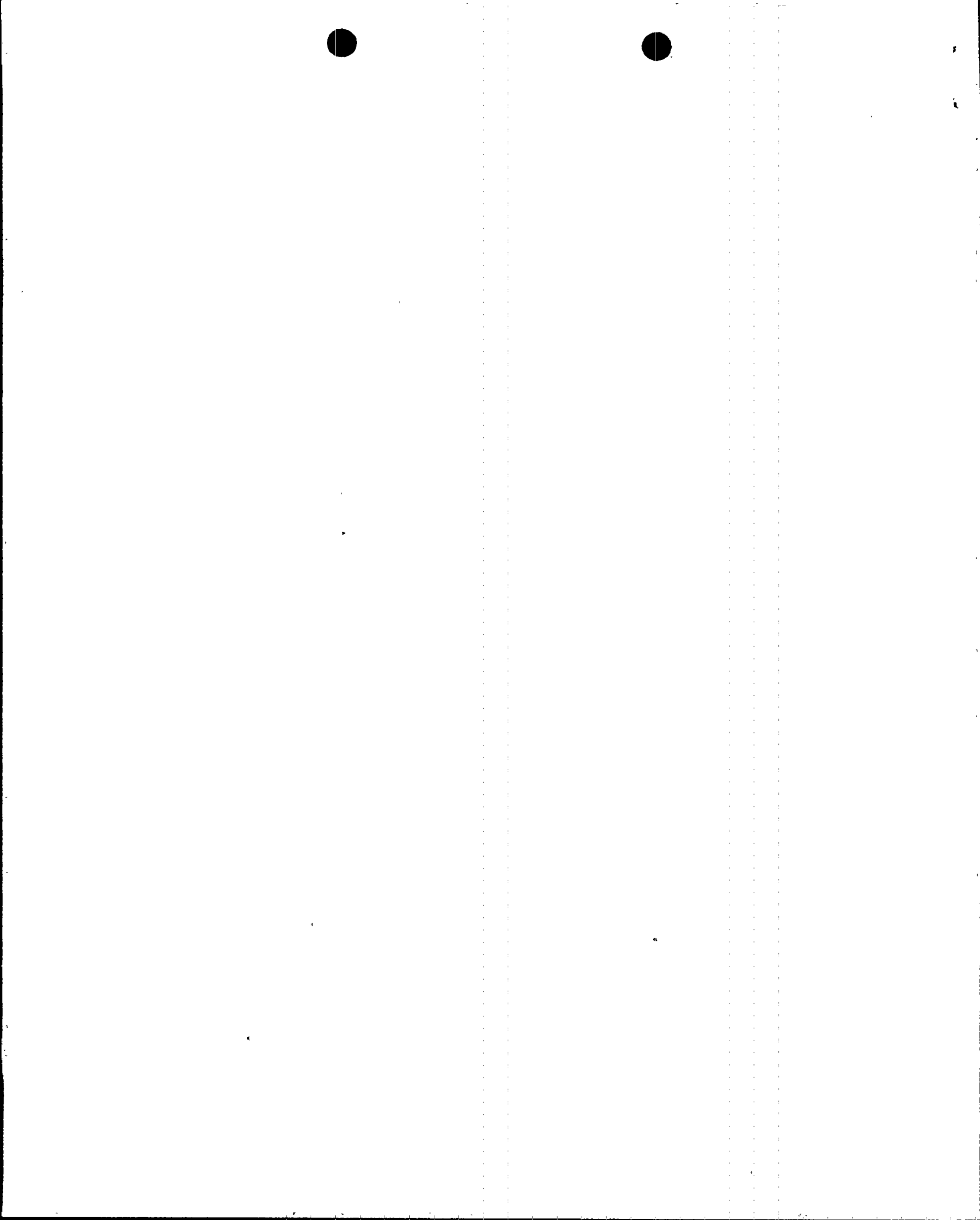
As shown, the average lift-off force for the hoop tendon group is larger than the minimum design prestress force (6.29 kips/wire). Also, the average lift-off force for the dome tendon group is larger than the minimum design prestress force (6.55 kips/wire). Therefore, it is concluded that the subject tendon groups presently provide adequate prestress force to maintain the containment integrity. This conclusion is consistent with the guidance provided in Section 7.1.5 of Regulatory Guide 1.35 (Reference 5.7) and Section IWL-3221.1 (a) of ASME Code (Reference 5.8).

The magnitude of the Unit 4 low lift-off forces for the subject hoop and dome tendons is similar to the Unit 3 lift-off force measurements and correlates well with the results of the evaluation provided to the NRC by Letter L-92-262, dated September 14, 1992 (Reference 5.10) for the Unit 3 low lift-off values. Therefore, it can be stated that the probable cause of the Unit 4 low lift-off measurements is also due to increased tendon wire steel relaxation losses resulting from the temperatures experienced by the tendons. The lift-off readings for the remaining surveillance tendons will provide additional data to further investigate the extent of this condition. Upon completion of the lift-off testing, an engineering evaluation will be prepared to include the additional data and the results of the investigation relative to this condition. A more detailed report will be submitted to the NRC following completion of the tendon surveillance.

2.1 Review Of Regulatory Guides and ASME Code Section XI Acceptance Criteria

Regulatory Guide 1.35 (reference 5.7), Section 7.0, and ASME Code Section XI (reference 5.8), Section IWL-3221.1, were reviewed relative to the tendon lift-off acceptance criteria to provide additional justification for the adequacy of the containment post-tensioning system. The following summarizes this review:

- a) Section 7.1.5 of reference 5.7 and Section IWL-3221.1 (a) of reference 5.8 require that the average of all measured tendon forces be equal to or greater than the minimum required prestress force at the anchorage.
- b) Section 7.1.2 of reference 5.7 implies that, if the measured lift-off force for a surveillance tendon lies above 95% of the predicted lower limit, no additional lift-off testing of adjacent tendons is required and the condition should be considered acceptable.



The measured normalized lift-off forces for surveillance tendons 13H54 and 1D40 were above 95% of the predicted lower limit. This meets the requirement of reference 5.7 (Criterion (b) above), and no additional testing would have been required if this criterion had been applied.

Finally, as shown in Section 2.0, the average lift-off force for hoop tendons is larger than the minimum design prestress force (6.29 kips/wire) which satisfies criterion (a) above. Also, the average lift-off force for dome tendons is larger than the minimum design prestress force (6.55 kips/wire). Therefore, based on this review, it can also be concluded that the Unit 4 hoop and dome tendon groups have sufficient prestress force to maintain the containment integrity, and the intent of the acceptance criteria included in References 5.7 and 5.8 is satisfied.

2.2 Design Margins Available in the Post-Tensioning System

Turkey Point UFSAR (reference 5.1), Section 5.1.2 states that any three adjacent tendons in any tendon group can be lost without significantly affecting the strength of the containment structure. This design feature considers the load redistribution capabilities of the containment shell.

3.0 Conclusion

Based on the available margins existing in the design of the Turkey Point post-tensioning system and the level of prestress force available in the subject hoop and dome tendons, it is concluded that the Unit 4 hoop and dome tendon groups have sufficient prestress force to maintain the containment integrity.

As part of the twentieth year surveillance, lift-off testing will be performed for the remaining hoop and dome surveillance tendons. These lift-off readings will provide additional data to further investigate the extent of this condition. Upon completion of the lift-off testing, an engineering evaluation will be prepared to include the additional data and the results of the investigation relative to this condition. A more detailed report will be submitted to the NRC following completion of the tendon surveillance.

4.0 Corrective Actions

According to the Turkey Point Plant Technical Specifications 3.6.1.6 (a), the lift-off forces in tendons 13H53, 13H54, 13H55, 1D40 and 1D41 have been restored to their required level of integrity by retensioning each tendon to a level equal to or above the twentieth year predicted lower limit. The following summarizes the new lift-off forces for the subject tendons:

<u>Tendon</u>	<u>Measured Average Lift-Off (kips)</u>	<u>Percentage of Predicted Lower Limit</u>
13H53	621.3	104.1%
13H54	619.8	103.9%
13H55	634.2	106.3%
1D40	622.0	104.2%
1D41	619.0	103.7%



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5.0 References

- 5.1 Turkey Point Units 3 and 4 Updated Final Safety Analysis Report (UFSAR), Revision 10, dated July 1992, Section 5.0
- 5.2 Technical Specifications, Amendment 151/146, Sections 4.6.1.6.1(a) and 3.6.1.6, and Amendments 152/147 issued via NRC letter dated August 20, 1992
- 5.3 Bechtel Calculation No. C-SJ539-05, "Evaluation of the Fifteenth Year Tendon Surveillance Lift-Off Forces", Revision 0
- 5.4 Non-Conformance Report N-92-0292
- 5.5 Non-Conformance Report N-92-0301
- 5.6 Bechtel Technical Requirements Document 21701-561-CP-1, Revision 0 for Unit 4 Twentieth Year Tendon Surveillance
- 5.7 Regulatory Guide 1.35, "In-service Inspection of UngROUTED Tendons in Prestressed Concrete Containment", Revision 3, dated July 1990
- 5.8 ASME Code, 1989 Edition, Section XI - Division 1, Article IWL-3000, "Acceptance Standards"
- 5.9 Turkey Point Plant Procedure 0-SMM-51.2, "Containment Tendon Inspection", dated June 26, 1992
- 5.10 FPL Transmittal to the NRC, Turkey Point Unit 3 Twentieth Year Tendon Inspection Report Hoop Tendons Low Lift-Off Force, L-92-262, dated September 14, 1992
- 5.11 Turkey Point Nuclear Power Plant, Unit 3, "Containment Structure Ring Girder Concrete Inspection", dated February 1975

