



LONG ISLAND LIGHTING COMPANY

175 EAST OLD COUNTRY ROAD • HICKSVILLE, NEW YORK 11801

ANDREW W. WOFFORD
VICE PRESIDENT

SNRC-421

August 15, 1979

Mr. Robert T. Carlson, Chief
Reactor Construction & Engineering Support Branch
U. S. Nuclear Regulatory Commission, Region I
631 Park Avenue
King of Prussia, Pennsylvania 19406

NRC Inspection No. 79-04
Shoreham Nuclear Power Station - Unit No. 1
Docket No. 50-322

Dear Mr. Carlson:

This letter responds to your letter of July 12, 1979, which forwarded the report of the inspection of activities authorized by NRC License No. CPPR-95, conducted by Mr. Toth of your office on March 27-30 and April 2-4, 1979. The letter stated that it appeared that one of our activities was not conducted in full compliance with NRC requirements. The apparent noncompliance and our response follow:

1. Apparent Noncompliance with 10CFR50, Appendix B
Criterion IX, and FSAR, Paragraph 17.1.9A

Contrary to the above, in October 1976, the mechanical contractor, under the direction of Stone and Webster, performed thermal cutting of attachment welds to remove pressure caps from nozzles N3 and N4 of residual heat removal heat exchangers No. 034A and No. 034B, without qualified and approved procedures and apparently without performing preheat required by the applicable specifications.

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Mr. Robert T. Carlson

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General Comment

ASME III, Section VIII, Appendix R, does require 175F preheat for material in the P-1 Group which has both a specified maximum carbon content in excess of 0.30 percent and a thickness at the joint in excess of one inch but it requires only 50F preheat for other materials in the P-1 Group. Material certifications for the nozzles in question state that the actual carbon content of the nozzles is less than 0.30 percent in all cases. The end caps were removed indoors in an unheated building during a period when the ambient exterior temperature was generally higher than 50F while the work was being performed. Therefore, little or no preheat would have been necessary to meet the 50F requirement to prevent harm to the base metal of the nozzles. Nevertheless the following corrective and preventive actions have been accomplished.

Corrective Action and Results

All remaining end cap metal and weld metal has been removed by grinding. The ground areas were magnetic particle inspected and all rejectable defects removed by grinding and blending into the surrounding surfaces using care not to violate minimum wall requirements. The ground and blended areas were again magnetic particle inspected and found acceptable.

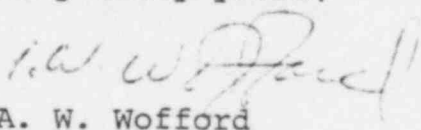
Steps Taken to Prevent Recurrence

Welding Procedures W 100B and W 200B, in effect at the construction site, contain the necessary guidance for use in thermal cutting. Also, an investigation by Field Quality Control has revealed that no additional ASME III nozzles have welded temporary pressure caps.

Date Full Compliance Will Be Achieved

Full compliance has been achieved.

Very truly yours,


A. W. Wofford
Vice President

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