



**Commonwealth Edison**

One First National Plaza, Chicago, Illinois  
Address Reply to: Post Office Box 767  
Chicago, Illinois 60690

May 29, 1979

Mr. James G. Keppler, Director  
Directorate of Inspection and  
Enforcement - Region III  
U.S. Nuclear Regulatory Commission  
799 Roosevelt Road  
Glen Ellyn, Illinois 60127

Subject: Byron Station Units 1 and 2  
Additional Response to IE Inspection  
Report Nos. 50-454/78-09 and 50-455/78-09  
NRC Docket Nos. 50-454 and 50-455

Reference (a): January 22, 1979 letter from C. Reed  
to James G. Keppler

Dear Mr. Keppler:

Per Reference (a), Commonwealth Edison Company, in response to an item of noncompliance (deviation), indicated that a written inquiry had been made to the American Society of Mechanical Engineers (ASME) Committee to "clarify whether a procedure qualification test specimen must meet the mils lateral expansion required by Tables NC-2331-1 and ND-2331(a)-1 of ASME Section III for the thickness tested or the thickness to which the procedure is qualified." Your letter of January 31, 1979 requested advisement of the ASME code committee interpretation of this item.

Enclosed for your review and information as Attachment 1 is the ASME response to Commonwealth Edison's inquiry regarding the mils lateral expansion requirement. Also enclosed, as Attachment 2, is Commonwealth Edison's inquiry of the subject matter.

Please address any additional questions that you might have regarding this matter to this office.

Very truly yours,

*C. Reed*

Cordell Reed  
Assistant Vice-President

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attachments

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# The American Society of Mechanical Engineers

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PRESSURE VESSEL  
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One First National Plaza  
Chicago, IL 60690

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Subject: Section III, Division 1,  
NB-4335.2 Impact Test of Heat Affected Zone  
Table NB-2332-1 Required  $C_v$  Valves for Piping,  
Pumps, and Valves  
Impact Testing for Weld Procedure Qualification

Ref: Your letter of January 25, 1979  
ASME File #NI 79-38

Gentlemen:

In response to your letter, it is our understanding that you are asking  
the following question:

## QUESTION:

For the condition where the weld procedure qualification is limited  
to material under  $1\frac{1}{2}$  in., is it permissible to use a 2 in. plate  
for the procedure qualification and qualify the impact properties  
to the thickness range of  $\frac{3}{4}$  in. to  $1\frac{1}{2}$  in. as specified in Section  
III Table NB-2332-1?

## REPLY:

Yes, providing all requirements of the weld procedure specification  
for the  $1\frac{1}{2}$  in. thickness are complied with.

Yours truly,

*Robert E. Glazier*

Robert E. Glazier  
Assistant Secretary  
(212) 644-8048

REG:cv

bcc: R. F. Reedy  
W. R. Smith  
P. M. Brister  
W. L. Harding  
F. N. Moschini  
W. G. Knecht

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Commonwealth Edison  
One First National Plaza, Chicago, Illinois  
Address Reply to, Post Office Box 767  
Chicago, Illinois 60690

NI 79-38

January 25, 1979

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BOILER CODE

Mr. G. M. Eisenberg, Secretary  
Boiler and Pressure Vessel Committee  
c/o The American Society  
of Mechanical Engineers  
345 E. 47th Street  
New York, NY 10017

Dear Mr. Eisenberg:

We are in need of interpretation of ASME Boiler and Pressure Vessel Code rules contained in Section III, Division 1 related to Charpy impact testing for weld procedure qualification. The specific rules are contained in Subsection NB.

The question involves the use of two inch thick material for a weld coupon to produce impact test specimens to qualify a procedure for  $1\frac{1}{2}$ -inch maximum material thickness. The specimens were needed to supplement PQR data for a weld procedure (P-1 material) which had been previously qualified without the use of pre-heat for  $1\frac{1}{2}$ -inch maximum material thickness (Section IX, QW-403.5 & NB-4335.2).

Under the above conditions, is it permissible to use the Charpy values for nominal wall thickness over  $3/4$ " to  $1\frac{1}{2}$ " inclusive shown in Table NB-2332-1 for acceptance of the specimens removed from the 2-inch thick coupon? We believe this to be acceptable on the basis that the welding procedure for  $1\frac{1}{2}$ -inch maximum thick material was followed and the procedure is not permitted to be used for material over  $1\frac{1}{2}$ -inch thickness.

An early response in this matter will be appreciated.

Sincerely,

W. L. Stiede

cc: R. F. Reedy  
F. N. Moschini  
E. J. Henzy

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