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

August 3, 1981

Mr. A. Schwencer, Chief
Licensing Branch No. 2
Division of Licensing
U.S. Nuclear Regulatory Commission
Washington, DC 20555

Subject: LaSalle County Station Unit 1
Update of Baseline Inspection Report
NRC Docket No. 50-373

Reference (1): L. O. DelGeorge letter to B. J. Youngblood dated December 12, 1980

Dear Mr. Schwencer:

Enclosed for your review are two (2) copies of the subject information. These materials should be consolidated with the report submitted by Reference (1). This update includes changeout pages dated April 17 and April 22, 1981.

If you have any questions in this regard, please direct them to this office.

Very truly yours,

L. O. DelGeorge

L. O. DelGeorge
Director of Nuclear Licensing

Enclosures

cc: NRC Resident Inspector - LSCS (w/o Enc.)

2370N

B001
S1/2

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GENERAL ELECTRIC

GENERAL ELECTRIC COMPANY, 814 COMMERCE DR., OAK BROOK, ILL. 60521

INSTALLATION AND
SERVICE ENGINEERING
DIVISION

April 22, 1981

Mr. George R. Crane
Station Nuclear Engineering Department
Commonwealth Edison Company
1 First National Plaza
P. O. Box 767
Chicago, Illinois 60690

SUBJECT: LaSalle Unit 1 PSI Report Update
April 22, 1981

Dear Mr. Crane:

The update package is issued in the form of replacement pages. Revisions, additions or deletions are incorporated directly into the affected pages. Attached is a table containing the necessary changes.

If you have any questions, please do not hesitate to call or write.

Sincerely yours,

R. C. Hooper
NDE Specialist-Technical Support
Central Nuclear Plant Services

RCH:ck
attachment

TABLE OF CONTENTS

LSCS Unit 1 - PSI Report

April 22, 1981

Update Package

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. 1-NIR REV. 4

PAGE 4 of 7

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L D Whatley DATE 4/13/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-3D	0	B-D	NIR	13	0	Z1CW	99023	99019	MP-1	N/A	L D Whatley 4/13/81	saf 4/13/81
					13	0	Z1CCW	45526	45522	MP-1	N/A		
					16	0	Z2CW	73012	73008	MP-1	N/A		
					16	0	Z2CCW	73012	73008	MP-1	N/A		
N/A	1-NIR-4A* (30°)	0	B-D	NIR	13	0	Z1CW	16023	16021	MP-1	N/A	L D Whatley 4/13/81	saf 4/13/81
					13	0	Z1CCW	16023	16021	MP-1	N/A		
					16	0	Z2CW	16029	16022	MP-1	N/A		
					16	0	Z2CCW	16029	16022	MP-1	N/A		
N/A	1-NIR-4B* (90°)	0	B-D	NIR	13	0	Z1CW	16024	16021	MP-1	N/A	L D Whatley 4/13/81	saf 4/13/81
					13	0	Z1CCW	16024	16021	MP-1	N/A		
					16	0	Z2CW	16030	16022	MP-1	N/A		
					16	0	Z2CCW	16030	16022	MP-1	N/A		
N/A	1-NIR-4C* (150°)	0	B-D	NIR	13	0	Z1CW	16025	16021	MP-1	N/A	L D Whatley 4/13/81	saf 4/13/81
					13	0	Z1CCW	16025	16021	MP-1	N/A		
					16	0	Z2CW	16031	16022	MP-1	N/A		
					16	0	Z2CCW	16031	16022	MP-1	N/A		
N/A	1-NIR-4D* (210°)	0	B-D	NIR	13	0	Z1CW	16026	16021	MP-1	N/A	L D Whatley 4/13/81	saf 4/13/81
					13	0	Z1CCW	16026	16021	MP-1	N/A		
					16	0	Z2CW	16032	16022	MP-1	N/A		
					16	0	Z2CCW	16032	16022	MP-1	N/A		

* NIR
For PT examinations: See PSI Ref. No. RPV-11.
For additional UT examinations: See PSI Ref. Nos. RPV-5 and RPV-12
Nozzle Bore
For PT examinations: See PSI Ref. No RPV-11
For UT examinations: See PSI Ref. No. RPV-6

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. 1-NIR REV.4

PAGE 5 of 7

REVIEWED AND APPROVED BY:

Q.C. SUPERVISOR L D Whatley DATE 4/13/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-4E* (270°)	0	B-D	NIR	13	0	Z1CW	16027	16021	MP-1	N/A	L D Whatley 4/13/81	daf 4/13/81
					13	0	Z1CCW	16027	16021	MP-1	N/A		
					16	0	Z2CW	16033	16022	MP-1	N/A		
					16	0	Z2CCW	16033	16022	MP-1	N/A		
N/A	1-NIR-4F* (330°)	0	B-D	NIR	13	0	Z1CW	16028	16021	MP-1	N/A	L D Whatley 4/13/81	daf 4-13-81
					13	0	Z1CCW	16028	16021	MP-1	N/A		
					16	0	Z2CW	73014	73013	MP-1	73013		
					16	0	Z2CCW	73014	73013	MP-1	73013		
N/A	1-NIR-5	0	B-D	NIR	13	0	Z1CW	99002	99000	MP-1	N/A	L D Whatley 4/13/81	daf 4-13-81
					13	0	Z1CCW	45501	45500	MP-1	N/A		
					16	0	Z2CW	73006	73005	MP-1	N/A		
					16	0	Z2CCW	73006	73005	MP-1	N/A		
N/A	1-NIR-6A	0	B-D	NIR	13	0	Z1CW	45505	45504	MP-1	N/A	L D Whatley 4/13/81	daf 4-13-81
					13	0	Z1CCW	45505	45504	MP-1	N/A		
					16	0	Z2CW	16018	16017	MP-1	N/A		
					16	0	Z2CCW	16018	16017	MP-1	N/A		
N/A	1-NIR-6B	0	B-D	NIR	13	0	Z1CW	45506	45504	MP-1	N/A	L D Whatley 4/13/81	daf 4-13-81
					13	0	Z1CCW	45506	45504	MP-1	N/A		
					16	0	Z2CW	16019	16017	MP-1	N/A		
					16	0	Z2CCW	16019	16017	MP-1	N/A		

* NIR
For PT examinations: See PSI Ref. No. RPV-11.
For additional UT examinations: See PSI Ref. Nos. RPV-5 and RPV-12.
Nozzle Bore
For PT examinations: See PSI Ref. No. RPV-11.
For UT examinations: See PSI Ref. No. RPV-6.

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1053 REV. 5

PAGE 2 of 3

REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 6/23/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
26"	IMS-1053-12LD	0	B-J	L.S.	1 1 2	2 0 2	UT-0° UT-45° PT	20096 70017	20093 70016	01-26-01 01-26-01	20052 10040	L D Wheatley 6/23/80	W J Caldwell 6-24-80
26"	IMS-1053-13LU	0	B-J	L.S.	1 1 2	3 0 2	UT-0° UT-45° PT	25110 70022 60010	25109 70020	01-26-01 01-26-01	25103 10040	L D Wheatley 6/23/80	W J Caldwell 6-24-80
26"	IMS-1053-13	0	B-J	P-V	1 1 2	2 0 2	UT-0° UT-45° PT	80052 70022 60010	80051 70020	01-26-01 01-26-01	10035 10040	L D Wheatley 6/23/80 also 92225, 92231 INCR-37 (10505)	W J Caldwell 6-24-80
26"	IMS-1053-8	0	B-J	P-P	1 1 2	2 2 2	UT-0° UT-45° PT	80066 20183 60015	80065 20182	01-26-01 01-26-01	10035 10035	L D Wheatley 6/23/80	W J Caldwell 6-24-80
26"	IMS-1053-8LU	0	B-J	L.S.	1 1 2	2 2 2	UT-0° UT-45° PT	80066 20183 40021	80065 20182	01-26-01 01-26-01	10035 10035	L D Wheatley 6/23/80	W J Caldwell 6-24-80
26"	IMS-1053-15	0	B-J	V-P	1 1 2	2 2 2	UT-0° UT-45° PT	20096 10080 60012	20093 10079	01-26-01 01-26-01	20052 10035	L D Wheatley 6/23/80	W J Caldwell 6-24-80
26"	IMS-1053-15LD	0	B-J	L.S.	1 1 2	2 2 2	UT-0° UT-45° PT	20096 80055 60012	20093 80054	01-26-01 01-26-01	20052 10035	L D Wheatley 6/23/80	W J Caldwell 6-24-80
26"	IMS-1053-18	0	B-J	P-PH	1 1 2	0 0 2	UT-0° UT-45° PT	20030 10008 60014	20029 10007	01-26-02 01-26-02	20001 10001	L D Wheatley 6/23/80	W J Caldwell 6-24-80

FORM 7TC 11

INSTALLATION & SERVICE ENGINEERING DIVISION

DATA SHEET
LS-POSTMAC-2

FINAL BORE PT INSPECTION

NOZZLE	INDICATIONS: APPROXIMATE AZIMUTH, DISTANCE FROM FACE, DESCRIPTION	EXAMINER, LEVEL, DATE
30	No relevant indications Note: Re-PT'd grind out area, no relevant indications noted. D.W. Level II 4/27/78	WHJ level II 4/14/78 EJ Brogan HSB ANI-
90	No relevant indications	WHJ level II 4/14/78 EJ Brogan HSB-ANI
150	No relevant indications	WHJ level II 4/14/78 EJB-HSB 4-14-78 ANI
210	No relevant indications	WHJ level II 4/14/78 EJ Brogan HSB ANI
270	No relevant indications	WHJ 4/12/78 level II EJ Brogan HSB ANI-
330	No relevant indications Proj. No. 391N0185	WHJ 4/14/78 level II EJ Brogan HSB ANI

Classification No. 11.65

GENERAL ELECTRIC

ISE TN-103P (8/77)

PSI Ref. No. RPV-1

GENERAL ELECTRIC

"INSTALLATION & TURNKEY ENGINEERING DIVISION"

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
(Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 30° FEEDWATER NOZZLE

COMPONENT FEEDWATER NOZZLE BORE MATERIAL CARBON STEEL

PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED SUMMER 76 ADDENDA

Penetrant Materials

Penetrant Materials Manufacture MAGNAFLUX SPOT CHECK

Pre-cleaning Solvent	Type	SKC-NF	Batch No.	78A167
Penetrant	Type	SKL-HF/S	Batch No.	78A052
Penetrant Remover	Type	SKC-NF	Batch No.	78A167
Developer	Type	SKD-NF	Batch No.	7K107
Post-Examination Cleaner	Type	SKC-NF	Batch No.	78A167

Penetrant Process

A. Pre-Examination Cleaning

[ ] Grinding [X] Flapper Wheels [ ] Other _____

[X] Normal Evaporation Drying (5 minutes minimum) 5 Minutes

[ ] Forced Hot Air Drying (5 minutes minimum) _____ Minutes

Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? X Yes ___ No

Penetrant Temperature Between 60°F and 125°F? X Yes ___ No

[ ] Dipping [ ] Brushing [X] Spraying

Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal

The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.

Type of Penetrant Cleaner Used SKC-NF

Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application

Type of Solvent Suspension Wet Developer Used SKD-NF

Development Time (7-30 minutes 7-15 Minutes

PSI Ref. No. RPV-11
Page 2 of 8

E. Post-Examination Cleaning

Type of solvent used for penetrant materials removal SKC-NF

NDE EXAMINER'S NAME & LEVEL D Dysart level II DATE 4/14/78

EXHIBIT I ANI- EJ Bryan 4-14-78

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
(Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 30° FEEDWATER NOZZLE

COMPONENT FEEDWATER NOZZLE BORE GRINDOUT MATERIAL CARBON STEEL

PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED SUMMER 76 ADDENDA

Penetrant Materials

Penetrant Materials Manufacturer MAGNAFLUX SPOT CHECK

Pre-cleaning Solvent	Type	SKC-NF	Batch No.	78A167
Penetrant	Type	SKL-HF/S	Batch No.	78A052
Penetrant Remover	Type	SKC-NF	Batch No.	78A167
Developer	Type	SKD-NF	Batch No.	7K107
Post-Examination Cleaner	Type	SKC-NF	Batch No.	78A167

Penetrant Process

A. Pre-Examination Cleaning

[X] Grinding [X] Flapper Wheels [ ] Other ____

[X] Normal Evaporation Drying (5 minutes minimum) 5 Minutes

[ ] Forced Hot Air Drying (5 minutes minimum) ____ Minutes

Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? X Yes ___ No

Penetrant Temperature Between 60°F and 125°F? X Yes ___ No

[ ] Dipping [ ] Brushing [X] Spraying

Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal

The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.

Type of Penetrant Cleaner Used SKC-NF

Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application

Type of Solvent Suspension Wet Developer Used SKD-NF

Development Time (7-30 minutes 10 Minutes

PSI Ref. No. RPV-11
Page 3 of 8

E. Post-Examination Cleaning

Type of solvent used for penetrant materials removal SKC-NF

NDE EXAMINER'S NAME & LEVEL Bill Wainscott DATE 4/27/78

GENERAL ELECTRIC

INSTALLATION & ENGINEERING DIVISION

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
(Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 90° FEEDWATER NOZZLE

COMPONENT FEEDWATER NOZZLE BORE MATERIAL CARBON STEEL

PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED SUMMER 76 ADDENDA

Penetrant Materials

Penetrant Materials Manufacturer MAGNAFLUX - SPOT CHECK

Pre-cleaning Solvent	Type	SKC-NF	Batch No.	78A167
Penetrant	Type	SKL-HF/S	Batch No.	78A052
Penetrant Remover	Type	SKC-NF	Batch No.	78A167
Developer	Type	SKD-NF	Batch No.	7K107
Post-Examination Cleaner	Type	SKC-NF	Batch No.	78A167

Penetrant Process

A. Pre-Examination Cleaning

- [ ] Grinding
- [X] Flapper Wheels
- [ ] Other
- [X] Normal Evaporation Drying (5 minutes minimum) 5 Minutes
- [ ] Forced Hot Air Drying (5 minutes minimum) Minutes

Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? X Yes ___ No
Penetrant Temperature Between 60°F and 120°F? X Yes ___ No

- [ ] Dipping
- [ ] Brushing
- [X] Spraying

Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal
The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.
Type of Penetrant Cleaner Used SKC-NF
Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application
Type of Solvent Suspension Wet Developer Used SKD-NF
Development Time (7-30 minutes 7-15 Minutes

PSI Ref. No. RPV-11
Page 4 of 8

E. Post-Examination Cleaning
Type of solvent used for penetrant materials removal SKC-NF

NDE EXAMINER'S NAME & LEVEL [signature] II DATE 4/14/78

EXHIBIT I ANI - EJ Brogan 4-14-78

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
(Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 150° FEEDWATER NOZZLE

COMPONENT FEEDWATER NOZZLE BORE MATERIAL CARBON STEEL

PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED SUMMER ADDENDA

Penetrant Materials

Penetrant Materials Manufacturer		MAGNAFLUX - SPOT CHECK		
Pre-cleaning Solvent	Type	SKC-NF	Batch No.	78A167
Penetrant	Type	SKL-HF/S	Batch No.	78A052
Penetrant Remover	Type	SKC-NF	Batch No.	78A167
Developer	Type	SKD-NF	Batch No.	7K107
Post-Examination Cleaner	Type	SKC-NF	Batch No.	78A167

Penetrant Process

A. Pre-Examination Cleaning

[ ] Grinding [X] Flapper Wheels [ ] Other ____

[ ] Normal Evaporation Drying (5 minutes minimum) 5 Minutes

[X] Forced Hot Air Drying (5 minutes minimum) ____ Minutes

Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? X Yes ___ No

Penetrant Temperature Between 60°F and 125°F? X Yes ___ No

[ ] Dipping [ ] Brushing [X] Spraying

Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal

The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.

Type of Penetrant Cleaner Used SKC-NF

Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application

Type of Solvent Suspension Wet Developer Used SKD-NF

Development Time (7-30 minutes 7-15 Minutes

PSI Ref. No. RPV-11 Page 5 of 8

E. Post-Examination Cleaning

Type of solvent used for penetrant materials removal SKC-NF

NDE EXAMINER'S NAME & LEVEL W. Wyatt Level II DATE 4/14/78

EXHIBIT I ANI - E. J. Brogan 4-14-78

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
(Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 210° FEEDWATER NOZZLE

COMPONENT FEEDWATER NOZZLE BORE MATERIAL CARBON STEEL

PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED. SUMMER 76 ADDENDA

Penetrant Materials

Penetrant Materials Manufacturer		MAGNAFLUX- SPOT CHECK		
Pre-cleaning Solvent	Type	SKC-NF	Batch No.	78A167
Penetrant	Type	SKL-HF/S	Batch No.	78A052
Penetrant Remover	Type	SKC-NF	Batch No.	78A167
Developer	Type	SKD-NF	Batch No.	7K107
Post-Examination Cleaner	Type	SKC-NF	Batch No.	78A167

Penetrant Process

A. Pre-Examination Cleaning

[ ] Grinding [X] Flapper Wheels [ ] Other ____

[X] Normal Evaporation Drying (5 minutes minimum) 5 Minutes

[ ] Forced Hot Air Drying (5 minutes minimum) ____ Minutes

Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? X Yes ___ No

Penetrant Temperature Between 60°F and 125°F? X Yes ___ No

[ ] Dipping [ ] Brushing [X] Spraying

Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal

The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.

Type of Penetrant Cleaner Used SKC-NF

Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application

Type of Solvent Suspension Wet Developer Used SKD-NF

Development Time (7-30 minutes 7-15 Minutes

PSI Ref. No. RPV-11
Page 6 of 8

E. Post-Examination Cleaning

Type of solvent used for penetrant materials removal SKC-NF

NDE EXAMINER'S NAME & LEVEL D. Donatt Level II DATE 4/14/78

ANI E J Brogan 4-14-78

EXHIBIT I

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
(Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 270° FEEDWATER NOZZLE

COMPONENT FEEDWATER NOZZLE BORE MATERIAL CARBON STEEL

PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED SUMMER 76 ADDENDA

Penetrant Materials

Penetrant Materials Manufacturer		MAGNAFLUX - SPOT CHECK		
Pre-cleaning Solvent	Type	SKC-NF	Batch No.	78A167
Penetrant	Type	SKL-HF/S	Batch No.	78A052
Penetrant Remover	Type	SKC-NF	Batch No.	78A167
Developer	Type	SKD-NF	Batch No.	7K107
Post-Examination Cleaner	Type	SKC-NF	Batch No.	78A167

Penetrant Process

A. Pre-Examination Cleaning

[ ] Grinding [X] Flapper Wheels [ ] Other _____

[X] Normal Evaporation Drying (5 minutes minimum) 5 Minutes

[ ] Forced Hot Air Drying (5 minutes minimum) _____ Minutes

Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? X Yes ___ No

Penetrant Temperature Between 60°F and 125°F? X Yes ___ No

[ ] Dipping [ ] Brushing [X] Spraying

Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal

The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.

Type of Penetrant Cleaner Used SKC-NF

Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application

Type of Solvent Suspension Wet Developer Used SKD-NF

Development Time (7-30 minutes 7-15 Minutes

PSI Ref. No. RPV-11
Page 7 of 8

E. Post-Examination Cleaning

Type of solvent used for penetrant materials removal SKC-NF

NDE EXAMINER'S NAME & LEVEL W. Dopsth Level II DATE 4/12/78

ANI - EJ Brogan 4-12-78

EXHIBIT I

GENERAL ELECTRIC

INTERNATIONAL ENGINEERING DIVISION

LIQUID PENETRANT MATERIALS AND PROCESS DATA SHEET
(Color Contrast - Solvent Removable)

CUSTOMER/STATION LASALLE COUNTY NUCLEAR STATION SYSTEM 330° FEEDWATER NOZZLE

COMPONENT FEEDWATER NOZZLE BORE MATERIAL CARBON STEEL

PT PROCEDURE NO. NDE-PT-1001 REV. 5 GOVERNING SPEC. SEC 5 NDE 1974 ED SUMMER 76 ADDENDA

Penetrant Materials

Penetrant Materials Manufacturer MAGNAFLUX-SPOT CHECK

Pre-cleaning Solvent	Type	SKC-NF	Batch No.	78A167
Penetrant	Type	SKL-HF/S	Batch No.	78A052
Penetrant Remover	Type	SKC-NF	Batch No.	78A167
Developer	Type	SKD-NF	Batch No.	7K107
Post-Examination Cleaner	Type	SKC-NF	Batch No.	78A167

Penetrant Process

A. Pre-Examination Cleaning

[ ] Grinding [X] Flapper Wheels [ ] Other

[ ] Normal Evaporation Drying (5 minutes minimum) 5 Minutes

[X] Forced Hot Air Drying (5 minutes minimum) Minutes

Type of Solvent Used SKC-NF

B. Penetrant Application

Surface Temperature Between 60°F and 125°F? X Yes ___ No

Penetrant Temperature Between 60°F and 125°F? X Yes ___ No

[ ] Dipping [ ] Brushing [X] Spraying

Penetration Time (10-30 minutes) 10 Minutes

C. Excess Penetrant Removal

The penetrant was removed by wiping with a clean white cotton cloth and/or absorbent paper, repeating the operation until most traces of penetrant had been removed. The remaining traces were removed by wiping the surface lightly with a clean white cotton cloth and/or absorbent paper moistened with penetrant cleaner. To minimize removal of penetrant from discontinuities, care was taken to avoid the use of excess penetrant cleaner.

Type of Penetrant Cleaner Used SKC-NF

Normal Evaporation Drying Time Prior to Developer Application (5-10 min.) 5 Min.

D. Developer Application

Type of Solvent Suspension Wet Developer Used SKD-NF

Development Time (7-30 minutes 7-15 Minutes

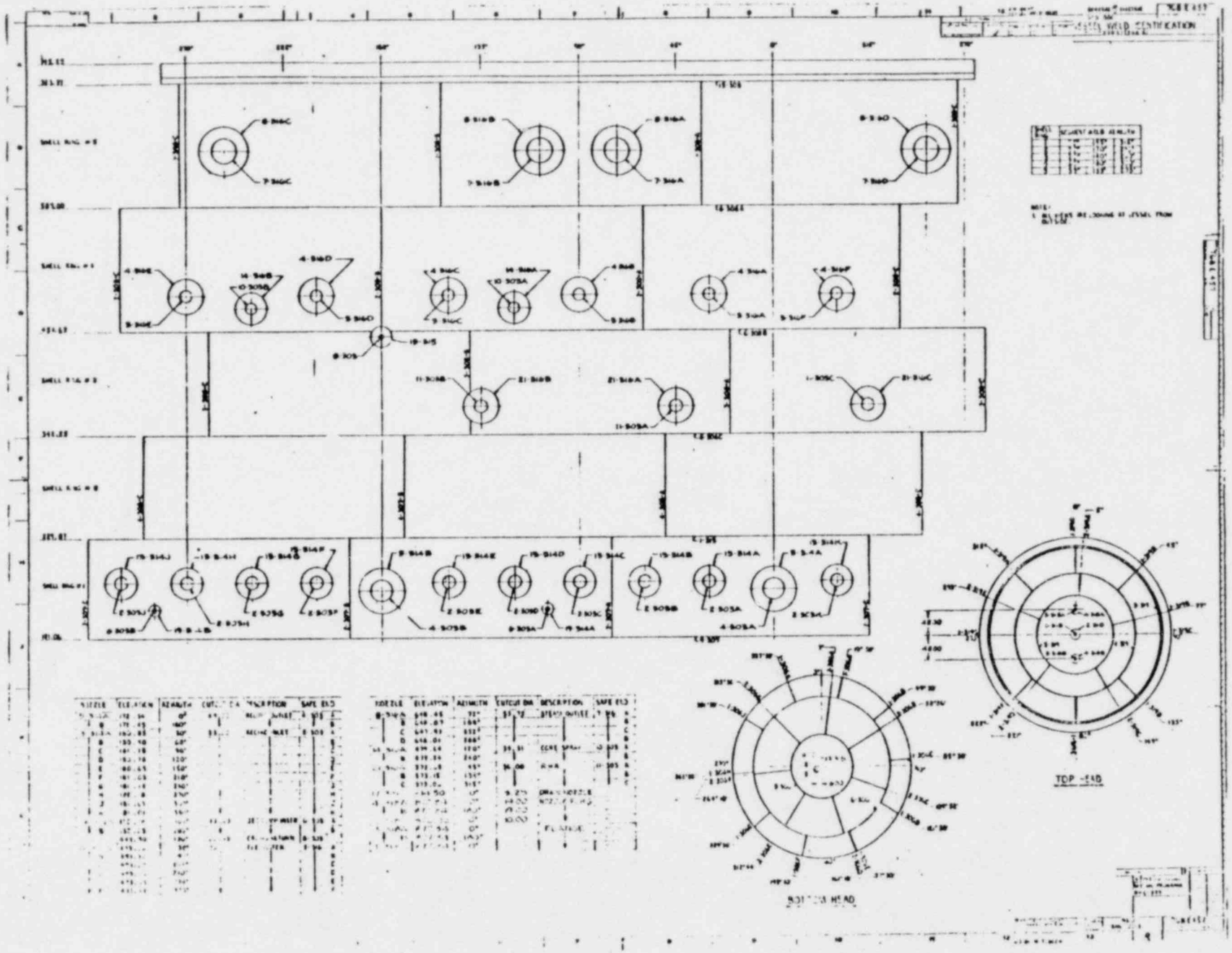
PSI Ref. No. RPV-11
Page 8 of 8

E. Post-Examination Cleaning

Type of solvent used for penetrant materials removal SKC-NF

NDE EXAMINER'S NAME & LEVEL W. Dyatt Level II DATE 4/14/78

EXHIBIT I ANI - Eg Eroger 4-14-78


TOP HEAD
BOTTOM HEAD

NUCLEAR QUALITY ASSURANCE
COMBUSTION ENGINEERING, INC.
CHATTANOOGA, TENNESSEE

ULTRASONIC INSPECTION REPORT

☐ INFORMATION
REPORTABLE Yes ☐ No ☐

☐ ACCEPTANCE
☐ Satisfactory
☐ Unsatisfactory

[3] CONTRACT 2867 [4] JOB & CONTROL NO.: V-20777-053 [5] SEQ. 50 [6] OPERATION 4278 [7] DATE 12/11/76
[8] COMPONENT: Final Vessel Assy [9] QTY 1 [10] SEAM PART OR CODE NO.: 316-02-1
[11] TYPE SEAM: GIRTH ☐ LONG ☐ NOZZLE ☒ OTHER _____ [12] REPAIR ☐
[13] M&P SPECIFICATION 2.4.4.111 (a) [14] RECEIVING ☐ [15] IN-PROCESS ☐ [16] FINAL ☒
[17] COMPLETE ☒ [18] INCOMPLETE ☐ [19] NDE EVALUATE _____ [20] REJ. NO. _____ [21] RECORD ☐
[22] INSPECTOR(S) R. Wille II S. Wells II [23] CUSTOMER _____

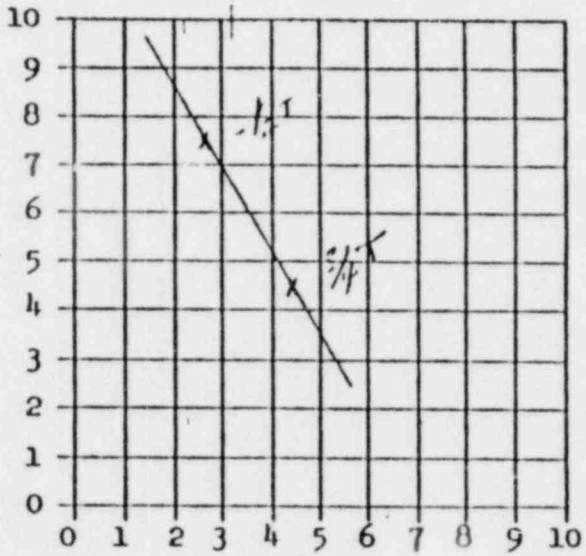
Reviewed W J Caldwell ANST HSB 4-8-81

TEST

BM ☐ 0°-HAZ ☐ 45° ☒ 60° ☐ ____
B.R. ____ % I.D. ☐ O.D. ☒
11W BLOCK ANGLE 45°
CALIBRATION BLOCK NO. 2867-8'
TRANSDUCER S/N 564 #7-CW Shoe
CABLE S/N n/a
EQUIPMENT S/N 740916
C-E S/N 9445
PULSER/RECEIVER S/N FTS/MKI
COUPLANT: WATER ☐ GLYCERINE ☒
SILICONE GREASE ☐

TEST TEMPERATURE:
AMBIENT ☒ ELEVATED ☐ ____ °F

DAC



LINEARITY CHECKS

		TIME (MILITARY)	
____	DB @ 10X	0830	____
13	DB @ 5X	0930	____
____	DB @ 2X	____	____
____	DB @ 1/2X		
____	DB @ 1/4X		

INCHES/DIV. 2

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
n/a DB DIAL
FREQUENCY 1.0 ☐ 2.25 ☒ 5.0 ☐
OTHER ☐ _____
JACK (R) T
REP RATE 1K
FILTER Hi
DAMPING Med
VIDEO (NORMAL)/DIFFERENTIAL
REJECT (OFF)
SWEEP DELAY n/a COARSE
140 FINE
RANGE 10
MATERIAL CALIBRATION 8.52
SWEEP DIAL n/a
SWEEP RATIO n/a
CALIBRATION SHEET ~~13~~ 1 Unclear
N-2.4.4.111(a)
Figure D

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Page 2 of 25

N-2.4.4.111(a)
Figure E

WELD SCAN DATA SHEET

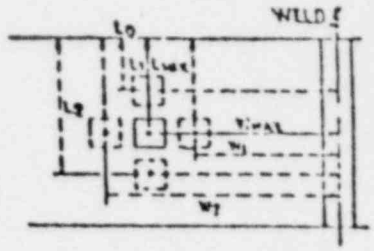
CONTRACT NO. 2867 SEAM, PIECE OR CODE NO. 316-02-1 I.D. ☐ O.D. ☒ DATE 1/21/76

CALIBRATION SHEET NO. 1 (reviewed) SHEET NO. 1 OF 1 TIME 0830

SEAM LENGTH 360°

TEST PARAMETER: START 0° END 360° INSPECTORS R. Wille II & S. Wells II

START ____ END ____ #7 - CW shee



(L) measured from: Top of Nozzle Body TYPE OF TEST HAZ ☐ 45° ☒ 60° ☐

L1			L	L2				W1				W	W2				MP				MP	MP			DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW
20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max	

PSLRef. No. RPV-12
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SCAN COMPLETE ☒ NO REPORTABLE INDICATIONS ☒

SCAN INCOMPLETE ☐ REPORTABLE INDICATIONS ☐

NDE Pa H

Reviewed
W J Caldwell ANII HSB
4-8-81

NUC C LITY ASSURANCE

COMBUSTION ENGINEERING, INC.
CHATTANOOGA, TENNESSEE

ULTRASONIC INSPECTION REPORT

☐ INFORMATION
REPORTABLE
Yes ☐ No ☐

☐ ACCEPTAN
☐ Satisfactory
☐ Unsatisfactory

[1] CONTRACT 2867 [4] JOB & CONTROL NO. Y70777-053 [5] SEQ. 50 [6] OPERATION 4278 [7] DATE 1/12/76

[8] COMPONENT: Final Vessel Assy [9] QTY 1 [10] SEAM/PART OR CODE NO.: 316-02-1

[11] TYPE SEAM: GIRTH ☐ LONG ☐ NOZZLE ☒ OTHER _____ [12] REPAIR ☐

[13] M&P SPECIFICATION 2.4.4.111 (a) [14] RECEIVING ☐ [15] IN-PROCESS ☐ [16] FINAL ☒

[17] COMPLETE ☒ [18] INCOMPLETE ☐ [19] NDE EVALUATE _____ [20] REJ. NO. _____ [21] RECORD ☐

[22] INSPECTOR(S) R. Wille II S. Wells II [23] CUSTOMER _____

Received w/ Cobleal ANII 4-8-81 HSB

TEST

BM ☐ 0° - HAZ ☐ 45° ☒ 60° ☐ ____

B.R. ____ % I.D. ☐ O.D. ☒

11W BLOCK ANGLE 45.° (M)

CALIBRATION BLOCK NO. 2867-8"

TRANSDUCER S/N S-64 #8CCW Shoe

CABLE S/N n/a

EQUIPMENT S/N 740916

C-E S/N 9445

PULSER/RECEIVER S/N FTS/KI

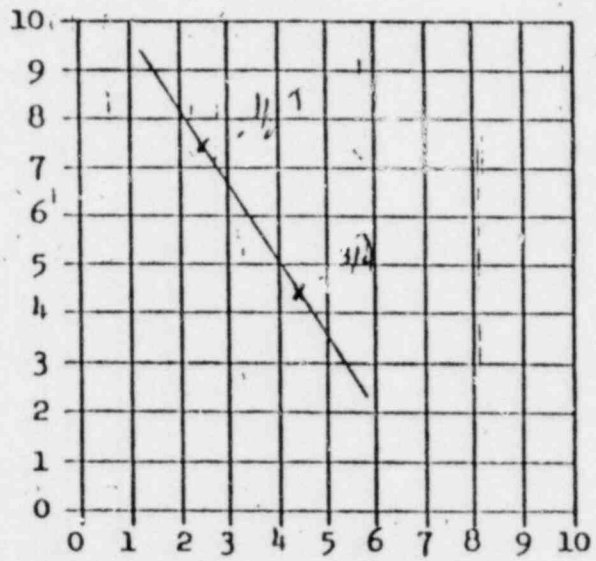
COUPLANT: WATER ☐ GLYCERINE ☒

SILICONE GREASE ☐

TEST TEMPERATURE:

AMBIENT ☒ ELEVATED ☐ ____ °F

DAC



LINEARITY CHECKS

		TIME (MILITARY)	
____	DB @ 10X	0830	____
13	DB @ 5X	0930	____
____	DB @ 2X	____	____
____	DB @ 1/2X		
____	DB @ 1/4X		

INCHES/DIV. 2

SET-UP

SENSITIVITY -1 DB FINE
1-36 DB COARSE
n/a DB DIAL

FREQUENCY 1.0 ☐ 2.25 ☒ 5.0 ☐
OTHER ☐ _____

JACK (R) T

REP RATE 1K

FILTER Hi

DAMPING Med

VIDEO (NORMAL)/DIFFERENTIAL

REJECT (OFF)

SWEEP DELAY n/a COARSE
140 FINE

RANGE 10

MATERIAL CALIBRATION 8.52

SWEEP DIAL n/a

SWEEP RATIO n/a

CALIBRATION SHEET 42

N-2.4.4.111(a)
Figure D

D Wear

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N-2.4.4.111(a)
Figure E

WELD SCAN DATA SHEET

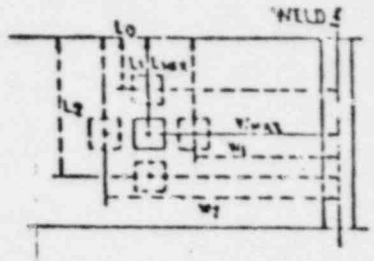
CONTRACT NO. 2867 SEAM, PIECE OR CODE NO. 316-02-1 I.D. ☐ O.D. ☒ DATE 1/12/76

CALIBRATION SHEET NO. 42 SHEET NO. 1 OF 1 TIME 0830

SEAM LENGTH 360° V. Weaver

TEST PARAMETER START 0° END 360° INSPECTORS R. Wille II & S. Walls II

START END #8 CCW SL



*(L) measured from Nec. Body TYPE OF TEST HAZ ☐ 45° ☐ 60° ☐

L1				*L	L2				W1				W	W2				MP				MP	MP				DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW
0	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max	

PSL Ref. No. Rev. 12 Page 5 of 25

SCAN COMPLETE ☒ NO REPORTABLE INDICATIONS ☒

SCAN INCOMPLETE ☐ REPORTABLE INDICATIONS ☐

NDE P.A.

Reviewed W. J. Colbert ANII HSB 4-8-81

NU[illegible] R C [illegible]LITY ASSURANCE
COMBUSTION ENGINEERING, INC.
CHATTANOOGA, TENNESSEE

ULTRASONIC INS[illegible]CT[illegible]N REPORT

☐ INFORMATION
REPORTABLE
Yes ☐ No ☐

☐ ACCEPTA
☐ Satisfactory
☐ Unsatisfactor

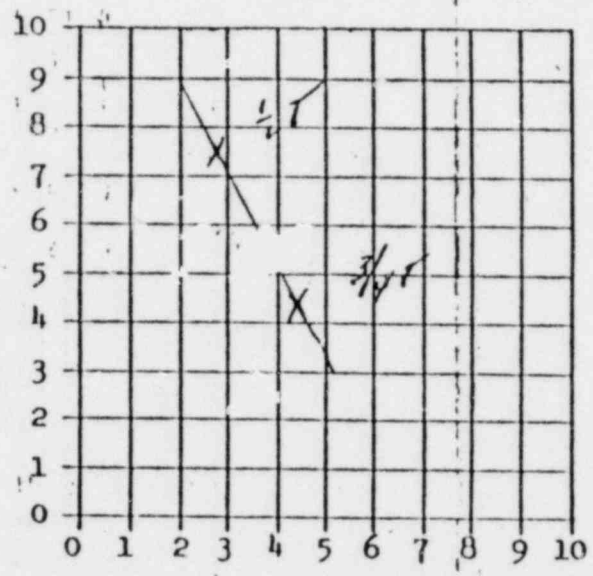
[1] CONTRACT 2867 [2] JOB & CONTROL NO.: V-707-7-053 [3] SEQ. 50 [4] OPERATION 4278 [5] DATE 1/12/86
[6] COMPONENT: Final Vessel assy [7] QTY 1 [10] SEAM PA[illegible]T OR CODE NO.: 316-02-2
[11] TYPE SEAM: GIRTH ☐ LONG ☐ NOZZLE ☒ OTHER Rodins [12] REPAIR ☐
[13] M&P SPECIFICATION 2.4.4.111(b) [14] RECEIVING ☐ [15] IN-PROCESS ☐ [16] FINAL ☒
[17] COMPLETE ☒ [18] INCOMPLETE ☐ [19] NDE EVALUATE _____ [20] REJ. NO. _____ [21] RECORD ☐
[22] INSPECTOR(S) G. Phillips II R. Hartsell II [23] CUSTOMER _____

Reviewed w/ Caldwell NASS 1158 4-8-81

TEST

BM ☐ 0°-HAZ ☐ 45° ☒ 60° ☐ ____
B.R. ____ % I.D. ☐ O.D. ☒
11W BLOCK ANGLE 45°
CALIBRATION BLOCK NO. 2867-8"
TRANSDUCER S/N S-64 #7 CW shoe
CABLE S/N N/A
EQUIPMENT S/N 940916
C-E S/N 9445
PULSER/RECEIVER S/N FTS MK I
COUPLANT: WATER ☐ GLYCERINE ☒
SILICONE GREASE ☐
TEST TEMPERATURE:
AMBIENT ☒ ELEVATED ☐ ____ °F

DAC



LINEARITY CHECKS

		TIME (MILITARY)	
____	DB @ 10X	06:00	____
13	DB @ 5X	06:30	____
____	DB @ 2X	____	____
____	DB @ 1/2X		
____	DB @ 1/4X		

INCHES/DIV. ☒ N/A

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
N/A DB DIAL
FREQUENCY 1.0 ☐ 2.25 ☒ 5.0 ☐
OTHER ☐ _____
JACK (R) T
REP RATE 1K
FILTER Hi
DAMPING med
VIDEO (NORMAL) DIFFERENTIAL
REJECT (OFF)
SWEEP DELAY N/A COARSE
1.40 FINE
RANGE 10
MATERIAL CALIBRATION 8.52
SWEEP DIAL N/A
SWEEP RATIO N/A
CALIBRATION SHEET NO. 3

N-2.4.4.111(b)
Figure D

1306

PSI Ref. No.

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N-2.4.4.11(a)
Figure E

WELD SCAN DATA SHEET

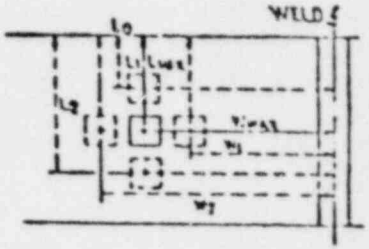
CONTRACT NO. 2867 SEAM, PIECE OR CODE NO. 316-02-2 I.D. ☐ O.D. ☒ DATE 1/12/76

CALIBRATION SHEET NO. 3 SHEET NO. 1 OF 1 TIME 06:00 06:30

SEAM LENGTH 360°

TEST PARAMETER: START 0° CW END 360° CW INSPECTORS G. Phillips II & R. Horton II

START _____ END _____



*(L) measured from: 0°

TYPE OF TEST HAZ ☐ wedge #7 45° ☒ 60° ☐

L1				*L	L2				W1				W	W2				MP				MP	MP				DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW
0	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max	

NF

CAN COMPLETE ☑ NO REPORTABLE INDICATIONS ☑

SCAN INCOMPLETE ☐ REPORTABLE INDICATIONS ☐

NDE Reed

Reviewed W J Caldwell ANII - HSB 4-8-84

PSI Ref. No. RPV-12 Page 1 of 25

NUC[illegible]R C[illegible]LITY ASSURANCE
C[illegible]MBUSTION ENGINEERING, INC.
[illegible]HATTANOOGA, TENNESSEE

ULTRASONIC INS[illegible]ECT[illegible]N REPORT

☐ INFORMATION
REPORTABLE
Yes ☐ No ☐

☐ ACCEPTA
☐ Satisfactory
☐ Unsatisfactor

[1] CONTRACT 2867 [8] JOB & CONTROL NO.: V-7077-053 [9] SEQ. 50 [6] OPERATION 4278 [7] DATE/ 12/1/76
[4] COMPONENT: Final Vessel assy [5] QTY 1 [10] SEAM PART OR CODE NO.: 316-02-2
[11] TYPE SEAM: GIRTH ☐ LONG ☐ NOZZLE ☒ OTHER Bodies [12] REPAIR ☐
[13] M&P SPECIFICATION 2.4.4.111(A) [14] RECEIVING ☐ [15] IN-PROCESS ☐ [16] FINAL ☒
[17] COMPLETE ☒ [18] INCOMPLETE ☐ [19] NDE EVALUATE _____ [20] REJ. NO. _____ [21] RECORD ☐
[22] INSPECTOR(S) G. Phillips II R. Horton II [23] CUSTOMER _____

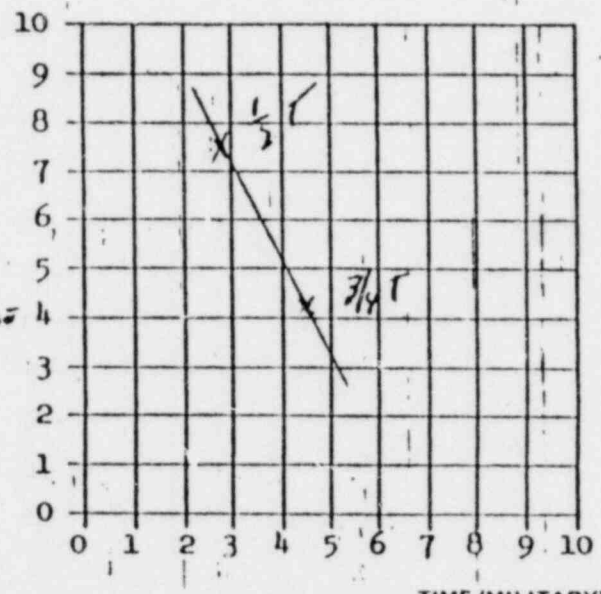
Reviewed
w/ Caldwell AHFF-HSB
4-8-81

TEST

BM ☐ 0° - HAZ ☐ 45° ☒ 60° ☐ ____
B.R. ____ % I.D. ☐ O.D. ☒
11W BLOCK ANGLE 45°
CALIBRATION BLOCK NO. 2867-8"
TRANSDUCER S/N 5-64 #8 cow shot
CABLE S/N N/A
EQUIPMENT S/N 740916
C-E S/N 9445
PULSER/RECEIVER S/N FTS-111KT
COUPLANT: WATER ☐ GLYCERINE ☒
SILICONE GREASE ☐

TEST TEMPERATURE:
AMBIENT ☒ ELEVATED ☐ ____ °F

DAC



LINEARITY CHECKS
____ DB @ 10X
13 DB @ 5X
____ DB @ 2X
____ DB @ 1/2X
____ DB @ 1/4X

TIME (MILITARY)
05:30 ____
06:00 ____
____ ____

INCHES/DIV.
N/A

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
N/A DB DIAL

FREQUENCY 1.0 ☐ 2.25 ☒ 5.0 ☐
OTHER ☐ ____

JACK (R) T
REP RATE 1K
FILTER Hi
DAMPING Med
VIDEO (NORMAL) DIFFERENTIAL
REJECT (OFF)
SWEEP DELAY N/A COARSE
1.40 FINE
RANGE 10
MATERIAL CALIBRATION 8.52
SWEEP DIAL N/A
SWEEP RATIO N/A
CALIBRATION SHEET NO. 4

N-2.4.4.111(a)
Figure D

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RPV-12
Page 8 of 25

N-2.4.4.111(b)
Figure E

WELD SCAN DATA SHEET

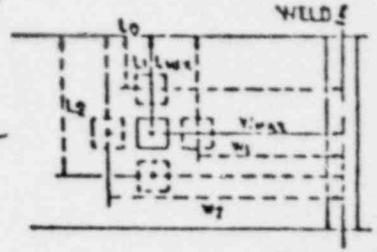
CONTRACT NO. 2869 SEAM, PIECE OR CODE NO. 316-02-2 I.D. ☐ O.D. ☒ DATE 1/21/76

CALIBRATION SHEET NO. 4 SHEET NO. 1 OF 1 TIME 05:30 06:00

SEAM LENGTH 360°

TEST PARAMETER: START 0° CCW END 360° CCW INSPECTORS G. Phillips II & L. Hosler II

START ____ END ____



*(L) measured from: 0° TYPE OF TEST HAZ ☐ 45° ☒ 60° ☐ wedge #8

L1				*L	L2				W1				W	W2				MP				MP	MP				DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW
10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max	

PSI Ref. No. RPV-12
Page 9 of 25

SCAN COMPLETE ☒ NO REPORTABLE INDICATIONS ☒
SCAN INCOMPLETE ☐ REPORTABLE INDICATIONS ☐

NDE Pell

Reviewed
W J Caldwell ANII - HSB
4-8-81

UCLE[illegible] LITY ASSURANCE
OMBUSTION ENGINEERING, INC.
CHATTANOOGA, TENNESSEE

ULTRASONIC INSPE[illegible]N REPORT

☐ INFORMATION
REPORTABLE
Yes ☐ No ☐

☒ ACCEPTANC
☒ Satisfactory
☐ Unsatisfactory

[3] CONTRACT 2867 [4] JOB & CONTROL NO.: V-70777-053 [5] SEQ. 50 [6] OPERATION 4278 [7] DATE 1/21/76
[8] COMPONENT: Final Vessel assy [9] QTY 1 [10] SEAM, PART OR CODE NO.: 316-02-3
[11] TYPE SEAM: GIRTH ☐ LONG ☐ NOZZLE ☒ OTHER Radius [12] REPAIR ☐
[13] M&P SPECIFICATION 2.4.4.111(A) [14] RECEIVING ☐ [15] IN-PROCESS ☐ [16] FINAL ☒
[17] COMPLETE ☒ [18] INCOMPLETE ☐ [19] NDE EVALUATE _____ [20] REJ. NO. _____ [21] RECORD ☐
[22] INSPECTOR(S) G. Phillips II R. Ristad II [23] CUSTOMER _____

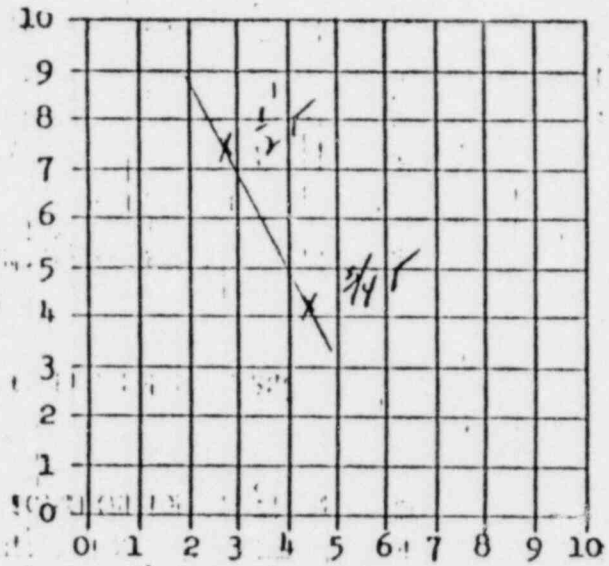
Reviewed
Wm Caldwell ANII - HSB
4-8-81

TEST

BM ☐ 0° - HAZ ☐ 45° ☒ 60° ☐ ____
B.R. ____ % I.D. ☐ O.D. ☒
1.1W BLOCK ANGLE 45°
CALIBRATION BLOCK NO. 2867-8
TRANSDUCER S/N S-64 #7 shoe cw
CABLE S/N N/A
EQUIPMENT S/N 240916
C-E S/N 9445
PULSER/RECEIVER S/N FYS-MKI
COUPLANT: WATER ☐ GLYCERINE ☒
SILICONE GREASE ☐

TEST TEMPERATURE:
AMBIENT ☒ ELEVATED ☐ ____ °F

DAC



LINEARITY CHECKS

____	DB @ 10X
13	DB @ 5X
____	DB @ 2X
____	DB @ 1/2X
____	DB @ 1/4X

TIME (MILITARY)
04:30 ____
05:30 ____
____ ____

INCHES/DIV.
1"

SET-UP

SENSITIVITY ±1 DB FINE
+30 DB COARSE
N/A DB DIAL

FREQUENCY 1.0 ☐ 2.25 ☒ 5.0 ☐
OTHER ☐ _____

JACK (R) T
REP RATE 1K
FILTER Hi
DAMPING Med
VIDEO (NORMAL) DIFFERENTIAL
REJECT (OFF)
SWEEP DELAY N/A COARSE
6.40 FINE
RANGE 10
MATERIAL CALIBRATION 8.52
SWEEP DIAL N/A
SWEEP RATIO N/A
CALIBRATION SHEET 5

N-2.4.4.111(a)
Figure D

1308
PSI Ref. No.
RPV-12
Page 10 of 25

N-2.4.4.111(a)
Figure E

WELD SCAN DATA SHEET

CONTRACT NO. 2867 SEAM, PIECE OR CODE NO. 316-01-3 I.D. ☐ O.D. ☒ DATE 1/12/76

CALIBRATION SHEET NO. 5 SHEET NO. 1 OF 1 TIME 04:30 05:30

SEAM LENGTH 360°

TEST PARAMETER: START 0° cw END 360° cw INSPECTORS G. Phillips II & R. Hartford II

START ____ END ____

Wedge #7

*(L) measured from: 0°

TYPE OF TEST HAZ ☐ 45° ☒ 60° ☐

*L1				*L	L2				W1				W	W2				MP				MP	MP				DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW
0	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max	

CAN COMPLETE ☒ NO REPORTABLE INDICATIONS ☒

SCAN INCOMPLETE ☐ REPORTABLE INDICATIONS ☐

NDE [illegible]

Removed w/ Calibrated ANSI-1458 7-8-81

NUCLEAR QUALITY ASSURANCE
COMBUSTION ENGINEERING, INC.
CHATTANOOGA, TENNESSEE

ULTRASONIC INSPECTION REPORT

☐ INFORMATION — REPORTABLE Yes ☐ No ☐

☐ ACCEPTANCE — ☐ Satisfactory ☐ Unsatisfactory

CONTRACT: 2867 JOB & CONTROL NO.: U-70777-053 SEQ. 50 OPERATION 4278 DATE 1/12/76

COMPONENT: Fuel Vessel Ass'y QTY 1 SEAM, PART OR CODE NO.: 316-02-3

TYPE SEAM: GIRTH ☐ LONG ☐ NOZZLE ☒ OTHER Radius REPAIR ☐

M&P SPECIFICATION 2.4.4.111 A RECEIVING ☐ IN-PROCESS ☐ FINAL ☒

COMPLETE ☒ INCOMPLETE ☐ NDE EVALUATE _____ REJ. NO. _____ RECORD ☐

INSPECTOR(S) G. Phillips & R. Ainsworth CUSTOMER _____

Removed w/ Caldwell ANII - HSB 4-8-81

TEST

BM ☐ 0° HAZ ☐ 45° ☒ 60° ☐ ____

B.R. ____ % I.D. ☐ O.D. ☒

11W BLOCK ANGLE 45°

CALIBRATION BLOCK NO. 2867-8

TRANSDUCER S/N S-64 #8 shoe ccw

CABLE S/N N/A

EQUIPMENT S/N 740916

C.E. S/N 9445

PULSER/RECEIVER S/N ATS-11K-5

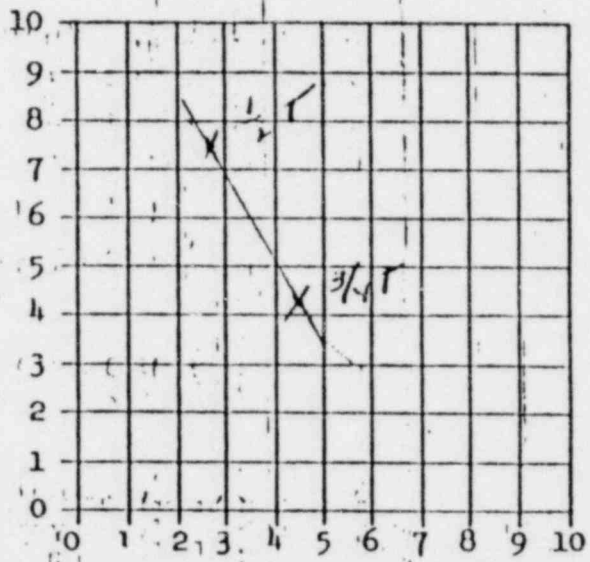
COUPLANT: WATER ☐ GLYCERINE ☒

SILICONE GREASE ☐

TEST TEMPERATURE:

AMBIENT ☒ ELEVATED ☐ ____ °F

DAC



LINEARITY CHECKS

		TIME (MILITARY)
____	DB @ 10X	04:00 ____
13	DB @ 5X	04:30 ____
____	DB @ 2X	____ ____
____	DB @ 1/2X	
____	DB @ 1/4X	

INCHES/DIV. 1"

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
N/A DB DIAL

FREQUENCY 1.0 ☐ 2.25 ☒ 5.0 ☐ OTHER ☐ ____

JACK (R) T

REP RATE 1K

FILTER N/A

DAMPING med

VIDEO (NORMAL) DIFFERENTIAL

REJECT (OFF)

SWEEP DELAY N/A COARSE
1.40 FINE

RANGE 10

MATERIAL CALIBRATION 8.5V

SWEEP DIAL N/A

SWEEP RATIO N/A

CALIBRATION SHEET NO. 6

N-2.4.4.111(a)
Figure D

1309 PSI Ref. No. RPV-12
Page 12 of 25

N-2.4.4.111(a)
Figure E

WELD SCAN DATA SHEET

CONTRACT NO. 2867 SEAM, PIECE OR CODE NO. 316-02-3 I.D. ☐ O.D. ☒ DATE 1/12/76

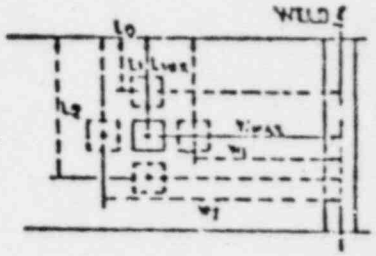
CALIBRATION SHEET NO. 6 SHEET NO. 1 OF 1 TIME 04:00 04:30

SEAM LENGTH 360°

TEST PARAMETER: START 0° ccw END 360° ccw INSPECTORS G. Phillips II & L. Lobsiod II

START _____ END _____

wedge #8



*(L) measured from: 0°

TYPE OF TEST HAZ ☐ 45° ☒ 60° ☐

L1				*L	L2				W1				W	W2				MP				MP	MP				DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW
0	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max	

45°

Est. Ref. Not Rev. Le

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SCAN COMPLETE ☑ NO REPORTABLE INDICATIONS ☑

SCAN INCOMPLETE ☐ REPORTABLE INDICATIONS ☐

NDE Fred

Reviewed W J Caldwell AMIF - HSB 4-8-81

NUCLEAR QUALITY ASSURANCE
COMBUSTION ENGINEERING, INC.
CHATTANOOGA, TENNESSEE

ULTRASONIC INSPECTION REPORT

1 ☐ INFORMATION — REPORTABLE Yes ☐ No ☐

2 ☐ ACCE — ☐ Satisfact ☐ Unsatisf.

3 CONTRACT 2867 4 JOB & CONTROL NO.: V-70777-053 5 SEQ. 50 6 OPERATION 4278 7 DATE 1121

8 COMPONENT: FINAL VESSEL ASSY 9 QTY 1 10 SEAM, ~~PART OR CODE~~ NO.: 316-02-4

11 TYPE SEAM: GIRTH ☐ LONG ☐ NOZZLE ☒ OTHER ____ 12 REPAIR ☐

13 M&P SPECIFICATION 2.4.4.111(a) 14 RECEIVING ☐ 15 IN-PROCESS ☐ 16 FINAL ☒

17 COMPLETE ☒ 18 INCOMPLETE ☐ 19 NDE EVALUATE ____ 20 REJ. NO. ____ 21 RECORD ☐

22 INSPECTOR(S) R. WILLE II S. WELLS II 23 CUSTOMER ____

Reviewed W J Caldwell ANFT-NSB 4-8-81

TEST

BM ☐ 0° - HAZ ☐ 45° ☒ 60° ☐ ____

B.R. ____ % I.D. ☐ O.D. ☒

11W BLOCK ANGLE 45°

CALIBRATION BLOCK NO. 2867-8

TRANSDUCER S/N 5-64 #7cw

CABLE S/N N/a

EQUIPMENT S/N FTS 740916

C-E S/N 9445

PULSER/RECEIVER S/N FTS MARK I

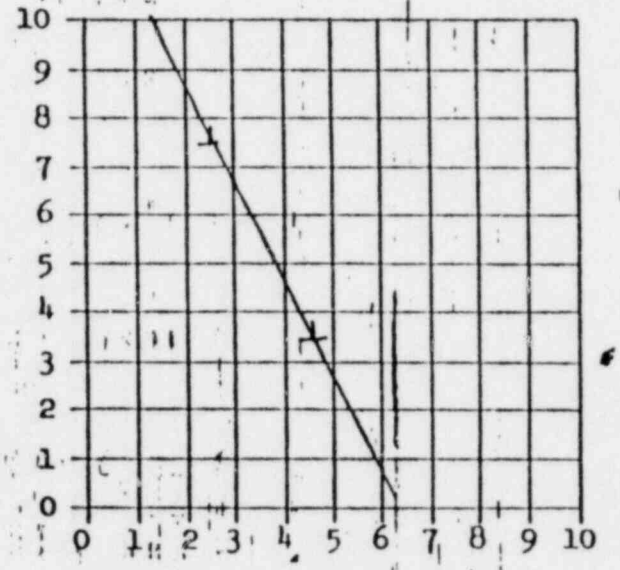
COUPLANT: WATER ☐ GLYCERINE ☒

SILICONE GREASE ☒

TEST TEMPERATURE:

AMBIENT ☒ ELEVATED ☐ ____ °F

DAC



LINEARITY CHECKS

____ DB @ 10X
13 DB @ 5X
____ DB @ 2X
____ DB @ 1/2X
____ DB @ 1/4X

TIME (MILITARY)

1300 ____
1330 ____

INCHES/DIV. 2

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
N/a DB DIAL

FREQUENCY 1.0 ☐ 2.25 ☒ 5
OTHER ☐ ____

JACK (R) T

REP RATE 1K

FILTER HI

DAMPING MED

VIDEO (NORMAL) DIFFERENTIAL

REJECT (OFF)

SWEEP DELAY N/a COAR
1.40 FINE

RANGE 10

MATERIAL CALIBRATION 8.52

SWEEP DIAL N/a

SWEEP RATIO N/a

CALIBRATION STD. NO. 7
N-2.4.4.111(a), Figure D

1311

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N-2.4.4.111(a)
Figure E

WELD SCAN DATA SHEET

CONTRACT NO. 2867 SEAM, PIECE OR CODE NO. 316-02-4 I.D. ☐ O.D. ☒ DATE 1/21/76

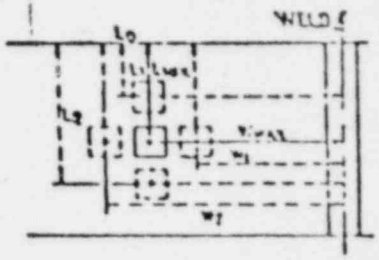
CALIBRATION SHEET NO. 7 SHEET NO. 1 OF 1 TIME 1300

SEAM LENGTH 360°

TEST PARAMETER: START 0° END 360° INSPECTORS R. WILLE III & S. WELLS

START ____ END ____ HT CW floor

L1 measured from: TOP OF NOZZLE BODY TYPE OF TEST HAZ ☐ 45° ☒ 60° ☐



L1			*L	L2				W1				W	W2				MP				MP	MP			DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW
20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max	
	40																										

PSI Ref. No. RPV-12 Page 5 of 25

AN COMPLETE, ☒ NO REPORTABLE INDICATIONS ☒

SCAN INCOMPLETE ☐ REPORTABLE INDICATIONS ☐

NDE Pad

Reviewed
W J Gallivan ANII - HSB
4-8-81

NUCLEAR C LITY ASSURANCE
COMBUSTION ENGINEERING, INC.
CHATTANOOGA, TENNESSEE

ULTRASONIC INSPECT, N REPORT

1 ☐ INFORMATION
REPORTABLE Yes ☐ No ☐

2 ☐ ACCI
☐ Satisfact
☐ Unsatisf

3 CONTRACT 2867 4 JOB & CONTROL NO.: V-70777-053 5 SEQ. 50 6 OPERATION 4278 7 DATE 1 12

8 COMPONENT: FINAL VESSEL Assy 9 QTY 1 10 SEAM, ~~PART OR CODE~~ NO.: 316-02-4

11 TYPE SEAM: GIRTH ☐ LONG ☐ NOZZLE ☒ OTHER ____ 12 REPAIR ☐

13 M&P SPECIFICATION 2.4.4.111(a) 14 RECEIVING ☐ 15 IN-PROCESS ☐ 16 FINAL ☐

17 COMPLETE ☒ 18 INCOMPLETE ☐ 19 NDE EVALUATE ____ 20 REJ. NO. ____ 21 RECORD ☐

22 INSPECTOR(S) R. WILLE II S. WELLS II 23 CUSTOMER ____

Reviewed W J Caldwell 9HFT- MSB 4-8-81

TEST

BM ☐ 0° - HAZ ☐ 45° ☒ 60° ☐ ____

B.R. ____ % I.D. ☐ O.D. ☒

11W BLOCK ANGLE 45°

CALIBRATION BLOCK NO. 2867-8"

TRANSDUCER S/N 5-64 #8 CEW

CABLE S/N n/a

EQUIPMENT S/N 740916

C-E S/N 9445

PULSER/RECEIVER S/N FIS MARK I

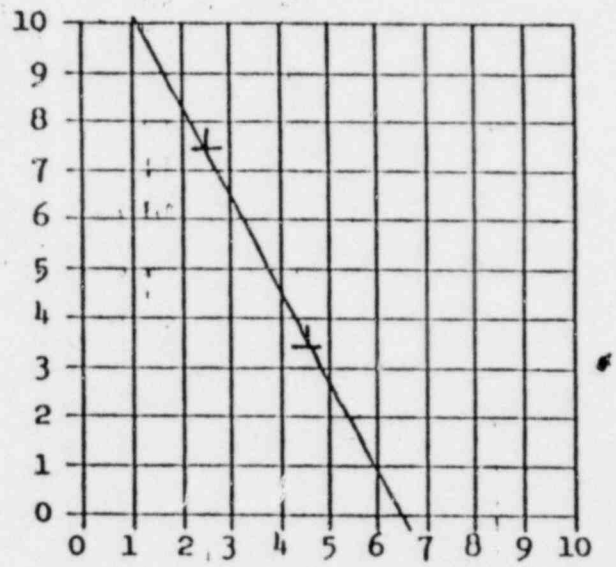
COUPLANT: WATER ☐ GLYCERINE ☐

SILICONE GREASE ☐

TEST TEMPERATURE:

AMBIENT ☒ ELEVATED ☐ ____ °F

DAC



LINEARITY CHECKS

		TIME (MILITARY)	
____	DB @ 10X	1300	____
13	DB @ 5X	1330	____
____	DB @ 2X	____	____
____	DB @ 1/2X		
____	DB @ 1/4X		

INCHES/DIV. 2"

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
n/a DB DIAL

FREQUENCY 1.0 ☐ 2.25 ☒ 5
OTHER ☐ ____

JACK (R) T

REP RATE 1K

FILTER Hi

DAMPING MED

VIDEO (NORMAL) DIFFERENTIAL

REJECT (OFF)

SWEEP DELAY n/a COAR
1.40 FINE

RANGE 10

MATERIAL CALIBRATION 2.5

SWEEP DIAL n/a

SWEEP RATIO n/a

CALIBRATION SET NO. 8
N-2.4.4.111(a,
Figure D

1C10

PSI Ref. No. RPV-12
Page 16 of 25

N-2.4.4.111(a)
Figure E

WELD SCAN DATA SHEET

CONTRACT NO. 2867 SEAM, PIECE ~~OR CODE~~ NO. 316-02-4 I.D. ☐ O.D. ☒ DATE 1/21/76

CALIBRATION SHEET NO. 8 SHEET NO. 1 OF 1 TIME 1300

SEAM LENGTH 360°

TEST PARAMETER START 0° END 360° INSPECTORS R. Wille II & S. Wells II

START ____ END ____

#8 CCW Shaft

(L) measured from TOP OF NOZZLE BOSS TYPE OF TEST HAZ ☐ 45° ☒ 60° ☐

L1			L	L2				W1				W	W2				MP				MP	MP			DAC	X R FILM NO. TOP OR BOTTOM CW OR CCW
20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max	

PSI Ref. No. RPV-12
Page 17 of 25

SCAN COMPLETE ☒ NO REPORTABLE INDICATIONS ☒
SCAN INCOMPLETE ☐ REPORTABLE INDICATIONS ☐

NDE Paul

Reviewed by J Caldwell ANII HSB 4-8-81

NUCL C LITY ASSURANCE
COMBUSTION ENGINEERING, INC.
CHATTANOOGA, TENNESSEE

ULTRASONIC INS CT N REPORT

☐ INFORMATION
REPORTABLE Yes ☐ No ☐

☐ ACCEPTAN
☐ Satisfactory
☐ Unsatisfactory

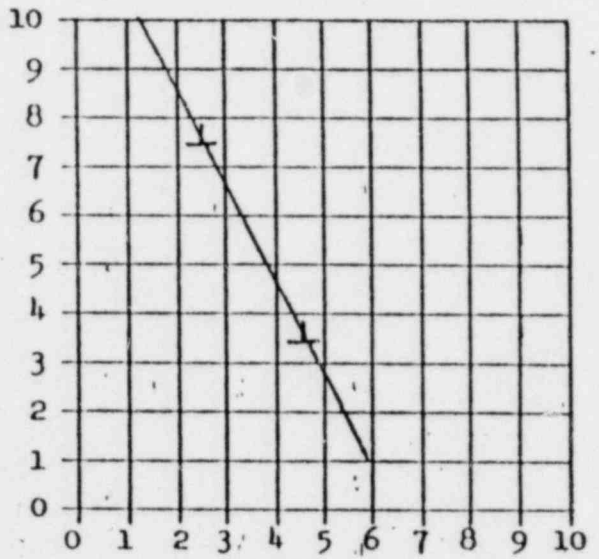
[3] CONTRACT 2867 [4] JOB & CONTROL NO.: V-70777-053 [5] SEQ. 50 [6] OPERATION 4278 [7] DATE 1/21/76
[8] COMPONENT: FINAL VESSEL ASSY [9] QTY 1 [10] SEAM, ~~PART OR CODE~~ NO.: 316-02-5
[11] TYPE SEAM: GIRTH ☐ LONG ☐ NOZZLE ☒ OTHER ____ [12] REPAIR ☐
[13] M&P SPECIFICATION 2.4.4 111(a) [14] RECEIVING ☐ [15] IN-PROCESS ☐ [16] FINAL ☒
[17] COMPLETE ☒ [18] INCOMPLETE ☐ [19] NDE EVALUATE ____ [20] REJ. NO. ____ [21] RECORD ☐
[22] INSPECTOR(S) R. WILLE II S. WELLS II [23] CUSTOMER ____

W J Caldwell AN II - HSB
4-8-81

TEST

BM ☐ 0° - HAZ ☐ 45° ☒ 60° ☐ ____
B.R. ____ % I.D. ☐ O.D. ☒
11W BLOCK ANGLE 45 °
CALIBRATION BLOCK NO. 2867-8
TRANSDUCER S/N S-64 #8 CCW SHOE
CABLE S/N N/a
EQUIPMENT S/N 740916
C-E S/N 9445
PULSER/RECEIVER S/N FT3 MARK II
COUPLANT: WATER ☐ GLYCERINE ☒
SILICONE GREASE ☐
TEST TEMPERATURE:
AMBIENT ☒ ELEVATED ☐ ____ °F

DAC



LINEARITY CHECKS

		TIME (MILITARY)	
	DB @ 10X	1100	
		1130	
13	DB @ 5X		
	DB @ 2X		
	DB @ 1/2X		
	DB @ 1/4X		

INCHES/DIV. 2

SET-UP

SENSITIVITY -1 DB FINE
150 DB COARSE
N/a DB DIAL
FREQUENCY 1.0 ☐ 2.25 ☒ 5.0 ☐
OTHER ☐ ____
JACK (R) T
REP RATE 1K
FIL. 5 Hi
DAMPING MED
VIDEO (NORMAL) DIFFERENTIAL
REJECT (OFF)
SWEEP DELAY N/a COARSE
1.40 FINE
RANGE 10
MATERIAL CALIBRATION 8.52
SWEEP DIAL N/a
SWEEP RATIO N/a
CALIBRATION SHEET NO 9

N-2.4.4.111(a)
Figure D

1312 PSI Ref. No.

N-2.4.4.11(a)
Figure E

WELD SCAN DATA SHEET

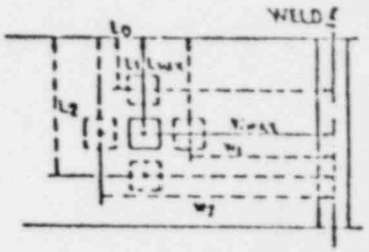
CONTRACT NO. 2867 SEAM, ~~PIECE OR CODE~~ NO. 316-02-5 I.D. ☐ O.D. ☒ DATE 1/21/76

CALIBRATION SHEET NO. 9 SHEET NO. 1 OF 1 TIME 1100

SEAM LENGTH 360°

TEST PARAMETER: START 0° END 360° INSPECTORS L. WILLE II & S. WELLS II

START ____ END ____



*(L) measured from: TOP OF NOZZLE BODY TYPE OF TEST HAZ ☐ 45° ☒ 60° ☐

L1				*L	L2				W1				W	W2				MP				MP	MP				DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW
10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max	

466

PSI Ref. No. Rev-2
Page 19 of 25

SCAN COMPLETE ☒ NO REPORTABLE INDICATIONS ☒
SCAN INCOMPLETE ☐ REPORTABLE INDICATIONS ☐

NDE [illegible]

Reviewed w/ Cal Level ANII - HSB 4-8-81

NU[illegible] R C LITY ASSURANCE
COMBUSTION ENGINEERING, INC.
CHATTANOOGA, TENNESSEE

ULTRASONIC IN[illegible]CT[illegible]N REPORT

☐ INFORMATION
REPORTABLE Yes ☐ No ☐

☐ ACCEPTA
☐ Satisfactory
☐ Unsatisfactor

CONTRACT 2867 JOB & CONTROL NO.: V-70777-053 SEQ. 50 OPERATION 4278 DATE 1/21/76
COMPONENT: FINAL VESSEL ASSY QTY 1 SEAM, ~~PART OR CODE~~ NO.: 316-02-5
TYPE SEAM: GIRTH ☐ LONG ☐ NOZZLE ☒ OTHER ____ REPAIR ☐
M&P SPECIFICATION 2:4.4:111(a) RECEIVING ☐ IN-PROCESS ☐ FINAL ☒
COMPLETE ☒ INCOMPLETE ☐ NDE EVALUATE ____ REJ. NO. ____ RECORD ☐
INSPECTOR(S) R. WILLE II S. WELLS II CUSTOMER ____

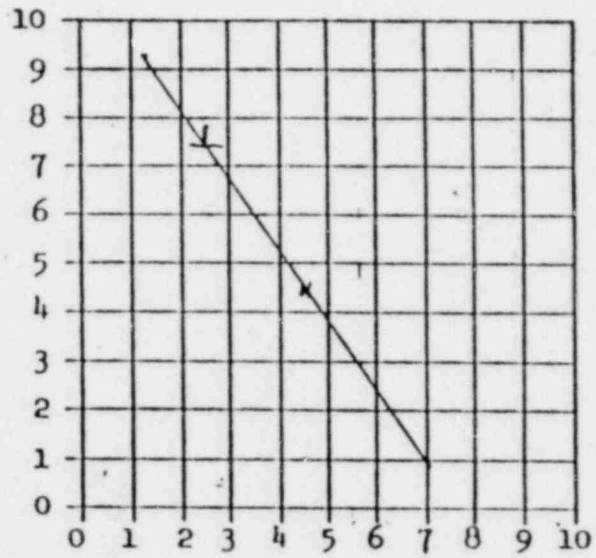
Reviewed
W J Caldwell ANFF - NSB
4-8-81

TEST

BM ☐ 0°-HAZ ☐ 45° ☒ 60° ☐ ____
B.R. ____ % I.D. ☐
11W BLOCK ANGLE 45°
CALIBRATION BLOCK NO. 2867-8"
TRANSDUCER S/N 5-64 #7 Curshoe
CABLE S/N N/a
EQUIPMENT S/N 740916
C-E S/N 9445
PULSER/RECEIVER S/N FIS MARK I
COUPLANT: WATER ☐ GLYCERINE ☒
SILICONE GREASE ☐

TEST TEMPERATURE:
AMBIENT ☒ ELEVATED ☐ ____ °F

DAC



LINEARITY CHECKS
____ DB @ 10X
13 DB @ 5X
____ DB @ 2X
____ DB @ 1/2X
____ DB @ 1/4X

TIME (MILITARY)
1100 ____
1130 ____
____ ____

INCHES/DIV. 2

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
N/a DB DIAL
FREQUENCY 1.0 ☐ 2.25 ☒ 5.0 ☐
OTHER ☐ ____
JACK (R) T
REP RATE 1K
FILTER Hi
DAMPING MED
VIDEO (NORMAL) DIFFERENTIAL
REJECT (OFF)
SWEEP DELAY N/a COARSE
1.40 FINE
RANGE 10
MATERIAL CALIBRATION 8.57
SWEEP DIAL N/a
SWEEP RATIO N/a
CALIBRATION SHEET ** 10

N-2.4.4.111(a)
Figure D

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RPV-12
Page 20 of 25

N-2.4.4.111(a)
Figure E

WELD SCAN DATA SHEET

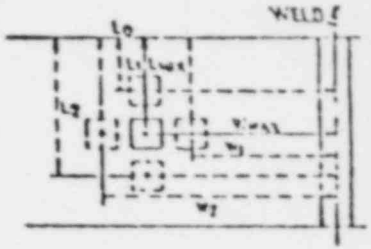
CONTRACT NO. 2867 SEAM, ~~PIECE OR CODE~~ NO. 316-02-5 I.D. ☐ O.D. ☒ DATE 1/21/79

CALIBRATION SHEET NO. 10 SHEET NO. 1 OF 1 TIME 1100

SEAM LENGTH 360°

TEST PARAMETER: START 0° END 360° INSPECTORS R. Wille II & S. Wells II

START _____ END _____



*(L) measured from Top of Nozzle Body TYPE OF TEST HAZ ☐ 45° ☒ 60° ☐

L1				*L	L2				W1				W	W2				MP				MP	MP				DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW
10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max	

PSI Ref. No. RPV-112 Page 21 of 25

SCAN COMPLETE ☒ NO REPORTABLE INDICATIONS ☒
SCAN INCOMPLETE ☐ REPORTABLE INDICATIONS ☐

NDE P.H.

Reviewed w/ Carroll AII-MSB 4-8-81

NUCLEAR QUALITY ASSURANCE
COMBUSTION ENGINEERING, INC.
CHATTANOOGA, TENNESSEE

ULTRASONIC INSPECTION REPORT

☐ INFORMATION
REPORTABLE Yes ☐ No ☐

☐ ACCEPTANCE
☐ Satisfactory
☐ Unsatisfactory

CONTRACT 2867 JOB & CONTROL NO.: V-10772-053 SEQ. 50 OPERATION 4228 DATE 1/21/76
COMPONENT: Final Vessel Assy QTY 1 SEAM PART OR CODE NO.: 316-02-6
TYPE SEAM: GIRTH ☐ LONG ☐ NOZZLE ☒ OTHER ____ REPAIR ☐
M&P SPECIFICATION 2.4.4.111 (a) RECEIVING ☐ IN-PROCESS ☐ FINAL ☒
COMPLETE ☒ INCOMPLETE ☐ NDE EVALUATE ____ REJ. NO. ____ RECORD ☐
INSPECTOR(S) R. Wills II S. Walls II CUSTOMER ____

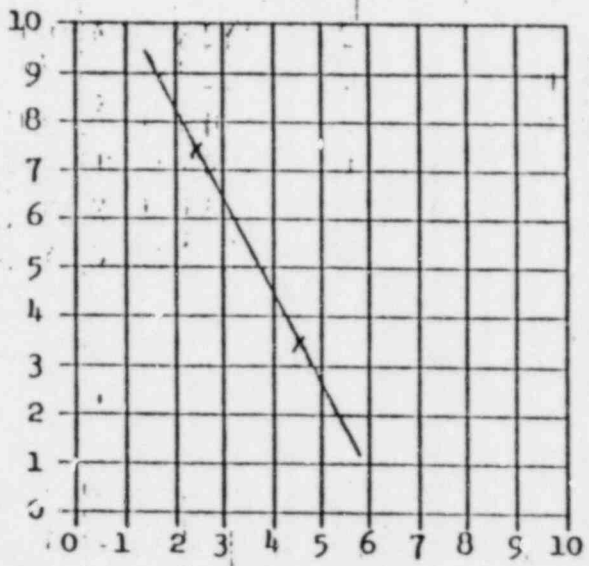
Reviewed w/ Caldwell NII II HSB 4-8-81

TEST

BM ☐ 0° HAZ ☐ 45° ☒ 60° ☐ ____
B.R. ____ % I.D. ☐ O.D. ☒
11W BLOCK ANGLE 45°
CALIBRATION BLOCK NO. 2867-8"
TRANSDUCER S/N 5-64 #7-Cw Shoe
CABLE S/N n/a
EQUIPMENT S/N 74091
C-E S/N 9445
PULSER/RECEIVER S/N ETS/MKI
COUPLANT: WATER ☐ GLYCERINE ☒
SILICONE GREASE ☐

TEST TEMPERATURE:
AMBIENT ☒ ELEVATED ☐ ____ °F

DAC



LINEARITY CHECKS
____ DB @ 10X
13 DB @ 5X
____ DB @ 2X
____ DB @ 1/2X
____ DB @ 1/4X

TIME (MILITARY)
1032
1130

INCHES/DIV. 2

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
n/a DB DIAL
FREQUENCY 1.0 ☐ 2.25 ☒ 5.0 ☐
OTHER ☐ ____
JACK (R) T
REP RATE 1K
FILTER 4i
DAMPING Med
VIDEO (NORMAL)/DIFFERENTIAL
REJECT (OFF)
SWEEP DELAY n/a COARSE
1.40 FINE
RANGE 10
MATERIAL CALIBRATION 8.52
SWEEP DIAL n/a
SWEEP RATIO n/a
CALIBRATION SHEET NO. 11
N-2.4.4.111(a)
Figure D

1314 PSJ Ref. No. RPV-12
Page 22 of 25

N-2.4.4.111(a)
Figure E

WELD SCAN DATA SHEET

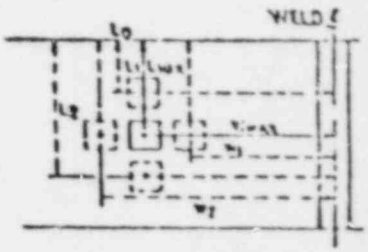
CONTRACT NO. 2867 SEAM, PIECE OR CODE NO. 316-026 I.D. ☐ O.D. ☒ DATE 1/21/76

CALIBRATION SHEET NO. 11 SHEET NO. 11 OF 1 TIME 1030

SEAM LENGTH 360°

TEST PARAMETER: START 0° END 360° INSPECTORS R. Willett & S. Wells II

START ____ END ____ #7 Cw Shoe



*(L) measured from: Top of Nozzle Edge TYPE OF TEST HAZ ☐ 45° ☒ 60° ☐

L1				*L	L2				W1				W	W2				MP				MP	MP				DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW
10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max	

476

ESI Ref. No. 5 RPV-12 Page 23 of 23

SCAN COMPLETE ☒ NO REPORTABLE INDICATIONS ☒

SCAN INCOMPLETE ☐ REPORTABLE INDICATIONS ☐

NDE [illegible]

Reviewed
W D Caldwell MNI NSB
4-8-81

NUCLEAR QUALITY ASSURANCE
COMBUSTION ENGINEERING, INC.
CHATTANOOGA, TENNESSEE

ULTRASONIC INSPECTION REPORT

☐ INFORMATION
REPORTABLE Yes ☐ No ☐

☑ ACCEPTANCE
☒ Satisfactory
☐ Unsatisfactory

CONTRACT: 2867 JOB & CONTROL NO.: V-70777-053 SEQ. 50 OPERATION 4278 DATE 1/12/76
COMPONENT: Final Vessel Assy QTY 1 SEAM, PART OR CODE NO.: 316-02-6
TYPE SEAM: GIRTH ☐ LONG ☐ NOZZLE ☒ OTHER ____ REPAIR ☐
M&P SPECIFICATION 2.4.4.111 (a) RECEIVING ☐ IN-PROCESS ☐ FINAL ☑
COMPLETE ☒ INCOMPLETE ☐ NDE EVALUATE ____ REJ. NO. ____ RECORD ☐
INSPECTOR(S) R. Ville II S. Wells II CUSTOMER ____

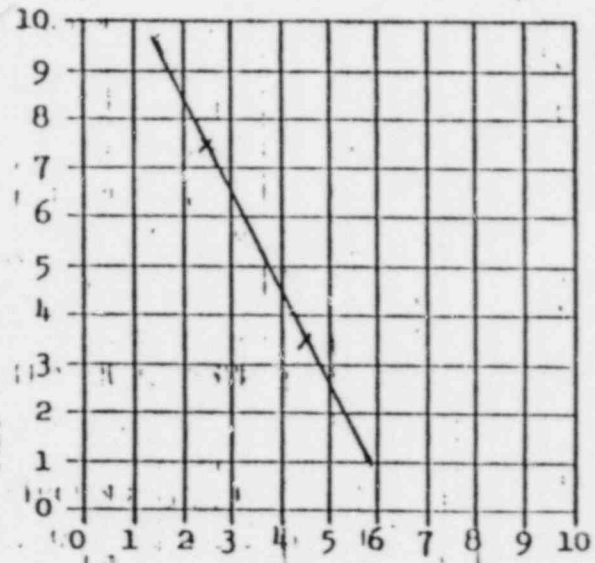
Reviewed w/ Caldwell ANII - HSB 4-8-81

TEST

BM ☐ 0° - HAZ ☐ 45° ☒ 60° ☐ ____
B.R. ____ % I.D. ☐ O.D. ☒
11W BLOCK ANGLE 45°
CALIBRATION BLOCK NO. 2867-8"
TRANSDUCER S/N S-6c #Screw Shoe
CABLE S/N N.a.
EQUIPMENT S/N 7409V6
C-E S/N 9445
PULSER/RECEIVER S/N FTS/MKII
COUPLANT: WATER ☐ GLYCERINE ☑
SILICONE GREASE ☐

TEST TEMPERATURE:
AMBIENT ☒ ELEVATED ☐ ____ °F

DAC



LINEARITY CHECKS

		TIME (MILITARY)
	N	1030
	DB @ 10X	1130
13	DB @ 5X	
	DB @ 2X	
	DB @ 1/2X	
	DB @ 1/4X	

INCHES/DIV. 2

SET-UP

SENSITIVITY -1 DB FINE
+30 DB COARSE
n/a DB DIAL
FREQUENCY 1.0 ☐ 2.25 ☒ 5.0 ☐
OTHER ☐ ____
JACK (R) T
REP RATE 1K
FILTER H1
DAMPING Med
VIDEO (NORMAL) DIFFERENTIAL
REJECT (OFF)
SWEEP DELAY n/a COARSE
1.40 FINE
RANGE 10
MATERIAL CALIBRATION 8.52
SWEEP DIAL n/a
SWEEP RATIO n/a
CALIBRATION SHEET 12

N-2.4.4.111(a)
Figure D

1315 PSI Ref. No. RPV-12
Page 24 of 25

N-2.4.4.111(a)
Figure E

WELD SCAN DATA SHEET

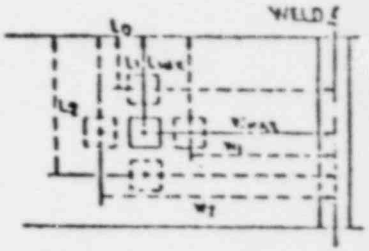
CONTRACT NO. 2867 SEAM, PIECE OR CODE NO. 316-02-6 I.D. ☐ O.D. ☒ DATE 1/21/86

CALIBRATION SHEET NO. 12 SHEET NO. 1 OF 1 TIME 1030

SEAM LENGTH 360°

TEST PARAMETER: START 0° END 360° INSPECTORS R. Wille II & S. Wells II

START ____ END ____ #8 CCW Shot



*(L) measured from: Top of Nozzle Body TYPE OF TEST HAZ ☐ 45° ☒ 60° ☐

L1				*L	L2				W1				W	W2				MP				MP	MP			DAC	X-R FILM NO. TOP OR BOTTOM CW OR CCW
10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	10	20	50	100	Max	100	50	20	10	Max	

477

ES IRPT No. RPV-12 Page 25 of 26

SCAN COMPLETE ☒ NO REPORTABLE INDICATIONS ☒
SCAN INCOMPLETE ☐ REPORTABLE INDICATIONS ☐

NDE Pc A

Reviewed
W J Caldwell ANII - HSB
4-8-81

GENERAL ELECTRIC

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT I E.D.S. NO. 10005 F

A. Procedure No. PP-S751 REV. 5

B. Examination Personnel:

NAME Lyndon Tiago LEVEL II

NAME N/A LEVEL N/A

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 78D056

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☒ NO ☐ Temp.

2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☒ NO ☐ Temp.

b. SURFACE PREPARATION:

*1. Grinding *2. Flappering *3. None *4. Other

E. Data: Note: All Exam. Components are ASME Section XI Category

LINE NO. 00	DATE 01	PRE-CLEAN EVAP. TIME (MIN) 02	PEN. DWELL TIME (MIN) 03	PEN. REM. EVAP. TIME (MIN) 04	DEV. TIME (MIN) 05	EXAMINATION COMPONENT I.D. NO. 06	MAT'L 07	SURF. PREP. * 08	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	RELEVANT INDICATION LOCATION/SIZE OR COMMENTS 13
1	6-7-79	5	20	5	15	IRH 1011-41	CS	1,2	✓		✓		
2		9 5/8" CCW		FROM	TDC,	9/16" DOWNSTREAM		FROM		WELD	CENTERLINE,		
3		CIRCULAR INDICATION 3/32" IN DIAMETER.											
4													
5													
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By:

NDE SUPERVISOR [signature] DATE 6/12/79

QC SUPERVISOR [signature] DATE 6/13/79

AUTHORIZED INSPECTOR W J Caldwell DATE 3-23-81

GE-10/78 (P1)

GENERAL ELECTRIC

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT I E.D.S. NO. 13001

A. Procedure No. PP-S751 REV. 5

Examination Personnel:

NAME [illegible] LEVEL II

NAME N/A LEVEL N/A

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 78D056

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp.

2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp.

b. SURFACE PREPARATION:

*1. Grinding *2. Flappering *3. None *4. Other

E. Data: Note: All Exam. Components are ASME Section XI Category B J

LINE NO. 00	DATE 01	PRE-CLEAN EVAP. TIME (MIN) 02	PEN. DWELL TIME (MIN) 03	PEN. REM. EVAP. TIME (MIN) 04	DEV. TIME (MIN) 05	EXAMINATION COMPONENT I.D. NO. 06	MAT'L 07	SURF. PREP. * 08	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	RELEVANT INDICATION LOCATION/SIZE OR COMMENTS 13
1	6-15-79	5	10	5	15	I-MS-1053-1ALU	C/S	2		✓	✓		
2													
3													
4													
5													
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By:

NDE SUPERVISOR [illegible] DATE 6/18/79

QC SUPERVISOR [illegible] DATE 6/18/79

AUTHORIZED INSPECTOR W J Cathcart DATE 3-23-81

GE-10/78 (P1)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 55096

CDS # 55095

ULTRASONIC EXAMINATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

A. Procedure No. MPUP S751 REV. 3

B. Examination Personnel:
NAME [illegible] LEVEL II NAME Charles E. Mills LEVEL II

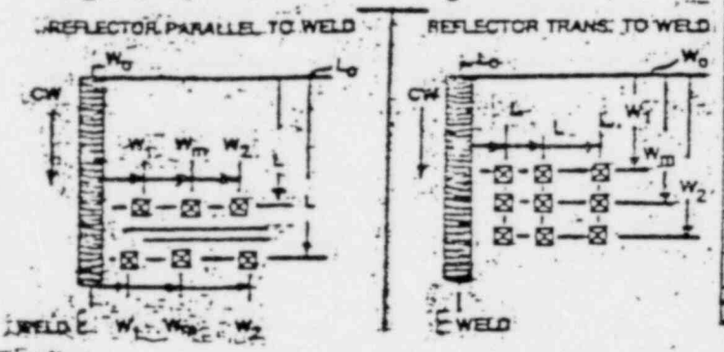
C. Search Unit Beam Angle (± 2°): ☐ 0° ☒ 45° ☐ 60° ☐ Other

D. Couplant: ☒ Glycerine ☐ Ultragel II ☐ Other

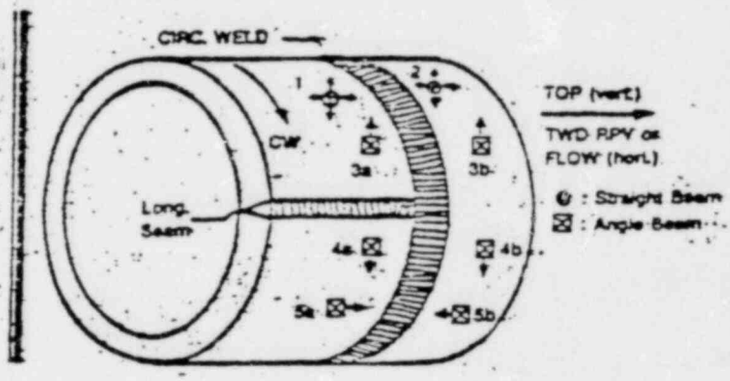
E. Scan Sensitivity: (+) 8 dB

F. Reference System

L_o = "V" Stamp W_o = "V" Stamp



G. Scan Orientation



H. Data

00 DATE 1979	01 LINE NO.	02 EXAM/ COMP. I.D. NO.	03 COMP FIG.	04 REC. IND. YES/ NO	05 MAX% DAC @ W_m	06 L_o / W_o	07 L	08 W_1	09 W_m	10 W_2	11 SRP_1 or MP_1	12 SRP_m or MP_m	13 SRP_2 or MP_2	14 SCAN	15 Comments (Thickness Meas.)
4/3	1	IRR1007 -3ALU	LS	YES	100%	℄*/℄	6		2.5			48		4A	O.D. FINGER DAMP LENGTH OF LONG SEAM INTERMITTENT
4/3	2	IRR1007 -3ALU	LS	YES	80%	℄*/℄	5.5		1.6			22		4A	LENGTH OF LONG SEAM: INTERMITTENT
4/3	3	IRR1007 -3ALU	LS	YES	100% +6	℄*/℄	6.5		4.4			76		4A	LENGTH OF LONG SEAM: INTERMITTENT
4/3	4	IRR1007 -3ALU	LS	YES	70%	℄*/℄	8.0		1.0			18		4A	LENGTH OF LONG SEAM INTERMITTENT
4/3	5	IRR1007 -3ALU	LS	YES	66	℄*/℄	6.0		2.0			26		3A	LENGTH OF LONG SEAM INTERMITTENT
4/3	6	IRR1007 -3ALU	LS	YES	100%	℄*/℄	4.5		3.2			58		3A	O.D. FINGER DAMP LENGTH OF LONG SEAM INTERMITTENT
4/3	7	IRR1007 -3ALU	LS	YES	100% +2	℄*/℄	5.0		3.8			7.4		3A	LENGTH OF LONG SEAM INTERMITTENT
	8	*L_o IS MEASURED FROM ℄ OF WELD IRR1007-3													
	9														

I. Reviewed By:

NDE SUPERVISOR SD Connelly DATE 4/4/79

QC SUPERVISOR: Salahuddin [illegible] DATE 7/12/79

AUTHORIZED INSPECTOR W J Caldwell DATE 3-26-81

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT

E.D.S. NO. 62028

A. Procedure No. PP-S751 REV. 5

Examination Personnel:

NAME David W. Fraser LEVEL II

NAME Gordon Craigo LEVEL I

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 78D056

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp.

2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp.

b. SURFACE PREPARATION:

*1. Grinding *2. Flappering *3. None *4. Other

E. Data: Note: All Exam. Components are ASME Section XI C-F Category

E NO. 00	DATE 01	PRE-CLEAN EVAP. TIME (MIN) 02	PEN. DWELL TIME (MIN) 03	PEN. REM. EVAP. TIME (MIN) 04	DEV. TIME (MIN) 05	EXAMINATION COMPONENT I.D. NO. 06	MAT'L 07	SURF. PREP. * 08	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	RELEVANT INDICATION LOCATION/SIZE OR COMMENTS 13
1	5-17	5min	20min	5min	15min	IRH 1077 F48	CS	2	✓			✓	
2	NOTE	LINEAR	INDICATIONS	9"	CW	U STAMP	1-40"	FROM					
3	WELD	CENTERLINE	—	UPSTREAM									
4	NOTE-	AREA	ABOVE	WILL	NEED	A BASE	METAL	THICKNESS	CHECK				
5													
6					REF.	EDS	65049						
7													
8													
9													
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By:

NDE SUPERVISOR [signature] DATE 5-18-79

QC SUPERVISOR [signature] DATE 5/21/79

AUTHORIZED INSPECTOR [signature] DATE 3-26-81

GE-10/78 (P1)

GENERAL ELECTRIC

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT

E.D.S. NO. 62C3xp

A. Procedure No. PP-S751 REV. 5

B. Examination Personnel:

NAME [illegible] LEVEL II

NAME NA LEVEL NA

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT	TYPE SKC-S	BATCH NO. 79C014
c. PENETRANT	TYPE SKL-HF /SKL-S	BATCH NO. 78E073
d. PENETRANT REMOVER	TYPE SKC-S	BATCH NO. 79C014
e. DEVELOPER	TYPE SKD-S	BATCH NO. 78D056
f. POST EXAMINATION CLEANER	TYPE SKC-S	BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp.
2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp.

b. SURFACE PREPARATION:

*1. Grinding (*2.) Flappering *3. None *4. Other

E. Data: Note: All Exam. Components are ASME Section XI C-F Category

LINE NO. 00	DATE 01	PRE-CLEAN EVAP. TIME (MIN) 02	PEN. DWELL TIME (MIN) 03	PEN. REM. EVAP. TIME (MIN) 04	DEV. TIME (MIN) 05	EXAMINATION COMPONENT I.D. NO. 06	MAT'L 07	SURF. PREP. * 08	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	RELEVANT INDICATION LOCATION/SIZE OR COMMENTS 13
1	K-1	5min	[illegible]	5min	15min	IRH/OUT FZB	CS	2		✓	✓		*
2	NOTE -	TUD	CATIONS	NOTED	ON	FDSH	2C1B	WERE					
3	REMOVED	BY	FLAPPERING	WELD	REPAIR	AREA ONLY							
4	+ 1"	EACH	SIDE	WAS	INSPECTED	BY PT	AND						
5	FOUND	ACCEPTABLE											
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By:

NDE SUPERVISOR R. Hooper DATE 6-1-79

QC SUPERVISOR Selahuddin Ahmed DATE 6-6-79

AUTHORIZED INSPECTOR W J Caldwell DATE 3-26-81

GE-10/78 (P1)

GENERAL ELECTRIC

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT

E.D.S. NO. 62035

A. Procedure No. PP-S751 REV.

B. Examination Personnel:

NAME Leonard E. Fagan LEVEL II

NAME NA LEVEL NA

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 78D056

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp.

2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp.

b. SURFACE PREPARATION:

*1. Grinding *2. Flappering *3. None *4. Other

E. Data: Note: All Exam Components are ASME Section XI C-F Category

LINE NO. 00	DATE 01	PRE-CLEAN EVAP. TIME (MIN) 02	PEN. DWELL TIME (MIN) 03	PEN. REM. EVAP. TIME (MIN) 04	DEV. TIME (MIN) 05	EXAMINATION COMPONENT I.D. NO. 06	MAT'L 07	SURF. PREP. * 08	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	RELEVANT INDICATION LOCATION/SIZE OR COMMENTS 13
1	K-1	5min	10min	5min	5min	TRH1007 #41	CS	2		—	—		P
2	P	INTE-	INDICATIONS	NOTED	ON	EDS # 2018	WERE						
3	REMOVED	BY	FLAPPERING	WELD	REPAIR	AREA							
4	COLD +	1"	EACH	SIDE	WAS	RETESTED	BY						
5	PT	AND	FOUND	ACCEPTABLE									
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By:

NDE SUPERVISOR R. E. Hooper DATE 6-1-79

QC SUPERVISOR Salutmeldimentos DATE 6-6-79

AUTHORIZED INSPECTOR W J Cotterell DATE 3-26-81

GE-10/78 (P1)

GENERAL ELECTRIC

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT

E.D.S. NO. 600 [illegible]

A. Procedure No. PP-S751 REV. 5

B. Examination Personnel:

NAME L. Curtis Hooper LEVEL II

NAME N/A LEVEL N/A

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 78D056

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp.

2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp.

b. SURFACE PREPARATION:

*1. Grinding *2. Flappering *3. None *4. Other

E. Data: Note: All Exam Components are ASME Section XI C-F Category

LINE NO. 00	DATE 01	PRE-CLEAN EVAP. TIME (MIN) 02	PEN. DWELL TIME (MIN) 03	PEN. REM. EVAP. TIME (MIN) 04	DEV. TIME (MIN) 05	EXAMINATION COMPONENT I.D. NO. 06	MAT'L 07	SURF. PREP. * 08	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	RELEVANT INDICATION LOCATION/SIZE OR COMMENTS 13
1	A-1	Same	Same	Same	Same	IRH1007 #4/6	CS	2		✓	—		*
2	Rate-Tubing Tee					noted on	105	7	80187	welded			
3	Removed	by	flappering			weld repair	only						
4	+ 1"	each	side	was	retested	but	not						
5	Found	acceptable											
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By:

NDE SUPERVISOR R.S. Hooper DATE 6-1-79

QC SUPERVISOR Salahuddin Mahmood DATE 6-6-79

AUTHORIZED INSPECTOR W J Caldwell DATE 3-26-81

GE-10/78 (P1)

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT

E.D.S. NO. 65066

A. Procedure No. PP-S751 REV. 5

Examination Personnel:

NAME Daniel Sytzler LEVEL II

NAME N/A LEVEL N/A

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT	TYPE	SKC-S	BATCH NO.	79C014
c. PENETRANT	TYPE	SKL-HF /SKL-S	BATCH NO.	78E073
d. PENETRANT REMOVER	TYPE	SKC-S	BATCH NO.	79C014
e. DEVELOPER	TYPE	SKD-S	BATCH NO.	78D056
f. POST EXAMINATION CLEANER	TYPE	SKC-S	BATCH NO.	79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☒ NO ☐ Temp.

2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☒ NO ☐ Temp.

b. SURFACE PREPARATION:

*1. Grinding *2. Flappering *3. None *4. Other

E. Data: Note: All Exam Components are ASME Section XI Category CF

ITEM NO. 00	DATE 01	PRE-CLEAN EVAP. TIME (MIN) 02	PEN. DWELL TIME (MIN) 03	PEN. REM. EVAP. TIME (MIN) 04	DEV. TIME (MIN) 05	EXAMINATION COMPONENT I.D. NO. 06	MAT'L 07	SURF. PREP. * 08	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	RELEVANT INDICATION LOCATION/SIZE OR COMMENTS 13
1	5-18-79	8	20	8	25	IRH-1077-1.8	C/S	2		X	X		SEE NOTE 1
2													
3						Not Mid well							
4													
5													
6	NOTE 1:	See	"T"	EDS	94098	for thickness	measurement.						DRB 7/23/80
7													
8													
9													
10													
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By:

NDE SUPERVISOR [signature] DATE 6-7-79

QC SUPERVISOR [signature] DATE 6-6-79

AUTHORIZED INSPECTOR [signature] DATE 3-26-81

GE-10/78 (P1)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS# 70014

CDS# 70016

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT ___

A. PROCEDURE NO. MPUP-5751 REV. 0

B. EXAMINATION PERSONNEL:
NAME B. Dummer LEVEL II ; NAME G. Fey LEVEL I

C. SEARCH UNIT BEAM ANGLE: ☐ 0°; ☒ 45°; ☐ 60°; OTHER 47°

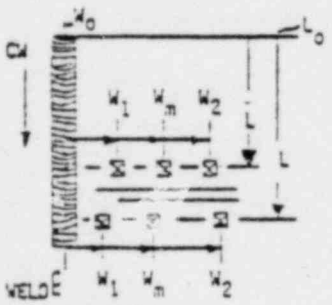
D. COUPLANT: ☒ GLYCERINE: ☐ ULTRAGEL II; ☐ OTHER N/A

E. SCAN SENSITIVITY: (+) 8 dB

F. REFERENCE SYSTEM

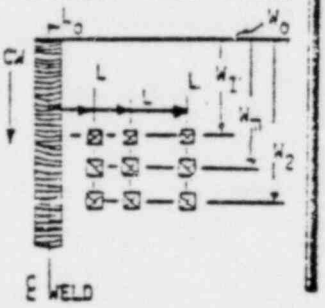
L_o = 'V' STAMP

REFLECTOR PARALLEL TO WELD

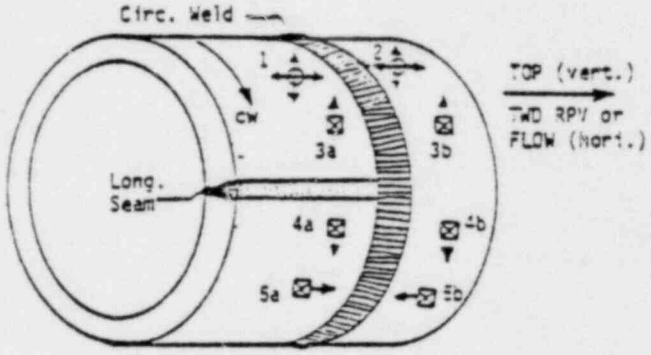


W_o = 'V' STAMP

REFLECTOR TRANS. TO WELD



G. SCAN ORIENTATION



H. DATA

DATE 1978	LINE NO.	EXAM/COMP. I.D. NO.	COMP FIG.	REC. IND. YES/NO	MAX % DAC @ W_m	L_o / W_o	L	W_1 (50% DAC)	W_m	W_2 (50% DAC)	SRP_1 (50% DAC)	SRP_m	SRP_2 (50% DAC)	SCAN	Comments (Thickness Meas.)
8/25	1	I-MS-1051 15	P/V	YES	80%	V/℄	0		1.4			30		5b	INTERMITTENT 360°
8/25	2	I-MS-1051 15	P/V	YES	60%	V/℄	39.7		1.7			41		5b	LINES 2,3,4
8/25	3	I-MS-1051 15	P/V	YES	50%	V/℄	39.6		1.7			41		5b	SAME INDICATION
8/25	4	I-MS-1051 15	P/V	YES	50%	V/℄	39.8		1.7			41		5b	LENGTH 0.2"
	5							SCAN	PIPE	SIDE	ONLY	DUE	TO	GEOMETRY ON VALVE	
	6														
	7														
	8														
	9														

I. REVIEWED BY:
NDE SUPERVISOR John Dunbar DATE 9-26-78

QC SUPERVISOR Wylie Hart DATE 9-26-78

AUTHORIZED INSPECTOR W J Caldwell DATE 3-26-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY NUCLEAR STATION UNIT 1

E.D.S. NO. 77012

A. PROCEDURE NO. PP-S751 REV. 6

B. EXAMINATION PERSONNEL:

NAME C A Homlin LEVEL II

NAME [illegible] LEVEL II

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 79E033

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☒ NO ☐
2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☒ NO ☐

b. SURFACE PREPARATION:

*1. GRINDING *2. BLAPPERING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

00 LINE NO.	01 DATE	02 PRE-CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. *	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	13 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
1	11-14-79	5	10	5	15	1-RH-1040-9	CS	2	X			X	LINEAR INDI-
2													CATION, 39 1/2"
3													FROM V STAMP
4	NOTE 1:		See "T"		EDS	77036 for		thickness					(CW). LOCATED
5			measurement.										IN SURFACE ONE
6						DJB	7/23/80						.300 IN LENGTH
7													1.3" FROM ℄ OF
8													1-RH-1040-9.
9													GRINDER WAS GONE
10													APRX. .075" IN
11													DEPTH. No Change in
12													Depth OR DIRECTION,
13													IND. IS PARALLEL
14													TO CIRCLE SEAM.
15													(SEE NOTE 1)

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(s) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR S Flomelly DATE 11/28/79

QC SUPERVISOR Salahuddin Ahmed DATE

AUTHORIZED INSPECTOR W J Caldwell DATE 3-26-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY NUCLEAR STATION UNIT 1

E.D.S. NO. 77028

A. PROCEDURE NO. PP-S751 REV. 6

B. EXAMINATION PERSONNEL:

NAME E.A. Homeler LEVEL II

NAME Edward Hale LEVEL II

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 79E033

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES [X] NO [ ]
2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES [X] NO [ ]

b. SURFACE PREPARATION:

*1. GRINDING *2. FLAPPERING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

00 LINE NO.	01 DATE	02 PRE-CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. *	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	13 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
1	11-19-79	5	10	5	15	1-RH-1041 13	CS	2	X			X	24" FROM 'V' STAMP. CLUSTER
2													POROSITY CONNECTED BY LINEAR INDICATION
3													DIRECTLY IN CENTER OF WELD. GROUND
4													JUST BELOW BASE METAL. LONGEST
5													LINEAR INDICATION IS 1/8"
6													See Note 1
7													
8	Note 1:	See "T" EDS 76001 for thickness measurement.											DRB 7/23/80
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(s) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR A Flomally DATE 11/28/79

QC SUPERVISOR R.J. Whatley DATE 11/28/79

AUTHORIZED INSPECTOR W J Caldwell DATE 3-28-81

LASALLE UNIT I

WELD IRH-1048-20

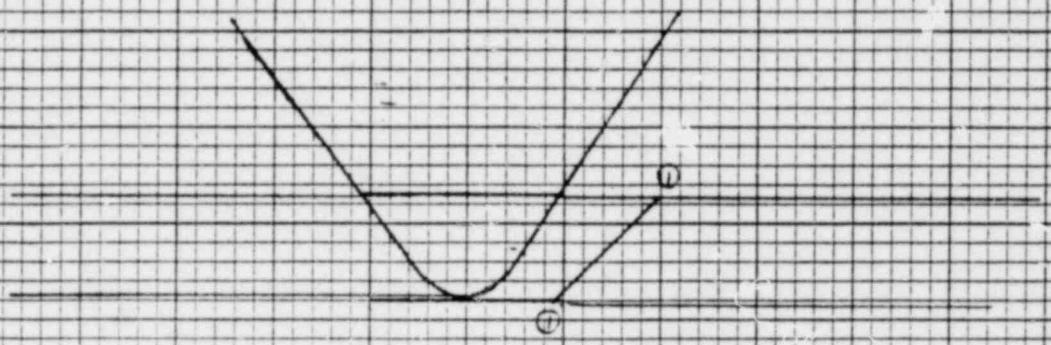
EDS 77497

T_p = 0.52

T_w = 0.58

T_L = 0.55

GENERAL ELECTRIC



LINE	EVALUATION
1	ID geometry from counterbore
2	OD geometry from fan toe of weld
3-8	Mode conversion
9	ID geometry from weld root
10	OD geometry & subsequent mode conversion

EVALUATED BY L D Whatley Level III DATE 9/8/80

REVIEWED BY R J Caldwell ANII DATE 9-9-80

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY NUCLEAR STATION UNIT 1

E.D.S. NO. 77597

A. PROCEDURE NO. PP-S751 REV. 7

B. EXAMINATION PERSONNEL:

NAME C A Homler LEVEL II

NAME NA LEVEL NA

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 79B109

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 79E033

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☒ NO ☐
2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☒ NO ☐

b. SURFACE PREPARATION:

*1. GRINDING (*2.) FLAPPERING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

00 LINE NO.	01 DATE 1981	02 PRE-CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. *	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	13 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
1	2-27	5	15	5	15	1R1-1015-1	CS	2		X	X		
2	2-27	5	15	5	15	1R1-1015-1B	CS	2		X	X		
3	2-27	5	15	5	15	1R1-1015-1A	CS	2		X	X		
4	2-27	5	15	5	15	1R1-1015-2	CS	2		X	X		
5	2-27	5	15	5	15	1R1-1014-4	CS	2		X	X		
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(s) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR A D Connelly DATE 3/2/81

QC SUPERVISOR L D Whitson DATE 3/4/81

AUTHORIZED INSPECTOR W J Caldwell DATE 3-13-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET

LASALLE COUNTY STATION UNIT 1

CDS 77598

LDS 0064

A. Procedure No. MPUP-5751 REV. 6

Examination Personnel: NAME [illegible] LEVEL II NAME [illegible] LEVEL I

Instrument: SERIAL NO. 1348 MAKE/MODEL: – BRANSON/303: ☐ SONIC/MK I: ☒ KK/USL32 ☐ OTHER

D. Search Unit: BEAM ANGLE/MODE: ☒ STRAIGHT BEAM/LONG WAVE: ☐ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE

TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ☐ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz

SERIAL NO.: A22016 ; ☐ 1.0" DIA/2.25 MHz ☒ 0.5"x0.5"/2.25 MH_z

TRANSDUCER TYPE: ☐ CERAMIC SINGLE ELEMENT ☒ CERAMIC DUAL ELEMENT ☐ OTHER

WEDGE TYPE: ☒ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE

CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = 0°

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ☒ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ☒ PARALLEL ☐ TRANSVERSE TO PIPE AXIS

FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ☒ PARALLEL ☐ TRANSVERSE to hole centerline

G. Calibration Standards: LSCS CAL. STD. NO. 01-10-01 THICKNESS .75" DIAMETER 10"

MATERIAL: ☒ CARBON ☐ STAINLESS ☐ INCONEL ☐ OTHER

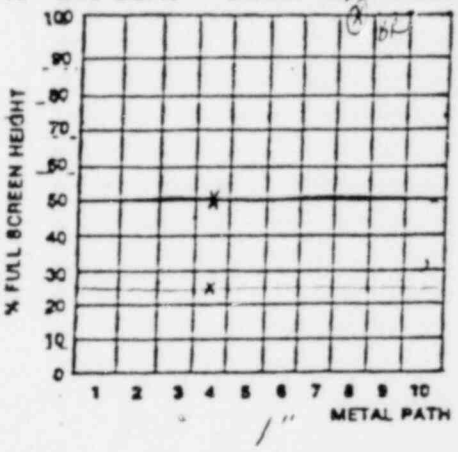
H. Couplant: ☒ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

I. Comments: +4dB = BR To 100% FSH

J. Dac Curve — Data

REFLECTOR 00	PEAK AMP 01	W1 02	Wm 03	W2 04	MP1 05	MPm 06	MP2 07	HOLE DEPTH 08
¼ T or /8 Vee								
½ T or /8 Vee	50%					.35		.35
¾ T or /8 Vee								
F.B. or /8 Vee	100% +4dB					.75		

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	34 dB	✓	✓						
SCAN GAIN	42 dB	✓	✓						
SWEEP	.5/675	✓	✓						
DELAY	749	✓	✓						
FILTER	AUTO	✓	✓						
REP RATE	MED	✓	✓						
DAMPENING	OFF	✓	✓						
REJECT	OFF	✓	✓						
OTHER	NA	✓	✓						

M. Calibration Time — Records

DATE 1981	01 ORIG. CAL TIME	02 CAL. CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
2-27	1135	NA	NA	NA	YES
2-27	NA	1240	NA	NA	YES
2-27	NA	1525	77599	7	YES

N. Reviewed By: NDE SUPERVISOR [signature] DATE 3/2/81

Q.C. SUPERVISOR [signature] DATE 3/13/81

AUTHORIZED INSPECTOR [signature] DATE 3-13-81

GE-70/78 (U2)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 77599

CDS # 77598

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

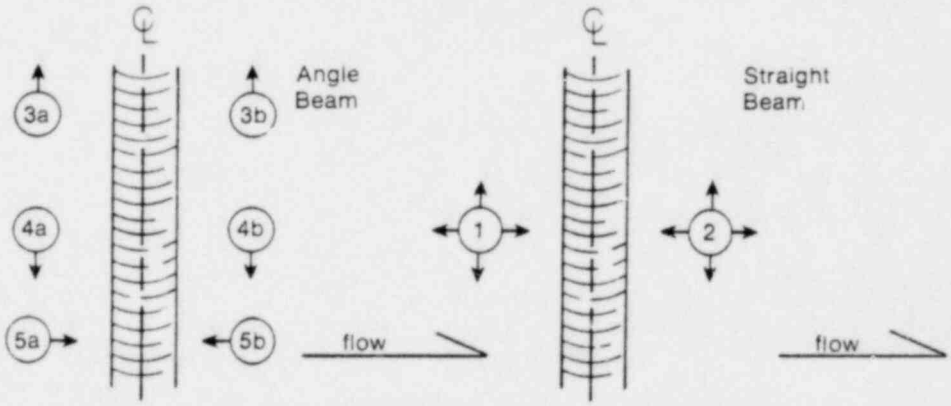
EXAMINATION PERSONNEL:
NAME C.A. Homler LEVEL II ; NAME A.D. Connelly LEVEL II

SEARCH UNIT BEAM ANGLE: 0°: X 45°: ____ 60°: ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE 1987	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L_1/W_1	L_m/W_m	L_2/W_2	MP_1	MP_m	MP_2	SCAN	STAT.	COMMENTS
2-27	1	IRI 1014 4	PE		P .73	CL .78	E .79					A	
2-27	2	IRI 1014 4	PE		EXCAVATION	.64		PT INDICATION REMOVAL EXCAVATION LOCATED 2" CCW FROM 'V' IN SURFACE 2 WELD TOE.					
2-27	3	IRI 1014 7	EP		E .81	CL .82	P .71					A	
2-27	4	IRI 1015 1A	EP		E .83	CL .73	P .73					A	
2-27	5	IRI 1015 1B	EE		E .74	CL .83	E .76					A	
2-27	6	IRI 1015 1	TE		T .92	CL .83	E .75	NO SCAN (.) 4" EA. SIDE OF TDC DUE TO TEE CONFIGURATION.				A	
2-27	7	IRI 1015 2	TP		T .98	CL .79	P .67	NO SCAN (.) 4" EA. SIDE OF TDC DUE TO TEE CONFIGURATION.				A	

REVIEWED BY:
NDE SUPERVISOR A.D. Connelly DATE 3/2/81

QC SUPERVISOR R.D. Whatley DATE 3/12/81

AUTHORIZED INSPECTOR W.J. Cathcart DATE 3-13-81

GE-U3

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY NUCLEAR STATION UNIT 1

E.D.S. NO. 77600

A. PROCEDURE NO. PP-S751 REV. 7

EXAMINATION PERSONNEL:

NAME E A Homler LEVEL II

NAME NA LEVEL NA

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 79B109

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 79E033

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES [X] NO [ ]
2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES [X] NO [ ]

b. SURFACE PREPARATION:

*1. GRINDING (*2.) FLAPPERING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

00 LINE NO.	01 DATE 1981	02 PRE-CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. *	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	13 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
1	3-5	5	15	5	15	IMS-1044-46	CS	2	X		X		16.5" CCW FROM V 1/8" RD. IND. WELD CL
2													
3													
4													
5													
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(s) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR A D Connelly DATE 3/6/81

QC SUPERVISOR L D Heathy DATE 3/13/81

AUTHORIZED INSPECTOR W J Caldwell DATE 3-13-81

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

CDS 77601
LDS. 0065

A. Procedure No. MPUP-5751 REV. 6

Examination Personnel: NAME [illegible] LEVEL II NAME T.E. Williams LEVEL II

Instrument: SERIAL NO. 521 MAKE/MODEL: – BRANSON/303: ☐ SONIC/MK II: ☒ KK/USL32: ☐ OTHER

D. Search Unit: BEAM ANGLE/MODE: ☐ STRAIGHT BEAM/LONG WAVE: ☒ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE
TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ☒ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz
SERIAL NO.: L07944 ; ☐ 1.0" DIA/2.25 MHz ☒ 0.5"x0.5"/2.25 MHz
TRANSDUCER TYPE: ☒ CERAMIC SINGLE ELEMENT ☐ CERAMIC DUAL ELEMENT ☐ OTHER
WEDGE TYPE: ☒ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE
CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = 44.5°

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ☒ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ☐ PARALLEL ☒ TRANSVERSE TO PIPE AXIS to hole centerline
FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ☐ PARALLEL ☐ TRANSVERSE

G. Calibration Standards: LSCS CAL. STD. NO. 01-10-01 THICKNESS .75 DIAMETER 10"
MATERIAL: ☒ CARBON ☐ STAINLESS ☐ INCONEL ☐ OTHER

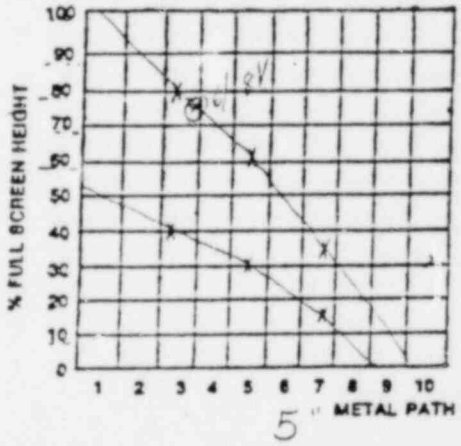
H. Couplant: ☒ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

I. Comments: +10 dB = 6/8 V To 100% DAC

J. Dac Curve — Data

REFLECTOR 00	PEAK AMP 01	W1 02	Wm 03	W2 04	MP1 05	MPm 06	MP2 07	HOLE DEPTH 08
4 T-or 4/8 Vee	80		.76			1.1		
4 T-or 8/8 Vee	62		1.53			2.2		
4 T-or 12/8 Vee	35		2.28			3.3		
4 T-or 6/8 Vee	100 + 10		1.01			1.4		.36

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	52 dB	✓							
SCAN GAIN	60 dB	✓							
SWEEP	2.5/078	✓							
DELAY	753	✓							
FILTER	Auto	✓							
REP RATE	Med	✓							
DAMPENING	OFF	✓							
[illegible]	OFF	✓							
OTHER	NA	✓							

M. Calibration Time — Records

DATE 1981	01 ORIG. CAL. TIME	02 CAL. CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
3-5	0830	NA	NA	NA	Yes
3-5	NA	1135	77602	8	Yes
3-5	NA	1135	77602	9	Yes
3-5	NA	1135	77603	8	Yes

N. Reviewed By: NDE SUPERVISOR [signature] DATE 3/6/81
Q.C. SUPERVISOR [signature] DATE 3/16/81
AUTHORIZED INSPECTOR [signature] DATE 3-18-81

GE-70/73 (U2)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 77602

CDS # 77601

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

EXAMINATION PERSONNEL:
NAME C A Homlin LEVEL II ; NAME M E Williams LEVEL II

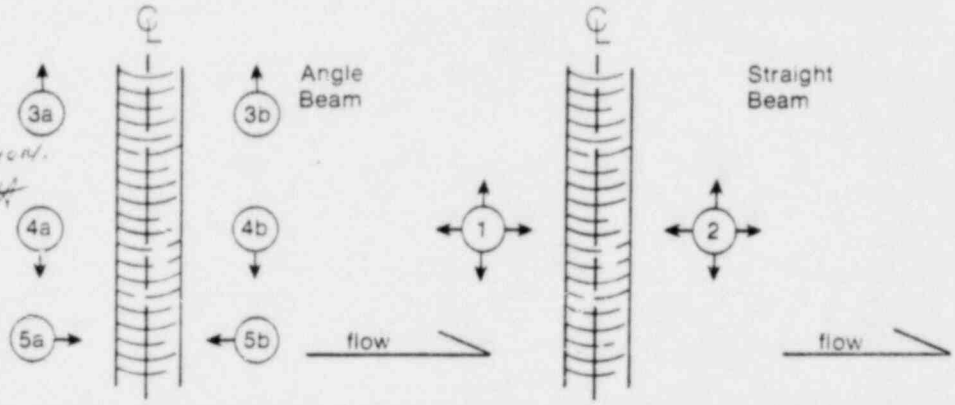
SEARCH UNIT BEAM ANGLE: 0°: ____ 45°: X 60°: ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION

* STARRED INDICATIONS APPEAR INDIVIDUALLY & SIMULTANEOUSLY. POSSIBLE MODE CONVERSION. CAH



DATE 1981	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L 1/ W 1	L m/ W m	L 2/ W 2	MP 1	MP m	MP 2	SCAN	STAT.	COMMENTS
3-5	1	IRI 1015 2	TP		No Scan 5A - 4" E4. Side of Tee Configuration.							TOC	DUE
3-5	2	2	TP	75	360 INT	2.15			3.05		5B	E	FDINS
3-5	3	2	TP	100	360 INT	.9			2.2		5A	A	FDFS *
3-5	4	2	TP	50	360 INT	.9			2.3		5A	E	FDFS *
3-5	5	2	TP	60	360 INT	.9			2.5		5A	E	FDFS *
3-5	6	2	TP	75	360 INT	.9			2.7		5A	E	FDFS *
3-5	7	2	TP	100 -2	360 INT	.38			1.1		5A	E	*
3-5	8	IRI 1015 2	TP	50	360 INT	.38			1.5		5A	E	FDFS *

REVIEWED BY:
NDE SUPERVISOR A D Connelly DATE 3/6/81
QC SUPERVISOR L D Wheatley DATE 3/16/81
AUTHORIZED INSPECTOR W J Caldwell DATE 3-18-81

38-117

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 77602

CDS # 77601

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

EXAMINATION PERSONNEL:
NAME LA Romb LEVEL II ; NAME ME Williams LEVEL IT

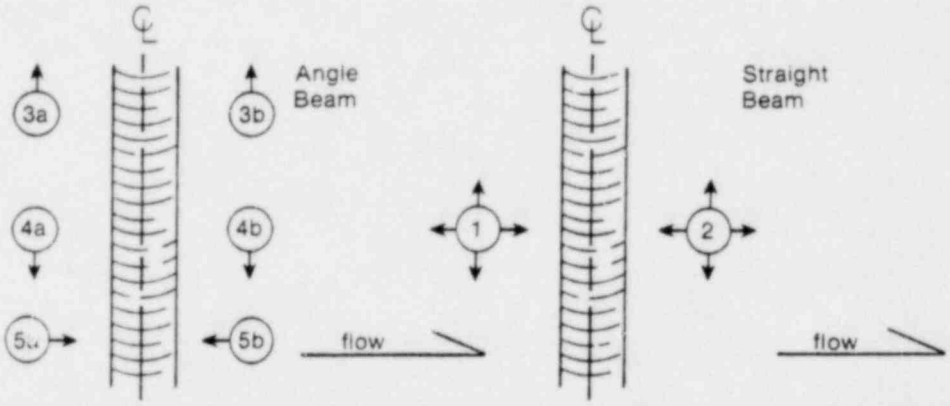
SEARCH UNIT BEAM ANGLE: 0°; ____ 45°; X 60°; ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION

★ See Note Page 1 Att



DATE 1981	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L 1/ W 1	L m/ W m	L 2/ W 2	MP 1	MP m	MP 2	SCAN	STAT.	COMMENTS
3-5	9	IRI-1015 2	TP	50	360 / WT	.38			2.0		5A	E	★ FDFS

REVIEWED BY:
NDE SUPERVISOR S D Connelly DATE 3/6/81
QC SUPERVISOR L D Wheatley DATE 3/16/81
AUTHORIZED INSPECTOR W J Caldwell DATE 3-18-81

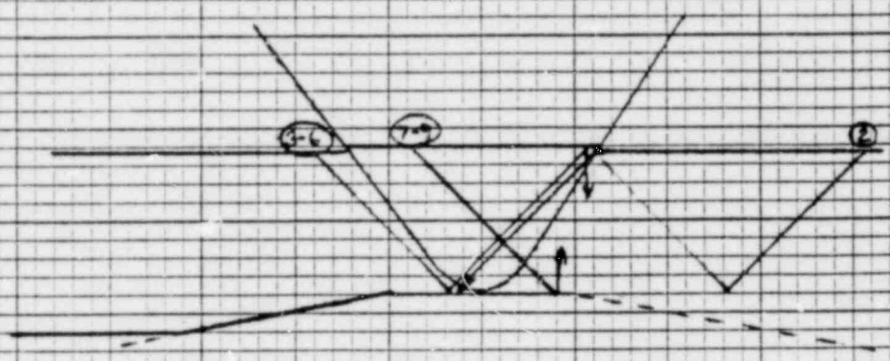
GE-U3

LASALLE UNIT 1 T_T = .98

WELD 1R1-1015-2 T_W = .79

EDS 77602 T_P = .67

GENERAL ELECTRIC



LINE	EVALUATION
2	ID geometry from weld root
3-6	OD geometry from weld cap & subsequent mode conversion
7-9	ID geometry from weld root & subsequent mode conversion

EVALUATED BY L W Wheatley Level III DATE 3/16/81

REVIEWED BY W J Caldwell ANII DATE 3-18-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 77603

CDS # 77601

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

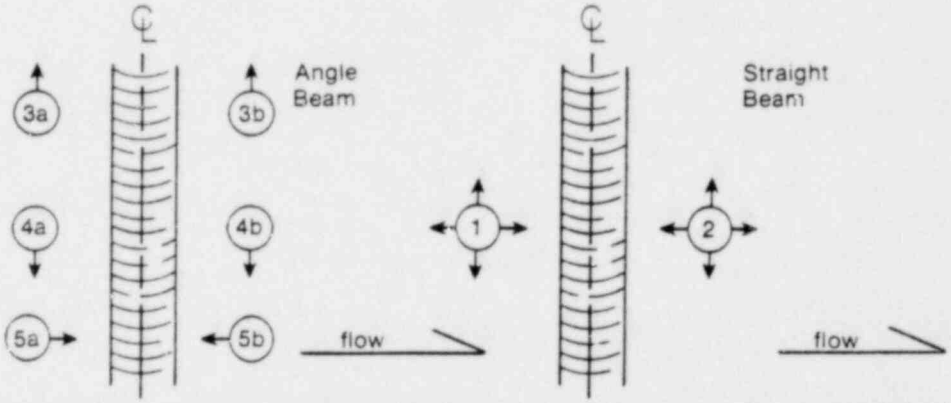
EXAMINATION PERSONNEL:
NAME C A Hamler LEVEL II ; NAME M E Williams LEVEL II

SEARCH UNIT BEAM ANGLE: 0°; ____ 45°; X 60°; ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE 1981	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L 1/ W 1	L m/ W m	L 2/ W 2	MP 1	MP m	MP 2	SCAN	STAT.	COMMENTS
3-5	1	IRI 1015 1	TP		No Scan 5A - 4" EA. SIDE OF TOC DUE To TEE Configuration.								
3-5	2	1	TP	75	360 INT	1.6			1.1		5B	E	
3-5	3	1	TP	100 +2	360 INT	1.8			2.0		5B	A	* fdns
3-5	4	1	TP	90	360 INT	1.8			3.6		5B	E	* fdns
3-5	5	1	TP	100	360 INT	1.15			2.6		5A	A	* fdfs
3-5	6	1	TP	75	360 INT	1.15			2.9		5A	E	* fdfs
3-5	7	1	TP	75	360 INT	1.15			3.3		5A	E	* fdfs
3-5	8	IRI 1015 1	TP		* Stapped Indications Appear Simultaneously Possible Mode Conversion.								

REVIEWED BY:
NDE SUPERVISOR A D Connelly DATE 3/6/81

QC SUPERVISOR L D Whatley DATE 3/16/81

AUTHORIZED INSPECTOR W J Caldwell DATE 3-18-81

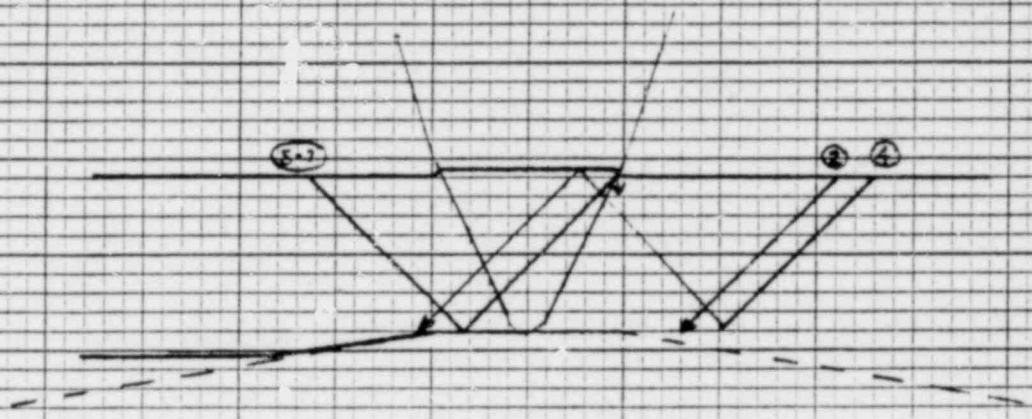
GE-U3

LASALLE UNIT 2 T_T = .92

WELD 1R1-1015-1 T_W = .83

EDS 77603 T_E = .75

GENERAL ELECTRIC



LINE	EVALUATION
2,4	ID geometry from counterbore
5-7	OD geometry from weld cap & subsequent mode conversion

EVALUATED BY L D Wheatley Level III DATE 3/16/81

REVIEWED BY W J Caldwell ANII DATE 3-18-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY NUCLEAR STATION UNIT 1

E.D.S. NO. 77603

A. PROCEDURE NO. PP-S751 REV. 7

B. EXAMINATION PERSONNEL:

NAME L A Hamler LEVEL II

NAME NA LEVEL NA

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 79B109

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 79E033

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☒ NO ☐
2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☒ NO ☐

b. SURFACE PREPARATION:

*1. GRINDING *2. FLAPPERING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

00 LINE NO.	01 DATE 1981	02 PRE-CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. *	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	13 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
1	3-6	5	15	5	15	1MS1044-31	CS	2	X		X		1/8" RDIND - 0" FROM V-weld CL
2	3-6	5	15	5	15	1MS1044-16	CS	2	X		X		3/32" RDIND - 14" CCW FROM V. SURF 2 TOE
3	3-6	5	15	5	15	1MS1044-1	CS	2		X	X		
4													
5													
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(s) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR M J Connelly DATE 3/9/81

QC SUPERVISOR L D Shotts DATE 3/13/81

AUTHORIZED INSPECTOR W J Caldwell DATE 3-13-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

CDS 77604
EDS. 0065

A. Procedure No. MPUP-5751 REV. 6

Examination Personnel: NAME [illegible] LEVEL II NAME [illegible] LEVEL II

Instrument: SERIAL NO. 521 MAKE/MODEL: – BRANSON/303: ☐ SONIC/MK I: ☒ KK/USL32: ☐ OTHER

D. Search Unit: BEAM ANGLE/MODE: ☒ STRAIGHT BEAM/LONG WAVE: ☐ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE

TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ☐ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz

SERIAL NO.: K25806 : ☐ 1.0" DIA/2.25 MHz ☒ 0.5"x0.5"/2.25 MHz

TRANSDUCER TYPE: ☐ CERAMIC SINGLE ELEMENT ☒ CERAMIC DUAL ELEMENT ☐ OTHER

WEDGE TYPE: ☒ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE

CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = 0 °

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ☒ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ☒ PARALLEL ☐ TRANSVERSE TO PIPE AXIS

FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ☒ PARALLEL ☐ TRANSVERSE to hole centerline

G. Calibration Standard: LSCS CAL. STD. NO. 01-26-02 THICKNESS 1.06 DIAMETER 26"

MATERIAL: ☒ CARBON ☐ STAINLESS ☐ INCONEL ☐ OTHER

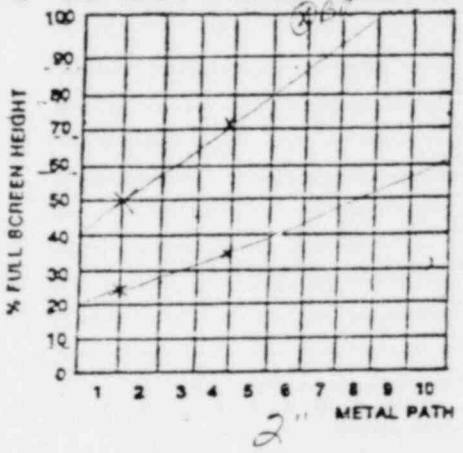
H. Couplant: ☒ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

I. Comments: +6 dB = BR to 100% FSH

J. Dac Curve — Data

REFLECTOR 00	PEAK AMP 01	W1 02	Wm 03	W2 04	MP1 05	MPm 06	MP2 07	HOLE DEPTH 08
¼ T or /8 Yes	50					.20		.20
½ T or /8 Yes								
¾ T or /8 Yes	72					.78		.78
B.R. or /8 Yes	100 +6					1.06		

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	44 dB	✓							
SCAN GAIN	52 dB	✓							
SWEEP	.5/42	✓							
DELAY	758	✓							
FILTER	Hi	✓							
REP RATE	Mid	✓							
DAMPENING	off	✓							
[illegible]	off	✓							
OTHER	na	✓							

M. Calibration Time — Records

DATE 1981	01 ORIG. CAL. TIME	02 CAL. CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
3-6	1255	na	na	na	yes
3-6	NA	1535	77605	6	yes
3-6	NA	1535	77606	8	yes

N. Reviewed By: NDE SUPERVISOR [illegible] DATE 3/9/81

Q.C. SUPERVISOR [illegible] DATE 3/16/81

AUTHORIZED INSPECTOR [illegible] DATE 3-18-81

GE-[illegible]/78 (U2)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 77605

CDS # 77604

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUPS751 REV. 6

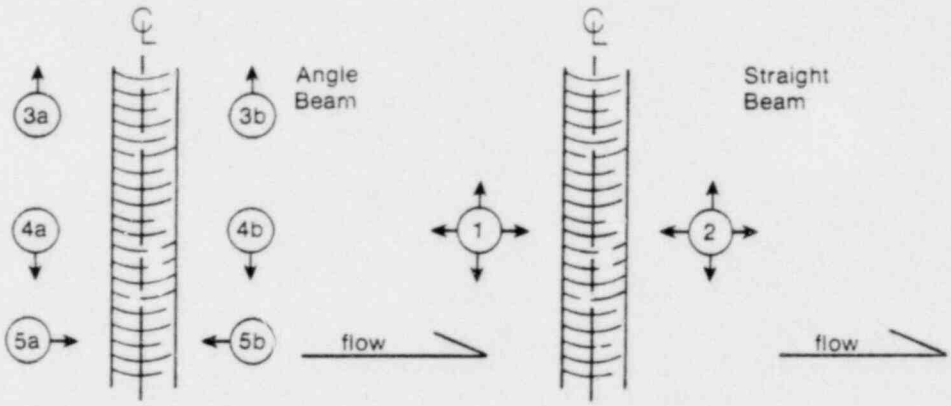
EXAMINATION PERSONNEL:
NAME E A Hombler LEVEL II ; NAME S D Connelly LEVEL II

SEARCH UNIT BEAM ANGLE: 0°; X 45°; ____ 60°; ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE 1981	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L 1/ W 1	L m/ W m	L 2/ W 2	MP 1	MP m	MP 2	SCAN	STAT.	COMMENTS
3-6	1	1MS1044 31	P-P		P / 1.00	2 / 1.12	P / 1.00					NA	
3-6	2	1MS1044 31	P-P	100%	16.20 / 1.25	16.00 / 1.50	15.30 / 1.80		.84		2	E	BR 100% -4db
3-6	3	1MS1044 31	P-P	50%		9.3 / 2.75			.86		1	A	SPOT ONLY
3-6	4	1MS1044 31	P-P	60%		55.5 / 2.50			.54		2	A	SPOT ONLY
3-6	5	1MS1044 31	P-P	100%	42.2 / 2.15	42.5 / 2.25	42.6 / 2.41		.5		2	E	B.R. 100%
3-6	6	1MS1044 31	P-P	75%		48.3 / 1.5			.4		2	A	SPOT ONLY

REVIEWED BY:
NDE SUPERVISOR S D Connelly DATE 3/9/81

QC SUPERVISOR [illegible] DATE 3/16/81

AUTHORIZED INSPECTOR W J Caldwell DATE 3-18-81

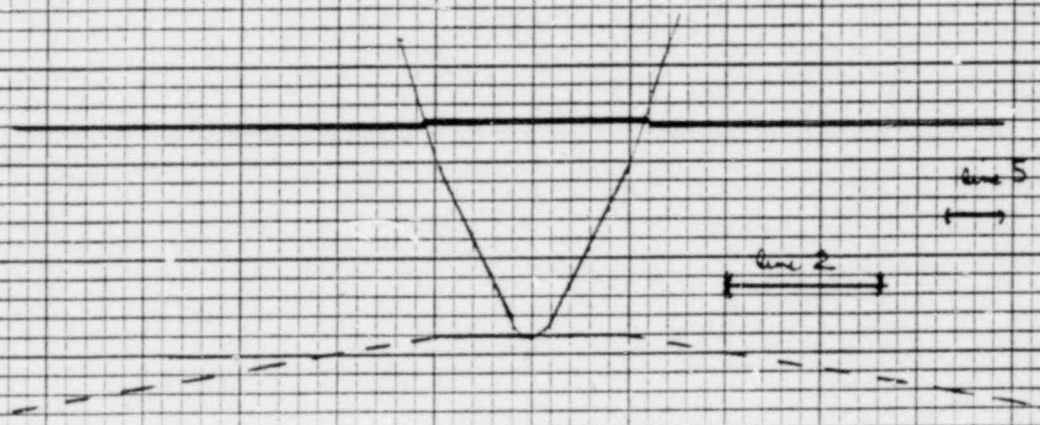
GE-U3

LASALLE UNIT 1 T_P = 1.0

WELD IMS-1049-31 T_W = 1.12

EDS 77605 T_P = 1.02

GENERAL ELECTRIC



LINE	EVALUATION
2,5	There are laminations in the base metal. They are acceptable per Section XI ~~figure~~ IWB-3514.2 as area does not exceed 8 in².

EVALUATED BY R W Whatley Level III DATE 3/16/81

REVIEWED BY W J Caldwell ANII DATE 3-18-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 77.06

CDS # 77604

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

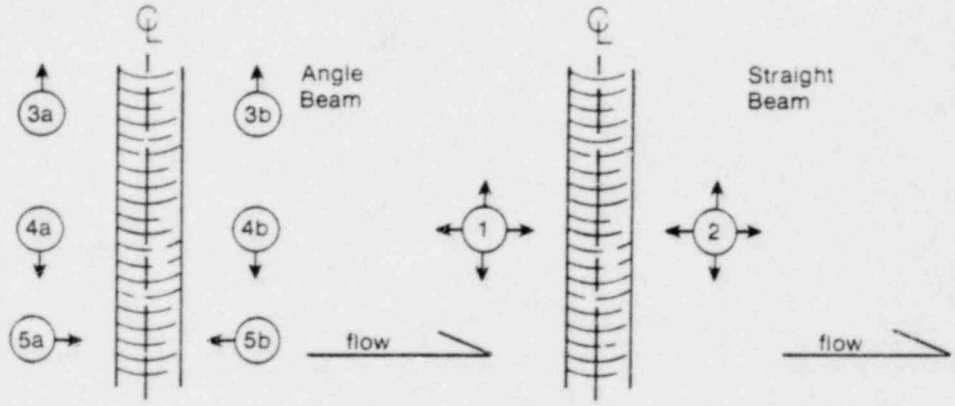
EXAMINATION PERSONNEL:
NAME C A Homler LEVEL II ; NAME A D Connelly LEVEL II

SEARCH UNIT BEAM ANGLE 0°: X 45°: ____ 60°: ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE 1981	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L_1/ W_1	L_m/ W_m	L_2/ W_2	MP_1	MP_m	MP_2	SCAN	STAT.	COMMENTS
3-6	1	1MS1044 46	PP		P / 1.04	CL / 1.08	P / 1.04					IIA	
3-6	2	1MS1044 46	PP	100 +2	71.55 / 2.80	71.7 / 2.85	71.8 / 3.15		.52		2	E	BR= 100% + 2 100-100 Length
3-6	3	1MS1044 46	PP	100 +2	71.4 / 2.70	71.7 / 2.85	71.9 / 3.30		.52		2	E	BR= 100% + 2 50-50 Length
3-6	4	1MS1044 46	PP	60		15.4 / 1.9			.48		2	A	SPOT ONLY
3-6	5	1MS1044 46	PP	100 +6	16.2 / 2.6	16.0 / 2.75	15.8 / 3.1		.54		2	E	BR= 100% -6dB 100-100 Length
3-6	6	1MS1044 46	PP	100 +6	16.4 / 2.5	16.0 / 2.75	15.75 / 3.2		.54		2	E	BR= 100% -6dB 50-50 Length
3-6	7	1MS1044 46	PP	60		32.75 / 1.30			.6		2	A	SPOT ONLY
3-6	8	1MS1044 46	PP	50		39.2 / 3.25			.44		2	A	SPOT ONLY

REVIEWED BY:
NDE SUPERVISOR A D Connelly DATE 3/9/81
QC SUPERVISOR L D Whatley DATE 3/17/81
AUTHORIZED INSPECTOR W J Caldwell DATE 3-18-81

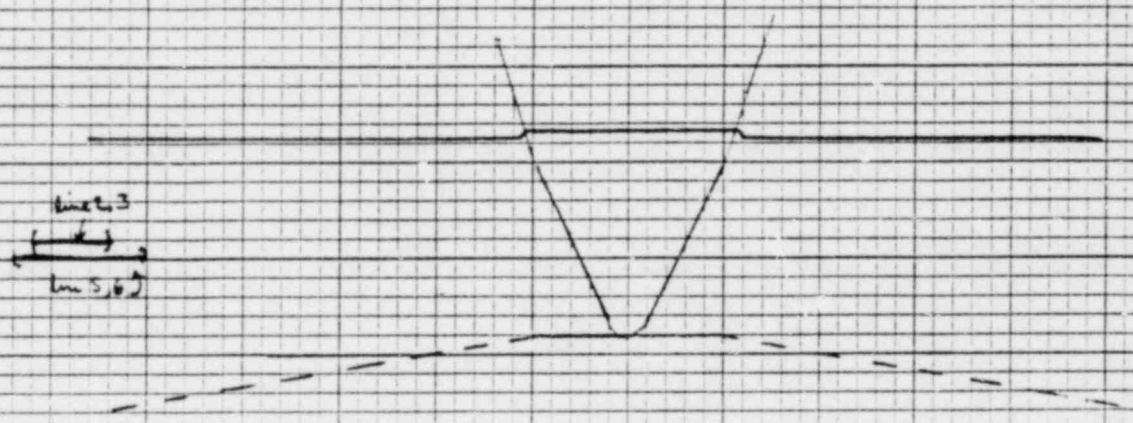
GE-U3

LASALLE UNIT 1 T =

WELD 1MS-1044-46 T_W =

EDS 77606 T =

GENERAL ELECTRIC



LINE	EVALUATION
2,3,5 6	These are base metal lamination well outside the 1T area from the weld toe, thus do not require evaluation

EVALUATED BY L D Whatley DATE 3/17/81
Level III

REVIEWED BY W J Caldwell DATE 3-18 81
ANII

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

CDS 77607
LDS. 0065

A. Procedure No. MPUP-5751 REV. 6

Examination Personnel: NAME SD Connelly LEVEL II NAME ME Williams LEVEL II

Instrument: SERIAL NO. 521 MAKE/MODEL: – BRANSON/303: ☐ SONIC/MK I: ☒ KK/USL32: ☐ OTHER

D. Search Unit: BEAM ANGLE/MODE: ☒ STRAIGHT BEAM/LONG WAVE: ☐ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE
TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ☐ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz
SERIAL NO.: A22016 ; ☐ 1.0" DIA/2.25 MHz ☒ 0.5"x0.5"/2.25 MHz
TRANSDUCER TYPE: ☐ CERAMIC SINGLE ELEMENT ☒ CERAMIC DUAL ELEMENT ☐ OTHER
WEDGE TYPE: ☒ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE
CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = 0 °

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ☒ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ☒ PARALLEL ☐ TRANSVERSE TO PIPE AXIS
FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ☒ PARALLEL ☐ TRANSVERSE to hole centerline

G. Calibration Standard: LSCS CAL STD. NO. 01-26-02 THICKNESS 1.06 DIAMETER 26"
MATERIAL: ☒ CARBON ☐ STAINLESS ☐ INCONEL ☐ OTHER

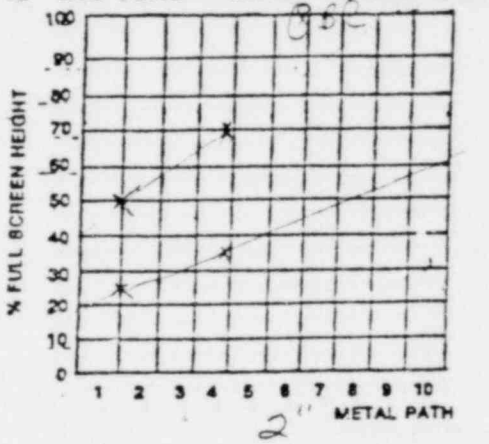
H. Couplant: ☒ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

I. Comments: +6db = BR = 100% FSH

J. Dac Curve — Data

[illegible] 00	PEAK AMP 01	W1 02	Wm 03	W2 04	MP1 05	MPm 06	MP2 07	HOLE DEPTH 08
¼ T or /8 Yes	50%					.20		.20
½ T or /8 Yes								
¾ T or /8 Yes	70%					.76		.76
B.R. or /8 Yes	100 +6					1.06		

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	46 dB	✓							
SCAN GAIN	54 dB	✓							
SWEEP	.5/143	✓							
DELAY	759	✓							
FILTER	Auto	✓							
REP RATE	Med	✓							
DAMPENING	Off	✓							
[illegible]	Off	✓							
OTHER	na	✓							

M. Calibration Time — Records

DATE 1981	01 ORIG. CAL TIME	02 CAL. CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
3-9	0830	na	na	na	yes
3-9	na	1131	77608	6	yes
3-9	na	1131	77609	4	yes

N. Reviewed By: NDE SUPERVISOR SD Connelly DATE 3/10/81
Q.C. SUPERVISOR [illegible] DATE 3/13/81
AUTHORIZED INSPECTOR W J [illegible] DATE 3-18-81

GE-10/75 (U2)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 77608

CDS # 77607

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

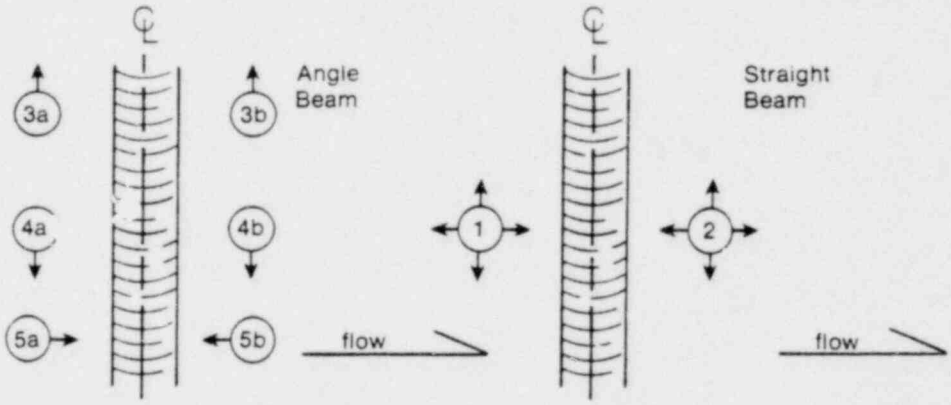
EXAMINATION PERSONNEL:
NAME [illegible] LEVEL II ; NAME M E Williams LEVEL II

SEARCH UNIT BEAM ANGLE: 0°; X 45°; ____ 60°; ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE 1981	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L 1/ W 1	L m/ W m	L 2/ W 2	MP 1	MP m	MP 2	SCAN	STAT.	COMMENTS
3-9	1	IMS 1044 16	PP		P 1.04	CL 1.08	P 1.02					NA	
3-9	2	16	PP	60		19.5 2.5			.44		2	A	SPOT ONLY
3-9	3	16	PP	75		39.4 1.44			.42		2	A	SPOT ONLY
3-9	4	16	PP	75		50.95 1.62			.52		2	A	SPOT ONLY
3-9	5	16	PP	100	15.8 1.4	15.6 1.6	15.4 2.0		.74		2	E	BR = 100% + 2
3-9	6	IMS 1044 16	PP	50		4.5 CCW CL			.58		1	A	SPOT ONLY

REVIEWED BY:
NDE SUPERVISOR S D Connelly DATE 3/10/81
QC SUPERVISOR [illegible] DATE 3/13/81
AUTHORIZED INSPECTOR W J Caldwell DATE 3-18-81

GE-U3

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 77609

CDS # 77607

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPuP 5751 REV. 6

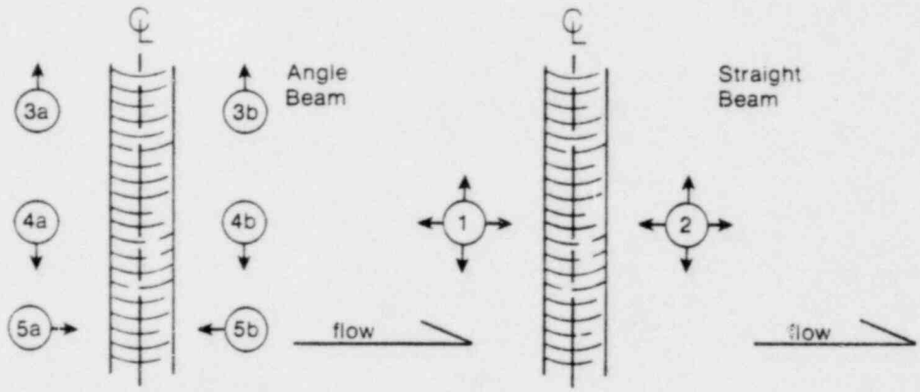
EXAMINATION PERSONNEL:
NAME [illegible] LEVEL II ; NAME M E Williams LEVEL II

SEARCH UNIT BEAM ANGLE: 0°; X 45°; ____ 60°; ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE 1981	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L 1/ W 1	L m/ W m	L 2/ W 2	MP 1	MP m	MP 2	SCAN	STAT.	COMMENTS
3-9	1	1MS1044 1	PP		P 1.02	CL 1.10	P 1.04					A	
3-9	2	1	PP	75		15.4 1.8			.88		2	A	SPOT ONLY
3-9	3	1	PP	50		21.52 2.5			.46		2	A	SPOT ONLY
3-9	4	1MS1044 1	PP	50		50.25 CL			.40		1	A	SPOT ONLY

REVIEWED BY:
NDE SUPERVISOR S D Connelly DATE 3/10/81
QC SUPERVISOR L D Whatley DATE 3/13/81
AUTHORIZED INSPECTOR W J Caldwell DATE 3-18-81

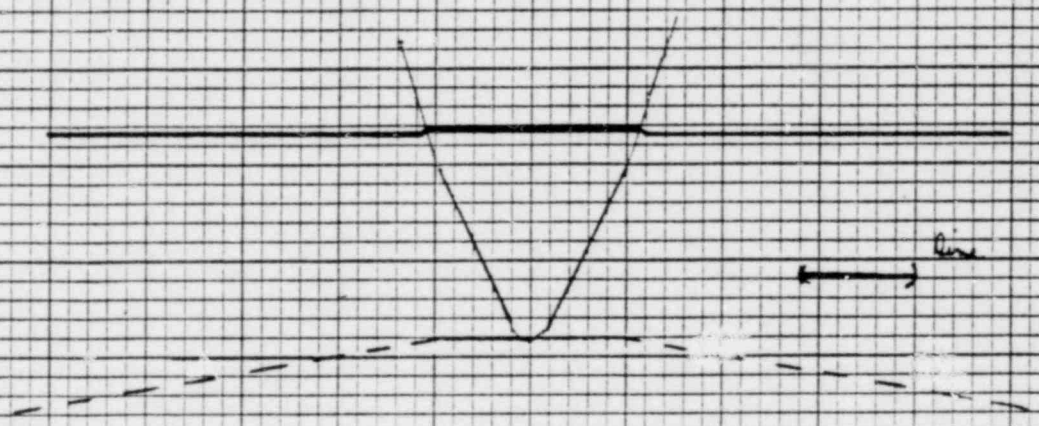
GE-U3

LASALLE UNIT 2 T = _____

WELD IMS-1044-16 T_W = _____

EDS 77608 T = _____

GENERAL ELECTRIC



LINE	EVALUATION
5	This is a base metal lamination. This is acceptable per Section XI Figure IWB-3360 as there is no total loss of back reflection & size does not exceed criteria per paragraph IWB-3514-2.

EVALUATED BY L D Whatley Level III DATE 3/13/81

REVIEWED BY W J Caldwell ANII DATE 3-18-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

CDS 77610
LDS. 0065

A. Procedure No. MPUP-5751 REV. 6

Examination Personnel: NAME EA Lomelin LEVEL II NAME ME Williams LEVEL II

Instrument: SERIAL NO. 521 MAKE/MODEL: – BRANSON/303: ☐ SONIC/MK I: ☒ KK/USL32: ☐ OTHER

D. Search Unit: BEAM ANGLE/MODE: ☐ STRAIGHT BEAM/LONG WAVE: ☒ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE

TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ☒ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz

SERIAL NO.: L07944 ; ☐ 1.0" DIA/2.25 MHz ☒ 0.5"x0.5"/2.25 MHz

TRANSDUCER TYPE: ☒ CERAMIC SINGLE ELEMENT ☐ CERAMIC DUAL ELEMENT ☐ OTHER

WEDGE TYPE: ☒ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE

CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = 44.5°

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ☒ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ☐ PARALLEL ☒ TRANSVERSE TO PIPE AXIS to hole center

FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ☐ PARALLEL ☐ TRANSVERSE

G. Calibration Standards: LSCS CAL. STD. NO. 01-26-02 THICKNESS 1.06" DIAMETER 26"

MATERIAL: ☒ CARBON ☐ STAINLESS ☐ INCONEL ☐ OTHER

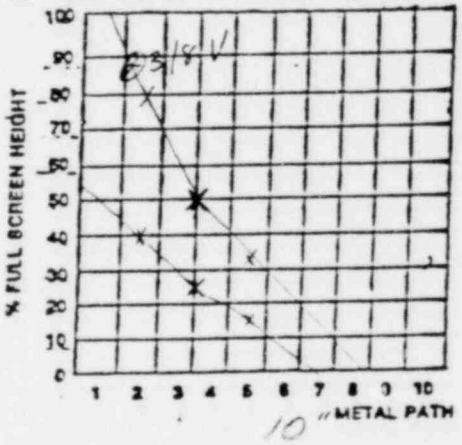
H. Couplant: ☒ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

I. Comments: +10 dB: 3/8 V To 100% DAC

J. Dac Curve — Data

REFLECTOR 00	PEAK AMP 01	W1 02	Wm 03	W2 04	MP1 05	MPm 06	MP2 07	HOLE DEPTH 08
W-T or 4 ft Vee	80		1.05			1.5		
W-T or 6 ft Vee	50		2.13			3.0		
W-T or 12 ft Vee	32		3.20			4.5		
B.R. or 3 ft Vee	100 +10		.82			1.1		.81

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	48	✓							
SCAN GAIN	56	✓							
SWEEP	10/956	✓							
DELAY	764	✓							
FILTER	AUTO	✓							
REP RATE	MED	✓							
DAMPENING	OFF	✓							
REJECT	OFF	✓							
OTHER	NA	✓							

M. Calibration Time — Records

DATE 1981	01 ORIG. CAL TIME	02 CAL. CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
3-9	1252	NA	NA	NA	Yes
3-9	NA	1535	77611	6	Yes
3-9	NA	1535	77612	8	Yes

N. Reviewed By: NDE SUPERVISOR [signature] DATE 3/10/81

Q.C. SUPERVISOR [signature] DATE 3/16/81

AUTHORIZED INSPECTOR [signature] DATE 3-18-81

GE-10/78 (U2)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 77611

CDS # 77610

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

EXAMINATION PERSONNEL:
NAME CA Homler LEVEL II ; NAME ME Williams LEVEL II

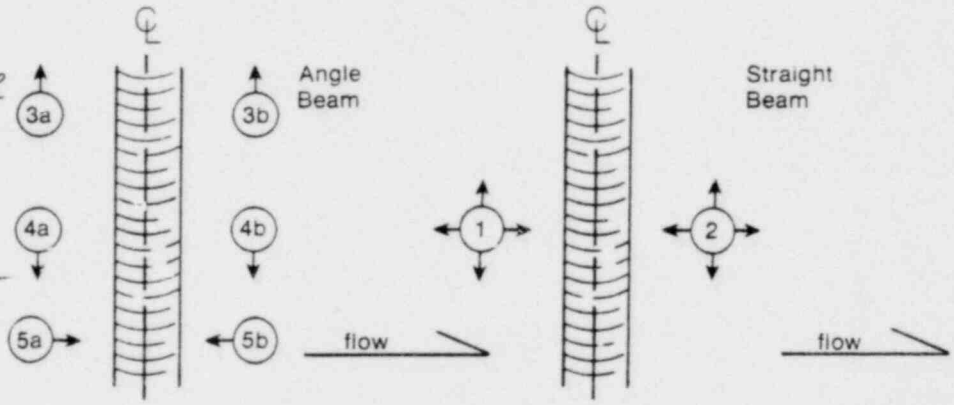
SEARCH UNIT BEAM ANGLE: 0°; ____ 45°; X 60°; ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION

★ INDICATIONS APPEAR INDIVIDUALLY & SIMULTANEOUSLY. POSSIBLE MODE CONVERSION. CAH



DATE 1981	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L 1/ W 1	L m/ W m	L 2/ W 2	MP 1	MP m	MP 2	SCAN	STAT.	COMMENTS
3-9	1	IMS1044 1	PP	75	360 INT	1.15			1.6		5A	E	
3-9	2	1	PP	100	360 INT	1.55			3.0		5A	A	★ FDFS
3-9	3	1	PP	60	360 INT	1.55			4.1		5A	E	★ FDFS
3-9	4	1	PP	50	360 INT	1.55			5.2		5A	E	★ FDFS
3-9	5	1	PP	100 +2	360 INT	1.5			3.0		5B	A	FDFS
3-9	6	MS-1044 1	PP	75	360 INT	3.0			4.6		5B	E	FDNS

REVIEWED BY:
NDE SUPERVISOR S D Connelly DATE 3/10/81

QC SUPERVISOR L D Whitley DATE 3/16/81

AUTHORIZED INSPECTOR W J Caldwell DATE 3-18-81

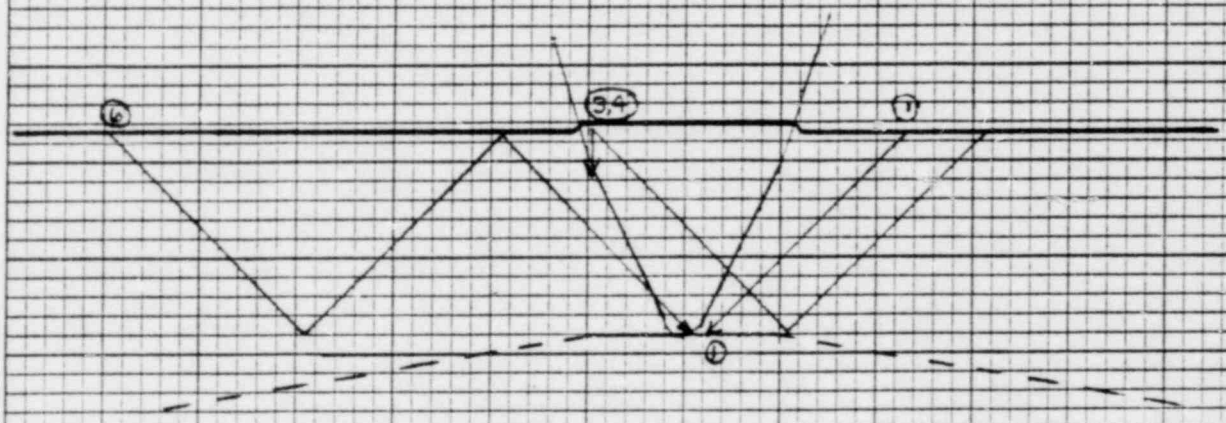
GE-U3

LASALLE UNIT 1 T_f = 1.02

WELD IMS-1044-1 T_W = 1.1

EDS 77611 T_f = 1.04

GENERAL ELECTRIC



LINE	EVALUATION
3,4	Mode conversion from weld toe
1,6	ID geometry from weld root

EVALUATED BY L D Wheatley Level III DATE 3/16/81

REVIEWED BY W J Caldwell ANII DATE 3-18-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 77612

CDS # 77610

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP 5751 REV. 6

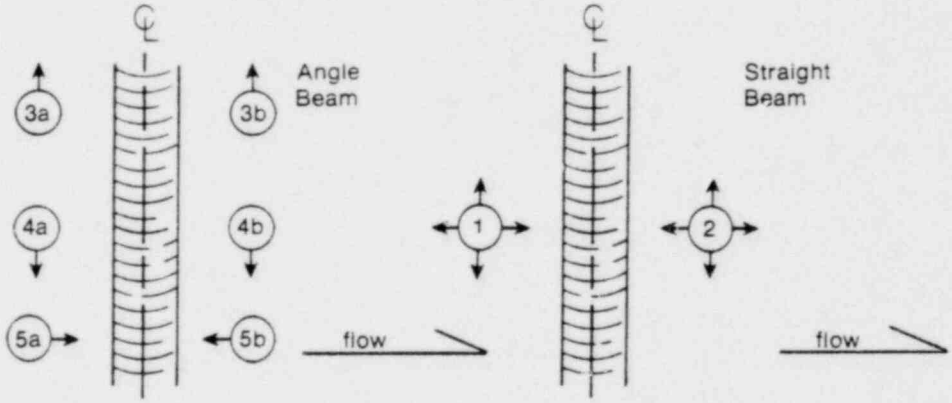
EXAMINATION PERSONNEL:
NAME CA Bomler LEVEL II; NAME ME Williams LEVEL IT

SEARCH UNIT BEAM ANGLE: 0°; ____ 45°; X 60°; ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE 1981	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L 1/ W 1	L m/ W m	L 2/ W 2	MP 1	MP m	MP 2	SCAN	STAT.	COMMENTS
3-9	1	IMS 1044 16	PP	100 +2	360 INT	1.35			3.0		5B	A	FDFS
3-9	2	16	PP	100 +4	360 INT	1.3			2.9		5A	A	FDFS
3-9	3	16	PP	90	360 INT	3.15			4.5		5A	E	FDNS
3-9	4	16	PP	60	360 INT	1.15			1.5		5A	E	
3-9	5	IMS 1044 31	PP	100 +2	360 INT	1.6			3.1		5B	A	FDFS
3-9	6	31	PP	100	360 INT	1.6			3.2		5A	A	FDFS
3-9	7	IMS 1044 46	PP	60	360 INT	1.55			3.0		5B	A	FDFS
3-9	8	46	PP	75	360 INT	1.50			2.9		5A	A	FDFS

REVIEWED BY:
NDE SUPERVISOR AD Connelly DATE 3/10/81

QC SUPERVISOR LD Whatley DATE 3/16/81

AUTHORIZED INSPECTOR WJ Caldwell DATE 3-18-81

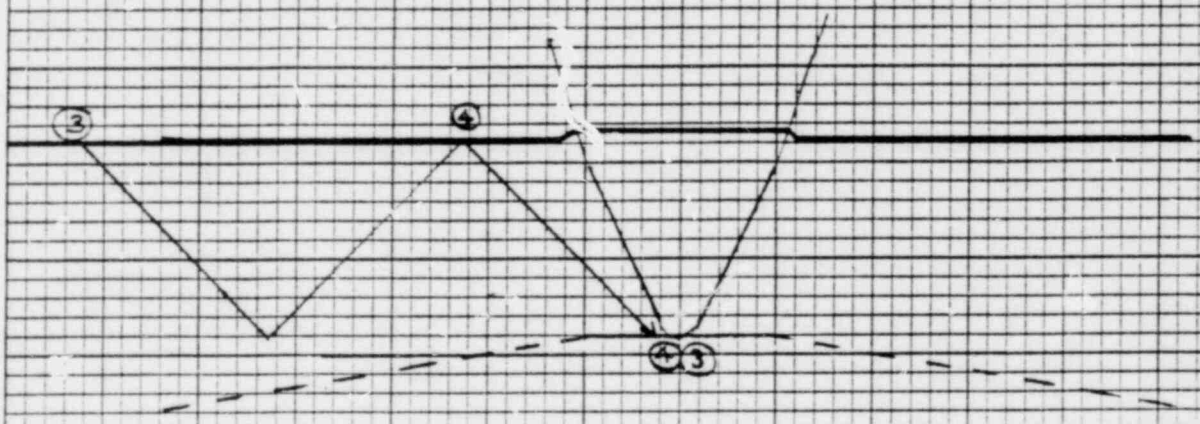
GE-U3

LASALLE UNIT 1 T_p = 1.04

WELD IMS-1044-16 T_W = 1.08

EDS 77612 T_p = 1.02

GENERAL ELECTRIC



LINE	EVALUATION
3,4	ID geometry from weld root

EVALUATED BY L D Whatley Level III DATE 3/16/81

REVIEWED BY W J Caldwell ANII DATE 3-18-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY NUCLEAR STATION UNIT 1

E.D.S. NO. 77613

A. PROCEDURE NO. PP-S751 REV. 7

B. EXAMINATION PERSONNEL:

NAME E A Hamler LEVEL II

NAME NA LEVEL NA

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 79B109

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 79E033

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☒ NO ☐
2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☒ NO ☐

b. SURFACE PREPARATION:

*1. GRINDING (*2.) FLAPPERING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

00 LINE NO.	01 DATE 1981	02 PRE-CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. *	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	13 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
1	3-26	5	10	5	15	1RH1023-16	CS	2	X		X		3/32" RDIND - IN weld @ Surf 1, 15.5" from 'V'
2	3-26	5	10	5	15	1RH1024-4A	CS	2		X	X		
3	3-26	5	10	5	15	1RH1024-4B	CS	2		X	X		
4	3-26	5	10	5	15	1RH1023-14	CS	2	X		X		1/8" RDIND - SURF. 1 TOE OF WELD 10.1" CCW FROM TDC
5													
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

* NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(s) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NCE SUPERVISOR S D Connelly DATE 3/27/81

QC SUPERVISOR [illegible] DATE 4/2/81

AUTHORIZED INSPECTOR W J Caldwell DATE 4-2-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY NUCLEAR STATION UNIT 1

E.D.S. NO. 77614

A. PROCEDURE NO. PP-S751 REV. 7

B. EXAMINATION PERSONNEL:

NAME [illegible] LEVEL II

NAME NA LEVEL NA

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 79B109

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 79E033

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES [X] NO [ ]
2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES [X] NO [ ]

b. SURFACE PREPARATION:

*1. GRINDING *2. FLAPPERING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CE

00 LINE NO.	01 DATE 1981	02 PRE-CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. *	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
1	3-27	5	10	5	15	1RH1023-9	CS	2		X	X		
2	3-27	5	10	5	15	1RH1023-8	CS	2		X	X		
3	3-27	5	10	5	15	1RH1023-7	CS	2		X	X		
4	3-27	5	10	5	15	1RH1023-4A	CS	2		X	X		CHECK MICROWELL - TDC
5	3-27	NA	NA	NA	NA	1RH-1023-4A	CS	2	NA	NA	NA	NA	IN WELD CL EXCAVATIONS
6						SEE INCR-106							
7													
8													
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(s) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR [illegible] DATE 3/30/81

QC SUPERVISOR [illegible] DATE 4/2/81

AUTHORIZED INSPECTOR W. J. Eldridge DATE 4-2-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS# 83035

CDS# 83034

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT I

PROCEDURE NO. MPUP - S751 REV. 6

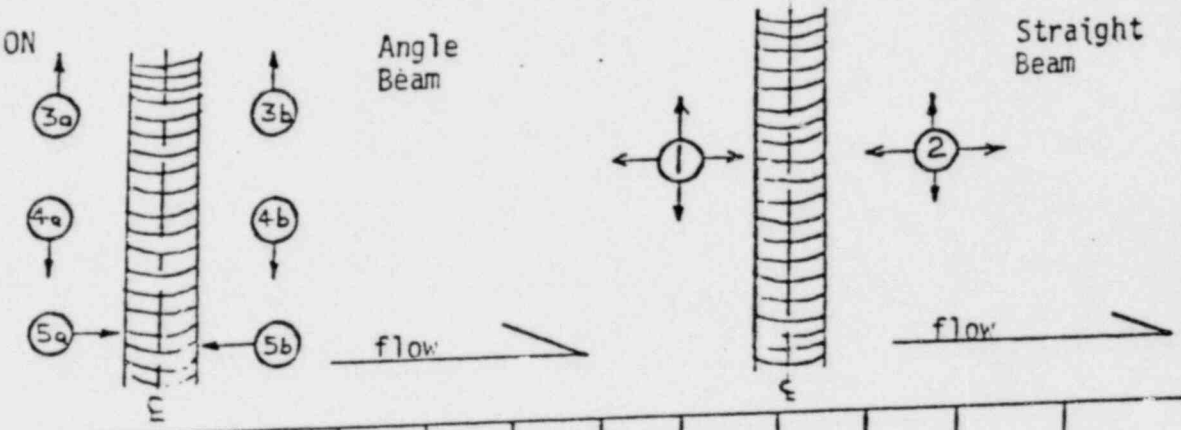
EXAMINATION PERSONNEL:
NAME F. Abuge, Jr. LEVEL II ; NAME NA LEVEL NA

SEARCH UNIT BEAM ANGLE: 0°; ___ 45°; ✓ 60°; ___ OTHER ___

COUPLANT: GLYCERINE: ✓ ULTRAGEL II: ___ OTHER ___

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L_1/W_1	L_m/W_m	L_2/W_2	MP_1	MP_m	MP_2	SCAN	STAT.	COMMENT
					360° INT.							*	OD FD
7/1/80	1	1R1-1022 -11	P-E	70%		.562			1.05		5a	A	FAR TOE
7/1/80	2	1R1-1022 -12	E-P									A	

REVIEWED BY:
NDE SUPERVISOR S D Connelly DATE 7/3/80
QC SUPERVISOR [illegible] DATE 7/9/80
AUTHORIZED INSPECTOR W D Caldwell DATE 3-26-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 85100

CDS # 85096

ULTRASONIC EXAMINATION DATA SHEET
LASALLE COUNTY STATION UNIT _____

A. Procedure No. MPUP 5751 REV. 3

B. Examination Personnel:
NAME [illegible] LEVEL II NAME Gary [illegible] LEVEL II

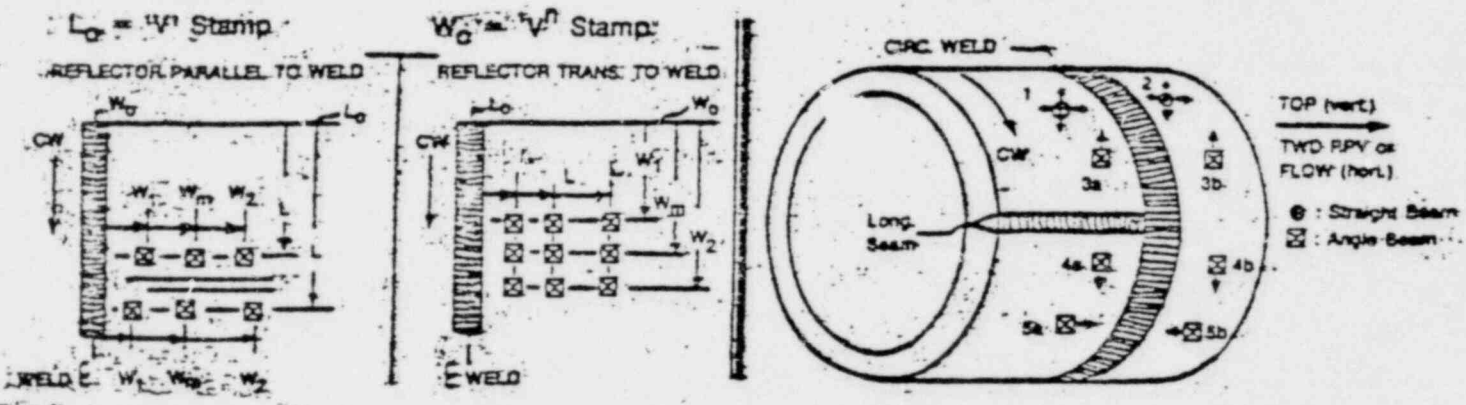
C. Search Unit Beam Angle (± 2°): ☐ 0° ☒ 45° ☐ 60° ☐ Other _____

D. Couplant: ☒ Glycerine ☐ Ultragel II ☐ Other _____

E. Scan Sensitivity: (+) 8 dB

F. Reference System

G. Scan Orientation



H. Data

00 DATE 1979	01 LINE NO.	02 EXAM/ COMP. I.D. NO.	03 COMP FIG.	04 REC. IND. YES/NO	05 MAX% DAC @ W_m	06 L_o / W_o	07 L	08 W_1	09 W_m	10 W_2	11 SRP_1 or MP_1	12 SRP_m or MP_m	13 SRP_2 or MP_2	14 SCAN	15 Comments (Thickness Meas.)
4/5	1	IMS-1044 13	P/E	Yes	50	* / E	14		13			60		5A	FINGER DAMP 360° INT
4/5	2	IMS-1044 13	P/E	Yes	50	* / E	19		16			32		5A	360° INT
4/5	3	IMS-1044 13	P/E	Yes	50	* / E	7		16			64		5B	FINGER DAMP 360° INT
4/5	4	IMS-1044 13	P/E	Yes	50	* / E	10		17			30		5B	360° INT
	5	*	Center of Weld STAMP												
	6														
	7														
	8														
	9														

I. Reviewed By:

NDE SUPERVISOR [illegible] Connelly DATE 4/6

QC SUPERVISOR: [illegible] Hartley DATE 4/17/79

AUTHORIZED INSPECTOR W J Caldwell DATE 3-26-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

CDS 85101
LDS 25745

A. Procedure No. MPUP-5751 REV. 3

Examination Personnel: NAME [illegible] LEVEL II NAME [illegible] LEVEL I-T

Instrument: SERIAL NO. 204503 MAKE/MODEL: – BRANSON/303: ☐ SONIC/MK I: ☐ KK/USL32: ☒ OTHER USM-2

D. Search Unit: BEAM ANGLE/MODE: ■ STRAIGHT BEAM/LONG WAVE: ☐ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE

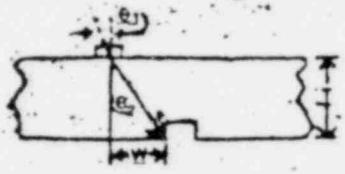
TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ☐ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz

SERIAL NO.: L20811 : ☐ 1.0" DIA/2.25 MHz ■ 0.5"x0.5"/2.25 MH_z

TRANSDUCER TYPE: ☐ CERAMIC SINGLE ELEMENT ■ CERAMIC DUAL ELEMENT ☐ OTHER

WEDGE TYPE: ■ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE

CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = N/A °



$\theta = \text{ARC TAN } (\frac{W}{T})$

T = CAL. STD. THICKNESS

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ■ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ■ PARALLEL ☐ TRANSVERSE TO PIPE AXIS to hole centerline

FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ■ PARALLEL ☐ TRANSVERSE

G. Calibration Standards: LSCS CAL. STD. NO. 01-24-02 THICKNESS .7 DIAMETER 24

MATERIAL: ■ CARBON ☐ STAINLESS ☐ INCONEL ☐ OTHER

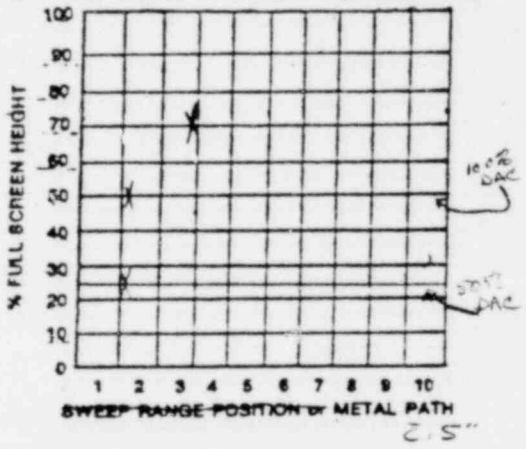
H. Couplant: ■ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

I. Comments:

J. Dac Curve — Data ☐ SRP; ☒ MP in Inches

ECTOR 00	PEAK AMP 01	W1 02	Wm 03	W2 04	SRP or 1 MP1 05	SRP or m MPm 06	SRP or 2 MPz 07	HOLE DEPTH 08
½ T or /8 Vee								
½ T or /8 Vee	50					.3		
¾ T or /8 Vee								
B.R. or /8 Vee	70					.7		.3

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	14	✓							
SCAN GAIN	22	✓							
SWEEP	2.5	✓							
DELAY	684	✓							
FILTER	Auto	✓							
REP RATE	Auto	✓							
DAMPENING	Auto	✓							
FT.	off	✓							
OTHER	N/A	✓							

M. Calibration Time — Records

DATE 1979	01 ORIG. CAL. TIME	02 CAL. CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
4/6	0900	—	—	—	Yes
4/6	—	1030	85102	2	Yes

N. Reviewed By: NDE SUPERVISOR [illegible] DATE 4/9/79

Q.C. SUPERVISOR [illegible] DATE 4/17/79

AUTHORIZED INSPECTOR [illegible] DATE 3-26-81

GE-10/78 (UZ)

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

CDS 85133
LDS 60099

A. Procedure No. MPUP-5751 REV. 3

Examination Personnel: NAME [illegible] LEVEL II NAME [illegible] LEVEL II

Instrument: SERIAL NO. 26680-1348 MAKE/MODEL: – BRANSON/303: ☐ SONIC/MK I: ☒ KK/USL32: ☐ OTHER

D. Search Unit: BEAM ANGLE/MODE: ☒ STRAIGHT BEAM/LONG WAVE: ☐ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE

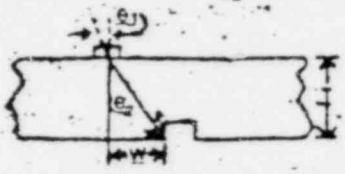
TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ☐ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz

SERIAL NO.: H 25833 ; ☐ 1.0" DIA/2.25 MHz ☒ 0.5"x0.5"/2.25 MHz

TRANSDUCER TYPE: ☐ CERAMIC SINGLE ELEMENT ☒ CERAMIC DUAL ELEMENT ☐ OTHER

WEDGE TYPE: ☒ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE

CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = N/A



θ = ARC TAN $(\frac{W}{T})$

T = CAL. STD. THICKNESS

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ☒ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ☒ PARALLEL ☐ TRANSVERSE TO PIPE AXIS to hole centerlin

FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ☒ PARALLEL ☐ TRANSVERSE

G. Calibration Standards: LSCS CAL. STD. NO. 01-24-08 THICKNESS 1.0 DIAMETER 24

MATERIAL: ☐ CARBON ☒ STAINLESS ☐ INCONEL ☐ OTHER

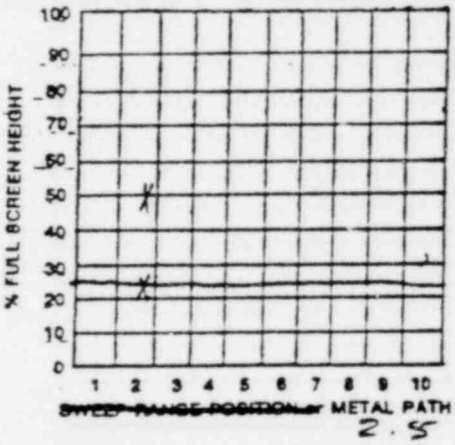
K. Couplant: ☒ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

L. Comments:

J. Dac Curve — Data ☐ SRP; ☒ MP in inches

REFLECTOR 00	PEAK AMP 01	W1 02	Wm 03	W2 04	SRP or 1 MP1 05	SRP or m MPm 06	SRP or 2 MP2 07	HOLE DEPTH 08
¼ T or /8 Vee								
½ T or /8 Vee	50					.45		.45
¾ T or /8 Vee								
B.R. or /8 Vee						1.0		

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	36	✓							
SCAN GAIN	44	✓							
SWEEP	2.5/642	✓							
DELAY	948	✓							
FILTER	Auto	✓							
REP RATE	Auto	✓							
DAMPENING	Auto	✓							
REJECT	Off	✓							
OTHER	N/A	✓							

M. Calibration Time — Records

DATE 1979	01 ORIG. CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
4/12	1530	—	—	—	Yes
4/12	—	1630	85134	1	Yes

N. Reviewed By: NDE SUPERVISOR [illegible] DATE 4/13/79

Q.C. SUPERVISOR [illegible] DATE 4/13/79

AUTHORIZED INSPECTOR [illegible] DATE 3-26-81

GE-10/78 (U2)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 85134

CDS # 85133

ULTRASONIC EXAMINATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

A. Procedure No. MPUP S751 REV. 3

B. Examination Personnel:
NAME [illegible] LEVEL II NAME Gary R. Webb LEVEL II

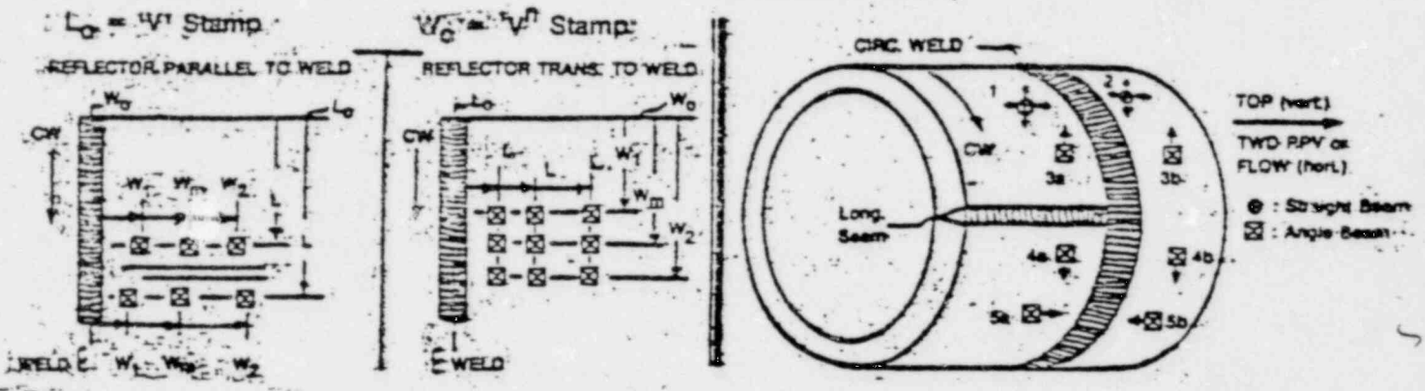
C. Search Unit Beam Angle (± 2°): ☒ 0° ☐ 45° ☐ 60° ☐ Other

D. Couplant: ☒ Glycerine ☐ Ultragel II ☐ Other

E. Scan Sensitivity: (+) 8 dB

F. Reference System

G. Scan Orientation



H. Data

DATE 1979	01 LINE NO.	02 EXAM/ COMP. I.D. NO.	03 COMP FIG.	04 REC. IND. YES/ NO	05 MAX% DAC @ W_m	06 L_o / W_o	07 L	08 W_1	09 W_m	10 W_2	11 SRP_1 or MP_1	12 SRP_m or MP_m	13 SRP_2 or MP_2	14 SCAN	15 Comments (Thickness Meas.)
4/12	1	IRE-1007 1	R/SE	NO		/									1.2" T
	2					/									
	3					/									
	4					/									
	5					/									
	6					/									
	7					/									
	8					/									
	9					/									

I. Reviewed By:

NDE SUPERVISOR [illegible] DATE 4/13/79

QC SUPERVISOR: [illegible] DATE 4/17/79

3 AUTHORIZED INSPECTOR W J Caldwell DATE 3-26-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET
LASALLE COUNTY STATION (UNIT 1)

CDS 85135
LDS 60099

A. Procedure No. MPUP-5751 REV. 3

Examination Personnel: NAME B.W. Wachuck LEVEL II NAME Gary K. [illegible] LEVEL II

Instrument: SERIAL NO. 26680-1348 MAKE/MODEL: – BRANSON/303: ☐ SONIC/MK I: ■ KK/USL32: ☐ OTHER

D. Search Unit: BEAM ANGLE/MODE: ☐ STRAIGHT BEAM/LONG WAVE: ■ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE

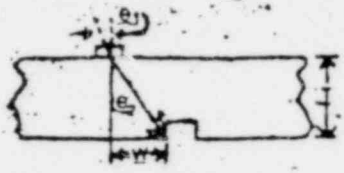
TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ■ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz

SERIAL NO.: D 05861 ; ☐ 1.0" DIA/2.25 MHz ☐ 0.5"x0.5"/2.25 MHz

TRANSDUCER TYPE: ■ CERAMIC SINGLE ELEMENT ☐ CERAMIC DUAL ELEMENT ☐ OTHER

WEDGE TYPE: ■ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE

CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = 45°



$\theta = \text{ARC TAN } (\frac{W}{T})$

T = CAL. STD. THICKNESS

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ■ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ■ PARALLEL ☐ TRANSVERSE TO PIPE AXIS to hole centerlin

FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ☐ PARALLEL ☐ TRANSVERSE

G. Calibration Standards: LSCS CAL. STD. NO. 01-18-01 THICKNESS .62 DIAMETER 18

MATERIAL: ■ CARBON ☐ STAINLESS ☐ INCONEL ☐ OTHER

H. Couplant: ■ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

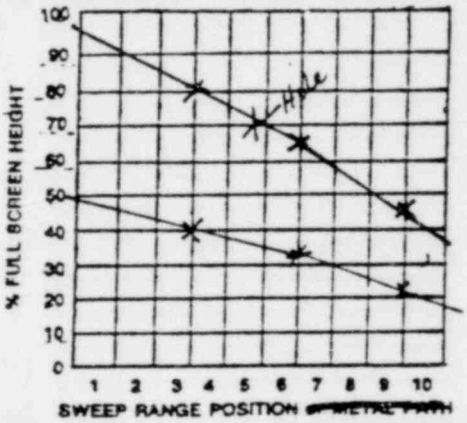
I. Comments: +10dB To bring Hole To 100% DAC

I.D. Corner used to determine beam angle

J. Dac Curve — Data ■ SRP; ☐ MP in inches

SELECTOR 00	PEAK AMP 01	W1 02	Wm 03	W2 04	SRP or 1 MPt 05	SRP or m MPm 06	SRP or 2 MPz 07	HOLE DEPTH 08
½ T or /8 Vee	80		.62			30		
½ T or /8 Vee	65		1.2			60		
½ T or /8 Vee	45		1.75			90		
B.R. or /8 Vee	70		1.0			46		.2

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	44	✓							
SCAN GAIN	52	✓							
SWEEP	7.5/616	✓							
DELAY	756	✓							
FILTER	Auto	✓							
REP RATE	Auto	✓							
DAMPENING	Auto	✓							
REJECT	off	✓							
OTHER	N/A	✓							

M. Calibration Time — Records

DATE 1979	01 ORIG. CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
4/12	1400	—	—	—	YES
4/12	—	1530	85136	8	YES

N. Reviewed By: NDE SUPERVISOR [signature] DATE 4/16/79

Q.C. SUPERVISOR Dave Holstrom DATE 4-20-79

AUTHORIZED INSPECTOR W. J. Cathcart DATE 3-26-81

GE-10/78 (U2)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

CDS 88015
LDS 0002

Procedure No. MPUP-5751 REV. 4

Examination Personnel: NAME RF Pollmann LEVEL II NAME Gary E. Wells LEVEL I T

Instrument: SERIAL NO. 522 MAKE/MODEL: – BRANSON/303: ☐ SONIC/MK4: ■ KK/USL32: ☐ OTHER

D. Search Unit: BEAM ANGLE/MODE: ☐ STRAIGHT BEAM/LONG WAVE: ■ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE

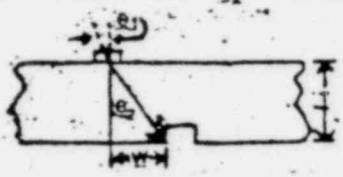
TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ■ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz

SERIAL NO.: 005954 ; ☐ 1.0" DIA/2.25 MHz ■ 0.5"x0.5"/2.25 MHz

TRANSDUCER TYPE: ■ CERAMIC SINGLE ELEMENT ☐ CERAMIC DUAL ELEMENT ☐ OTHER

WEDGE TYPE: ■ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE

CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = 45°



θ = ARC TAN $(\frac{W}{T})$

T = CAL. STD. THICKNESS

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ■ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ■ PARALLEL ☐ TRANSVERSE TO PIPE AXIS to hole centerline

FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ☐ PARALLEL ☐ TRANSVERSE

G. Calibration Standards: LSCS CAL. STD. NO. 01-17-01 THICKNESS .47 DIAMETER 12

MATERIAL: ■ CARBON ☐ STAINLESS ☐ INCONEL ☐ OTHER

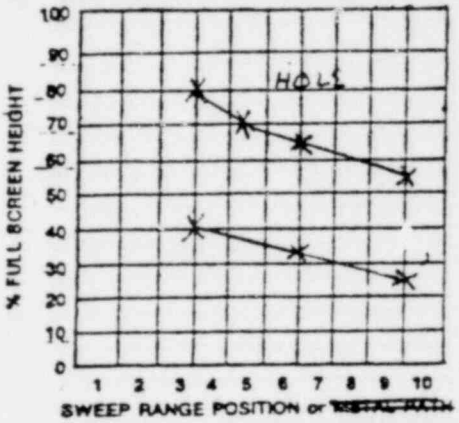
H. Couplant: ■ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

I. Comments: +9dB To Bring References Hole To 100% Dac

J. Dac Curve — Data ■ SRP; ☐ MP in inches

CTOR 00	PEAK AMP 01	W1 02	Wm 03	W2 04	SRP or 1 ~~MPH~~ 05	SRP or m ~~MPm~~ 06	SRP or 2 ~~MPH~~ 07	HOLE DEPTH 08
¼ T or 4/8 Vee	80		.42			30		
½ T or 8/8 Vee	65		1.0			60		
¾ T or 12/8 Vee	55		1.4			90		
B.R. or 6/8 Vee	70		.6			48		.59

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	42	✓	✓	✓					
SCAN GAIN	50	✓	✓	✓					
SWEEP	2.5/4.18	✓	✓	✓					
DELAY	7.56	✓	✓	✓					
FILTER	AUTO	✓	✓	✓					
REP RATE	AUTO	✓	✓	✓					
DAMPENING	AUTO	✓	✓	✓					
[illegible]ST	OFF	✓	✓	✓					
[illegible]KER	N/A	✓	✓	✓					

M. Calibration Time — Records

DATE 1979	01 ORIG. CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
4/26	8:00am	12:00am	88016 3-3	5	Yes
4/26		12:30am			Yes
4/26		3:00am			Yes

N. Reviewed By: NDE SUPERVISOR SD Connelly DATE 4/27/79

Q.C. SUPERVISOR [illegible] DATE 5/21/79

AUTHORIZED INSPECTOR [illegible] DATE 3-26-81

GE-10/78 (U2)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

CDS 88023
LDS 0002

A. Procedure No. MPUP-5751 REV. 4

Examination Personnel: NAME [illegible] LEVEL II NAME [illegible] LEVEL I

Instrument: SERIAL NO. 522 MAKE/MODEL: – BRANSON/303: ☐ SONIGAGE I: ☒ KK/USL32: ☐ OTHER

D. Search Unit: BEAM ANGLE/MODE: ☐ STRAIGHT BEAM/LONG WAVE: ☒ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE

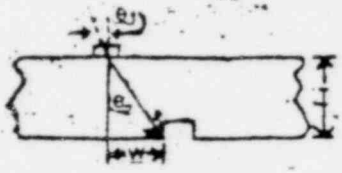
TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ☒ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz

SERIAL NO.: D05561 ; ☐ 1.0" DIA/2.25 MHz ☒ 0.5"x0.5"/2.25 MH_z

TRANSDUCER TYPE: ☒ CERAMIC SINGLE ELEMENT ☐ CERAMIC DUAL ELEMENT ☐ OTHER

WEDGE TYPE: ☒ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE

CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = 45°



θ = ARC TAN $(\frac{W}{T})$

T = CAL. STD. THICKNESS

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ☒ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ☒ PARALLEL ☐ TRANSVERSE TO PIPE AXIS to hole centerline

FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ☐ PARALLEL ☐ TRANSVERSE

G. Calibration Standards: LSCS CAL. STD. NO. 01-18-01 THICKNESS .55 DIAMETER 18"

MATERIAL: ☒ CARBON ☐ STAINLESS ☐ INCONEL ☐ OTHER

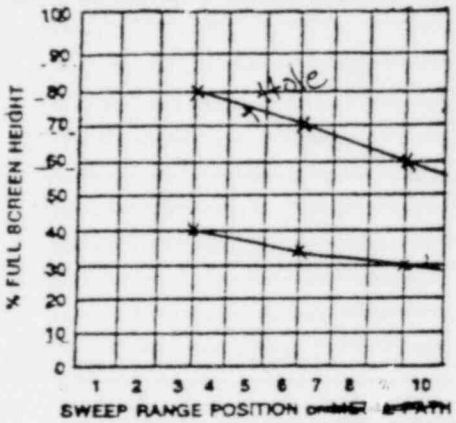
H. Couplant: ☒ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

I. Comments: T8JB needed to bring reference hole to DAC.

J. Dac Curve — Data ☒ SRP; ☐ MP in Inches

ECTOR 00	PEAK AMP 01	W1 02	Wm 03	W2 04	SRP or 1 MP1 05	SRP or m MPm 06	SRP or 2 MP2 07	HOLE DEPTH 08
¼ T or 4/8 Vee	80		.55			30		
½ T or 8/8 Vee	70		1.15			60		
¾ T or 12/8 Vee	60		1.7			90		
B.P. or 6/8 Vee	75		.8			46		.77

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	40	✓	✓	✓					
SCAN GAIN	48	✓	✓	✓					
SWEEP	2.5/6.9	✓	✓	✓					
DELAY	7.56	✓	✓	✓					
FILTER	Auto	✓	✓	✓					
REP RATE	Auto	✓	✓	✓					
DAMPENING	OFF	✓	✓	✓					
CT	OFF	✓	✓	✓					
OTHER	N/A	✓	✓	✓					

M. Calibration Time — Records

DATE 00	01 ORIG. CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
5/2	8:00 am	12:00 pm			Yes
5/2		12:30 pm			Yes
5/2		3:00 pm	88024 P2F2	#6	Yes

N. Reviewed By: NDE SUPERVISOR [illegible] DATE 5/3/79

Q.C. SUPERVISOR [illegible] DATE 5/9/79

AUTHORIZED INSPECTOR [illegible] DATE 3-26-81

GE-10/78 (U2)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 88024

CDS # 88023

ULTRASONIC EXAMINATION DATA SHEET
LASALLE COUNTY STATION UNIT I

A. Procedure No. MPUP-5751 REV. 4

B. Examination Personnel:
NAME [illegible] LEVEL II NAME Roy [illegible] LEVEL I

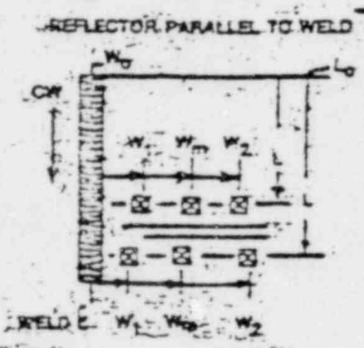
C. Search Unit Beam Angle (± 2°): ☐ 0° ☒ 45° ☐ 60° ☐ Other

D. Couplant: ☒ Glycerine ☐ Ultragel II ☐ Other

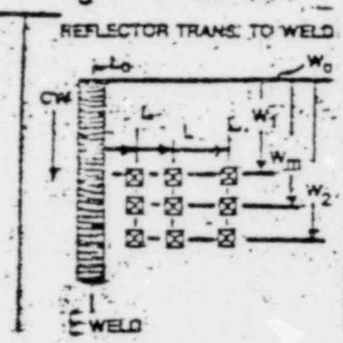
E. Scan Sensitivity: (+) 8 dB

F. Reference System

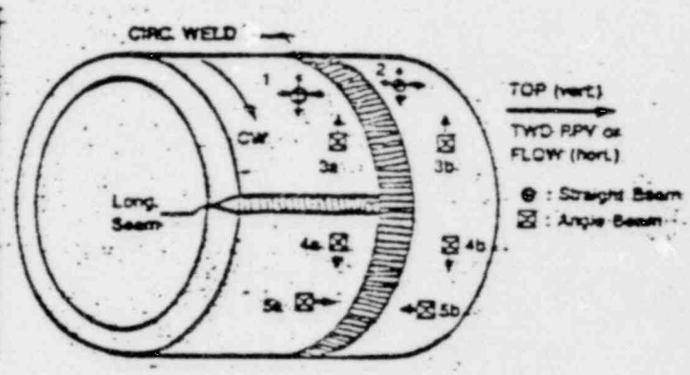
L_o = "V" Stamp



W_o = "V" Stamp



G. Scan Orientation



H. Data

00 DATE	01 LINE NO.	02 EXAM/ COMP. I.D. NO.	03 COMP FIG.	04 REC. IND. YES/ NO	05 MAX% DAC @ W_m	06 L_o / W_o	07 L	08 W_1	09 W_m	10 W_2	11 SRP_1 or MP_1	12 SRP_m or MP_m	13 SRP_2 or MP_2	14 SCAN	15 Comments (Thickness Meas.)
5/2/79	1	IRH 1006-1	E/T	YES	80	TDC/X	0		.95			70		5A	SCANNED ELBOW SIDE only - INTERM
5/2/79	2	IRH 1006-5	P/T	YES	100	TDC/X	0		2.3			28		5B	SCANNED PIPE SIDE only - (SPOT)
5/2/79	3	IRH 1006-14	P/E	YES	100+	V/X	CCW 12		1.25			98		5B	Intermittent
5/2/79	4	IRH 1006-14	P/E	YES	70	V/X	CCW 10.9		.95			75		5B	Intermittent
5/2/79	5	IRH 1006-14	P/E	YES	80	V/X	CCW 11.0		.95			68		5B	Intermittent
5/2/79	6	IRH 1006-14	P/E	YES	85	V/X	CCW 19.1		1.15			90		5B	Intermittent
5/2/79	7	IRH 1006-14	P/E	YES	100+	V/X	CW 9.75		.85			62		5B	Intermittent
5/2/79	8	IRH 1006-14	P/E	YES	90	V/X	CW 6.75		1.6			90		5A	Intermittent
5/2/79	9	IRH 1006-14	P/E	YES	50	V/X	CCW 31.9		1.45			48		5A	Intermitten

I. Reviewed By:

NDE SUPERVISOR [illegible] DATE 5/3/79

QC SUPERVISOR: [illegible] DATE 5/9/79

AUTHORIZED INSPECTOR [illegible] DATE 3-26-81

3

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

CDS 92278
I.DS. CC64

A. Procedure No. MPUP-S751 REV. 6

Examination Personnel: NAME [illegible] LEVEL II NAME [illegible] LEVEL II

Instrument: SERIAL NO. 1348 MAKE/MODEL: – BRANSON/303: ☐ SONIC/MK I: ☒ KK/USL32: ☐ OTHER

D. Search Unit: BEAM ANGLE/MODE: ☐ STRAIGHT BEAM/LONG WAVE: ☒ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE

TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ☒ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz

SERIAL NO.: D05854 ☐ 1.0" DIA/2.25 MHz ☒ 0.5"x0.5"/2.25 MHz

TRANSDUCER TYPE: ☒ CERAMIC SINGLE ELEMENT ☐ CERAMIC DUAL ELEMENT ☐ OTHER

WEDGE TYPE: ☒ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE

CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = 45.7 °

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ☒ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ☐ PARALLEL ☒ TRANSVERSE TO PIPE AXIS to hole center

FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ☐ PARALLEL ☐ TRANSVERSE

G. Calibration Standards: LSCS CAL. STD. NO. 01-10-01 THICKNESS .75 DIAMETER 10"

MATERIAL: ☒ CARBON ☐ STAINLESS ☐ INCONEL ☐ OTHER

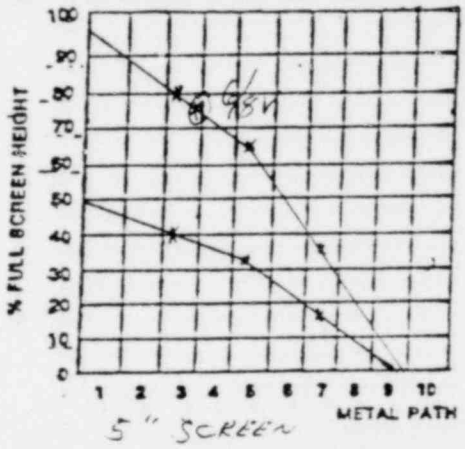
H. Couplant: ☒ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

I. Comments: + 12 db TO BRING 6/8 V TO 100% DAC

J. Dac Curve — Data

REFLECTOR 00	PEAK AMP 01	W1 02	Wm 03	W2 04	MP1 05	MPm 06	MP2 07	HOLE DEPTH 08
¼ T or 4T/8 Vee	80%		.81			1.1		
½ T or 5T/8 Vee	65%		1.58			2.2		
¾ T or 6T/8 Vee	35%		2.27			3.25		
B.P. or 6T/8 Vee	100% + 12 db		1.05			1.4		37

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	46	✓							
SCAN GAIN	54	✓							
SWEEP	2.5 / 867	✓							
DELAY	757	✓							
FILTER	AUTO	✓							
REP RATE	MED	✓							
DAMPENING	OFF	✓							
REJECT	OFF	✓							
OTHER	NA	✓							

M. Calibration Time — Records

DATE 1981	01 ORIG. CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
3-9	1305	NA	NA	NA	YES
3-9	NA	1510	92279	6	YES

N. Reviewed By: NDE SUPERVISOR [illegible] DATE 3/11/81

Q.C. SUPERVISOR [illegible] DATE 3/16/81

AUTHORIZED INSPECTOR [illegible] DATE 3-18-81

GE-70/78 (U2)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 92279

CDS # 92278

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP-S75-1 REV. 6

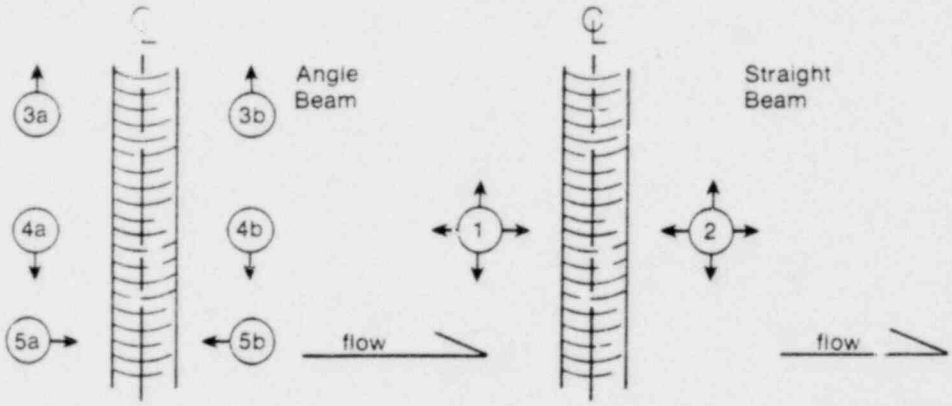
EXAMINATION PERSONNEL:
NAME [illegible] LEVEL II ; NAME [illegible] LEVEL II

SEARCH UNIT BEAM ANGLE: 0°; ____ 45°; X 60°; ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



1981 DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L 1/ W 1	L m/ W m	L 2/ W 2	MP 1	MP m	MP 2	SCAN	STAT.	COMMENTS
3-9	1	IR1-1615 1A	E-P	NO SCAN (5A)	SCAN (5B) LTD TO 1.5"	(5B) FROM 4.5" TO 6" FROM 6" CW	FROM 4.5" TO 6" TO 5" CCW						DUE TO WIRE ROPE U-BOLT FROM "V"
3-9	2	1A	E-P	DUE TO WIRE ROPE									
3-9	3	1A	E-P	100%	360 INT .75				2.15		5B	A	FDFT
3-9	4	1A	E-P	60%	360 INT 1.7				1.0		5B	E	
3-9	5	1A	E-P	100% +2	360 INT .7				1.95		5A	A	FDFT
3-9	6	1A	E-P	75%	360 INT 1.75				1.15		5A	E	

REVIEWED BY:
NDE SUPERVISOR S D Connelly DATE 3/11/81
QC SUPERVISOR L W Whatley DATE 3/16/81
AUTHORIZED INSPECTOR W J Caldwell DATE 3-18-81

GE-U3

LASALLE UNIT 1

WELD IRI-1015-1A

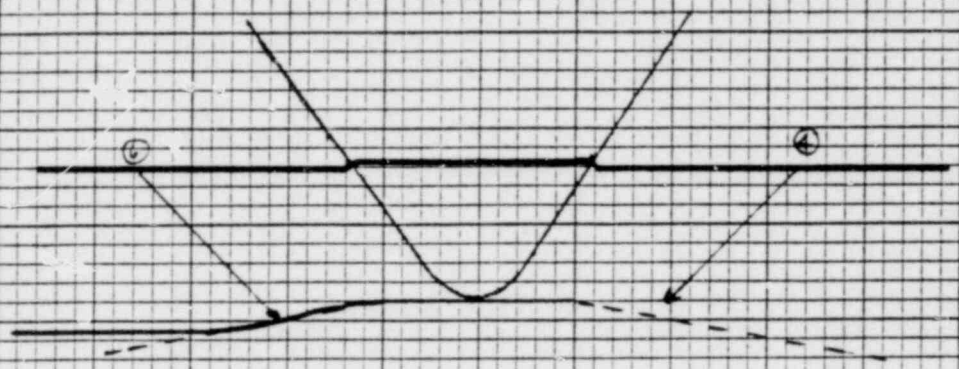
EDS 92279

T_E = .83

T_W = .73

T_F = .73

GENERAL ELECTRIC



LINE	EVALUATION
4,6	ID geometry from centerbore

EVALUATED BY L.D. Whatley Level III DATE 3/16/81

REVIEWED BY W. J. Caldwell ANII DATE 3-18-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

CDS 92280
LDS 0069

A. Procedure No. MPUP-5751 REV. 6

Examination Personnel: NAME [illegible] LEVEL II NAME [illegible] LEVEL II

Instrument: SERIAL NO. 1398 MAKE/MODEL: – BRANSON/303: ☐ SONIC/MK I: ☒ KK/USL32: ☐ OTHER

D. Search Unit: BEAM ANGLE/MODE: ☐ STRAIGHT BEAM/LONG WAVE: ☒ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE

TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ☒ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz

SERIAL NO.: DC5854 : ☐ 1.0" DIA/2.25 MHz ☒ 0.5"x0.5"/2.25 MHz

TRANSDUCER TYPE: ☒ CERAMIC SINGLE ELEMENT ☐ CERAMIC DUAL ELEMENT ☐ OTHER

WEDGE TYPE: ☒ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE

CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = 45.7 °

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ☒ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ☐ PARALLEL ☒ TRANSVERSE TO PIPE AXIS to hole centerli

FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ☐ PARALLEL ☐ TRANSVERSE

G. Calibration Standards: LSCS CAL STD. NO. C1-10-C1 THICKNESS .75 DIAMETER 10"

MATERIAL: ☒ CARBON ☐ STAINLESS ☐ INCONEL ☐ OTHER

H. Couplant: ☒ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

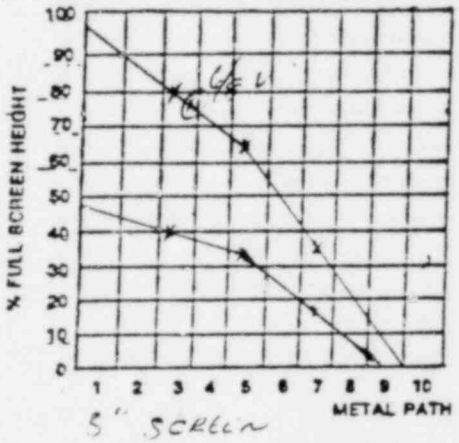
I. Comments:

+10 dB TO BRING 4/8 U TO 100% DAC

J. Dac Curve — Data

REFLECTOR 00	PEAK AMP 01	W1 02	Wm 03	W2 04	MP1 05	MPm 06	MP2 07	HOLE DEPTH 08
¼ T or 4/8 Vee	80%		.81			1.1		
½ T or 8/8 Vee	65%		1.55			2.2		
¾ T or 12/8 Vee	35%		2.27			3.25		
B.R. or 6/8 Vee	100% 60%		1.05			1.4		.37

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	44	✓							
SCAN GAIN	52	✓							
SWEEP	2.5/867	✓							
DELAY	757	✓							
FILTER	AUTO	✓							
REP RATE	MED	✓							
DAMPENING	OFF	✓							
CT	OFF	✓							
OTHER	NA	✓							

M. Calibration Time — Records

DATE 1981	01 ORIG. CAL TIME	02 CAL CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
3-10	0830	NA	NA	NA	YES
3-10	NA	1205	92281	4	YES
3-10	NA	1205	92282	8	YES
3-10	NA	205	92282	6	YES

N. Reviewed By: NDE SUPERVISOR [illegible] DATE 3/11/81

Q.C. SUPERVISOR [illegible] DATE 4/2/81

AUTHORIZED INSPECTOR [illegible] DATE 4-6-81

GE-70/78 (U2)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 92281

CDS # 92280

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP - S 751 REV. 6

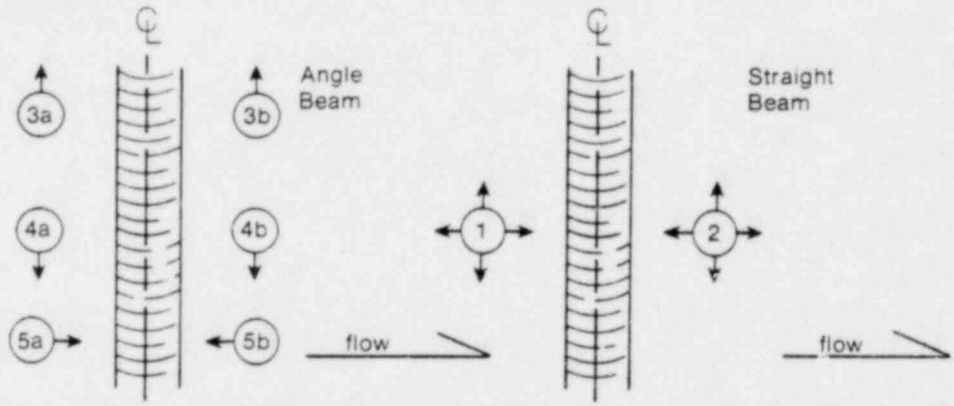
EXAMINATION PERSONNEL:
NAME [illegible] LEVEL II ; NAME [illegible] LEVEL II

SEARCH UNIT BEAM ANGLE: 0°: ____ 45°: X 60°: ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION



DATE 1981	LINE NO.	EXAM I.D.	CC..IP FIG.	MAX AMP	L_1/ W_1	L_m/ W_m	L_2/ W_2	MP_1	MP_m	MP_2	SCAN	STAT.	COMMENTS
3-10	1	IR1-1014 7	E-P	75%		360° / 1.3	INT		2.3		5A	A	FDFT
3-10	2	7	E-P	70%		360° / 2.2	INT		3.6		5A	E	FDNS
3-10	3	7	E-P	55%		360° / 1.2	INT		1.05		5B	E	
3-10	4	7	E-P	80%		360° / 1.1	INT		2.25		5B	A	FDFT

REVIEWED BY:
NDE SUPERVISOR S D Connelly DATE 3/11/81
QC SUPERVISOR L D Heatley DATE 4/2/81
AUTHORIZED INSPECTOR W J Caldwell DATE 4-6-81

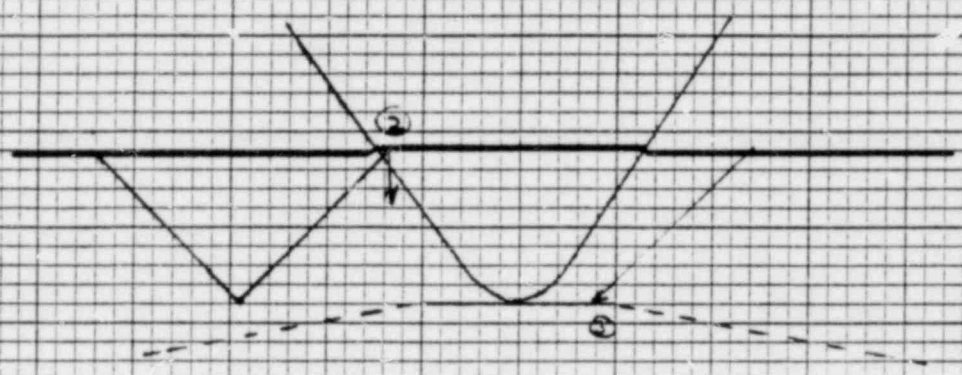
GE-U3

LASALLE UNIT 2 T_p = .71

WELD 1R1-1014-7 T_w = .82

EDS 92281 T_c = .81

GENERAL ELECTRIC



LINE	EVALUATION
2	Mode conversion off, weld cap
3	ID geometry

EVALUATED BY L W Whatley Level III DATE 4/2/81

REVIEWED BY W J Caldwell ANII DATE 4-6-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS # 92282

CDS # 92280

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP-5751 REV. 6

EXAMINATION PERSONNEL:
NAME [signature] LEVEL II ; NAME [signature] LEVEL II

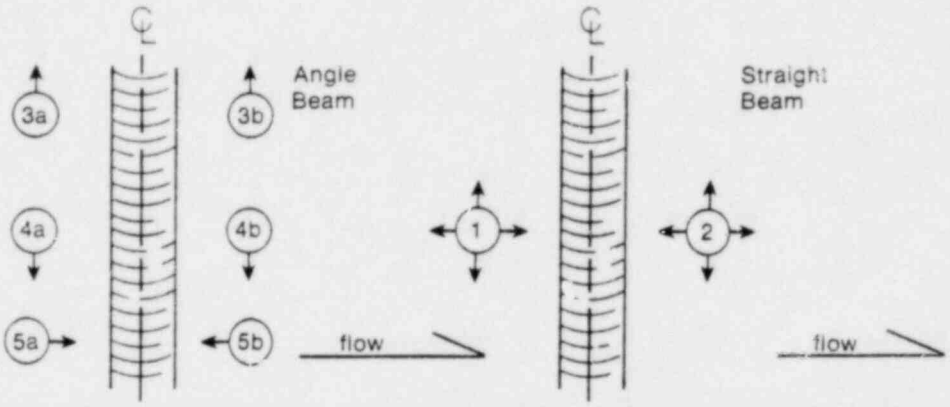
SEARCH UNIT BEAM ANGLE: 0°; ____ 45°; X 60°; ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION

*: APPEAR SAME TIME ON CRT



1981 DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L_1/ W_1	L_m/ W_m	L_2/ W_2	MP_1	MP_m	MP_2	SCAN	STAT.	COMMENTS
3-10	1	IR1-1015 1B	E-E	100%	360 INT	1.5			1.05		5A	E	
3-10	2	1B	E-E	100%	360 INT	1.7			2.7		5A	E	FDNS
3-10	3	1B	E-E	90%	5.75 / 1.45	8.0 / 1.6	11.0 / 1.8	1.85	1.95	2.15	5A	E	
3-10	4	1B	E-E	90%	360 INT	1.9			2.2		5A	A	FDNT
3-10	5	1B	E-E	60%	360 INT	2.0			2.1		5B	A	FDNT
3-10	6	1B	E-E	75%	360 INT	1.4			2.65		5B	E	FDWC *
3-10	7	1B	E-E	50%	360 INT	1.4			2.45		5B	E	FDWC *
3-10	8	1B	E-E	100% +2	360 INT	1.4			3.3		5B	E	FDWC *

REVIEWED BY:
NDE SUPERVISOR [signature] DATE 3/11/81

QC SUPERVISOR [signature] DATE 4/2/81

AUTHORIZED INSPECTOR [signature] DATE 4-6-81

GE-U3

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

PAGE 2 OF 2

EDS # 92282

CDS # 92280

EXHIBIT 3

ULTRASONIC EXAMINATION DATA SHEET

LaSALLE COUNTY NUCLEAR STATION UNIT 1

PROCEDURE NO. MPUP-5751 REV. 6

EXAMINATION PERSONNEL:
NAME [illegible] LEVEL II ; NAME [illegible] LEVEL II

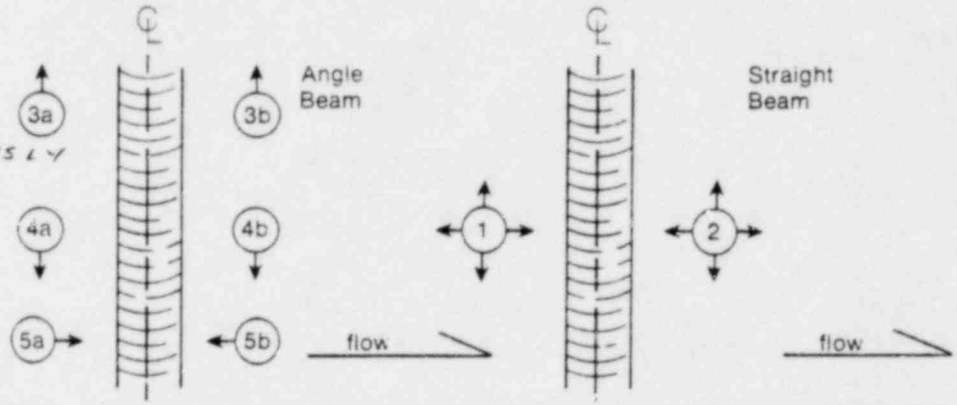
SEARCH UNIT BEAM ANGLE: 0°: ____ 45°: X 60°: ____ OTHER ____

COUPLANT: GLYCERINE: X ULTRAGEL II: ____ OTHER ____

SCAN SENSITIVITY: (+) 8 dB

SCAN ORIENTATION

*- INDICATIONS APPEAR SIMULTANEOUSLY ON CRT SCREEN



1981 DATE	LINE NO.	EXAM I.D.	COMP FIG.	MAX AMP	L 1/ W 1	L m/ W m	L 2/ W 2	MP 1	MP m	MP 2	SCAN	STAT.	COMMENTS
3-10	1	IR1-1015 1B	E-E	100% +2	360 INT	1.4			3.5		5B	E	FDWC *
3-10	2	IR1-1014 4	P-E	90%	360 INT	1.1			2.1		5A	A	FDFT
3-10	3	4	P-E	65%	360 INT	1.0			2.05		5B	A	FDFT
3-10	4	4	P-E	75%	360 INT	1.4			2.45		5B	E	FDWC *
3-10	5	4	P-E	75%	360 INT	1.4			2.7		5B	E	FDWC *
3-10	6	4	P-E	80%	360 INT	1.4			1.0		5B	E	

REVIEWED BY:
NDE SUPERVISOR [illegible] DATE 3/11/81

QC SUPERVISOR [illegible] DATE 4/2/81

AUTHORIZED INSPECTOR W J Caldwell DATE 4-6-81

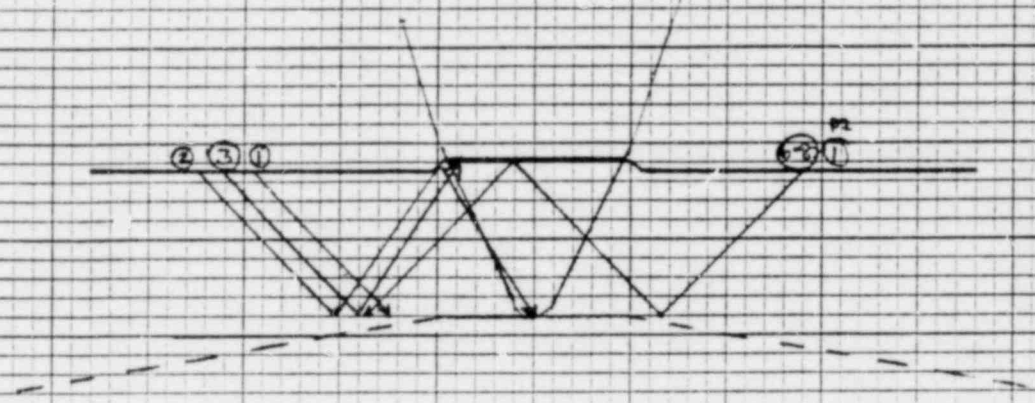
GE-U3

LASALLE UNIT 1 T_E = .74

WELD 1R1-1015-1B T_W = ~~.78~~ .83

EDS 92282 T_E = .76

GENERAL ELECTRIC



LINE	EVALUATION
1,6-8, 1 P2	ID geometry & mode conversion from counterbore
2	ID geometry from weld root
3	OD geometry from weld cap

EVALUATED BY L D Wheatley Level III DATE 4/2/81

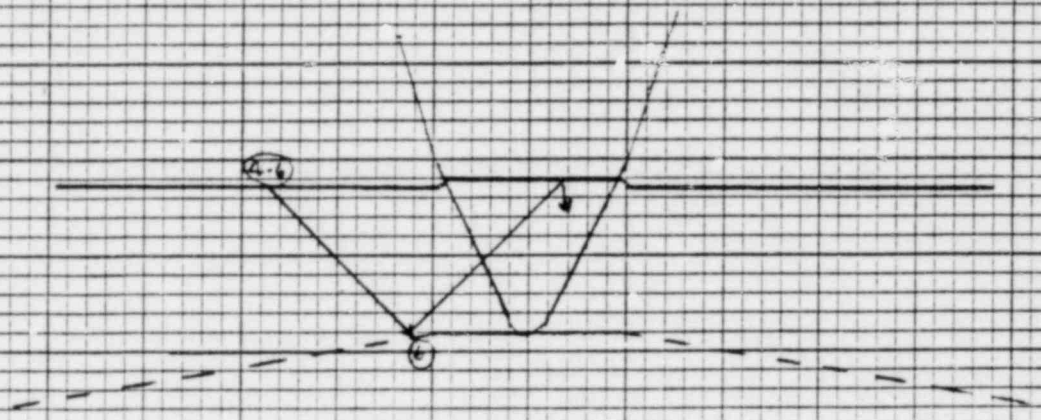
REVIEWED BY W J Caldwell ANII DATE 4-6-81

LASALLE UNIT 2 T_p = .73

WELD 1R1-1014-4 T_W = .78

EDS 92282 T_E = .79

GENERAL ELECTRIC



LINE	EVALUATION
6	ID geometry off counterbore
4,5	Made conversion from weld cap

EVALUATED BY L D Wheatley Level III DATE 4/2/81

REVIEWED BY W J Caldwell ANII DATE 4-6-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

U.T. CALIBRATION DATA SHEET
LASALLE COUNTY STATION UNIT 1

CDS 94124
LDS 0004

A. Procedure No. MPUP-5751 REV. 4

Examination Personnel: NAME [illegible] LEVEL II NAME [illegible] LEVEL II

Instrument: SERIAL NO. 736 MAKE/MODEL: – BRANSON/303: ☐ SONIC/MK I: ☐ KK/USL32: ☒ OTHER KK/USL 01

D. Search Unit: BEAM ANGLE/MODE: ☒ STRAIGHT BEAM/LONG WAVE: ☐ 45°/TRANS WAVE: ☐ 60°/TRANS WAVE

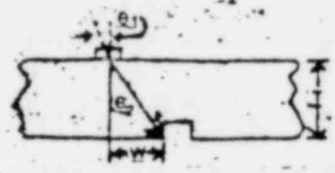
TRANSDUCER SIZE/FREQ: ☐ 0.25" DIA/2.25 MHz ☐ 0.5" DIA/2.25 MHz ☐ 1.0" DIA/2.25 MHz

SERIAL NO.: H25733 ; ☐ 1.0" DIA/2.25 MHz ☒ 0.5"x0.5"/2.25 MHz

TRANSDUCER TYPE: ☐ CERAMIC SINGLE ELEMENT ☒ CERAMIC DUAL ELEMENT ☐ OTHER

WEDGE TYPE: ☒ STANDARD WEDGE ☐ SPECIAL WEDGE/TYPE

CALCULATED BEAM ANGLE IN MATERIAL: θ_2 = N/A °



θ = ARC TAN $\left(\frac{W}{T}\right)$

T = CAL STD. THICKNESS

E. Cable: LENGTH: 6 FT. TYPE: ☐ RG-58 ☐ RG-59 ☐ RG-57 ☒ RG-174 ☐ OTHER

F. Calibration Orientation: CALIBRATION REFERENCE REFLECTOR: ☒ PARALLEL ☐ TRANSVERSE TO PIPE AXIS to hole centerline

FOR DUAL ELEMENT: SPLIT FOR MAXIMUM RESPONSE ☒ PARALLEL ☐ TRANSVERSE

G. Calibration Standards: LSCS CAL STD. NO. 81-26-01 THICKNESS 1.25 DIAMETER 26

MATERIAL: ☒ CARBON ☐ STAINLESS ☐ INCONEL ☐ OTHER

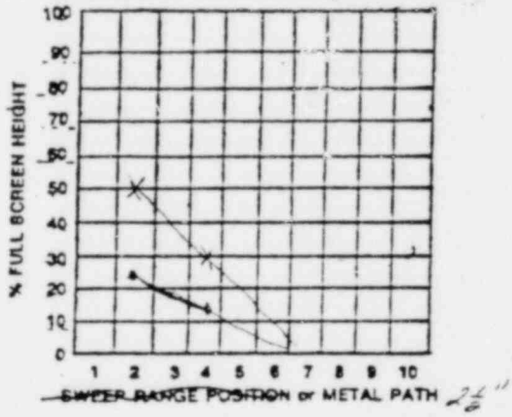
H. Couplant: ☒ GLYCERINE ☐ ULTRAGEL II ☐ OTHER

I. Comments:

J. Dac Curve — Data ☐ SRP; ☐ MP in inches

CTOR 00	PEAK AMP 01	W1 02	Wm 03	W2 04	SRP or 1 MP1 05	SRP or m MPm 06	SRP or 2 MPz 07	HOLE DEPTH 08
¼ T or ½ Vee	50					250		250
¼ T or ⅛ Vee								
¼ T or ⅛ Vee	30					880		880
B.R. or ⅛ Vee	95					1.25		1.25

K. Dac Curve — Screen Representation



L. Instrument Settings/Checks

CONTROLS 00	SET 01	CHECK BOXES 02	03	04	05	06	07	08	09
GAIN	32	✓							
SCAN GAIN	40	✓							
SWEEP	25/46	✓							
DELAY	7.59	✓							
FILTER	AUTO	✓							
REP RATE	MED	✓							
DAMPENING	OFF	✓							
ST	OFF	✓							
ER	N/A	✓							

M. Calibration Time — Records

DATE 1979	01 ORIG. CAL. TIME	02 CAL. CHECK TIME	03 LAST E.D.S. #	04 LAST E.D.S. LINE #	05 VERIFICATION OF 25°F LIMIT (YES/NO)
6-15	1230	N/A	N/A	N/A	~~yes~~
6-15	N/A	1430	94125	2	~~yes~~

N. Reviewed By: NDE SUPERVISOR [illegible] DATE 6/8/79

Q.C. SUPERVISOR [illegible] DATE 6/18/79

AUTHORIZED INSPECTOR [illegible] DATE 3-26-81

GE-10/78 (U2)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EDS# 94125

CDS# 94124

ULTRASONIC EXAMINATION DATA SHEET
LaSALLE COUNTY NUCLEAR STATION UNIT 1

A. PROCEDURE NO. MPUPS751 REV. 4

B. EXAMINATION PERSONNEL:
NAME [illegible] LEVEL II ; NAME [illegible] LEVEL II

C. SEARCH UNIT BEAM ANGLE: ☒ 0°; ☐ 45°; ☐ 60°; ☐ OTHER

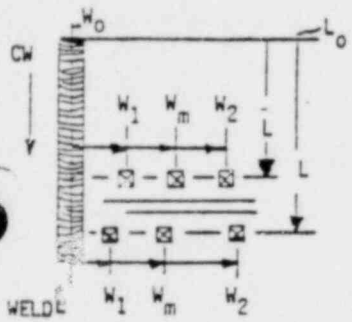
D. COUPLANT: ☒ GLYCERINE: ☐ ULTRAGEL II; ☐ OTHER

E. SCAN SENSITIVITY: (+) 8 dB

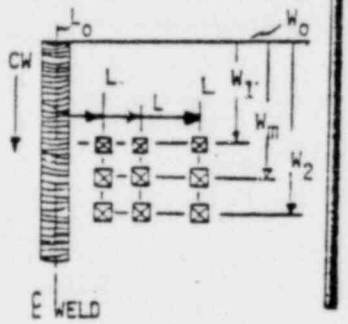
F. REFERENCE SYSTEM (CIRC. WELD)

L_o = 'V' STAMP W_o = 'V' STAMP

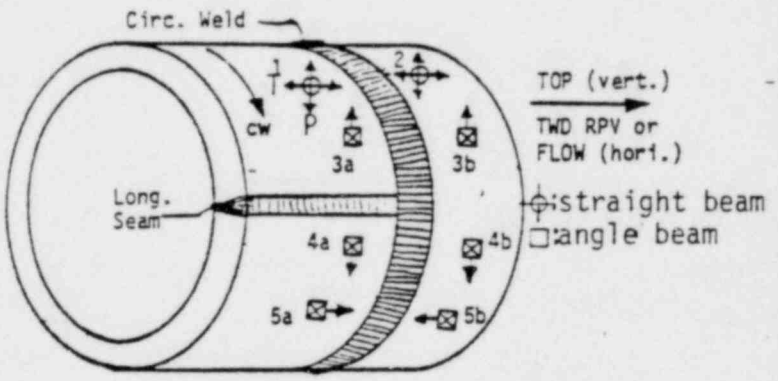
REFLECTOR PARALLEL TO WELD



REFLECTOR TRANS. TO WELD



G. SCAN ORIENTATION



H. DATA

DATE	LINE NO.	EXAM/COMP. I.D. NO.	COMP FIG.	REC. IND. YES/NO	MAX % DAC @ W_m	L_o / W_o	L	W_1	W_m	W_2	SRP_1 or MP_1	SRP_m or MP_m	SRP_2 or MP_2	SCAN	Comments (Thickness Meas.)
6/18/79	1.	INS 1053 1ALU	LS	YES	100% -4db	0 / ℄	0-6	5.5	5.7	6"	.70	.70	.70	1	P = 1.25 W = 1.35
6/18/79	2.	INS 1053 1ALU	LS			/	0	POINT	TAKEN	FROM	JCT	℄	1A	& 1ALU	
	3.					/									
	4.					/									
	5.					/									
	6.					/									
	7.					/									

Line 1 See INCR-82

I. REVIEWED BY:
NDE SUPERVISOR [illegible] DATE 6/18/79

QC SUPERVISOR [illegible] DATE 6/18/79

AUTHORIZED INSPECTOR [illegible] DATE 3-26-81

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT 1 E.D.S. NO. 96,000A

A. Procedure No. PP-S751 REV. 5

B. Examination Personnel:

NAME M.A. Michlewicz LEVEL II

NAME _____ LEVEL _____

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 78D056

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp. _____

2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp. _____

b. SURFACE PREPARATION:

*1. Grinding *2. Flappering *3. None *4. Other _____

E. Data: Note: All Exam. Components are ASME Section XI Category B-J

LINE NO. 00	DATE 01	PRE-CLEAN EVAP. TIME (MIN) 02	PEN. DWELL TIME (MIN) 03	PEN. REM. EVAP. TIME (MIN) 04	DEV. TIME (MIN) 05	EXAMINATION COMPONENT I.D. NO. 06	MAT'L 07	SURF. PREP. * 08	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	RELEVANT INDICATION LOCATION/SIZE OR COMMENTS 13
1	5/24/79	5	20	5	15	IFW 1001-65	C/S	2		✓	✓		SEE NOTE 1
2													
3													
4													
5													
6													
7													
8													
9	NOTE 1 -		0 - 11.5 AND 29-41.5 CW WERE NOT EXAMINED DUE TO										
10			PIPE SUPPORT RESTRICTION.										
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By:

NDE SUPERVISOR [signature] DATE 5-29-79

QC SUPERVISOR Salahuddin Ahmad DATE 5/30/79

AUTHORIZED INSPECTOR W. J. Caldwell DATE 3-26-81

GE-10/78 (P1)

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT I

E.D.S. NO. 96E01

A. Procedure No. PP 5751 REV. 5

Examination Personnel:

NAME M O Mechlenburg LEVEL II

NAME LEVEL

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 78D056

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp.

2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☑ NO ☐ Temp.

b. SURFACE PREPARATION:

*1. Grinding *2. Flappering *3. None *4. Other

E. Data: Note: All Exam. Components are ASME Section XI Category BJ

LINE NO. 00	DATE 01	PRE-CLEAN EVAP. TIME (MIN) 02	PEN. DWELL TIME (MIN) 03	PEN. REM. EVAP. TIME (MIN) 04	DEV. TIME (MIN) 05	EXAMINATION COMPONENT I.D. NO. * 06	MAT'L 07	SURF. PREP. * 08	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO. 10	ACCEPTABLE YES 11	ACCEPTABLE NO. 12	RELEVANT INDICATION LOCATION/SIZE OR COMMENTS 13
1	7-25-79	5	30	5	15	I-MS-1002-4LD	CS	2		X	X		SEE NOTE 1
2													SEE NOTE 2
3													
4													
5													
6													
7													
8													
9													
10	NOTE 1 —	TWO INDICATIONS REPORTED ON EDS 50003 WERE											
11		FLAPPERED PRIOR TO PENETRANT EXAMINATION.											
12		AREAS WERE CHECKED FOR MINIMUM WALL THICKNESS											
13													
14	NOTE 2:	See "T"	EDS	96003 for thickness measurement							DXB 7/23/80		
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By:

NDE SUPERVISOR R C Hooper DATE 5-29-79

QC SUPERVISOR [illegible] DATE 5/30/79

AUTHORIZED INSPECTOR W J Caldwell DATE 3-26-81

GENERAL ELECTRIC

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY STATION UNIT I

E.D.S. NO. 96 004

A. Procedure No. PP-S751 REV. 5

B. Examination Personnel:

NAME Mechlenburg LEVEL II

NAME LEVEL

C. Penetrant Materials:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 78D056

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. Pre-Examination Requirements:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☒ NO ☐ Temp.

2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☒ NO ☐ Temp.

b. SURFACE PREPARATION:

*1. Grinding *2. Flappering *3. None *4. Other

E. Data: Note: All Exam. Components are ASME Section XI B-J Category

LINE NO. 00	DATE 01	PRE-CLEAN EVAP. TIME (MIN) 02	PEN. DWELL TIME (MIN) 03	PEN. REM. EVAP. TIME (MIN) 04	DEV. TIME (MIN) 05	EXAMINATION COMPONENT I.D. NO. * 06	MAT'L 07	SURF. PREP. * 08	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	RELEVANT INDICATION LOCATION/SIZE OR COMMENTS 13
1	5/29/79	5	25	5	15	IRR 1003-2	S/S	2		✓	✓		SEE NOTE 1
2													
3													
4													
5													
6													
7													
8													
9	NOTE 1: INDICATION REPORTED EDS 30012 OF 8-14-78 REMOVED												
10	BY FLAPPERING AND AREA OF INTEREST RETESTED.												
11													
12													
13													
14													
15													

* Note: For each exam component ID NO., place the applicable number(s) (1,2,3 etc) in its appropriate column.

Reviewed By:

NDE SUPERVISOR R.C. Hooper DATE 5-29-79

QC SUPERVISOR Sadaluddin Ahmad DATE 5/30/79

AUTHORIZED INSPECTOR W J Caldwell DATE 3-26-81

GE-10/78 (P1)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY NUCLEAR STATION UNIT I

E.D.S. NO. 97005

A. PROCEDURE NO. PP-S751 REV. 5

EXAMINATION PERSONNEL:

NAME Robert Austin LEVEL II

NAME Kevin Cullaghan LEVEL II

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 78E073

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 79E033

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☒ NO ☐
2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☒ NO ☐

b. SURFACE PREPARATION:

*1. GRINDING *2. FLAPPERING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. C-F

00 INDEX NO	01 DATE	02 PRE-CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. *	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	13 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
1	10-25-79	5	15	5	20	IRH-1023	C/S	2		NO	YES		
2	10-25-79	5	15	5	20	IRH-1024 3	C/S	2		NO	YES		
3	10-25-79	5	15	5	20	IRH-1047 2	C/S	2		NO	YES		
4	10-25-79	5	15	5	20	IRH-1047 4	C/S	2		NO	YES		
5	10-25-79	5	15	5	20	IRH-1047 7	C/S	2		NO	YES		
6	10-25-79	5	15	5	20	IRH-1047 8	C/S	2		NO	YES		
7													
8		* Data on line 1,2 voided per MCCO					MRD		540	6343,	540	6379	
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(s) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR S W Connelly DATE 10/29/79

QC SUPERVISOR L D Whetley DATE 11/6/79

AUTHORIZED INSPECTOR W F Caldwell DATE 11-7-79

GENERAL ELECTRIC

GENERAL ELECTRIC COMPANY, 814 COMMERCE DR., OAK BROOK, ILL. 60521

INSTALLATION AND
SERVICE ENGINEERING
DIVISION

April 17, 1981

Mr. George R. Crane
Station Nuclear Engineering Department
Commonwealth Edison Company
1 First National Plaza
P. O. Box 767
Chicago, Illinois 60690

SUBJECT: LaSalle Unit 1 PSI Report Update
April 17, 1981

Dear Mr. Crane:

The update package is issued in the form of replacement pages. Revisions, additions or deletions are incorporated directly into the affected pages. Attached is a table containing the necessary changes.

If you have any questions, please do not hesitate to call or write.

Sincerely yours,

R. C. Hooper
NDE Specialist - Technical Support
Central Nuclear Plant Services

RCH:ck
attachment

TABLE OF CONTENTS

LSCS Unit 1 - PSI Report

April 17, 1981

Update Package

April 17, 1981

Section	Volume	Description
10.4.8	5	IRH-1024B, Page 1, Rev. 0 IRH-1031B, Page 1, Rev. 1 IRH-1045, Page 1, Rev. 2 IRH-1047, Page 1, Rev. 1
10.4.9	5	IRI-1001B, Page 1, Rev. 1 IRI-1003B, Page 1, Rev 1 IRI-1004, Page 3, Rev. 0 IRI-1004, Page 4, Rev. 1 IRI-1005, Page 1, Rev. 0 IRI-1013, Page 1, Rev. 2 IRI-1016, Page 1, Rev. 1 IRI-1018, Page 1, Rev. 1 IRI-1019, Page 2, Rev. 0 IRI-1020, Page 1, Rev. 2 IRI-1022, Page 1, Rev. 2 IRR-1009B, Page 1, Rev. 1 IRR-1010B, Page 1, Rev. 1 IRT-1001, Page 2, Rev. 1 IRT-1001, Page 3, Rev. 1
11.3	5	Nonconformity Report 1NCR-94 Nonconformity Report 1NCR-95 Nonconformity Report 1NCR-98 Nonconformity Report 1NCR-99 Nonconformity Report 1NCR-103 Nonconformity Report 1NCR-104 Nonconformity Report 1NCR-105
12.1.1	6	Data Sheets 16,000 thru 16,033 Data Sheets 73,005 thru 73,014 PSI Ref. No. RPV-3 PSI Ref. No. RPV-4, Pages 1 thru 4 PSI Ref. No. RPV-8, Pages 1 thru 55 PSI Ref. No. RPV-9, Pages 1 thru 6 PSI Ref. No. RPV-10, Pages 1 and 2
12.2	7	Piping, Pump and Valve Components Tab Index Pages 6 and 7
12.2.1		Examination Data Sheet No. 77596

April 17, 1981

Section	Volume	Description
12.2.6	12	PSI Ref. No. RH-2
		PSI Ref. No. RI-1
		PSI Ref. No. RI-2
		PSI Ref. No. RI-3
		PSI Ref. No. RI-4
		PSI Ref. No. RI-5
		PSI Ref. No. RI-6

CALIBRATION TRANSFER DATA - ZONE 1
FROM A 3/4 INCH DEEP NOTCH IN THE GE NOZZLE MOCK-UP

A dB GAIN INCREASE OF 22 HAS BEEN DETERMINED FOR THE WEDGES IDENTIFIED BY THE FOLLOWING NAME AND SERIAL NUMBERS

- * LS-N5-Z1-CW & CCW
- LS-N~~3~~-Z1-CW & CCW
- 10 Sam 2-5-81
-

THESE WEDGES ARE INTENDED FOR USE ON THE NOZZLES AT THE FOLLOWING REACTOR/S

- LaSalle 1
-
-

THIS DATA WAS OBTAINED USING TRANSDUCERS OF THE FOLLOWING DESCRIPTION AND APPLIES ONLY TO TRANSDUCERS OF THE SAME DESCRIPTION EXCEPTING SERIAL NUMBERS

- 1 INCHES DIAMETER • FREQUENCY 1 MHz
- MANUFACTURER KB AEROTECH • MODEL GAMMA
- SERIAL NO/S. K02612, B10716

A SIGNAL AMPLITUDE OF 80% FSH, 10% FSH, HAS BEEN OBTAINED FROM THE 3/4 INCH DEEP, ZONE 1 NOTCH IN THE GE NOZZLE MOCK-UP FOLLOWING THE ULTRASONIC SENSITIVITY CALIBRATION PROCEDURE DESCRIBED IN GE DOCUMENT NUMBER NIRZ1-S751 REVISION 0

DATE OF CALIBRATION TRANSFER - 2 June 80
PERFORMED BY: [illegible]

*LS-N5-Z1 CW & CCW meets this design for feedwater (N4) nozzles on unit 1.
Steven [illegible]
8-31-81

FIGURE 9 CALIBRATION TRANSFER DATA FORM

9.0 RELIEF REQUESTS

TAB		DESCRIPTION
1	RI-01	ASME Category B-K-1, Support Fillet Welds
2	RI-02	ASME Category C-D, Class 2 Bolting
3	RI-03	ASME IWC-1220(a), Design Pressure and Temperature
4	RI-04	ASME Category B-F, B-J, C-F, C-G, Ultrasonic Sensitivity
5	RI-05	ASME Category B-J, C-F, Welds Inaccessible by Flued Heads
6	RI-06	Deleted
7	RI-07	ASME Category C-F, Saddle Welds
8	RI-08	ASME Category C-F, Underground Piping
9	RI-09	ASME Category B-D, RPV Top Head Nozzle Inner Radii
10	RI-10	ASME Category C-F, Ultrasonic Testing of Thin Wall Piping
11	RI-11	ASME Category B-J, Welds Inaccessible by Penetration Sleeves
12	RI-12	ASME Category C-F, Pressure Retaining Fillet Welds
13	RI-13	ASME Category B-L-2, Internal Surfaces of Pumps
14	RI-14	ASME Category B-M-2, Internal Surfaces of Valves
15	RI-15	ASME Category B-B, RPV Welds Inaccessible by CRD
16	RI-16	ASME Category B-J, C-F, Welds Inaccessible by Supports
17	RI-17	ASME Category C-F, Inaccessible Pump Welds
18	RI-18	ASME Category C-F, Welds Inaccessible by Penetration Seal

Commonwealth Edison
LaSalle County Nuclear Station

PRESERVICE INSPECTION

RELIEF REQUESTS FOR COMPONENTS AND PIPING

RELIEF REQUEST 00	SYSTEM OR COMPONENT 01	CLASS 02	CATEGORY AND ITEM NUMBER 03	EXEMPTED COMPONENT 04	SECTION XI TEST REQUIREMENT 05	BASIS FOR RELIEF 06	ALTERNATIVE TEST 07
RI-03	PC	2	ALL	All pressure retaining and support components.	IWC-1220 (a) Exempt components in systems where both the maximum design pressure and temperature are equal to or less than 275 Psig and 200° respectively.	Maximum design pressure and temperature conditions are much higher than actual conditions which the components will see.	Exempt components in systems where both the maximum Operating Pressure and Temperature are equal to or less than 275 Psig and 200° F respectively.

GE-I 80

RELIEF REQUEST 00	SYSTEM OR COMPONENT 01	CLASS 02	CATEGORY AND ITEM NUMBER 03	EXEMPTED COMPONENT 04	SECTION XI TEST REQUIREMENT 05	BASIS FOR RELIEF 06	ALTERNATIVE TEST 07
RI-07	MS	2	C-F C2.3	Branch Pipe connection welds.	Volumetric	8 of the branch pipe connections on carbon steel piping are constructed with reinforcement saddles. These saddles are fillet welded over the actual branch pipe connection weld. (See Sketch attached). A volumetric examination consisting of a radiograph was performed on the actual branch pipe connection weld during fabrication. The fabrication documents are available on site for audit. A meaningful volumetric examination cannot be done on either the branch connection weld or the two saddle welds.	Surface examination of the two Saddle Welds.

GE-218

RELIEF REQUEST 00	SYSTEM OR COMPONENT 01	CLASS 02	CATEGORY AND ITEM NUMBER 03	EXEMPTED COMPONENT 04	SECTION XI TEST REQUIREMENT 05	BASIS FOR RELIEF 06	ALTERNATIVE TEST 07
RI-09	N7-Head Spray Nozzle Inner Radius N8-Vent Nozzle Inner Radius N18-Spare Nozzle Inner Radius	1	B-D B1.4	N7 NIR N8 NIR N18 NIR	Volumetric examination of the nozzle inner radius is required.	An ultrasonic examination of the nozzle inner radius (NIR) was performed during the informational baseline at the vessel manufacturer. The UT exam data is available on site for audit. During refueling activities the RPV Closure Head is removed allowing access to the RPV Closure Head NIR. A surface examination is more sensitive in detecting surface defects at the NIR. Vessel Manufacturer: Unit 1-Combustion Engineering. Unit 2-CBI Nuclear	Surface Examination.

10.1 FORMAT LEGEND AND NOTES CONT'd

FIELD	DESCRIPTION
12 QC REVIEW SIGNATURE/DATE	Quality Control Supervisor's Audit of Data, Signature of Inspection being complete, accepted and date signed.
13 AI INIT./DATE	Authorized Nuclear Inservice Inspector's initials and date of Data Review.

10.1 FORMAT LEGEND AND NOTES

FIELD	DESCRIPTION
00 SIZE	Nominal size in inches.
01 EXAM COMP. ID. NO.	Examination component identification number used to identify the component for examination. For bolting components, the "Dwg. No." refers to the ISI Bolting Detail Drawing.
02 DWG. REV. NO.	The Inspection Checklist Drawing Revision Number.
03 ASME CAT.	ASME Section XI Inspection Category as described by Tables IWB-2500 and IWC-2520 for ASME Class 1 and 2 components respectively.
04 COMP. FIG.	Component Figuration eg. P-E= pipe to elbow weld. See Note 1 for abbreviation listing.
05 PROCEDURE NO.	Nondestructive examination procedure used to perform the inspections eg. 1 = MPUP-S751. See Note 2 for inspection checklist procedure correlation.
06 REV. NO.	Nondestructive examination procedure revision number.
07 EXAM TYPE	Examination type that is used to inspect the component. UT-0° = Ultrasonic testing using a 0° straight beam technique. UT-45° = Ultrasonic testing using a 45° shear wave technique. UT-60° = Ultrasonic testing using a 60° shear wave technique. PT = Liquid penetrant technique. VT = Visual testing technique. MT = Magnetic particle technique. Z1CW/CCW = Ultrasonic testing of NIR Zone 1 using GE 3 Zone technique. Z2CW/CCW = Ultrasonic testing of NIR Zone 2 using GE 3 Zone technique. (CW-clockwise, CCW-counter-clockwise).
08 EDS NO.	Examination Data Sheet Number on which the specific examination is documented.
09 CDS NO.	Ultrasonic testing (UT) Calibration Data Sheet used to perform the specific examination.
10 LSCS CAL. STD. NO.	LaSalle County Station Ultrasonic Calibration Standard used to effect the UT calibration.
11 LDS NO.	Ultrasonic testing linearity data sheet number on which the particular UT instrument's screen height and amplitude linearity checks are documented.

10.1 Format Legend and Notes
Note 1

COMPONENT FIGURATION ABBREVIATIONS
LSCS PSI

BH--Bottom Head
C--Cap
CHC--Closure Head Cladding
CR--Cross
E--Elbow
EX--Safe End Extension
F--Flange
FB--Flange Bolting
FL--Flange Ligament
H--Reactor Pressure Vessel Top Head
HD--Head (RHR Heat Exchanger or Pump)
IALS--Inside Arc Longitudinal Seam
IS--Instrumentation Seal
LS--Longitudinal Seam
N--Nozzle
NIR--Nozzle Inner Radius
OALS--Outside Arc Longitudinal Seam
P--Pipe
PB--Pump Bolting
PC--Pump Casing
PH--Penetration Head
PL--Plate
PU--Pump
PULS--Pump Longitudinal Seam
R--Reducer
RH--Rams Head
RHLS--Rams Head Longitudinal Seam
RPV--Reactor Pressure Vessel
S--Saddle
SE--Safe End
SH--Shell
SK--Reactor Pressure Vessel Skirt
SP--Spindle
ST--Stanchion
SUP--Support
SW--Sweepolet
T--Tee
TVH--Reactor Pressure Vessel Top Head
V--Valve
VB--Valve Bolting
VHLS--Reactor Pressure Vessel Top Head Longitudinal Seam
W--Weldolet

INSPECTION CHECKLIST PROCEDURE CORRELATION

IC Procedure No.	NDE Procedure
1	MPUP-S751
2	PP-S751
3	MPUD-S751
4	PV1-S751
5	PV3-S751
6	MPURHX-S751
7	MPUV-S751
8	APUN-S751
9	APUV-S751
10	MPUSK-S751
11	MPUL-S751
12	NDT-C-14-L
13	NIRZ1-S751
14	MPSU1-S751
15	TP-508-0654
16	NIRZ2-S751

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. 1-Internals REV. 1

PAGE 1 of 4

REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whatley DATE 12/9/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-Surveillance Sample Baskets	N/A	B-N-2	N/A	4	2	VT	84503A	N/A	N/A	N/A	L D Whatley 12/9/80	W J Caldwell 12-9-80
N/A	1-Core Plate Hold Down Bolts	N/A	B-N-1	N/A	5	2	VT	84003	N/A	N/A	N/A	L D Whatley 12/9/80	W J C 12-9-80
N/A	1-Steam Separator	N/A	B-N-1	N/A	5	2	VT		N/A	N/A	N/A		
N/A	1-Steam Dryer	N/A	B-N 1	N/A	5	2	VT		N/A	N/A	N/A		
N/A	1-Core Delta P and SBLC Piping Welds	N/A	B-N-1	N/A	5	2	VT		N/A	N/A	N/A	See PSI Ref. No. RPV-9	W J C 3-13-81
N/A	1-Shroud Support Welds	N/A	B-N-2	N/A	4	2	VT		N/A	N/A	N/A	See PSI Ref. No. RPV-10	W J C 3-13-81
N/A	1-Incore Housing to Incore Guide Tube Welds	N/A	B-N-2	N/A	4	2	VT		N/A	N/A	N/A	See PSI Ref. No. RPV-8	W J C 3-13-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. 1-NIR REV. 1

PAGE 1 of 7

REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whatley DATE 1/13/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-1A	0	B-D	NIR	13	0	Z1CW	45528	45527	MP-1	NA	L D Whatley 2/25/81	W J Caldwell 2-25-81
					13	0	Z1CCW	45528	45527	MP-1	NA		
					16	0	Z2CW	16013	16012	MP-1	NA		
					16	0	Z2CCW	16013	16012	MP-1	NA		
N/A	1-NIR-1B	0	B-D	NIR	13	0	Z1CW	99016	99015	MP-1	NA	L D Whatley 2/25/81	W J C 2-25-81
					13	0	Z1CCW	45518	45517	MP-1	NA		
					16	0	Z2CW	16014	16012	MP-1	NA		
					16	0	Z2CCW	16014	16012	MP-1	NA		
N/A	1-NIR-2A	0	B-D	NIR	13	0	Z1CW	99025	99024	MP-1	NA	L D Whatley 2/25/81	W J C 2-25-81
					13	0	Z1CCW	99025	99024	MP-1	NA		
					16	0	Z2CW	16006	16001	MP-1	NA		
					16	0	Z2CCW	16006	16001	MP-1	NA		
N/A	1-NIR-2B	0	B-D	NIR	13	0	Z1CW	99005	99004	MP-1	NA	L D Whatley 2/25/81	W J C 2-25-81
					13	0	Z1CCW	45508	45507	MP-1	NA		
					16	0	Z2CW	16005	16001	MP-1	NA		
					16	0	Z2CCW	16005	16001	MP-1	NA		
N/A	1-NIR-2C	0	B-D	NIR	13	0	Z1CW	99006	99004	MP-1	NA	L D Whatley 2/25/81	W J C 2-25-81
					13	0	Z1CCW	45509	45507	MP-1	NA		
					16	0	Z2CW	16004	16001	MP-1	NA		
					16	0	Z2CCW	16004	16001	MP-1	NA		

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. 1-NIR REV. 1

PAGE 2 of 7

REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 1/13/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-2D	0	B-D	NIR	13	0	Z1CW	99007	99004	MP-1	NA	L D Wheatley 2/23/81	w J Caldwell
					13	0	Z1CCW	45510	45507	MP-1	NA		2-25-81
					16	0	Z2CW	16003	16001	MP-1	NA		
					16	0	Z2CCW	16003	16001	MP-1	NA		
N/A	1-NIR-2E	0	B-D	NIR	13	0	Z1CW	99008	99004	MP-1	NA	L D Wheatley 2/23/81	w JC
					13	0	Z1CCW	45511	45507	MP-1	NA		2-25-81
					16	0	Z2CW	16002	16001	MP-1	NA		
					16	0	Z2CCW	16002	16001	MP-1	NA		
N/A	1-NIR-2F	0	B-D	NIR	13	0	Z1CW	99009	99004	MP-1	NA	L D Wheatley 2/23/81	w JC
					13	0	Z1CCW	45512	45507	MP-1	NA		2-25-81
					16	0	Z2CW	16011	16001	MP-1	NA		
					16	0	Z2CCW	16011	16001	MP-1	NA		
N/A	1-NIR-2G	0	B-D	NIR	13	0	Z1CW	99010	99004	MP-1	NA	L D Wheatley 2/23/81	w JC
					13	0	Z1CCW	45513	45507	MP-1	NA		2-25-81
					16	0	Z2CW	16010	16001	MP-1	NA		
					16	0	Z2CCW	16010	16001	MP-1	NA		
N/A	1-NIR-2H	0	B-D	NIR	13	0	Z1CW	99011	99004	MP-1	NA	L D Wheatley 2/23/81	w JC
					13	0	Z1CCW	45514	45507	MP-1	NA		2-25-81
					16	0	Z2CW	16009	16001	MP-1	NA		
					16	0	Z2CCW	16009	16001	MP-1	NA		

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. 1-NIR REV. 1

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Q.C. SUPERIVSOR L D Weatley DATE 1/12/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-2J	0	B-D	NIR	13	0	Z1CW	99013	99004	MP-1	NA	L D Weatley 2/25/81	w J. Caldwell
					13	0	Z1CCW	45515	45507	MP-1	NA		2-25-81
					16	0	Z2CW	16008	16001	MP-1	NA		
					16	0	Z2CCW	16008	16001	MP-1	NA		
N/A	1-NIR-2K	0	B-D	NIR	13	0	Z1CW	99014	99004	MP-1	NA	L D Weatley 2/25/81	w JC
					13	0	Z1CCW	45516	45507	MP-1	NA		2-25-81
					16	0	Z2CW	16007	16001	MP-1	NA		
					16	0	Z2CCW	16007	16001	MP-1	NA		
N/A	1-NIR-3A	0	B-D	NIR	13	0	Z1CW	99026	99019	MP-1	NA	L D Weatley 2/25/81	w JC
					13	0	Z1CCW	45523	45522	MP-1	NA		2-25-81
					16	0	Z2CW	73009	73008	MP-1	NA		
					16	0	Z2CCW	73009	73008	MP-1	NA		
N/A	1-NIR-3B	0	B-D	NIR	13	0	Z1CW	99021	99019	MP-1	NA	L D Weatley 2/25/81	w JC
					13	0	Z1CCW	45524	45522	MP-1	NA		2-25-81
					16	0	Z2CW	73010	73008	MP-1	NA		
					16	0	Z2CCW	73010	73008	MP-1	NA		
N/A	1-NIR-3C	0	B-D	NIR	13	0	Z1CW	99022	99019	MP-1	NA	L D Weatley 2/25/81	w JC
					13	0	Z1CCW	45525	45522	MP-1	NA		2-25-81
					16	0	Z2CW	73011	73008	MP-1	NA		
					16	0	Z2CCW	73011	73008	MP-1	NA		

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LASALLE COUNTY STATION UNIT 1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whatley DATE 2/4/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-3D	0	B-D	NIR	13	0	Z1CW	99023	99019	MP-1	N/A	L D Whatley 2/23/81	w g Caldwell 2-25-81
					13	0	Z1CCW	45526	45522	MP-1	N/A		
					16	0	Z2CW	73012	73008	MP-1	N/A		
					16	0	Z2CCW	73012	73008	MP-1	N/A		
N/A	1-NIR-4A (30°)	0	B-D	NIR	13	0	Z1CW	16023	16021	MP-1	N/A	L D Whatley 2/23/81 Also done by CECo See PSI Ref Nos RPV-5,6	w g c 2-25-81
					13	0	Z1CCW	16023	16021	MP-1	N/A		
					16	0	Z2CW	16029	16022	MP-1	N/A		
					16	0	Z2CCW	16029	16022	MP-1	N/A		
N/A	1-NIR-4B (90°)	0	B-D	NIR	13	0	Z1CW	16024	16021	MP-1	N/A	L D Whatley 2/25/81 Also done by CECo See PSI Ref No. RPV-5,6	w g c 2-25-81
					13	0	Z1CCW	16024	16021	MP-1	N/A		
					16	0	Z2CW	16030	16022	MP-1	N/A		
					16	0	Z2CCW	16030	16022	MP-1	N/A		
N/A	1-NIR-4C (150°)	0	B-D	NIR	13	0	Z1CW	16025	16021	MP-1	N/A	L D Whatley 2/25/81 Also done By CECo See PSI Ref No. RPV-5,6	w g c 2-25-8
					13	0	Z1CCW	16025	16021	MP-1	N/A		
					16	0	Z2CW	16031	16022	MP-1	N/A		
					16	0	Z2CCW	16031	16022	MP-1	N/A		
N/A	1-NIR-4D (210°)	0	B-D	NIR	13	0	Z1CW	16026	16021	MP-1	N/A	L D Whatley 2/25/81 Also done By CECo See PSI Ref Nos RPV-5,6	w g c 2-25-81
					13	0	Z1CCW	16026	16021	MP-1	N/A		
					16	0	Z2CW	16032	16022	MP-1	N/A		
					16	0	Z2CCW	16032	16022	MP-1	N/A		

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 2/4/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	EDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
N/A	1-NIR-4E (270°)	0	B-D	NIR	13	0	Z1CW	16027	16021	MP-1	N/A	L D Wheatley 2/25/81 Also done by CECo See PSI Ref No. RPV-5,6	W J Caldwell 2-25-81
					13	0	Z1CCW	16027	16021	MP-1	N/A		
					16	0	Z2CW	16033	16022	MP-1	N/A		
					16	0	Z2CCW	16033	16022	MP-1	N/A		
N/A	1-NIR-4F (330°)	0	B-D	NIR	13	0	Z1CW	16028	16021	MP-1	N/A	L D Wheatley 2/25/81 Also done by CECo See PSI Ref Nos RPV-5,6	W J C 2-25-81
					13	0	Z1CCW	16028	16021	MP-1	N/A		
					16	0	Z2CW	73014	73013	MP-1	73013		
					16	0	Z2CCW	73014	73013	MP-1	73013		
N/A	1-NIR-5	0	B-D	NIR	13	0	Z1CW	99002	99000	MP-1	N/A	L D Wheatley 2/25/81	W J C 2-25-81
					13	0	Z1CCW	45501	45500	MP-1	N/A		
					16	0	Z2CW	73006	73005	MP-1	N/A		
					16	0	Z2CCW	73006	73005	MP-1	N/A		
N/A	1-NIR-6A	0	B-D	NIR	13	0	Z1CW	45505	45504	MP-1	N/A	L D Wheatley 2/25/81	W J C 2-25-81
					13	0	Z1CCW	45505	45504	MP-1	N/A		
					16	0	Z2CW	16018	16017	MP-1	N/A		
					16	0	Z2CCW	16018	16017	MP-1	N/A		
N/A	1-NIR-6B	0	B-D	NIR	13	0	Z1CW	45506	45504	MP-1	N/A	L D Wheatley 2/25/81	W J C 2-25-81
					13	0	Z1CCW	45506	45504	MP-1	N/A		
					16	0	Z2CW	16019	16017	MP-1	N/A		
					16	0	Z2CCW	16019	16017	MP-1	N/A		

10.3 PUMPS

	DESCRIPTION	TAB	INSPECTION CHECKLIST
10.3.1	HP - High Pressure Core Spray Pump	1	IHP-PU
10.3.2	LP - Low Pressure Core Spray	2	ILP-PU
10.3.3	RH - Residual Heat Removal Pumps	3	IRH-PU1A
		4	IRH-PU1B
		5	IRH-PU1C
10.3.4	RI - Reactor Core Isolation Cooling Pump	6	IRI-PU
10.3.5	RR - Reactor Recirculation Pumps	7	IRR-PU1A
		8	IRR-PU1B

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Q.C. SUPERIVSOR L D Wheatley DATE 12/8/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
7/8" Head (12)	1E22-F004 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Wheatley 2/5/81	W J Caldwell 2-18-81
½" (4)	1E22-F005-1 (See Dwg. 6, Part 19A.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Wheatley 2/5/81	W J C 2-18-81
3/4" (8)	1E22-F005-2 (See Dwg. 6, Part 19.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Wheatley 2/5/81	W J C 2-18-81
1-1/8" Head (8)	1E22-F005-3 (See Dwg.6, Part 15.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Wheatley 2/5/81	W J C 2-18-81
1½" (20)	1E22-F038 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Wheatley 2/5/81	W J C 2-18-81

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LASALLE COUNTY STATION UNIT 1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
7/8" Head (12)	1E21-F005 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Wheatley 2/5/81	w g Caldwell 2-18-81
½" (4)	1E21-F006-1 (See Dwg. 6, Part 19A.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Wheatley 2/5/81	w gc 2-18-81
3/4" (8)	1E21-F006-2 (See Dwg. 6, Part 19.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Wheatley 2/5/81	w gc 2-18-81
1-1/8" (8)	1E21-F006-3 (See Dwg. 6, Part 15.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Wheatley 2/5/81	w gc 2-18-81
7/8" Head (12)	1E21-F051 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Wheatley 2/5/81	w gc 2-18-81

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INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. ILP-1011 REV. 1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR LD Wheatley DATE 3/20/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS. NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
14"	ILP-1011-1	0	C-F	E-P	2 1 1	5 4 5	PT UT-0° UT-45°	97040 78090 78159	 78089 78158	 01-14-01 01-14-01	 0018 0024	LD Wheatley 3/21/80	wJ Caldwell 3-21-80
14"	ILP-1011-2	0	C-F	P-E	2 1 1	6 4 5	PT UT-0° UT-45°	78016 78023 78116	 78022 78115	 01-14-01 01-14-01	 0015 0015	LD Wheatley 3/21/80	wJC 3-21-80
14"	ILP-1011-3	0	C-F	E-P	2 1 1	6 4 5	PT UT-0° UT-45°	78016 78023 78116	 78022 78115	 01-14-01 01-14-01	 0015 0015	LD Wheatley 3/21/80	wJC 3-21-80
14"	ILP-1011-4	0	C-F	P-E	2 1 1	5 4 5	PT UT-0° UT-45°	78010 78023 78159	 78022 78158	 01-14-01 01-14-01	 0015 0024	LD Wheatley 3/21/80	wJC 3-21-80
14"	ILP-1011-5	0	C-F	E-P	2 1 1	6 4 5	PT UT-0° UT-45°	78005 78023 78116	 78022 78115	 01-14-01 01-14-01	 0015 0015	LD Wheatley 3/21/80	wJC 3-21-80
14"	ILP-1011-6	0	C-F	P-E	2 1 1	6 4 5	PT UT-0° UT-45°	91190 91189 78116	 91188 78115	 01-14-01 01-14-01	 0009 0015	LD Wheatley 3/11/81 INCR-94	wJC 3-11-81
14"	ILP-1011-7	0	C-F	E-P	2 1 1	5 4 5	PT UT-0° UT-45°	91178 91189 78116	 91188 78115	 01-14-01 01-14-01	 0009 0015	LD Wheatley 5/30/80	wJC 7-22-80
14"	ILP-1011-8	0	C-F	P-E	2 1 1	5 4 5	PT UT-0° UT-45°	91178 91189 78116	 91188 78115	 01-14-01 01-14-01	 0009 0015	LD Wheatley 5/30/80	wJC 7-22-80

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LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1002B REV.1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
1" (12)	1B21-F013D (See Dwg.2, Part 16.)	1	B-G-2	VB	4	2	VT	84507	N/A	N/A	N/A	L D Wheatley 2/5/81	w J Caldwell 2-18-81
1" (12)	1B21-F013F (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84507	N/A	N/A	N/A	L D Wheatley 2/5/81	w jc 2-18-81
1" (12)	1B21-F013K (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	87510	N/A	N/A	N/A	L D Wheatley 2/5/81	w jc 2-18-81
1" (12)	1B21-F013S (See Dwg.2, Part 16.)	1	B-G-2	VB	4	2	VT	84510	N/A	N/A	N/A	L D Wheatley 2/5/81	w jc 2-18-81
1" (12)	1B21-F013M (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84507	N/A	N/A	N/A	L D Wheatley 2/5/81	w jc 2-18-81
1-3/8" (12)	IMS-1002B-15	1	B-G-2	FB	4	2	VT	84507	N/A	N/A	N/A	L D Wheatley 2/5/81	w jc 2-18-81
1-3/8" (12)	IMS-1002B-19	1	B-G-2	FB	4	2	VT	84507	N/A	N/A	N/A	L D Wheatley 2/5/81	w jc 2-18-81
1-3/8" (12)	IMS-1002B-23	1	B-G-2	FB	4	2	VT	84507	N/A	N/A	N/A	L D Wheatley 2/5/81	w jc 2-18-81

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INSTALLATION & SERVICE ENGINEERING DIVISION

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
1-3/8" (12)	IMS-1002B-27	1	B-G-2	FB	4	2	VT	84507	N/A	N/A	N/A	L D Wheatley 2/5/81	w g Caldwell 2-18-81
1-3/8" (12)	IMS-1002B-31	1	B-G-2	FB	4	2	VT	84507	N/A	N/A	N/A	L D Wheatley 2/5/81	wg 2-18-81

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INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1003B REV. 1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
1" (12)	1B21-F013C (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84508	N/A	N/A	N/A	L D Wheatley 2/5/81	W J Cl[illegible] 2-18-81
1" (12)	1B21-F013E (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84508	N/A	N/A	N/A	L D Wheatley 2/5/81	W J C 2-18-81
1" (12)	1B21-F013R (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84508	N/A	N/A	N/A	L D Wheatley 2/5/81	W J C 2-18-81
1" (12)	1B21-F013L (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84508	N/A	N/A	N/A	L D Wheatley 2/5/81	W J C 2-18-81
1" (12)	1B21-F013N (See Dwg. 2, Part 16.)	1	B-G-2	VB	4	2	VT	84508	N/A	N/A	N/A	L D Wheatley 2/5/81	W J C 2-18-81
1-3/8" (12)	IMS-1003B-13	1	B-G-2	FB	4	2	VT	84508	N/A	N/A	N/A	L D Wheatley 2/5/81	W J C 2-18-81
1-3/8" (12)	IMS-1003B-17	1	B-G-2	FB	4	2	VT	84508	N/A	N/A	N/A	L D Wheatley 2/5/81	W J C 2-18-81
1-3/8" (12)	IMS-1003B-21	1	B-G-2	FB	4	2	VT	84508	N/A	N/A	N/A	L D Wheatley 2/5/81	W J C 2-18-81

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whalley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
1-3/8" (12)	IMS-1003B-25	1	B-C-2	FB	4	2	VT	84508	N/A	N/A	N/A	L D Whalley 2/5/81	w J Caldwell 2-18-81
1-3/8" (12)	IMS-1003B-29	1	B-G-2	FB	4	2	VT	84508	N/A	N/A	N/A	L D Whalley 2/5/81	wjc 2-18-81

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LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1051B REV. 2

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whatley DATE 12/23/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
1-5/8" (24)	1B21-F022A (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Whatley 2/5/81	W J Caldwell 2-18-81
1-5/8" (24)	1B21-F028A (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Whatley 2/5/81	W J C 2-18-81

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LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1052B REV. 2

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Q.C. SUPERIVSOR L D Whatley DATE 12/23/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
1-5/8" (24)	1B21-F022B (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	8451	N/A	N/A	N/A	L D Whatley 2/5/81	W J Caldwell 2-18-81
1-5/8" (24)	1B21-F028B (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	8451	N/A	N/A	N/A	L D Whatley 2/5/81	W JC 2-18-81

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IC NO. IMS-1053B REV. 2

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Q.C. SUPERIVSOR L D Whatley DATE 12/23/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
1-5/8" (24)	1B21-F022C (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Whatley 2/5/81	w g Caldwell 2-18-81
1-5/8" (24)	1B21-F028C (Sec Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Whatley 2/5/81	w gc 2-18-81

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LASALLE COUNTY STATION UNIT 1

IC NO. IMS-1054B REV. 2

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Q.C. SUPERIVSOR L D Whatley DATE 12/23/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
1-5/8" (24)	1B21-F022D (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Whatley 2/5/81	w g Callicoat 2-18-81
1-5/8" (24)	1B21-F028D (See Dwg. 3, Parts 5 & 6)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Whatley 2/5/81	wgc 2 18-81

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LASALLE COUNTY STATION UNIT 1

IC NO. INS-1055B REV. 1

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Q.C. SUPERIVSOR L D Whatley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
7/8" (10)	1E51-F063 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Whatley 2/5/81	W J Caldwell 2-18-81

GENERAL ELECTRIC

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INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRH-1001 REV. 4

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 6/23/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
12"	IRH-1001-1	0	C-F	P-V	1 1 2	2 2 3	UT-0° UT-45° PT	25002 25006 20227	25001 25004A	01-12-01 01-12-01	70165 20192	INCR-98 L D Wheatley 3/11/81 also (97073)(97074)	W JC 3-11-81
12"	IRH-1001-2	0	B-J	P-V	1 1 2	2 3 3	UT-0° UT-45° PT	25004 25092 20228	25003 25091	01-12-03 01-12-03	70165 60099	L D Wheatley 6/23/80	W J Caldwell 6-23-80
12"	IRH-1001-4	0	B-K-1	P-PH	2	3	PT	20228				L D Wheatley 6/23/80 SEE RI-01	W J Caldwell 6-23-80
12"	IRH-1001-7	0	B-J	P-E	1 1 2	2 2 3	UT-0° UT-45° PT	25004 10167 (20228)	25003 10166	01-12-03 01-12-03	70165 20192	L D Wheatley 6/23/80 (05002)	W J Caldwell 6-23-80
12"	IRH-1001-10	0	B-J	P-E	1 1 2	2 2 3	UT-0° UT-45° PT	25004 10167 (20228)	25003 10166	01-12-03 01-12-03	70165 20192	L D Wheatley 6/23/80 (15003)	W J Caldwell 6-23-80
12"	IRH-1001-12	0	B-J	P-E	1 1 2	3 2 3	UT-0° UT-45° PT	25087 10183 80121	25086 10182	01-12-03 01-12-03	60099 20184	L D Wheatley 6/23/80	W J Caldwell 6-23-80
12"	IRH-1001-13	0	B-J	P-E	1 1 2	3 2 3	UT-0° UT-45° PT	25087 10184 (30040)	25086 10182	01-12-03 01-12-03	60099 20184	L D Wheatley 6/23/80 (95010)	W J Caldwell 6-23-80
12"	IRH-1001-14	0	B-J	P-E	1 1 2	2 3 3	UT-0° UT-45° PT	25038 25052 45007	25036 25051	01-12-03 01-12-03	20192 20192	L D Wheatley 6/23/80	W J Caldwell 6-23-80

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LASALLE COUNTY STATION UNIT 1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 1/23/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
½" (6)	1E12-F050B-1 (See Dwg. 6, Part 19A)	1	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Wheatley 2/5/81	W J Caldwell 2-18-81
3/4" (8)	1E12-F050B-2 (See Dwg. 6, Part 19)	1	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Wheatley 2/5/81	WJC 2-18-81
1-1/8" Head (8)	1E12-F050B-3 (See Dwg. 6, Part 15)	1	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Wheatley 2/5/81	WJC 2-18-81
3/4" (6)	1E12-F053B (See Dwg. 1, Part 232-4)	1	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Wheatley 2/5/81	WJC 2-18-81
7/8" Head (12)	1E12-F090B (See Dgw. 1, Part 232-4)	1	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Wheatley 2/5/81	WJC 2-18-81

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whatley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
½" (4)	1E12-F041B-1 (See Dwg. 6, Part 19A.)	0	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	L D Whatley 2/5/81	w g Caldwell 2-18-81
3/4" (8)	1E12-F041B-2 (See Dwg. 6, Part 19.)	0	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	L D Whatley 2/5/81	wgc 2-18-81
1-1/8" Head (8)	1E12-F041B-3 (See Dwg.6, Part 15.)	0	B-G-2	VB	4	2	VT	84510	N/A	N/A	N/A	L D Whatley 2/5/81	wgc 2-18-81
7/8" (12)	1E12-F042B (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Whatley 2/5/81	wgc 2-18-81
7/8" (12)	1E12-F092B (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	L D Whatley 2/5/81	wgc 2-18-81

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IC NO. IRH-1003B REV. 1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whatley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE
½" (4)	1E12-F041A-1 (See Dwg. 6, Part 19A.)	1	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	L D Whatley 2/5/81	W J Cottrell 2-18-81
3/4" (8)	1E12-F041A-2 (See Dwg. 6, Part 19.)	1	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	L D Whatley 2/5/81	W JC 2-18-81
1-1/8" Head (8)	1E12-F041A-3 (See Dwg. 6, Part 15.)	1	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	L D Whatley 2/5/81	W JC 2-18-81
7/8" (12)	1E12-F042A (See Dwg. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Whatley 2/5/81	W JC 2-18-81
7/8" (12)	1E12-F092A (See Dwg. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	L D Whatley 2/5/81	W JC 2-18-81

GENERAL ELECTRIC

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LASALLE COUNTY STATION UNIT 1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whatley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
½" (4)	1E12-F041C-1 (See Dwg. 6, Part 19A.)	1	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	L D Whatley 2/5/81	W J Caldwell 2-18-81
3/4" (8)	1E12-F041C-2 (See Dwg. 6, Part 19.)	1	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	L D Whatley 2/5/81	WJC 2-18-81
1-1/8" Head (8)	1E12-F041C-3 (See Dwg. 6, Part 15.)	1	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	L D Whatley 2/5/81	WJC 2-18-81
7/8" (12)	1E12-F042C (See Dwg. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Whatley 2/5/81	WJC 2-18-81
7/8" (12)	1E12-F092C (See Dwg. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84509	N/A	N/A	N/A	L D Whatley 2/5/81	WJC 2-18-81

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LASALLE COUNTY STATION UNIT 1

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Q.C. SUPERIVSOR L D Whatley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
½" (4)	1E12-F050A-1 (See Dwg. 6, Part 19A.)	2	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Whatley 2/5/81	w j Caldwell 2-18-81
3/4" (8)	1E12-F050A-2 (See Dwg. 6, Part 19.)	2	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Whatley 2/5/81	w jc 2-18-81
1-1/8" Head (8)	1E12-F050A-3 (See Dwg. 6, Part 15.)	2	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Whatley 2/5/81	w jc 2-18-81
3/4" (6)	1E12-F053A (See Dwg. 1, Part 232-4.)	2	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Whatley 2/5/81	w jc 2-18-81
7/8" Head (12)	1E12-F090A (See Dwg. 1, Part 232-4.)	2	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Whatley 2/5/81	w jc 2-18-81

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IC NO. IRH-1013 REV. 1

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Q.C. SUPERIVSOR L D Wheatley DATE 1/22/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS. NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
18"	IRH-1013-6	1	C-F	P-T	1 1 2	4 4 5	UT-0° UT-45° PT	94034 91042 89004	94033 91041	01-18-01 01-18-01	0004 0005	L D Wheatley 5/24/79	1-24-80 FFR
18"	IRH-1013-7	1	C-F	P-T	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91030 0004	94022 91029	01-18-01 01-18-01	0004 0005	L D Wheatley 5/11/79	1-23-80 FFR
18"	IRH-1013-13	1	C-F	P-V	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91030 0004	94022 91029	01-18-01 01-18-01	0004 0005	L D Wheatley 5/11/79	1-23-80 FFR
18"	IRH-1013-14	1	C-F	E-V	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91030 0003	94022 91029	01-18-01 01-18-01	0004 0005	L D Wheatley 5/11/79	1-23-80 FFR
18"	IRH-1013-15	1	C-F	T-V	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91032 0005	94022 91031	01-18-01 01-18-01	0004 0005	L D Wheatley 5/11/79	1-23-80 FFR
18"	IRH-1013-16	1	C-F	P-V	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91030 0005	94022 91029	01-18-01 01-18-01	0004 0005	L D Wheatley 5/11/79	1-23-80 FFR
18"	IRH-1013-19	1	C-F	P-T	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91030 0003	94022 91029	01-18-01 01-18-01	0004 0005	L D Wheatley 5/11/79	1-23-80 FFR
18"	IRH-1013-20	1	C-F	P-T	1 1 2	4 4 3	UT-0° UT-45° PT	94023 91030 0004	94022 91029	01-18-01 01-18-01	0004 0005	L D Wheatley 5/11/79	1-23-80 FFR

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INSTALLATION & SERVICE ENGINEERING DIVISION

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LASALLE COUNTY STATION UNIT 1

IC NO. IRH-1024B REV.0

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Q.C. SUPERIVSOR L W Wheatley DATE 12/22/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
1-1/8" (16)	1E12-F021	1	C-D	VB	4	2	VT		N/A	N/A	N/A	See RI-02.	

GENERAL ELECTRIC

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LASALLE COUNTY STATION UNIT 1

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Q.C. SUPERIVSOR R D Whalley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	I.DS. NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
1½" Head (8)	1E12-F008 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	R D Whalley 2/5/81	w g Caldwell 2-18-81
1½" Head (8)	1E12-F009 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	R D Whalley 2/5/81	wgc 2-18-81
1½" Head (8)	1E12-F020 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	R D Whalley 2/5/81	wgc 2-18-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

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LASALLE COUNTY STATION UNIT 1

IC NO. IRH-1045 REV. 2

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Q.C. SUPERIVSOR L D Whatley DATE 6/17/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
8"	IRH-1045-1	0	C-F	E-P	2	6	PT	78055				L D Whatley 3/24/80	W J C
					1	4	UT-0°	78057	78056	01-08-02	0015		7-30-80
					1	5	UT-45°	77170	77179	01-08-02	0020		
8"	IRH-1045-2	0	C-F	P-E	2	6	PT	78055				L D Whatley 3/24/80	W J C
					1	4	UT-0°	78057	78056	01-08-02	0015		7-30-80
					1	5	UT-45°	77170	77179	01-08-02	0020		
8"	IRH-1045-3	0	C-F	E-P	2	6	PT	97042				L D Whatley 3/24/80	W J C
					1	5	UT-0°	77212	77211	01-08-02	0020		7-30-80
					1	5	UT-45°	77214	77213	01-08-02	0020		
8"	IRH-1045-4	0	C-F	P-P	2	5	PT					Examinations Not Required per Table IWC-2520 Category C-F	
					1	4	UT-0°			01-08-02			
					1	4	UT-45°			01-08-02			
8"	IRH-1045-5	0	C-F	P-E	2	6	PT 0	97042					W J C
					1	5	UT-0	77212	77211	01-08-02	0020	INCR-99	3-11-81
					1	5	UT-45°	77170	77169	01-08-02	0020	L D Whatley 3/11/81	
8"	IRH-1045-6	0	C-F	E-P	2	6	PT	78055				L D Whatley 10/22/80	W J C
					1	4	UT-0°	78057	78056	01-08-02	0015		10-27-8
					1	5	UT-45°	77214	77213	01-08-02	0020		
8"	IRH-1045-7	0	C-F	P-E	2	6	PT	78055				L D Whatley 3/20/80	W J C
					1	4	UT-0°	78057	78056	01-08-02	0015		7-30-80
					1	4	UT-45°	78069	78068	01-08-02	0015		
8"	IRH-1045-8	0	C-F	E P	2	6	PT	78055				L D Whatley 3/24/80	W J C
					1	4	UT-0°	78057	78056	01-08-02	0015		7-30-80
					1	4	UT-45°	78069	78068	01-08-02	0015		

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRH-1047 REV. 1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 3/18/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS. NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
8"	IRH-1047-2	0	C-F	R-F	2		PT	97005				L D Wheatley 3/25/80	X wgc
					1	5	UT-0°	93071	93070	01-08-02	0024		3-28-80
					1	5	UT-45°	77164	77163	01-08-02	0020		
8"	IRH-1047-4	0	C-F	F-P	2	5	PT	97005				L D Wheatley 3/25/80	wgc
					1	5	UT-0°	93044	93042	01-08-02	0024		3-26-80
					1	5	UT-45°	93058	93057	01-08-02	0024		
8"	IRH-1047-7	0	C-F	P-V	2	5	PT	97005				L D Wheatley 3/25/80	wgc
					1	5	UT-0°	93043	93042	01-08-02	0024		3-26-80
					1	5	UT-45°	93058	93057	01-08-02	0024		
8"	IRH-1047-8	0	C-F	V-P	2	5	PT	97005				L D Wheatley 3/25/80	wgc
					1	5	UT-0°	93043	93042	01-08-02	0024		3-26-80
					1	5	UT-45°	93058	93057	01-08-02	0024		
8"	IRH-1047-11	0	C-F	P-E	2	6	PT	97051				L D Wheatley 3/25/80	X wgc
					1	5	UT-0°	93071	93070	01-08-02	0024		3-28-80
					1	5	UT-45°	77164	77163	01-08-02	0020		
8"	IRH-1047-15	0	C-F	E-V	2	5	PT	97006				L D Wheatley 3/25/80	wgc
					1	5	UT-0°	93043	93042	01-08-02	0024		3-26-80
					1	5	UT-45°	93055	93054	01-08-02	0024		
8"	IRH-1047-17	0	C-F	V-P	2	5	PT	91177				INCR-95	wgc
					1	5	UT-0°	93043	93042	01-08-02	0024		3-11-81
					1	5	UT-45°	93055	93054	01-08-02	0024	L D Wheatley 3/11/81	

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1001B REV. 1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whalley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
3/4" Head (6)	1B51-F008 (See Dwg. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Whalley 2/5/81	W J C 2-18-81
7/8" Head (10)	1B51-F064 (See Dwg. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Whalley 2/5/81	W J C 2-18-81

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INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1003B REV. 1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whalley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
3/4" Head (6)	1E51-F013 (See Dwg. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Whalley 2/5/81	W J Caldwell 2-18-81
5/8" (4)	1E12-F019 (See Dwg. 1, Part 232-4.)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Whalley 2/5/81	W JC 2-18-81
½" (14)	1E51-F065-1 (See Dwg. 7, Parts 19 & 19A)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Whalley 2/5/81	W JC 2-18-81
1-1/8" Head (4)	1E51-F065-2 (See Dwg.7, Part 15,)	1	B-G-2	VB	4	2	VT	84512	N/A	N/A	N/A	L D Whalley 2/5/81	W JC 2-18-81

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INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1004 REV. 0

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 6/12/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
8"	IRI-1004-22	0	C-F	T-P	2	6	PT	97088				L D Wheatley 8/1/80	W J C
					1	6	UT-0°	77346	77345	01-08-02	0040		8-1-80
					1	6	UT-45°	77348	77347	01-08-02	0040		
8"	IRI-1004-24	0	C-F	P-V	2	6	PT	77400				L D Wheatley 8/1/80	W J C
					1	6	UT-0°	77408	77407	01-08-02	0040		8-1-80
					1	6	UT-45°	77410	77409	01-08-02	0038		
8"	IRI-1004-25	0	C-F	V-P	2	6	PT	97087				L D Wheatley 8/1/80	W J C
					1	6	UT-0°	77340	77339	01-08-02	0040		8-1-80
					1	6	UT-45°	77342	77341	01-08-02	0040		
8"	IRI-1004-30	0	C-F	P-F	2	6	PT	97085				L D Wheatley 8/1/80	W J C
					1	6	UT-0°	77340	77339	01-08-02	0040		8-1-80
					1	6	UT-45°	77342	77341	01-08-02	0040		
8"	IRI-1004-32	0	C-F	F-P	2	6	PT	97085				L D Wheatley 8/1/80	W J C
					1	6	UT-0°	77340	77339	01-08-02	0040		8-1-80
					1	6	UT-45°	77342	77341	01-08-02	0040		
8"	IRI-1004-33	0	C-F	P-F	2	6	PT	97085				L D Wheatley 8/1/80	W J C
					1	6	UT-0°	77340	77339	01-08-02	0040		8-1-80
					1	6	UT-45°	77342	77341	01-08-02	0040		
8"	IRI-1004-35	0	C-F	F-E	2	6	PT	97085				L D Wheatley 8/1/80	W J C
					1	6	UT-0°	77340	77339	01-08-02	0040		8-1-80
					1	6	UT-45°	77342	77341	01-08-02	0040		
6"	IRI-1004-37	0	C-F	E-P	2	6	PT	(77382) (97086)				(77463)	W J C
					1	6	UT-0°	77553	77552	01-06-01	0053	INCR-103	3-11-81
					1	6	UT-45°	77561	77560	01-06-01	0057	L D Wheatley 3/11/81	

FORM (IC-1)

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1004 REV. 1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whatley DATE 2/17/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
6"	IRI-1004-37A	0	C-F	P-PU	2	6	PT	77388				L D Whatley 2/17/81	W. J. Caldwell 2-17-81
					1	6	UT-0°	77555	77554	01-06-02	0053		
					1	6	UT-45°	77557	77556	01-06-02	0053		
8"	IRI-1004-38B	0	C-F	F-F	2	6	PT	83008				L D Whatley 2/17/81	wjc 2-17-81
					1	6	UT-0°	83014	83013	01-08-02	0038		
					1	6	UT-45°	83012	83011	01-08-02	0038		
8"	IRI-1004-38C	0	C-F	E-P	2	6	PT	83008				L D Whatley 2/17/81	wjc 2-17-81
					1	6	UT-0°	83014	83013	01-08-02	0038		
					1	6	UT-45°	83012	83011	01-08-02	0038		
8"	IRI-1004-41	0	C-E-1	P-PH	NA	NA	MT	NA	NA	NA	NA	See PSI Ref. No. RI-1	wjc 2-18-81
8"	IRI-1004-43	0	C-F	P-V	2	6	PT	78348				L D Whatley 2/17/81	wjc 2-17-81
					1	6	UT-0°	78352	78350	01-08-02	0036		
					1	6	UT-45°	78363	78359	01-08-02	0036		
8"	IRI-1004-44	0	C-F	V-P	2	6	PT	78348				L D Whatley 2/17/81	wjc 2-17-81
					1	6	UT-0°	78351	78350	01-08-02	0036		
					1	6	UT-45°	78363	78359	01-08-02	0036		
8"	IRI-1004-46	0	C-F	P-V	2	6	PT	78348				L D Whatley 2/17/81	wjc 2-17-81
					1	6	UT-0°	78351	78350	01-08-02	0036		
					1	6	UT-45°	78363	78359	01-08-02	0036		
8"	IRI-1004-49	0	C-F	V-P	2	6	PT	78348				L D Whatley 2/17/81	wjc 2-17-81
					1	6	UT-0°	78351	78350	01-08-02	0036		
					1	6	UT-45°	78363	78359	01-08-02	0036		

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1005 REV. 0

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L W Wheatley DATE 6/11/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
6"	IRI-1005-1	0	C-F	Pu-E	2	6	PT	(77384)				(77463)	w gc
					1	6	UT-0°	77481	77480	01-06-02	0038	INCR-104	3-11-81
					1	6	UT-45°	77483	77482	01-06-02	0047	L W Wheatley 3/11/81	
6"	IRI-1005-3	0	C-F	E-V	2	6	PT	77323				L W Wheatley 8/1/80	w gc
					1	6	UT-0°	77326	77325	01-06-02	0040		8-1-80
					1	6	UT-45°	77328	77327	01-06-02	0040		
6"	IRI-1005-4	0	C-F	V-P	2	6	PT	77323				L W Wheatley 8/1/80	w gc
					1	6	UT-0°	77326	77325	01-06-02	0040		8-1-80
					1	6	UT-45°	77328	77327	01-06-02	0040		
6"	IRI-1005-6	0	C-F	P-E	2	6	PT	77323				L W Wheatley 8/1/80	w gc
					1	6	UT-0°	77326	77325	01-06-02	0040		8-1-80
					1	6	UT-45°	77328	77327	01-06-02	0040		
6"	IRI-1005-8	0	C-F	E-P	2	6	PT	77323				L W Wheatley 8/1/80	w gc
					1	6	UT-0°	77326	77325	01-06-02	0040		8-1-80
					1	6	UT-45°	77328	77327	01-06-02	0040		
6"	IRI-1005-7	0	C-E-1	E-ST	2	6	PT	97082				L W Wheatley 8/1/80	w gc
													8-1-80
6"	IRI-1005-11	0	C-F	P-E	2	6	PT	77323				L W Wheatley 8/1/80	w gc
					1	6	UT-0°	77326	77325	01-06-02	0040		8-1-80
					1	6	UT-45°	77328	77327	01-06-02	0040		

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1013 REV. 2

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whitley DATE 2/17/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
6"	IRI-1013-9	0	C-F	F-P	2	6	PT	83020				L D Whitley 2/17/81	w g Caldwell
					1	6	UT-0°	83038	83037	01-06-01	0036	"T EDS 77433	2-17-81
					1	6	UT-45°	77455	77454	01-06-01	0046		
6"	IRI-1013-10	0	C-E-1	P-PH	NA	NA	MT	NA	NA	NA	NA	See PSI Ref. No. RI-2	w g c 2-18-81
6"	IRI-1013-13	0	C-F	P-E	2	6	PT					See RI-16	
					1	6	UT-0°			01-06-01			
					1	6	UT-45°			01-06-01			
6"	IRI-1013-14	0	C-F	E-P	2	6	PT						
					1	6	UT-0°			01-06-01			
					1	6	UT-45°			01-06-01			

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INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1016 REV. 1

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Q.C. SUPERIVSOR L D Wheatley DATE 2/17/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
10"	IRI-1016-1	0	C-F	P-E	2	6	PT	93223				L D Wheatley 2/17/81	w g Caldwell
					1	6	UT-0°	93232	93231	01-10-01	0038		2-17-81
					1	6	UT-45°	93251	93249	01-10-01	0039		
10"	IRI-1016-2	0	C-F	E-P	2	6	PT	93223				L D Wheatley 2/17/81	w g c
					1	6	UT-0°	93232	93231	01-10-01	0038		2-17-81
					1	6	UT-45°	93251	93249	01-10-01	0039		
10"	IRI-1016-4	0	C-E-1	P-PH	NA	NA	MT	NA	NA	NA	NA	See PSI Ref. No. RI-3	w g c 2-18-81
10"	IRI-1016-6	0	C-F	P-E	2	6	PT	93237				L D Wheatley 2/17/81	w g c
					1	6	UT-0°	93023	93022	01-10-01	0036		2-17-81
					1	6	UT-45°	93252	93249	01-10-01	0039		
10"	IRI-1016-7	0	C-F	E-E	2	6	PT	93237				L D Wheatley 2/17/81	w g c
					1	6	UT-0°	93023	93022	01-10-01	0036		2-17-81
					1	6	UT-45°	93251	93249	01-10-01	0039		
10	IRI-1016-8	0	C-F	E-P	2	6	PT	93237				L D Wheatley 2/17/81	w g c
					1	6	UT-0°	93023	93022	01-10-01	0036		2-17-81
					1	6	UT-45°	93251	93249	01-10-01	0039		
10"	IRI-1016-12	0	C-F	P-E	2	6	PT	93239				L D Wheatley 2/17/81	w g c
					1	6	UT-0°	93241	93240	01-10-01	0036		2-17-81
					1	6	UT-45°	93252	93249	01-10-01	0039		
10"	IRI-1016-13	0	C-F	E-P	2	6	PT	93239				L D Wheatley 2/17/81	w g c
					1	6	UT-0°	93241	93240	01-10-01	0036		2-17-81
					1	6	UT-45°	93252	93249	01-10-01	0039		

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1018 REV. 1

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 2/17/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
10"	IRI-1018-1	0	C-F	P-E	2	6	PT	83025				L D Wheatley 2/17/81	w. g. Caldwell 2-17-81
					1	6	UT-0°	93241	93240	01-10-01	0036		
					1	6	UT-45°	93250	93249	01-10-01	0039		
10"	IRI-1018-2	0	C-F	E-P	2	6	PT	83026				L D Wheatley 2/17/81	wgc 2-17-81
					1	6	UT-0°	93246	93245	01-10-01	0036		
					1	6	UT-45°	93250	93249	01-10-01	0039		
10"	IRI-1018-4	0	C-E-1	P-PH	NA	NA	MT	NA	NA	NA	NA	See PSI Ref. No. RI-4.	wgc 2-18-81
10"	IRI-1018-5	0	C-F	P-E	2	6	PT	83021				L D Wheatley 2/17/81	wgc 2-17-81
					1	6	UT-0°	83023	83022	01-10-01	0036		
					1	6	UT-45°	93256	93255	01-10-01	0039		
10"	IRI-1018-7	0	C-F	E-E	2	6	PT	83021				L D Wheatley 2/17/81	wgc 2-17-81
					1	6	UT-0°	83023	830 2	01-10-01	0036		
					1	6	UT-45°	93257	93255	01-10-01	0039		
10"	IRI-1018-8	0	C-F	E-P	2	6	PT	83021				L D Wheatley 2/17/81	wgc 2-17-81
					1	6	UT-0°	83023	83022	01-10-01	0036		
					1	6	UT-45°	93257	93255	01-10-01	0039		
10"	IRI-1018-9	0	C-F	P-E	2	6	PT	93239				L D Wheatley 2/17/81	wgc 2-17-81
					1	6	UT-0°	1932[illegible]	93245	01-10-01	0036		
					1	6	UT-45°	83[illegible]	83028	01-10-01	0039		
10"	IRI-1018-11	0	C-F	E-P	2	6	PT	93239				L D Wheatley 2/17/81	wgc 2-17-81
					1	6	UT-0°	93246	93245	01-10-01	0036		
					1	6	UT-45°	83029	83028	01-10-01	0039		

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1019 REV. 0

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REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 6/11/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
10"	IRI-1019-11	0	C-F	P-R	2	6	PT	(97083) 77315				(77463) L D Wheatley 3/4/81 INCR-105	W J C 3-11-81
					1	6	UT-0°	77469	77468	01-10-02	0038		
					1	6	UT-45°	92213	92212	01-10-02	0050		
18"	IRI-1019-12	0	C-F	R-P	2	6	PT	97081				L D Wheatley 10/22/80	W J. Caldwell 10-23-80
					1	6	UT-0°	77412	77411	01-14-01	0040		
					1	6	UT-45°	77415	77413	01-14-01	0038		
10"	IRI-1019-13	0	C-F	P-W	2	6	PT	77400				L D Wheatley 8/1/80	W J C 8-1-80
					1	6	UT-0°	77402	77401	01-10-02	0038		
					1	6	UT-45°	77405	77403	01-10-02	0038		
18"	IRI-1019-14	0	C-F	P-C	2	6	PT	77406				L D Wheatley 10/22/80	W J C 10-23-80
					1	6	UT-0°	77412	77411	01-14-01	0040		
					1	6	UT-45°	77414	77413	01-14-01	0038		
10"	IRI-1019-15	0	C-F	W-P	2	6	PT	77400				L D Wheatley 8/1/80	W J C 8-1-80
					1	6	UT-0°	77402	77401	01-10-02	0038		
					1	6	UT-45°	77405	77403	01-10-02	0038		
10"	IRI-1019-16	0	C-F	P-E	2	6	PT	77400				L D Wheatley 10/22/80	W J C 10-23-80
					1	6	UT-0°	77402	77401	01-10-02	0038		
					1	6	UT-45°	77404	77403	01-10-02	0038		
10"	IRI-1019-17	0	C-F	E-P	2	6	PT	97087				L D Wheatley 8/1/80	W J C 8-1-80
					1	6	UT-0°	77387	77386	01-10-02	0040		
					1	6	UT-45°	77381	77375	01-10-02	0043		
10"	IRI-1019-18	0	C-F	P-E	2	6	PT	97084				L D Wheatley 8/1/80	W J C 8-1-80
					1	6	UT-0°	77330	77329	01-10-02	0040		
					1	6	UT-45°	77332	77331	01-10-02	0040		

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1020 REV. 2

PAGE 1 of 2

REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whatley DATE 2/17/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
10"	IRI-1020-1	0	C-F	E-P	2	6	PT	83017				L D Whatley 2/17/81	w g Caldwell
					1	6	UT-0°	93230	93229	01-10-02	0038		2-17-81
					1	6	UT-45°	77378	77375	01-10-02	0043		
10"	IRI-1020-3	0	C-F	P-V	2	6	PT	83020				L D Whatley 2/17/81	w g c
					1	6	UT-0°	93230	93229	01-10-02	0038		2-17-81
					1	6	UT-45°	77376	77375	01-10-02	0043		
10"	IRI-1020-4	0	C-F	V-E	2	6	PT	83020				L D Whatley 2/17/81	w g c
					1	6	UT-0°	93230	93229	01-10-02	0038		2-17-81
					1	6	UT-45°	77377	77375	01-10-02	0043		
10"	IRI-1020-5	0	C-F	E-P	2	6	PT	83020				L D Whatley 2/17/81	w g c
					1	6	UT-0°	93230	93229	01-10-02	0038		2-17-81
					1	6	UT-45°	77376	77375	01-10-02	0043		
10"	IRI-1020-9	0	C-F	P-V	2	6	PT	83020				L D Whatley 2/17/81	w g c
					1	6	UT-0°	93230	93229	01-10-02	0038		2-17-81
					1	6	UT-45°	77378	77375	01-10-02	0043		
10"	IRI-1020-10	0	C-F	V-P	2	6	PT	83020				L D Whatley 2/17/81	w g c
					1	6	UT-0°	93230	93229	01-10-02	0038		2-17-81
					1	6	UT-45°	77378	77375	01-10-02	0043		
10"	IRI-1020-13	0	C-E-1	P-PH	NA	NA	MT	NA	NA	NA	NA	See PSI Ref. No. RI-5.	w g c 2-18-81
10"	IRI-1020-16	0	C-F	P-E	2	6	PT	93212				L D Whatley 2/17/81	w g c
					1	6	UT-0°	93214	93213	01-10-02	0037		2-17-81
					1	6	UT-45°	93216	93215	01-10-02	0028		

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRI-1022 REV. 2

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 2/17/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
6"	IRI-1022 8	0	C-F	F-E	2	6	PT	83027				L D Wheatley 2/17/81	w g Caldwell
					1	6	UT-0°	83033	83032	01-06-01	0036		2-17-81
					1	6	UT-45°	83040	83039	01-06-01	0039		
6"	IRI-1022-9	0	C-F	E-E	2	6	PT	83027				L D Wheatley 2/17/81	w g c
					1	6	UT-0°	83033	83032	01-06-01	0036		2-17-81
					1	6	UT-45°	83040	83039	01-06-01	0039		
6"	IRI-1022-10	0	C-F	E-P	2	6	PT	83027				L D Wheatley 2/17/81	w g c
					1	6	UT-0°	83033	83032	01-06-01	0036		2-17-81
					1	6	UT-45°	83040	83039	01-06-01	0039		
6"	IRI-1022-11	0	C-F	P-E	2	6	PT	83036				L D Wheatley 2/17/81	w g c
					1	6	UT-0°	83033	83032	01-06-01	0036		2-17-81
					1	6	UT-45°	83035	83034	01-06-01	0039		
6"	IRI-1022-12	0	C-F	E-P	2	6	PT	83027				L D Wheatley 2/17/81	w g c
					1	6	UT-0°	83033	83032	01-06-01	0036		2-17-81
					1	6	UT-45°	83035	83034	01-06-01	0039		
6"	IRI-1022-13	0	C-E-1	P-PH	NA	NA	PT	NA	NA	NA	NA	See PSI Ref. No. RI-6	w g c 2-18-81
6"	IRI-1022-16	0	C-F	P-E	2	6	PT	83007				L D Wheatley 2/17/81	w g c
					1	6	UT-0°	4230	4229	01-06-01	0041		2-17-81
					1	6	UT-45°	83010	83009	01-06-01	0039		
6"	IRI-1022-17	0	C-F	E-P	2	6	PT						
					1	6	UT-0°			01-06-01			
					1	6	UT-45°			01-06-01			

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRR-1009B REV. 1

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whelly DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
3/4" Head (6)	1G33-F106 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	8451	N/A	N/A	N/A	L D Whelly 2/5/81	W J Caldwell 2-18-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRR-1010B REV. 1

PAGE 1 of 1

REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Whatley DATE 12/15/80

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
3/4" Head (6)	1G33-F100 (See Dwg. 1, Part 232-4.)	0	B-G-2	VB	4	2	VT	84511	N/A	N/A	N/A	L D Whatley 2/5/81	W J Caldwell 2-18-81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRT-1001 REV. 1

PAGE 2 of 6

REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L D Wheatley DATE 2/17/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
6"	IRT-1001-12	0	B-J	E-P	2	5	PT	94168				L D Wheatley 2/17/81	W J Caldwell
					1	4	UT-0°	94181	94178	01-06-03	0009		2-17-81
					1	4	UT-45°	94189	94187	01-06-03	0009		
6"	IRT-1001-12A	0	B-J	P-T	2	5	PT	94169				L D Wheatley 2/17/81	W J C
					1	4	UT-0°	94191	94178	01-06-03	0009		2-17-81
					1	4	UT-45°	94188	94187	01-06-03	0009		
6"	IRT-1001-12B	0	B-J	T-P	2	5	PT	94169				L D Wheatley 2/17/81	W J C
					1	4	UT-0°	94181	94178	01-06-03	0009		2-17-81
					1	4	UT-45°	94188	94187	01-06-03	0009		
4"	IRT-1001-13	0	B-J	T-P	2	5	PT	94169				L D Wheatley 2/17/81	W J C
					1	4	UT-0°	93013	93012	01-04-04	94134		2-17-81
					1	4	UT-45°	94177	94172	01-04-04	0009		
6"	IRT-1001-14	0	B-J	P-E	2	5	PT	94169				L D Wheatley 2/17/81	W J C
					1	4	UT-0°	94179	94178	01-06-03	0009		2-17-81
					1	4	UT-45°	94188	94187	01-06-03	0009		
4"	IRT-1001-15	0	B-J	P-E	2	5	PT	94169				L D Wheatley 2/17/81	W J C
					1	4	UT-0°	93013	93012	01-04-04	94134		2-17-81
					1	4	UT-45°	94177	94172	01-04-04	0009		
6"	IRT-1001-16	0	B-J	E-P	2	5	PT	94169				L D Wheatley 2/17/81	W J C
					1	4	UT-0°	94179	94178	01-06-03	0009		2-17-81
					1	4	UT-45°	94188	94187	01-06-03	0009		
6"	IRT-1001-18	0	B-J	P-F	2	7	PT	93278				L D Wheatley 2/17/81	W J C
					1	6	UT-0°	77577	77578	01-06-03	0057		2-17-81
					1	6	UT-45°	77581	77580	01-06-03	0053		

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

INSPECTION CHECKLIST

LASALLE COUNTY STATION UNIT 1

IC NO. IRT-1001 REV. 1

PAGE 3 of 6

REVIEWED AND APPROVED BY:

Q.C. SUPERIVSOR L W Wheatley DATE 2/17/81

SIZE 00	EXAM COMP ID NO 01	DWG. REV. NO. 02	ASME CAT 03	COMP FIG 04	PROCEDURE NO. 05	REV. NO. 06	EXAM TYPE 07	EDS NO. 08	CDS NO. 09	LSCS CAL STD. NO. 10	LDS NO. 11	Q.C. REVIEW SIGNATURE/DATE 12	AI INIT/DATE 13
6"	IRT-1001-19	0	B-J	F-P	2	7	PT	75278				L W Wheatley 2/17/81	w g. Caldwell
					1	6	UT-0°	77579	77578	01-06-03	0057		2-17-81
					1	6	UT-45°	77581	77580	01-06-03	0053		
6"	IRT-1001-20	0	B-J	P-E	2	5	PT	94171				L W Wheatley 2/17/81	w g c
					1	4	UT-0°	94179	94178	01-06-03	0009		2-17-81
					1	4	UT-45°	94188	94187	01-06-03	0009		
6"	IRT-1001-21	0	B-J	E-P	2	5	PT	15029				L W Wheatley 2/17/81	w g c
					1	4	UT-0°	94179	94178	01-06-03	0009		2-17-81
					1	4	UT-45°	94188	94187	01-06-03	0009		
6"	IRT-1001-22	0	B-J	P-E	2	5	PT	15029				L W Wheatley 2/17/81	w g c
					1	4	UT-0°	94179	94178	01-06-03	0009		2-17-81
					1	4	UT-45°	94188	94187	01-06-03	0009		
6"	IRT-1001-23	0	B-J	E-V	2	5	PT	94171				L W Wheatley 2/17/81	w g c
					1	4	UT-0°	94179	94178	01-06-03	0009		2-17-81
					1	4	UT-45°	94188	94187	01-06-03	0009		
6"	IRT-1001-24	0	B-J	V-P	2	5	PT	15029				L W Wheatley 2/17/81	w g c
					1	4	UT-0°	94179	94178	01-06-03	0009		2-17-81
					1	4	UT-45°	94188	94187	01-06-03	0009		
6"	IRT-1001-25	0	B-J	P-E	2	5	PT	15029				L W Wheatley 2/17/81	w g c
					1	4	UT-0°	94180	94178	01-06-03	0009		2-17-81
					1	4	UT-45°	94188	94187	01-06-03	0009		
6"	IRT-1001-26	0	B-J	E-P	2	5	PT	94171				L W Wheatley 2/17/81	w g c
					1	4	UT-0°	94180	94178	01-06-03	0009		2-17-81
					1	4	UT-45°	94188	94187	01-06-03	0009		

NONCONFORMITY REPORT

REVISION NO. 0

Project La Salle I PSI Report No. INCR-94

Initiated By L. W. Wheatley Date 2/20/80

Project No. LCS-P0173-1 Drawing No. ILP-1011

Item, Assembly Joint No. Weld ILP-1011-6

Heat & Lot, Serial No. (if applicable) NA

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. Exam Form 94487

Description of Nonconformity

During grinding out of indications found during penetrant examinations minimum wall has been violated. See enclosed drawing for details

Proposed Resolution

RESOLUTION PER CECO ENGINEERING

Signature [illegible] Date 2/28/80

Comments

Resolution Approved By [illegible] Date 2/28/80

Reviewed with AI By [illegible] Date 3-11-81

Completed [illegible] Date 3/11/81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EXAMINATION DATA FORM

EXAM FORM # 94487

CAL. FORM # 94486

DATE 2-27-80

EXAMINER [illegible] LEVEL II DATA TAKER Robert Austin LEVEL II

	TOP	LEFT SIDE	BOT.	RIGHT SIDE	WELD
MATERIAL THICKNESS	.362	.363	.390	.370	.482
PIT GAUGE READINGS					
REMAINING WALL THK.	.309				

WELD NO. ILP1011-#6 NOMINAL PIPE THICKNESS 0.375

NCR NO. INCR-94 MINIMUM WALL 0.328

MATERIAL THICKNESS				
PIT GAUGE READINGS				
REMAINING WALL THK.				

WELD NO. _____ NOMINAL PIPE THICKNESS _____

NCR NO. _____ MINIMUM WALL _____

MATERIAL THICKNESS				
PIT GAUGE READINGS				
REMAINING WALL THK.				

WELD NO. _____ NOMINAL PIPE THICKNESS _____

NCR NO. _____ MINIMUM WALL _____

MATERIAL THICKNESS				
PIT GAUGE READINGS				
REMAINING WALL THK.				

WELD NO. _____ NOMINAL PIPE THICKNESS _____

NCR. NO. _____ MINIMUM WALL _____

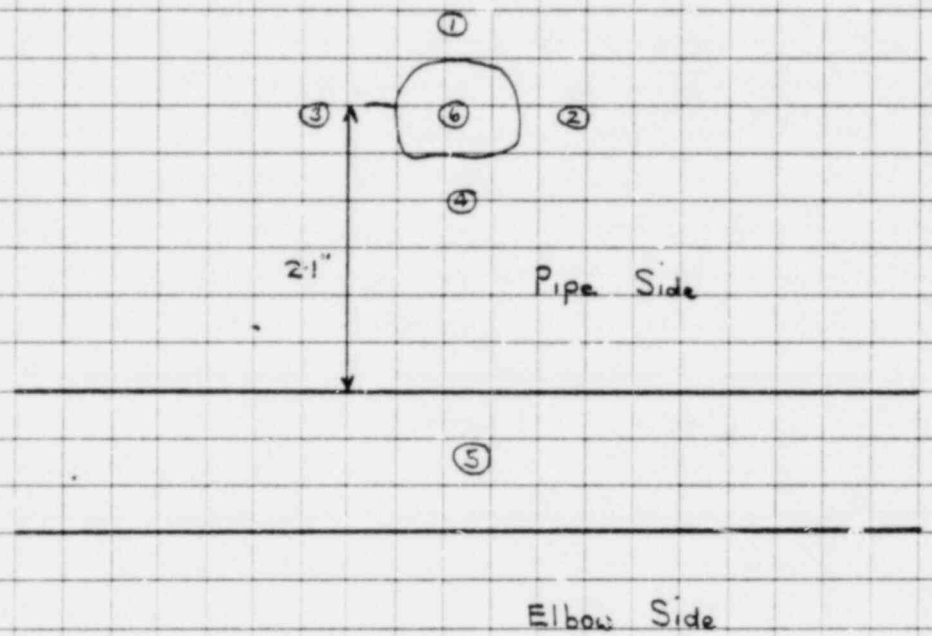
Form 184 (5-76)

Dev./Station La Salle County Nuclear Station Unit I File No.

Subject INCR-94 on Weld 1LP-1011-6

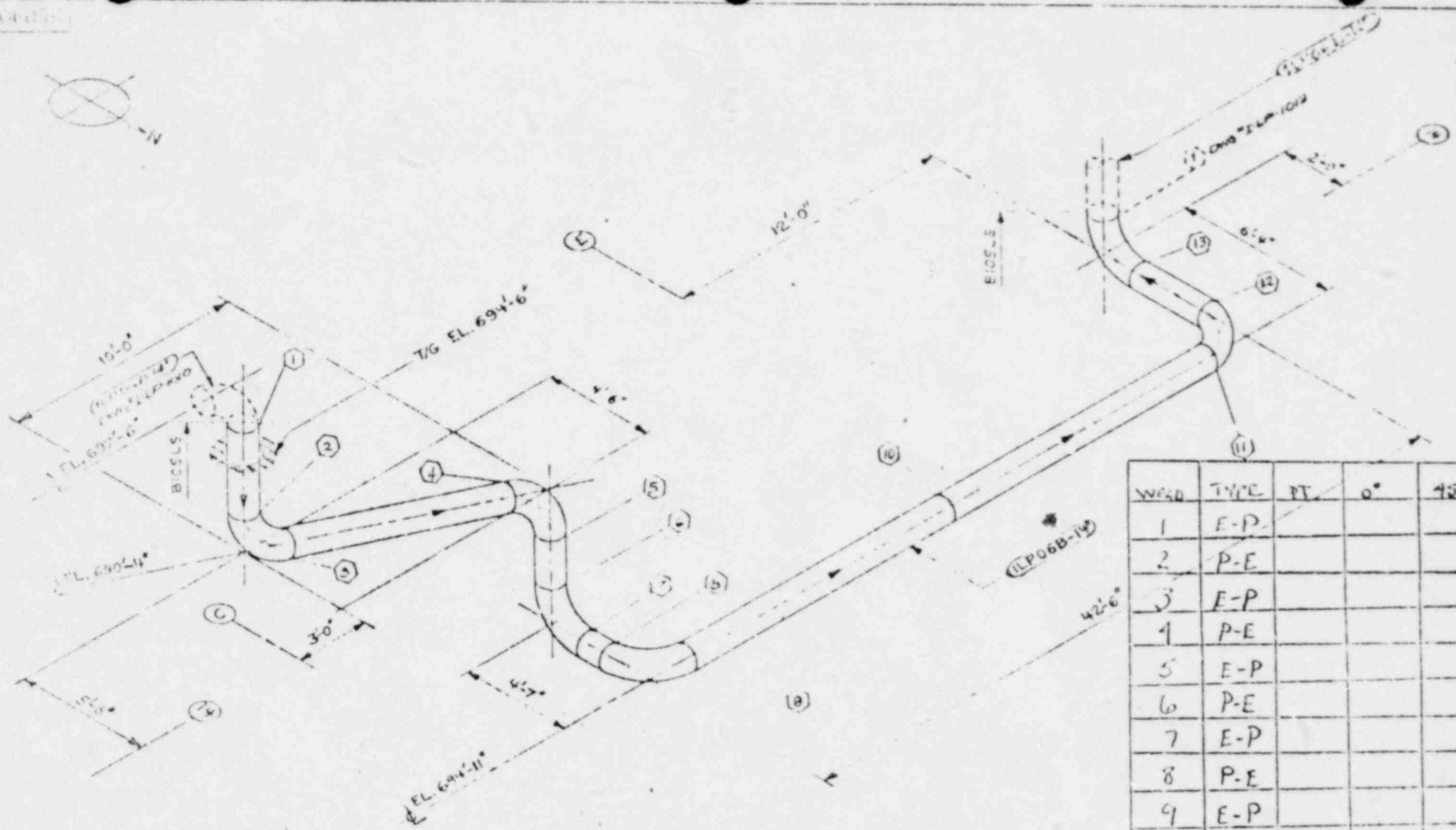
By Date

Sheet No. of Problem No. Checked By Date



Reading	Thickness
1	·362"
2	·370"
3	·363"
4	·390"
5	·482"
6	·309"

The excavation is approximately 0·9" diameter. Nominal pipe thickness is 0·375" and minimum wall is 0·328".



WELD	TYPE	PT.	0°	45°
1	E-P			
2	P-E			
3	E-P			
4	P-E			
5	E-P			
6	P-E			
7	E-P			
8	P-E			
9	E-P			
10	P-P			
11	P-E			
12	E-P			
13	P-E			

R. S. Rather 10/16/79
Quality Assurance Approval Date

S.E. P.S.I. Rev. 0 Changes
ASME Cat. C-F
Procedures: UT #1 Rev. 4, PT #2 Rev. 5
UT Cal. Std.: all welds 0J-14-01

REVISIONS

MORRISON CONSTRUCTION CO.

11LP-1011

INCR 94

FORM QP 15-1.1
12-15-78 (Rev. 2)

CONSTRUCTION AND TEST

NCR NO. 409

PAGE 1 OF 4

PART 1

LP DIESEL

LP UNIT

LP DIESEL

MORRISON CONST CO

CONTRACTOR
TEST

TIGHTNESS TEST WAS APPROXIMATELY 1/8" DIAMETER BELOW FUEL FILL FITTING ON LINE LF-DIB-2. RETEST OF FUEL FILL WELD LF-DIB-2 AND AREA IS OK. SEE REPORT.

CONTROL REMARKS

INSPECTOR

NCR REQUEST NO.

N/A

4892

DATE

STAT CONT 3/15/80

STAT REJ. 3/15/80

3-17-80

PART 2

10CFR 50.55e Report Required YES NO

PART 3

ACCEPTABLE AS IS.

NONE REQUIRED

PEO

SARGENT & LUNDY
ENGINEERS
FOUNDED BY [illegible] CARGENT 1891
55 EAST [illegible] WACKER STREET
CHICAGO, ILLINOIS 60603
TELEPHONE [illegible] 312 269 2000
CABLE ADDRESS [illegible] SATLUN CHICAGO

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 394, 402, 408, 409,
[illegible], 432, 433 & 420

Mr. [illegible] Watts
General Division Engineer
Commonwealth Edison Company
P. O. Box 767 - 36[illegible] W
Chicago, Illinois [illegible]

Dear Mr. Watts:

The above NCR's all deal with potential minimum wall violations due to flange [illegible] counterboring or PT indicator removal. A minimum wall calculation has been performed for each [illegible] under design conditions for the areas involved. In all cases the remaining wall thickness exceeds the required minimum wall thickness. Therefore, no repair is necessary and all the above NCR's should be accepted as is for the final disposition.

If you have any questions, please contact me.

Yours very truly,

G. I. Zuarich
Mechanical Engineer

GIZ:cb
In duplicate
Copies:
L. J. Bonk
R. H. Holtzek
W. E. Quinlan
D. [illegible] Mass
W. G. Schwartz
E. [illegible] Travel
G. C. Jones
[illegible] Kretz
C. A. Richel

NONCONFORMITY REPORT

REVISION NO. C

Project LaSalle I PSI Report No. INCR-95

Initiated By L. W. Wheatley Date 3/7/80

Project No. LCS-P0173-1 Drawing No. IRH-1047

Item, Assembly Joint No. Weld IRH-1047-17

Heat & Lot, Serial No. (if applicable) NA

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. UT Reports LW-05, 06

Description of Nonconformity

Minimum wall violation caused by flapping of liquid penetrant indications.
See enclosed drawing & data for further details

Proposed Resolution

RESOLUTION PER CECO ENGINEERING

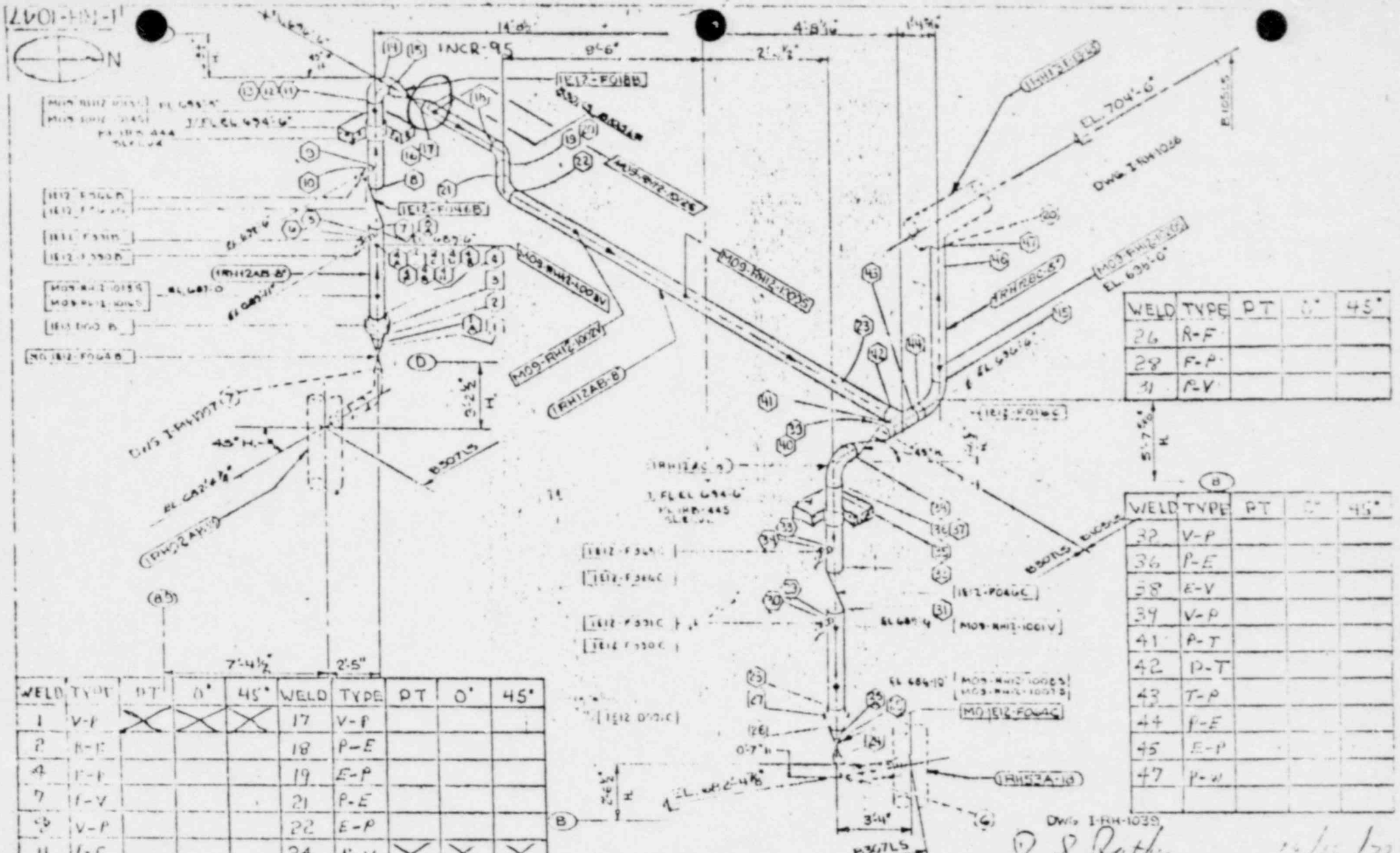
Signature [illegible] Date 3/7/80

Comments

Resolution Approved By L W Wheatley Date 3/7/80

Reviewed with AI By [illegible] Date 3-11-81

Completed L W Wheatley Date 3/11/81



WELD	TYPE	PT	0°	45°
26	R-F			
28	F-P			
31	P-V			

WELD	TYPE	PT	0°	45°
32	V-P			
36	P-E			
38	E-V			
39	V-P			
41	P-T			
42	P-T			
43	T-P			
44	P-E			
45	E-P			
47	P-V			

WELD	TYPE	PT	0°	45°	WELD	TYPE	PT	0°	45°
1	V-P	X	X	X	17	V-P			
2	P-E				18	P-E			
4	E-P				19	E-P			
7	P-V				21	P-E			
9	V-P				22	E-P			
11	P-E				24	E-V	X	X	X
15	E-V				25	V-K	X	X	X

G.E. P.S.I. Rev, 0 Changes
ASME Cat.: C-F
Procedures: UT #1 Rev. 4, PT #2 Rev.5
Cal. Std.: welds 01-08-02

R. S. Rathin 2/1/79
Quality Assurance Approval

REVISIONS			
REV. NO.	DESCRIPTION	BY	DATE
0	PRELIM		6-19-78

MORRISON CONSTRUCTION CO.
MARYLAND INDIANA
COMMONWEALTH EDISON CO. LASALLE COUNTY STATION UNITS 1 & 2
INSERVICE INSPECTION
RESIDUAL HEAT REMOVAL SYSTEM
1-RH-1047

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LASALLE COUNTY NUCLEAR STATION

U.T. CALIBRATION FORM

FORM#: LW-05
DATE: 3/7/80

EXAMINER L.W. Wheatley LEVEL III DATA TAKER _____ LEVEL _____

INSTRUMENT MODEL KK USL-32 SERIAL NO. 26680-521

TRANSDUCER SIZE 0.25"x0.25" DUAL FREQ. 5.0 MH_z SERIAL NO. I21611

CALIBRATION STD. 01-08-02 - Step Wedge MATERIAL Carbon Steel

COUPLANT Glycerine INITIAL CALIBRATION TIME 14:00

(CALIBRATION DATA)

STANDARD THICKNESS	INSTRUMENT READING
0.1	0.1
0.3	0.3
0.5	0.5
0.32	0.32 on block 01-08-02

Cal. Verification Times: 15:00

Final Cal. Check: 15:00

	INSTRUMENT SETTINGS: START	FINISH
Gain	64dB	64dB
Sweep	756	756
Delay	170	170
Filter	NA	NA
Rep. Rate	AUTO	AUTO
Dampening	OFF	OFF
Reject	OFF	OFF
Digital Range	0.5"	0.5"
Calibrate	NA	NA
Velocity	NA	NA

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EXAMINATION DATA FORM

EXAM FORM # LW-06

CAL. FORM # LW-05

DATE 3/7/80

EXAMINER L W Wheatley LEVEL III DATA TAKER _____ LEVEL _____

MATERIAL THICKNESS	0.36	0.31	0.33	
PIT GAUGE READINGS	NA	NA	NA	NA
REMAINING WALL THK.				0.235

WELD NO. 1RH-1047-17 NOMINAL PIPE THICKNESS 0.322

NCR NO. INCR-95 MINIMUM WALL 0.282

MATERIAL THICKNESS				
PIT GAUGE READINGS				
REMAINING WALL THK.				

WELD NO. _____ NOMINAL PIPE THICKNESS _____

NCR NO. _____ MINIMUM WALL _____

MATERIAL THICKNESS				
PIT GAUGE READINGS				
REMAINING WALL THK.				

WELD NO. _____ NOMINAL PIPE THICKNESS _____

NCR NO. _____ MINIMUM WALL _____

MATERIAL THICKNESS				
PIT GAUGE READINGS				
REMAINING WALL THK.				

WELD NO. _____ NOMINAL PIPE THICKNESS _____

NCR. NO. _____ MINIMUM WALL _____

Form 184 (5-76)

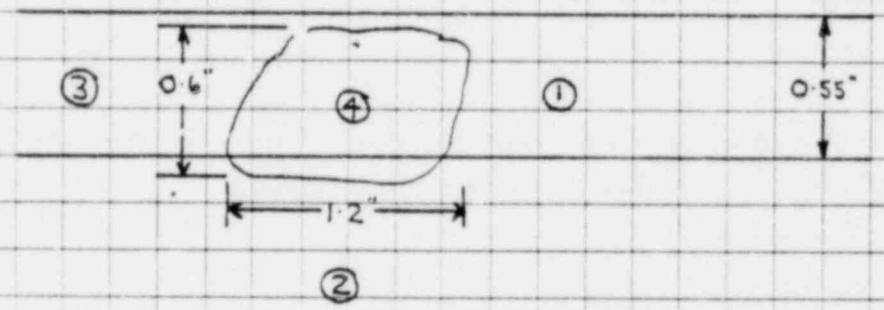
Dev./Station La Salle County Nuclear Station Unit I File No.

Subject INCR-95 on Weld 1RH-1047-17

By Date

Sheet No. of Problem No. Checked By Date

VALVE SIDE



PIPE SIDE

Area	Thickness
1	0.36
2	0.31
3	0.33
4	0.235

Minimum Wall = 0.282"

Nominal Pipe Thickness = 0.322"

"ORIGINAL" INCR 95

FORM QP 15-1.1
12-15-78 (Rev.2)

NONCONFORMANCE REPORT FOR CONSTRUCTION AND TEST

NCR NO. 408

Commonwealth Edison

PAGE 1 OF 4

PART 1

ITEM: FWR PIPING	ITEM NO. (PIPE, SPEC, EQUIP NO.): 1CH12AB-8"
UNIT: ZION UNIT #1	MANUFACTURER: MORRISON CONST Co

CATEGORY: ☐ CLASS ☐ FAILURE ☐ DAMAGE ☐ DOCUMENTATION ☐ OTHER

CAUSE: ☐ DESIGN ☐ CONTRACTOR ☐ TEST

DESCRIPTION OF NONCONFORMANCE: THERE IS A AREA APPROXIMATELY 1.2" x 0.6" BELOW MIN. WALL THICKNESS ON NCFO FIELD WELD # FH551 ON LINE # 1CH12AB-8". WALL THICKNESS IN SPOTTED AREA IS 0.235". SEE ATTACHED UT REPORT

1811C	489'	

INSPECTOR	[illegible]	QC INSP	3-13-8[illegible]
QC SUPERVISOR	[illegible]	QCD	3/14/80
QA SUPERVISOR	[illegible] 3/14/80		3/14/80
QA MGR	[illegible]	QA Cont	3/14/8[illegible]

PART 2

DISPOSITION: GROUND AREA CREATED FROM A [illegible] LOCATION DURING CASE 1E INSPECTION

10CFR50.55e Report Required: Yes ☐ No ☒

REWORK OR REPAIR: NONE

ISOLATED: [illegible] NONE REQD

[illegible] 4/23/81 [illegible]

PART 3

ACCEPTABLE AS IS.

NONE REQUIRED

[illegible] [illegible]

PART 4

SARGENT & LUNDY
ENGINEERS
FOUNDED BY WILLIAM SARGENT-1891
55 EAST MONROE STREET
CHICAGO, ILLINOIS 60603
TELEPHONE 312-269-2000
CABLE ADDRESS SARLUN-CHICAGO

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 384, 402, 408, 409,
429, 432, 453 & 480

Mr. F. E. Watts
Chief Design Engineer
Commonwealth Edison Company
P. O. Box 767 - 35FNW
Chicago, Illinois 60690

Dear Mr. Watts:

The above NCR's all deal with potential minimum wall violations due to either excessive counterboring or PT material removal. A minimum wall calculation has been performed for each case based upon design conditions for the area involved. In all cases the remaining wall thickness exceeds the required minimum wall thickness. Therefore, no repair is necessary and all the above NCR's should be accepted as is for the final disposition.

If you have any questions, please contact me.

Yours very truly,

G. I. Zwarich
Mechanical Engineer

GIZ:eb
In Duplicate
Copies:
C. J. Burke
R. H. McCreak
T. E. Quirka
D. C. Mann
W. G. Schw
E. R. Wom
G. C. Jones
E. R. Kurka
C. A. Riebel

INSTALLATION & SERVICE ENGINEERING DIVISION

NONCONFORMITY REPORT

REVISION NO. 0

Project La Salle I PSI Report No. INCR-98

Initiated By L W Wheatley Date 5/28/80

Project No. LCS-P0173-1 Drawing No. IRH-1001-1

Item, Assembly Joint No. Weld IRH-1001-1

Heat & Lot, Serial No. (if applicable) NA

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. UT Report LW-09 (84605)

Description of Nonconformity

In removing linear & clustered porosity indications during penetrant examinations, minimum wall has been violated. See enclosed UT Report for details.

Proposed Resolution

RESOLUTION PER CECO ENGINEERING

Signature [illegible] Date 5/28/80

Comments

Resolution Approved By L W Wheatley Date 5/28/80

Reviewed with ANI By [illegible] Date 3-11-81

Completed L W Wheatley Date 3/11/81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LASALLE COUNTY NUCLEAR STATION

U.T. CALIBRATION FORM

FORM # LW-08 (84604)

DATE 5/28/80

EXAMINER L W Whatley LEVEL III DATA TAKER _____ LEVEL _____

INSTRUMENT MODEL CL-202 SERIAL NO. 801203

TRANSDUCER SIZE 0.25" DIA FREQ. 5.0 MHz SERIAL NO. 025810

CALIBRATION STD. CSC-1 a Step Wedge MATERIAL Carbon Steel

COUPLANT Glycerine INITIAL CALIBRATION TIME 13:40

(CALIBRATION DATA)

STANDARD THICKNESS	INSTRUMENT READING
.755	.756
1.253	1.257
.300	.299
.400	.399
.500	.500

CAL. VERIFICATION TIMES: NA

Final Cal. Check: 16:00

	INSTRUMENT START	SETTINGS: FINISH
Gain	NA	NA
Sweep	↓	↓
Delay	↓	↓
Filter	↓	↓
Rep. Rate	↓	↓
Dampening	↓	↓
Reject	↓	↓
Digital Range	↓	↓
Calibrate	↓	↓
Velocity	2348	2349

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EXAMINATION DATA FORM

EXAM FORM # LW-08 (34605)

CAL. FORM # LW-08 (34604)

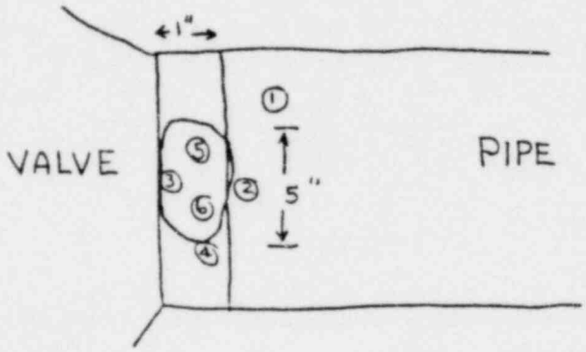
DATE 5/28/80

EXAMINER L W Wheatley LEVEL III DATA TAKER _____ LEVEL _____

MATERIAL THICKNESS	① 0.490	② 0.379	③ 0.330	④ 0.403
PIT GAUGE READINGS				
REMAINING WALL THK.	⑤ 0.330	⑥ 0.331		

WELD NO. IRH-1001 NOMINAL PIPE THICKNESS 0.406

NCR. NO. INCR-98 MINIMUM WALL 0.355

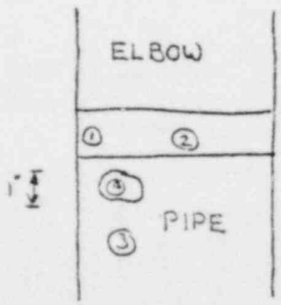


Area is 18" From top dead center

MATERIAL THICKNESS	① 0.404	② 0.396	③ 0.385	
PIT GAUGE READINGS				
REMAINING WALL THK.				④ 0.359

WELD NO. IHP-1005-68 NOMINAL PIPE THICKNESS 0.375

NCR. NO. NA MINIMUM WALL 0.328



INCR-98

FORM NO. 15-1.1 (Rev.2)

429

1 OF 4

NONCONFORMANCE REPORT FOR CONSTRUCTION AND TEST

ITEM NO. (PART NO., EQUIP NO.) 1RH03BB-12

MANUFACTURER/SUPPLIER B.F. SHAW

PIPING

RESIDUAL HEAT REMOVAL UNIT

CATEGORY: ☐ CRITICAL ☐ FAILURE

☐ DAMAGE ☐ DWG NONCONFORMANCE ☐ MFG NONCONFORMANCE

☐ CONTRACTOR ☐ TEST

P.O. NO. & P.O. ITEM NO. 172801

NA

NA

DESCRIPTION OF NONCONFORMANCE

THERE IS AN AREA APROX 1"x5" ON THE PIPE BETWEEN VALVE 1RH-F053B AND 1DRH03BB-12 WITH A WALL THICKNESS OF 0.320. THIS IS BELOW

SIGNATURE / NAME / DATE

NONCONF OBSERVED BY 5-29-80

NONCONF VERIFIED BY 5/29/80

5/30/80

10CFR50.55e Report Required YES ☐ NO ☒

WHEN WELDING ON THE CURVED SURFACE OF THE PIPE

DATE NOT KNOWN

ACCEPTABLE AS IS.

NONE REQUIRED

SARGENT & LUNDY
ENGINEERS
FOUNDED BY FREDERICK SARGENT-1891
55 EAST MONROE STREET
CHICAGO, ILLINOIS 60603
TELEPHONE 312-269-2000
CABLE ADDRESS - SARLUN-CHICAGO

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 394, 402, 408, 409,
429, 432, 453 & 480

Mr. T. [illegible]
General [illegible] Engineer
Commonwealth Edison Company
P. O. Box [illegible] - 35[illegible]W
Chicago, Illinois 60690

Dear Mr. [illegible]:

The above [illegible] deal with potential minimum wall thickness due to either excessive counterboring or PT [illegible]. A minimum wall calculation has been [illegible] for each case based upon design conditions for [illegible] the remaining wall thickness [illegible] required minimum wall thickness. Therefore, no [illegible] and all the above NCR's should be accepted [illegible] for the final disposition.

If you have any questions, please contact me.

Yours very truly,

G. I. Zwarich
Mechanical Engineer

GIZ:cb
In Duplicate
Copies:
L. J. Burke
R. H. Holzcat
T. E. Cosha
D. C. Hean
W. G. Schwartz
A. R. Beaver
G. C. Jones
A. R. Lurtz
C. A. Riebel

INSTALLATION & SERVICE ENGINEERING DIVISION

NONCONFORMITY REPORT

REVISION NO. 0

Project La Salle PSI Report No. INCR-99

Initiated By L W Wheatley Date 5/29/80

Project No. LCS-P0173-1 Drawing No. IRH-1045

Item, Assembly Joint No. Weld IRH-1045-5

Heat & Lot, Serial No. (if applicable)

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. UT Report LW-11

Description of Nonconformity

Minimum wall violation on weld IRH-1045-5 caused during grind-out of penetrant indications. See UT Report LW-11 for details

Proposed Resolution

RESOLUTION PER CECO ENGINEERING

Signature [signature] Date 5/30/80

Comments

Resolution Approved By [signature] Date 5/30/80

Reviewed with ANI By [signature] Date 3-11-81

Completed [signature] Date 3/11/81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LASALLE COUNTY NUCLEAR STATION

U.T. CALIBRATION FORM

FORM # LW-10

DATE 5/29/80

EXAMINER L W Whatley LEVEL III DATA TAKER _____ LEVEL _____

INSTRUMENT MODEL Nortec 131D SERIAL NO. 339

TRANSDUCER SIZE 0.25" DIA FREQ. 5.0 MHz SERIAL NO. 025810

CALIBRATION STD. CSC-1 & Step Wedge MATERIAL Carbon Steel

COUPLANT Glycerine INITIAL CALIBRATION TIME 1420

(CALIBRATION DATA)

STANDARD THICKNESS	INSTRUMENT READING
0.755	.758
1.255	1.258
.300	.302
.400	.404
.500	.504

CAL. VERIFICATION TIMES: NA

Final Cal. Check: 1600

	INSTRUMENT START	SETTINGS: FINISH
Gain	70dB	70dB
Sweep	880	880
Delay	468	468
Filter	OFF	OFF
Rep. Rate	3k	3k
Dampening	OFF	OFF
Reject	OFF	OFF
Digital Range	2"	2"
Calibrate	236	236
~~Velocity~~ Zero	596	596

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

EXAMINATION DATA FORM

EXAM FORM # LW-11

CAL. FORM # LW-10

DATE 5/29/80

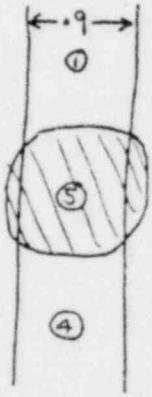
EXAMINER L D Whatley LEVEL III DATA TAKER _____ LEVEL _____

	①	②	③	④
MATERIAL THICKNESS	·347	·339	·313	·330
PIT GAUGE READINGS				
REMAINING WALL THK.	⑤ ·256			

WELD NO. IRH-1045-5 NOMINAL PIPE THICKNESS 0·322

NCR. NO. INCR-99 MINIMUM WALL ·0·282

ELBOW



PIPE

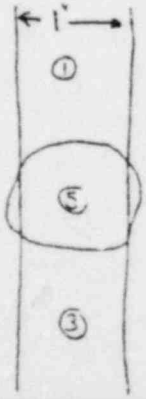
Ground out area is approximately 1·0" diameter and located 180° from Top Dead Center.

	①	②	③	④
MATERIAL THICKNESS	1·029	1·091	1·048	·985
PIT GAUGE READINGS				
REMAINING WALL THK.	⑤ ·875			

WELD NO. IRH-1001-13 NOMINAL PIPE THICKNESS 1·00

NCR. NO. NA MINIMUM WALL 0·875

ELBOW



PIPE

Ground out area is approximately 1·0" diameter and located 180° from Top Dead Center.

"ORIGINAL" INCR-99

FORM QP 15-1.1 (Rev.2)
12-15-78

NONCONFORMANCE REPORT FOR CONSTRUCTION AND TEST

ITEM NO. 432

SHEET 1 OF 7

PART 1

Commonwealth Edison

DESCRIPTION OF ITEM (EQUIPMENT, MATERIAL, COMPONENT, PART): RHR PIPING

ITEM NO. (PART NO., SER NO., EQUIP NO.): 1RH 23AB-8"

MANUFACTURER/SUPPLIER: MORRISON CONST CO.

5. SYSTEM AND UNIT: RESIDUAL HEAT REMOVAL UNIT #1

8. CATEGORY: [ ] DEFECT [ ] FAILURE [ ] DAMAGE [ ] DWG NONCONFORMANCE [X] SPEC NONCONFORMANCE [ ] POOR CONDITION [ ] POOR INSTALLATION

9. RESPONSIBLE TASKING: [ ] SUPPLIER INSPECTION [ ] CONSTRUCTION [ ] CONTRACTOR [ ] TEST

11. P.O. NO. / P.O. ITEM NO.: 181110

12. HOLD TAG NO.: —

13. WORK REQUEST NO.: N/A

10. DESCRIPTION OF NONCONFORMANCE

THERE IS AN AREA APPROX 1" DIA ON
ELBOW WELD WRH 50AB ON LINE
1RH23AB-8" WITH A WALL THICKNESS
OF 0.256". SEE ATTACHED UT REPORT

14. SIGNATURES

	NAME	DEPARTMENT	DATE
NONCONF. OBSERVED BY	[illegible]	SCD	6-2-80
NONCONF. VERIFIED BY	[illegible]	Hu Const.	6/2/80
QA SUPV OR COORDINAT	[illegible]	QA	6/2/80
SITE OR SITE PROJECT ENGINEER	[illegible]	[illegible]	6/2/80

PART 2

10CFR50.55e Reports Required Yes [ ] No [X]

15. CAUSE OF NONCONFORMANCE

WELD ALL PRE CREATED WHEN REMOVING
A PT INDICATION ON THE SURFACE OF THE WELD DURING ISI
BASELINE

16. CORRECTIVE ACTION RECOMMENDED

ACCEPT DUE AS IS

17. ANALYSIS OF CAUSE

ISOLATED OCCURRENCE NONE REQUIRED

18. ENGINEERING DISPOSITION

[illegible] 6-2-80 ENGINEERING, PRINCIPAL ENGINEER DATE

[illegible] 6-2-80 ENGINEERING DEPARTMENT HEAD DATE

PART 3

19. DESCRIPTION OF ACTION TAKEN TO CORRECT THE NONCONFORMANCE

ACCEPTABLE AS IS.

20. CORRECTIVE ACTION VERIFICATION INSPECTION REQUIRED

NONE REQUIRED.

[illegible] 6/2/80 SIGNATURE DATE

[illegible] QC DEPARTMENT

[illegible] 3-11 DATE

[illegible] QC DEPARTMENT HEAD DATE

PART 4

21. CORRECTIVE AUTHORIZATION

SARGENT & LUNDY
ENGINEERS
FOUNDED BY FREDERICK SARGENT-1891
55 EAST MONROE STREET
CHICAGO, ILLINOIS 60603
TELEPHONE - 312-269-2000
CABLE ADDRESS - SARLUN-CHICAGO

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 394, 402, 403, 409,
429, 432, 453 & 480

Mr. T. E. Watts
General Design Engineer
Commonwealth Edison Company
P. O. Box 767 - 35NW
Chicago, Illinois 60690

Dear Mr. Watts:

The above NCR's all deal with potential minimum wall thickness due to either once-thru counterboring or PT indication removal. A minimum wall calculation has been performed for each case based upon design conditions for the areas involved. In all cases the remaining wall thickness exceeds the required minimum wall thickness. Therefore, no repair is necessary and all the above NCR's should be accepted as is for the final disposition.

If you have any questions, please contact me.

Yours very truly,

G. I. Zwarich
Mechanical Engineer

GIZ:cb
In duplicate
Copies:
L. J. Burke — W. G. Schwartz — C. A. Riebel
R. H. Holzpak — E. R. Weaver
T. E. Quaka — G. C. Jones
D. C. Haan — E. R. Fortz

INSTALLATION & SERVICE ENGINEERING DIVISION

NONCONFORMITY REPORT

REVISION NO. 0

Project La Salle I PSI Report No. INCR-103

Initiated By L. W. Wheatley Date 8/14/80

Project No. LCS-P0173-1 Drawing No. IRI-1004

Item, Assembly Joint No. Weld IRI-1004-37

Heat & Lot, Serial No. (if applicable) NA

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. EDS 77465

Description of Nonconformity

During removal of penetrant indications, minimum wall has been violated. Remaining wall thickness is 0.258 in the excavation area whereas minimum wall is 0.273.

Proposed Resolution

RESOLUTION PER CECO ENGINEERING

Signature [illegible] Date 8/14/80

Comments

Resolution Approved By L W Wheatley Date 8/14/80

Reviewed with ANI By W J Caldwell Date 3-11-81

Completed L W Wheatley Date 3/11/81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LASALLE COUNTY NUCLEAR STATION

U.T. CALIBRATION FORM

FORM # 77464

DATE 8-6-80

EXAMINER C.A. Hamler LEVEL II DATA TAKER Al Green LEVEL II

INSTRUMENT MODEL CL 202 SERIAL NO. 801203

TRANSDUCER SIZE .25 FREQ. N/A MH_Z SERIAL NO. A-28031

CALIBRATION STD. CSC-1 MATERIAL C.S.

COUPLANT GLYCERINE INITIAL CALIBRATION TIME 0819

(CALIBRATION DATA)

STANDARD THICKNESS	INSTRUMENT READING
1.486	1.486
1.253	1.254
.755	.756

	INSTRUMENT START	SETTINGS: FINISH
Gain		
Sweep		
Delay		
Filter	N/A	
Rep. Rate		
Dampening		
Reject		
Digital Range		
Calibrate		
Velocity	2324	2324

CAL. VERIFICATION TIMES: 1109, 1233

Final Cal. Check: 1515

NDE Sup. S.D. Hamelly 8/7/80

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

NDE Sup. S Donnelly 8/7/80

EXAMINATION DATA FORM

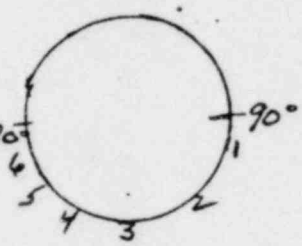
EXAM FORM # 77465

CAL. FORM # 77464

DATE 8-6-80

EXAMINER CA Homler LEVEL II DATA TAKER al Green LEVEL II

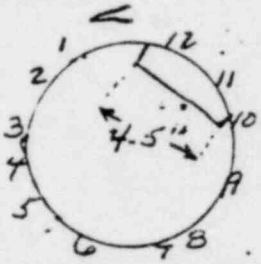
	1	2	3	4	5	6
MATERIAL THICKNESS (ELBOW)	.317	.263	[illegible]	.257	.256	.311
~~PIT GAUGE READINGS~~ (WELD)	.333	.295	.265	.294	.297	.334
~~REMAINING WALL THK.~~ (ELBOW)	.349	.257	.313	.311	.258	.271



WELD NO. 1R1-1004-37 NOMINAL PIPE THICKNESS

NCR NO. INCR-103 MINIMUM WALL .273

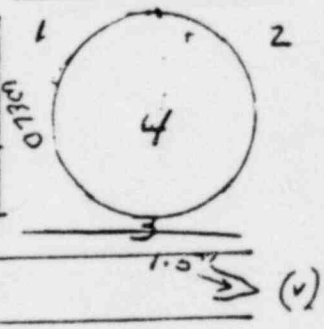
ELBOW MATERIAL THICKNESS	.499	.492	.522	.545
PIT GAUGE READINGS	.674	.673	.670	.654
REMAINING WALL THK.	.494	.463	.481	.468



WELD NO. 1R1 1005-1 NOMINAL PIPE THICKNESS

NCR NO. AREA BELOW MW EXTENDS 4.5" CCW; AND 1/2" FROM EDGE OF WELD MINIMUM WALL .490

	1	2	3	4
MATERIAL THICKNESS	.434	.472	.379	.308
PIT GAUGE READINGS				
REMAINING WALL THK.	EXCAVATION 1.5" by 1"			

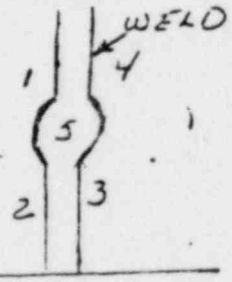


WELD NO. 1R1-1019-11 NOMINAL PIPE THICKNESS

NCR NO. INCR-105 MINIMUM WALL .310

12" FROM V

	1	2	3	4
MATERIAL THICKNESS	.307	.306	.426	.397
PIT GAUGE READINGS	5 .285			
REMAINING WALL THK.				



WELD NO. 1R1-1004-57 NOMINAL PIPE THICKNESS

NCR. NO. MINIMUM WALL

INCR103, INCR104, INCR105

FORM QP 15-7.1
12-1-78 (Rev. 2)

NONCONFORMANCE REPORT FOR CONSTRUCTION AND TEST

NCR No. 453

1 of 10

1. CORRECTIVE ACTION

3. DESCRIPTION OF ITEM (EQUIPMENT, MATERIAL, COMPONENT, PART)
PIPE WELD

4. ITEM NO. (PART NO., SER NO., EQUIP NO.)
N/A

5. MANUFACTURER
MCCO / SHAW

6. SYSTEM AND UNIT
FT UNIT #1

7. CATEGORY
DEFECT
FAILURE
DAMAGE
DIM. NONCONFORMANCE
MAT. NONCONFORMANCE

8. PHYSICAL CONDITION
DOCUMENTATION

9. OBSERVED DURING
SUPPLIER INSPECTION
CONSTRUCTION
CONTRACTOR
TEST

10. DESCRIPTION OF NONCONFORMANCE
THERE IS AN AREA OF MIN. WALL ... LINES/ROUTE-18 BETWEEN WELD # RI ... RI ... 4" ... WELD # RI 218 & RIII ... CCO ... WELD # RI 20... SEE ... SIZE OF MIN WALL AREA

11. P.O. NO. & P.O. ITEM NO.
181110 / 172801

12. HOLD TAG NO.
6333 - 6335

13. WORK REQUEST NO.
N/A

14. SIGNATURES

	NAME	DEPARTMENT	DATE
NONCONF. OBSERVED BY	[signature]	STA CONST	8/25/80
NONCONF. VERIFIED BY	[signature]	STA CONST.	8/25/80
QA SUPV OR COORDINATOR	[signature]	QA	8/26/80
REPRESENTATIVE OF ENGINEERING	[signature]	STA CONT	8/25/80

15. CAUSE OF NONCONFORMANCE
MIN WALL AREA CREATED DURING FT INDICATION DURING ISI BASELINE INSPECTION

10CFR50.55e Reports Required Yes [ ] No [X]

16. DISPOSITION OF NONCONFORMANCE
ACCEPTABLE AS IS

17. ... OF NONCONFORMANCE
NONE

18. IF NOT KNOWN
OCCURANCE

19. DESCRIPTION OF ACTION TAKEN TO CORRECT THE NONCONFORMANCE
ACCEPTABLE AS IS.

20. DESCRIPTION OF ACTION TAKEN TO PREVENT THE NONCONFORMANCE
NONE REQUIRED

21. PROJECT ENGINEER
2/23/81 APPROVED BY [signature] 2-23-81
DATE ENGINEERING DEPARTMENT

22. CORRECTIVE ACTION COMPLETED BY
[signature] PCD 3-11-81
NAME DEPARTMENT DATE

23. CORRECTIVE ACTION REVIEW

SARGENT & LUNDY
ENGINEERS
FOUNDED BY FREDERICK SARGENT-1891
55 EAST MONROE STREET
CHICAGO, ILLINOIS 60603
TELEPHONE - 312-269-2000
CABLE ADDRESS - SARLUN-CHICAGO

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 394, 402, 408, 409,
429, 432, 453 & 480

Mr. T. E. Watts
General Design Engineer
Commonwealth Edison Company
P. O. Box 767 - 35FNW
Chicago, Illinois 60690

Dear Mr. Watts:

The above NCR's all deal with potential minimum wall violation due to either excessive counterboring or PT indication removal. A minimum wall calculation has been performed for each case based upon design conditions for the areas involved. In all cases the remaining wall thickness exceeds the required minimum wall thickness. Therefore, no repair is necessary and all the above NCR's should be accepted as is for the final disposition.

If you have any questions, please contact me.

Yours very truly,

G. I. Zwarich
Mechanical Engineer

GIZ:cb
In duplicate
Copies:
L. J. Burke
R. H. Holyoak
T. E. Quaka
D. C. Haan
W. G. Schwartz
E. R. Weaver
G. C. Jones
E. R. Kurtz
C. A. Riebel

INSTALLATION & SERVICE ENGINEERING DIVISION

NONCONFORMITY REPORT

REVISION NO. 0

Project La Salle I PSI Report No. INCR-104

Initiated By L. W. Wheatley Date 8/14/80

Project No. LCS-P0173-1 Drawing No. IRI-1005

Item, Assembly Joint No. Weld IRI-1005-1

Heat & Lot, Serial No. (if applicable) NA

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. EDS 77465

Description of Nonconformity

During removal of penetrant indications, minimum wall has been violated. Remaining wall thickness in the excavation is 0.463" whereas minimum wall is 0.490".

Proposed Resolution

RESOLUTION PER CECO ENGINEERING

Signature [illegible] Date 8/14/80

Comments

Resolution Approved By L W Wheatley Date 8/14/80

Reviewed with ANI By W J Caldwell Date 3-11-81

Completed L W Wheatley Date 3/11/81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LASALLE COUNTY NUCLEAR STATION

U.T. CALIBRATION FORM

FORM # 77464

DATE 8-6-80

EXAMINER C A Homler LEVEL II DATA TAKER Al Green LEVEL II

INSTRUMENT MODEL CL 202 SERIAL NO. 801203

TRANSDUCER SIZE .25 FREQ. N/A MHz SERIAL NO. A-28031

CALIBRATION STD. CSC-1 MATERIAL C.S.

COUPLANT GLYCERINE INITIAL CALIBRATION TIME 0819

(CALIBRATION DATA)

STANDARD THICKNESS	INSTRUMENT READING
1.486	1.486
1.253	1.254
.755	.756

	INSTRUMENT START	SETTINGS: FINISH
Gain		
Sweep		
Delay		
Filter	N/A	
Rep. Rate		
Dampening		
Reject		
Digital Range		
Calibrate		
Velocity	2324	2324

CAL. VERIFICATION TIMES: 1109, 1233

Final Cal. Check: 1515

NDE Sup.
S Hamelly 8/7/80

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

NDE Sup. 8/7/80

EXAMINATION DATA FORM

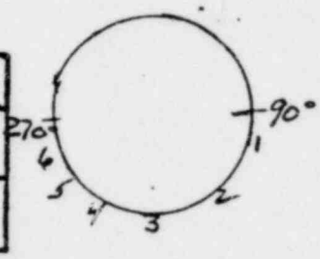
EXAM FORM # 77465

CAL. FORM # 77464

DATE 8-6-80

EXAMINER CA Homler LEVEL II DATA TAKER al Dwen LEVEL II

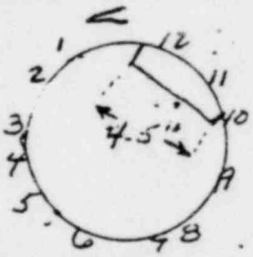
	1	2	3	4	5	6
MATERIAL THICKNESS (ELBOW)	.317	.263	.264	.257	.256	.311
~~PIT GAUGE READINGS~~ (WELD)	.333	.295	.265	.294	.297	.334
~~REMAINING WALL THK.~~ (ELBOW)	.349	.257	.313	.311	.258	.271



WELD NO. 1R1-1004-37 NOMINAL PIPE THICKNESS

NCR NO. INCR-103 MINIMUM WALL .273

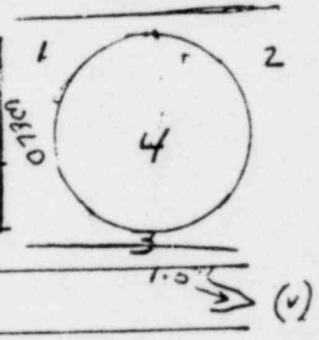
MATERIAL THICKNESS (ELBOW)	.499	.492	.522	.545
PIT GAUGE READINGS	.674	.673	.670	.654
REMAINING WALL THK.	.494	.463	.481	.468



WELD NO. 1R1 1005-1 NOMINAL PIPE THICKNESS

NCR NO. AREA BELOW MW EXTENDS 4.5" CCW; AND 1/2" FROM EDGE of WELD MINIMUM WALL .490

	1	2	3	4
MATERIAL THICKNESS	.434	.472	.379	.308
PIT GAUGE READINGS				
REMAINING WALL THK.	EXCAVATION 1.5" by 1"			

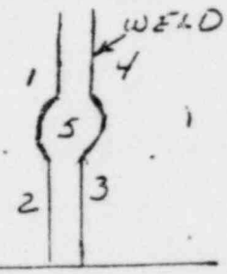


WELD NO. 1R1-1019-11 NOMINAL PIPE THICKNESS

NCR NO. INCR-105 MINIMUM WALL .310

12" FROM V

	1	2	3	4
MATERIAL THICKNESS	.307	.306	.426	.397
PIT GAUGE READINGS	.285			
REMAINING WALL THK.				



WELD NO. 1R1-1004-57 NOMINAL PIPE THICKNESS

NCR. NO. MINIMUM WALL

INCR103, INCR104, INCR105

FORM QP 15-1.1
12-1-78 (Rev. 2)

NONCONFORMANCE REPORT FOR CONSTRUCTION AND TEST

NCR No. 453

Page 1 of 10

Commonwealth Edison

3. DESCRIPTION OF ITEM (EQUIPMENT, MATERIAL, COMPONENT, PART)
PIPE WELD

4. ITEM NO. (PART NO., SER. NO., EQUIP. NO.)
N/A

5. MANUFACTURER/SUPPLIER
MCC O / SHAW

6. ITEM AND UNIT
PT UNIT #1

7. CATEGORY
☐ DEFECT ☐ FAILURE ☐ DAMAGE ☐ DWG. NONCONFORMANCE ☒ SPEC. NONCONFORMANCE ☐ PHYSICAL CONDITION ☐ DOCUMENTATION

8. OBSERVED DURING
☐ SUPPLIER INSPECTION ☒ CONSTRUCTION ☐ CONTRACTOR ☐ TEST

9. P.O. NO. & P.O. ITEM NO.
181110 / 172801

10. HOLD TAG NO.
6333-6335

11. WORK REQUEST NO.
N/A

16. DESCRIPTION OF NONCONFORMANCE
RE: ISI AREA [illegible] MIN. WALL [illegible]
S/RI 02E-18 [illegible] WELD # RI 15 [illegible]
[illegible] 218 & 1RI11 [illegible]
[illegible] RI 20[illegible] SEE NCR'S 10[illegible]
[illegible] SIZE OF MIN WALL AREA

14. SIGNATURES

	NAME	DEPARTMENT	DATE
NONCONF. OBSERVED BY	[illegible]	STA CONST	8/25/80
NONCONF. VERIFIED BY	Maurice E. LeSimonne	STA CONST.	8/25/80
QA SUPV OR COORDINATOR	[illegible]	QA	8/26/80
REPRESENTATIVE	[illegible]	STA CONT	8/25/80

10CFR 50.55(e) Reports Required Yes ☐ No ☒

17. CAUSE OF NONCONFORMANCE
[illegible] AREA CREATED DURING [illegible]
[illegible] INDICATION DURING ISI BASELINE INSPECTION

18. [illegible] ACCEPTABLE AS IS [illegible]

19. [illegible] OF NOTIFIED [illegible] NOT KNOWN
NONE [illegible] OCCURANCE

[illegible] 2/23/81 APPROVED BY [illegible] 2-23-81
DATE ENGINEERING DEPARTMENT HEAD

20. DESCRIPTION OF ACTION TAKEN TO ELIMINATE THE NONCONFORMANCE
ACCEPTABLE AS IS.

21. [illegible]
NONE REQUIRED

[illegible] PCD 3-11-[illegible]
NAME DEPARTMENT

[illegible] 3/[illegible]/81
DATE

22. CORRECTIVE ACTION ACCEPTED
☐ [illegible]

SARGENT & LUNDY
ENGINEERS
FOUNDED BY FREDERICK SARGENT-1891
55 EAST MONROE STREET
CHICAGO, ILLINOIS 60603
TELEPHONE - 312-269-2000
CABLE ADDRESS - SARLUN-CHICAGO

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 394, 402, 408, 409,
429, 432, 453 & 480

Mr. T. E. Watts
General Design Engineer
Commonwealth Edison Company
P. O. Box 767 - 35FNW
Chicago, Illinois 60690

Dear Mr. Watts:

The above NCR's all deal with potential minimum wall violation due to either excessive counterboring or PT indication removal. A minimum wall calculation has been performed for each case based upon design conditions for the areas involved. In all cases the remaining wall thickness exceeds the required minimum wall thickness. Therefore, no repair is necessary and all the above NCR's should be accepted as is for the final disposition.

If you have any questions, please contact me.

Yours very truly,

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W. G. Schwartz
E. R. Weaver
G. C. Jones
E. R. Hartz
C. A. Riebel

INSTALLATION & SERVICE ENGINEERING DIVISION

NONCONFORMITY REPORT

REVISION NO. 0

Project La Salle I PSI Report No. INCR-105

Initiated By L W Wheatley Date 8/14/80

Project No. LCS-P017?-1 Drawing No. IRI-1019

Item, Assembly Joint No. Weld IRI-1019-11

Heat & Lot, Serial No. (if applicable) NA

Identity Record No. Nonconformity Noted (Traveler, RIR, Item List UT, RT Report, etc.) No. EDS 77465

Description of Nonconformity

During removal of penetrant indications, minimum wall has been violated. Remaining wall thickness . the excavation is 0.308" whereas minimum wall is 0.310".

Proposed Resolution

~~Resol~~
RESOLUTION PER CECO ENGINEERING

Signature A Slomelly Date 8/14/80

Comments

Resolution Approved By L W Wheatley Date 8/14/80
Reviewed with ANI By W J Caillouet Date 3-11-81
Completed L W Wheatley Date 3/11/81

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LASALLE COUNTY NUCLEAR STATION

U.T. CALIBRATION FORM

FORM # 77464

DATE 8-6-80

EXAMINER C.A. Hamlin LEVEL II DATA TAKER Al Green LEVEL II

INSTRUMENT MODEL CL 202 SERIAL NO. 801203

TRANSDUCER SIZE .25 FREQ. N/A MH_Z SERIAL NO. A-28031

CALIBRATION STD. CSC-1 MATERIAL C.S.

COUPLANT GLYCERINE INITIAL CALIBRATION TIME 0819

(CALIBRATION DATA)

STANDARD THICKNESS	INSTRUMENT READING
1.486	1.486
1.253	1.254
.755	.756

	INSTRUMENT START	SETTINGS: FINISH
Gain		
Sweep		
Delay		
Filter	N/A	
Rep. Rate		
Dampening		
Reject		
Digital Range		
Calibrate		
Velocity	2324	2324

CAL. VERIFICATION TIMES: 1109
1233

Final Cal. Check: 1515

NDE Sup.
S Hamelly 8/7/80

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

NDE Sup. 8/7/80

EXAMINATION DATA FORM

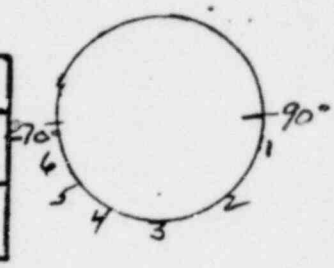
EXAM FORM # 77465

CAL FORM # 77464

DATE 8-6-80

EXAMINER CA Homler LEVEL II DATA TAKER Al Green LEVEL II

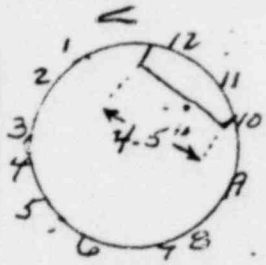
	1	2	3	4	5	6
MATERIAL THICKNESS (ELBOW)	.317	.263	.264	.257	.256	.311
~~PIT GAUGE READINGS~~ (WELD)	.333	.295	.265	.294	.297	.334
~~REMAINING WALL THK.~~ (ELBOW)	.349	.257	.313	.311	.258	.271



WELD NO. 1R1-1004-37 NOMINAL PIPE THICKNESS

NCR NO. 1NCR-103 MINIMUM WALL .273

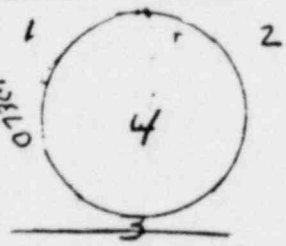
MATERIAL THICKNESS (ELBOW)	.499	.492	.522	.545
PIT GAUGE READINGS	.674	.673	.670	.654
REMAINING WALL THK.	.494	.463	.481	.468



WELD NO. 1R1 1005-1 NOMINAL PIPE THICKNESS

NCR NO. AREA BELOW MW EXTENDS 4.5" CCW; AND 1/2" FROM EDGE OF WELD MINIMUM WALL .490

	1	2	3	4
MATERIAL THICKNESS	.434	.472	.379	.308
PIT GAUGE READINGS				
REMAINING WALL THK.	EXCAVATION 1.5" by 1"			

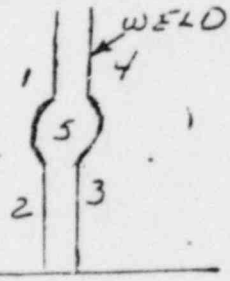


WELD NO. 1R1-1019-11 NOMINAL PIPE THICKNESS

NCR NO. 1NCR-105 MINIMUM WALL .310

12" FROM V

	1	2	3	4
MATERIAL THICKNESS	.307	.306	.426	.397
PIT GAUGE READINGS	5 .285			
REMAINING WALL THK.				



WELD NO. 1R1-1004-57 NOMINAL PIPE THICKNESS

NCR. NO. MINIMUM WALL

INCR103, INCR104, INCR105

FORM QP 15-1.1
12-1-78 (Rev. 2)

NONCONFORMANCE REPORT FOR CONSTRUCTION AND TEST

NCR No. 453

Page 1 of 10

1. OBSERVATION ERROR

2. DEPARTMENT

3. DESCRIPTION OF ITEM (EQUIPMENT, MATERIAL, COMPONENT, PART)
PIPE WELD

4. ITEM NO. (PART NO., SER NO., EQUIP NO.)
N/A

5. SYSTEM AND UNIT
RC UNIT #1

6. MANUFACTURER
MCR O / SHAW

7. CATEGORY
☐ DEFECT ☐ FAILURE ☐ DAMAGE ☐ DIM. NONCONFORMANCE ☒ MAT. NONCONFORMANCE ☐ WORK CONDITION ☐ DOCUMENTATION

8. OBSERVED DURING
☐ SUPPLIER INSPECTION ☒ CONSTRUCTION ☐ CONTRACTOR ☐ TEST

9. P.O. NO. & P.O. ITEM NO.
181110 / 172801

10. HOLD TAG NO.
6333-6335

11. WORK REQUEST NO
N/A

12. DESCRIPTION OF NONCONFORMANCE
THERE IS AN AREA OF MINIMUM WALL
LINES/RI 02L-18 DEFECTIVE WELD # RI 217
RI 218 & RI 11
CAUSE: # RI 20 SEE NCR 10
DUE TO SIZE OF MIN WALL AREA

13. SIGNATURES

	NAME	DEPARTMENT	DATE
NONCONF. OBSERVED BY		STA CONST	8/25/80
NONCONF. VERIFIED BY	Wayne E. Lehmann	STA CONST.	8/25/80
QA SUPV OR COORDINATOR		QA	8/26/80
REPORTING SUPERVISOR		STA CONT	8/25/80

14. CAUSE OF NONCONFORMANCE
MIN WALL AREA CREATED DURING
PT INDICATION DURING ISI BASELINE INSPECTION.

10CFR50.55e Reports Required Yes ☐ No ☒

15. DISPOSITION OF NONCONFORMANCE
ACCEPTABLE AS IS

16. ENGINEERING ANALYSIS OF NONCONFORMANCE
NONE AVAILABLE

17. ROOT CAUSE OF NONCONFORMANCE IF NOT KNOWN
OCCURANCE

18. PROJECT ENGINEER
2/23/81 APPROVED BY

19. DESCRIPTION OF ACTION TO BE TAKEN TO CORRECT THE NONCONFORMANCE
ACCEPTABLE AS IS.

20. DESCRIPTION OF ACTION TO BE TAKEN TO PREVENT RECURRENCE
NONE REQUIRED

21. ACTION COMPLETED BY
PCD 3-11-81

22. CORRECTIVE ACTION REVIEW

23. CLOSURE

SARGENT & LUNDY
ENGINEERS
FOUNDED BY FREDERICK SARGENT-1891
55 EAST MONROE STREET
CHICAGO, ILLINOIS 60603
TELEPHONE - 312-269-2000
CABLE ADDRESS - SARLUN-CHICAGO

February 5, 1981
Project Nos. 4266/67-00

Commonwealth Edison Company
LaSalle County Station - Units 1&2

NCR's 394, 402, 408, 409,
429, 432, 453 & 480

Mr. T. E. Watts
General Design Engineer
Commonwealth Edison Company
P. O. Box 767 - 35FNW
Chicago, Illinois 60690

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If you have any questions, please contact me.

Yours very truly,

G. I. Zwarich
Mechanical Engineer

GIZ:cb
In duplicate
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W. G. Schwartz
E. R. Weaver
G. C. Jones
E. R. Kurtz
C. A. Riebel

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751

Revision No. 0

No. 16001

Nozzle Inner Radius UT Calibration

Date 1/31/81

SITE La Salle I

ZONE 1 2

PROCEDURE NO. NIRZ2-S751 EXAMINER A. W. Clay ASNT II

REV. 0 RECORDER [illegible] ASNT II

CAL. BLOCK NO. MP-1 COUPLANT Glycerine

EQUIPMENT DATA: INSTRUMENT MODEL NO. KK USM2 SERIAL NO. 811368

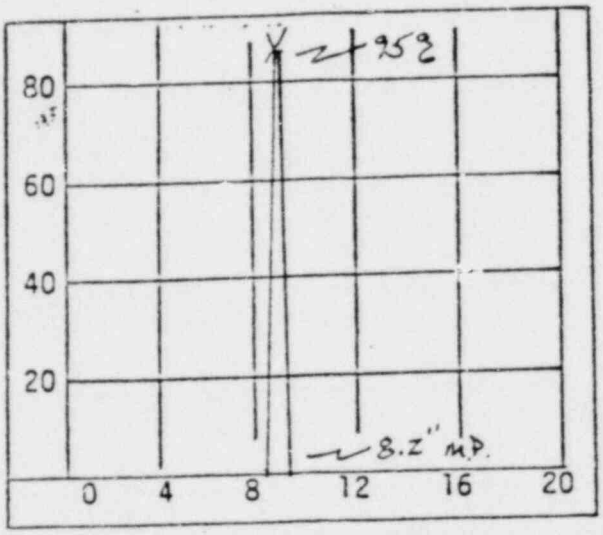
Transducer S/N B10716

CALIBRATION EXP. DATE 7/21/81

TRANSDUCER TYPE Aerotech ; SIZE 1.0" Ø FREQ. 1.0 MHz

WEDGE ID NO. LS-NZ-ZZ-CW/CCW

CABLE TYPE RG-174 ; LENGTH 10'



INSTRUMENT SETTINGS:

GAIN @ CTB	38	38
dB INCREASE	28	22 * See Note
GAIN @ 1 X	66	60
GAIN @ 2 X	72	66
SWEEP COURSE	10	10
SWEEP FINE	N/A	N/A
DELAY COURSE	796	796
DELAY FINE	N/A	N/A
FREQ.	N/A	N/A
PULSE REP.	Auto	Auto
PULSE LEVEL	N/A	N/A
PULSE DAMPING	off	off
REJECT	OFF	OFF

NA = NOT APPLICABLE TO THIS INSTRUMENT

INITIAL CALIBRATION TIME 1000 0-24 HR.

VERT LIN

A	B
100	50
90	45
80	40
70	35
60	30
50	25
40	20
30	15
20	10

B = 50% A ±5% FSH

CONT. LIN.

SET	dBΔ		LIMITS
80	-6	40	32-48
80	-12	21	16-24
40	+6	79	64-96
20	+12	80	64-96

* Scanning level reduced by 6db to make clad noise acceptable. (NA)

B-NOTCH AMP.	METAL PATH	TIME
95%	8.2	1205
95%	8.2"	1500
95%	8.2"	1745 Final

LAST PHOTO NO.

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: [illegible] DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL II

[illegible] 2/4/81 GE-GE

[illegible] 2/4/81 ANEI

A.W. Clay II
Chang with Q 3

SHEET NO. 16002 DATE 1/31/81 NOZZLE ID NZ-E

CAL. NO. 16001

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Stanley C. Mortenson DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: II

L.D. Whalley 3/4/81 GE-QC

S.A. Fetter 3/4/81 ANII

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

A. W. Clay II
Thomas M. Leavitt

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

SHEET NO. 16003 DATE 1/31/81 NOZZLE ID N2-D

CAL. NO. 16001

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

Procedure No. NIRZ2-S751
Revision No. 0

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Shawn C. Mortensen DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: II

L.D. Whitley 2/4/81 GE-QC

S.A. Pelton 2/4/81 ANII

A.W. Clay II
Thay and Clay II

SHEET NO. 16004 DATE 1/31/81 NOZZLE ID N2-C

CAL. NO. 16001

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Mortenson DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: II

L.N. Whatley 2/4/81 GE-QC

S.A. Felton 2/4/81 ANII

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

A.W. Clay III

SHEET NO. 16005 DATE 1/31/81 NOZZLE ID N2-B

CAL. NO. 16001

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Martenson DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: II

L.D. Whitby 2/4/81 GE-NC

S.A. Fetter 2/4/81 ANSC

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751

Revision No. 0

A. W. Clay II
Clay and Co

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

SHEET NO. 16006 DATE 1/31/81 NOZZLE ID N2-A

CAL. NO. 16001

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

Procedure No. NIRZ2-S751
Revision No. 0

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Morrison DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: II

R.D. Whatley 2/4/81 GE-QC

C.A. Felton 2/4/81 ANSI

A. W. Clay II
Thomas and Co

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

SHEET NO. 16007 DATE 1/31/81 NOZZLE ID N2-K

CAL. NO. 16001

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Mortensen DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: II

L.J. Whitley 2/4/81 GE-QC

S. A. Fotta 2/4/81 ANII

Procedure No. NIRZ2-S751

Revision No. 0

A.W. Clair II
Chas and II

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

SHEET NO. 16008 DATE 1/31/81 NOZZLE ID N2-J

CAL. NO. 16001

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

Procedure No. RZ2-S751
Revision No.

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Morton DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: II

L.D. Whitley 2/4/81 GE-QC

S.A. Felton 2/4/81 ANII

A. W. Clay III
Wang and G. B.

SHEET NO. 11009 DATE 1/31/81 NOZZLE ID N2-H

CAL. NO. 11001

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Shum C. Morton DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: II

L.J. Whitley 2/4/81 GE-QC

S.A. Peters 2/4/81 ANII

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

A.W. Clay II
Clay with II

SHEET NO. 16010 DATE 1/31/81 NOZZLE ID [illegible]2-G

CAL. NO. 16001

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Martens DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: II

L.W. Whatley 2/4/81 GE-QC

S.A. Pelton 2/4/81 ANII

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

A.W. Clay II
Clay III

SHEET NO. 16011 DATE 1/31/81 NOZZLE ID N2-F

CAL. NO. 16001

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Morlen DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: II

L.D. Wheatley 2/4/81 GE-QC

S.A. Felton 2/4/81 ANSE

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751

Revision No. 0

No. 16012

Nozzle Inner Radius UT Calibration

Date 1/31/81

SITE La Salle I

ZONE 1 2

PROCEDURE NO. NIRZ2-S751 EXAMINER A.W. Clay ASNT II

REV. 0 RECORDER [illegible] ASNT II

CAL. BLOCK NO. MP-1 COUPLANT Glycerine

EQUIPMENT DATA: INSTRUMENT MODEL NO. KK USM2 SERIAL NO. 811368

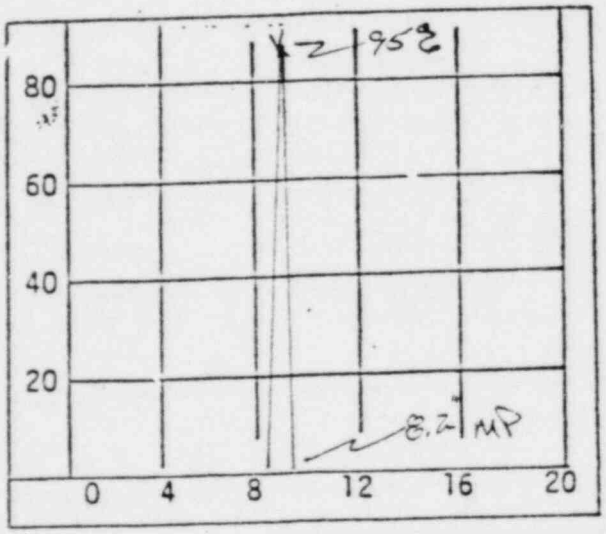
Transducer S/N B10716

CALIBRATION EXP. DATE 7/21/81

TRANSDUCER TYPE Aerotech ; SIZE 1.0" Ø FREQ. 1.0 MHz

WEDGE ID NO. LS-N1-Z2-CW & CCW

CABLE TYPE RG-174 ; LENGTH 10'



INSTRUMENT SETTINGS:

GAIN @ CTB	38	38	
dB INCREASE	32	26	* see note
GAIN @ 1 X	70	64	
GAIN @ 2 X	76	70	
SWEEP COURSE	10	10	
SWEEP FINE	N/A	N/A	
DELAY COURSE	796	796	
DELAY FINE	N/A	N/A	
FREQ.	N/A	N/A	
PULSE REP.	Auto	Auto	
PULSE LEVEL	N/A	N/A	
PULSE DAMPING	off	off	
REJECT	OFF	off	

NA = NOT APPLICABLE TO THIS INSTRUMENT

INITIAL CALIBRATION TIME 1500 0-24 HR.

VERT LIN

A	B
100	50
90	45
80	40
70	35
60	30
50	25
40	20
30	15
20	10

B = 50% A ±5% FSH

CONT. LIN.

SET	dBΔ		LIMITS
80	-6	40	32-48
80	-12	21	16-24
40	+6	79	64-96
20	+12	80	64-96

* Scanning level reduced by 6db to make Clad Noise acceptable.

B-NOTCH AMP.	METAL PATH	TIME
95%	8.2"	1745 Final

LAST PHOTO NO.

REVIEWED BY: [illegible] DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL II

[illegible] 2/4/81 GE-GC

[illegible] 2/4/81 ANII

FIGURE 8 CALIBRATION SHEET

A.W. Clay II
Thomas E. II

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

SHEET NO. 16013 DATE 1/31/81 NOZZLE ID N1-A

CAL. NO. 16012

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

Procedure No. NIRZ2-S751
Revision No. 0

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Shawn C. Morton DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: II

L.D. Whitley 2/4/81 GE-QC

S.A. Fetter 2/4/81 ANEB

A.W. Clair IV
Change with G.U

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

SHEET NO. 16014 DATE 1/31/81 NOZZLE ID N1-B

CAL. NO. 16012

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
45°	75° +4"	2½"	80	12"	CCW	*
					CW	No Recordable Indications
	*					
	The "D dist" was outside of the prescribed examination area per					
	Procedure NIR 2-5751. This indication revealed very little "walking"					
	which resembled that of "clad noise" as the transducer translated					
	up the radius towards the nozzle plate past the examination					
	area. The clad noise can exhibit an increase in amplitude					
	on clad nozzles.					
			James C. Mortenson			

Procedure No. NIRZ2-5751
Revision No. 0

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: James C. Mortenson DATE: 2-2-81

GENERAL ELECTRIC CO. LEVEL: II

L.W. Huntley 2/4/81 GE-QC
S.A. Felton 2/4/81 ANIS

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751

Revision No. 0

No. 16015

Date 2/2/81

Nozzle Inner Radius UT Calibration

ZONE 1 (2)

SITE La Salle I

PROCEDURE NO. NIRZZ-S751 EXAMINER A.L. Clay ASNT II

REV. 0 RECORDER [illegible] ASNT II

CAL. BLOCK NO. MP 1 COUPLANT Glycerine

EQUIPMENT DATA: INSTRUMENT MODEL NO. KK-USM2 SERIAL NO. 811368

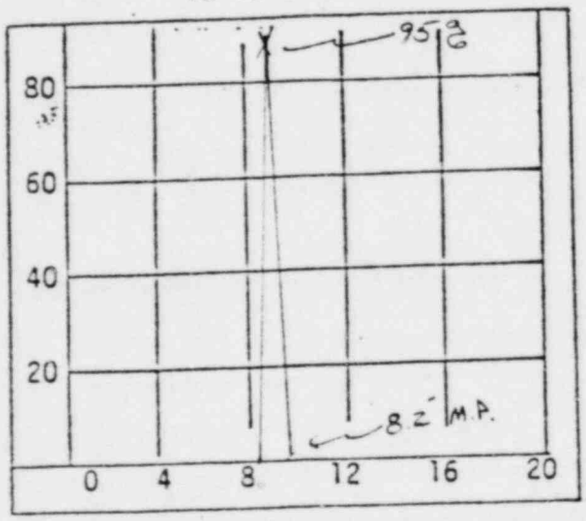
Transducer S/N 310716

CALIBRATION EXP. DATE 7/21/81

TRANSDUCER TYPE Aerotech ; SIZE 1.0" Ø FREQ. 1.0 MHz

WEDGE ID NO. LS-N10-ZZ-CW & CCW Sam 2-3-81

CABLE TYPE RG-174 ; LENGTH 10'



INSTRUMENT SETTINGS:

GAIN @ CTB	40	40
dB INCREASE	22	22
GAIN @ 1 X	62	62
GAIN @ 2 X	68	68
SWEEP COURSE	10	10
SWEEP FINE	N/A	N/A
DELAY COURSE	790	790
DELAY FINE	N/A	N/A
FREQ.	N/A	N/A
PULSE REP.	Auto	Auto
PULSE LEVEL	N/A	N/A
PULSE DAMPING	off	off
REJECT	OFF	off

NA = NOT APPLICABLE TO THIS INSTRUMENT

INITIAL CALIBRATION TIME 0909 0-24 HR.

VERT LIN

A	B
100	50
90	45
80	40
70	35
0	30
50	25
40	20
30	15
20	10

B = 50% A
±5% FSH

CONT. LIN.

SET	dBΔ		LIMITS
80	-6	41	32-48
80	-12	22	16-24
40	+6	78	64-96
20	+12	76	64-96

	B-NOTCH AMP.	METAL PATH	TIME
Final	95%	8.2"	1155

LAST PHOTO NO.

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: Steven C. Mortenson DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL II

[illegible] 2/4/81 GE-GE

S.A. Pelton 2/4/81 ANII

A.W. Clay II
Wesquinte II

SHEET NO. 16016 DATE 2/2/81 NOZZLE ID N-10

CAL. NO. 16015

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Mac Fenson DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL: II

L.W. Whatley 2/4/81 CC-QC

S.A. Pelkar 2/4/81 ANII

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751

Revision No. 0

No. 16017

Date 2/2/81

Nozzle Inner Radius UT Calibration

ZONE 1 (2)

SITE LA SALLE I

PROCEDURE NO. NIRZ2-S751 EXAMINER [illegible] ASNT [illegible]

REV. 0 RECORDER [illegible] ASNT [illegible]

CAL. BLOCK NO. MP.1 COUPLANT GLYCERINE

EQUIPMENT DATA: INSTRUMENT MODEL NO. KK USM2 SERIAL NO. 811368

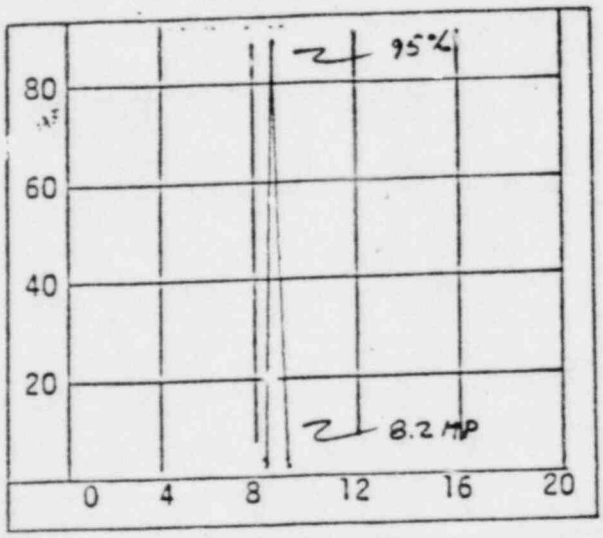
CALIBRATION EXP. DATE 7/21/81

TRANSDUCER S/N # B10716

TRANSDUCER TYPE AEROTECH ; SIZE 1.0" Ø FREQ. 1.0 MHz

WEDGE ID NO. LS-N4-Z2-CW & CCW

CABLE TYPE RG-174 ; LENGTH 10'



INSTRUMENT SETTINGS:

GAIN @ CTB	40	40	
dB INCREASE	26	28	* SEE NOTE
GAIN @ 1 X	66	68	
GAIN @ 2 X	72	74	
SWEEP COURSE	10	10	
SWEEP FINE	N/A	N/A	
DELAY COURSE	790	790	
DELAY FINE	N/A	N/A	
FREQ.	N/A	N/A	
PULSE REP.	AUTO	AUTO	
PULSE LEVEL	N/A	N/A	
PULSE DAMPING	OFF	OFF	
REJECT	OFF	OFF	

NA = NOT APPLICABLE TO THIS INSTRUMENT

INITIAL CALIBRATION TIME 0909 0-24 HR.

VERT LIN

A	B
100	50
90	45
80	40
70	35
60	30
50	25
40	20
30	15
20	10

B = 50% A ±5% FSH

CONT. LIN.

SET	dBΔ		LIMITS
80	-6	41	32-48
80	-12	22	16-24
40	+6	78	64-96
20	+12	76	64-96

* 2 dB WAS ADDED FINAL FOR SCANNING TO BRING UP CLADDING REFLECTIONS

B-NOTCH AMP.	METAL PATH	TIME
Final 95%	8.2"	1155

LAST PHOTO NO.

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: [illegible] DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL II

[illegible] 2/4/81 GE-QC

S.A. Pelton 2/4/81 ANII

A.W. Clair II
Thomas E. [illegible]

SHEET NO. 16018 DATE 2/2/81 NOZZLE ID N6-A

CAL. NO. 16017

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW / CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: [signature] DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL: II

L.D. Wheatley 2/4/81 CE-QC

S.A. Reiter 2/4/81 ANIS

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

A.W. Clay II
Chuck Clay II

SHEET NO. 16019 DATE 2/2/81 NOZZLE ID N6-B

CAL. NO. 16017

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW / CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Martenson DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL: II

L.D. Whatley 2/4/81 GE-QC

S.T. Felton 2/4/81 AMII

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-5751
Revision No. 0

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ1-S751

Revision No. 0

No. 16021

Date 2/3/81

Nozzle Inner Radius UT Calibration

SITE LA SALLE I

ZONE (1) 2

PROCEDURE NO. NIR Z1-S751 EXAMINER [illegible] ASNT II

REV. 0 RECORDER [illegible] ASNT II

CAL. BLOCK NO. MP-1 COUPLANT Glycerine

EQUIPMENT DATA: INSTRUMENT MODEL NO. KK USM-2 SERIAL NO. 811368

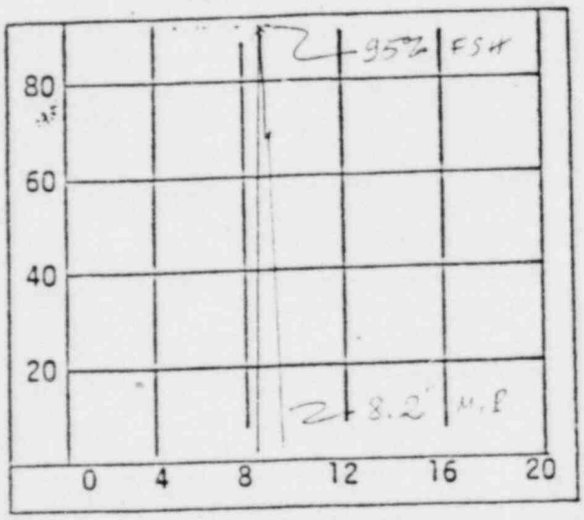
TRANSDUCER S/N: B10716

CALIBRATION EXP. DATE 7/21/81

TRANSDUCER TYPE Aerotech ; SIZE 1.0" Ø FREQ. 1.0 MHz

WEDGE ID NO. LS-N5-Z1 CW & CCW

CABLE TYPE RG 174 ; LENGTH 10'



INSTRUMENT SETTINGS:

GAIN @ CTB	38	38
dB INCREASE	22	22
GAIN @ 1 X	60	60
GAIN @ 2 X	66	66
SWEEP COURSE	10	10
SWEEP FINE	N/A	N/A
DELAY COURSE	8.02	8.02
DELAY FINE	N/A	N/A
FREQ.	N/A	N/A
PULSE REP.	Auto	Auto
PULSE LEVEL	N/A	N/A
PULSE DAMPING	off	off
REJECT	OFF	off

NA = NOT APPLICABLE TO THIS INSTRUMENT

INITIAL CALIBRATION TIME 08:50 0-24 HR.

VERT LIN

A	B
100	50
90	45
80	40
70	35
60	30
50	25
40	20
30	15
20	10

B = 50% A
±5% FSH

CONT. LIN.

SET	dBΔ		LIMITS
80	-6	42	32-48
80	-12	22	16-24
40	+6	78	64-96
20	+12	75	64-96

B-NOTCH AMP.	METAL PATH	TIME
95%	8.2"	12:08
95%	8.2"	14:08
95%	8.2"	17:15

LAST PHOTO NO.

REVIEWED BY: [illegible] DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL II

X-2 [illegible] 2/4/81 GE-QC

S.A. Fell

~~S.A. Fell 2/4/81 ANIS~~

FIGURE 8 CALIBRATION SHEET

A.W. Clay II
Thomas and G. II

SHEET NO. 16023 DATE 2/3/81 NOZZLE ID N-4 - A

CAL. NO. 16021

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW / CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Merlen DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL: II

R.D. Whatley 2/4/81 GE-QC

S.A. Felton 2/4/81 ANII

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

A.W. Clay II
Transmitter II

SHEET NO. 16024 DATE 2/3/81 NOZZLE ID W4-B

CAL. NO. 16021

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
45	330	1 5/8"	50	4.0	CW	
45	330	1 1/2"	50	5.8"	CW	These indication were typical weld metal indications recorded
45	345 +2	1.0"	30	5.0"	CW	for "information only." These indications are not rejectable
45	345 +2	1 1/4"	40	5.0"	CCW	due to the high db gain used by this technique
45	330	1 3/4"	40	5.0"	CCW	Steven C. Martin 2-4-81

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Martin DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL: II

L.W. Whitley 2/4/81 GE-QC

S.A. Felton 2/4/81 ANII

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-5751
Revision No. 0

A.W. Clay II
Transmitted to II

SHEET NO. 16025 DATE 2/3/81 NOZZLE ID N4-C

CAL. NO. 16021

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW / CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Martin DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL: II

W. Whatley 2/4/81 GE-QC

S.A. Fetton 2/4/81 ANFE

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ 2-S751
Revision No. 0

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

SHEET NO. 16026 DATE 2/3/81 NOZZLE ID N4-D

CAL. NO. 16021

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW / CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: [illegible] DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL: II

[illegible] 2/4/81 GE-QI

[illegible] 2/4/81 AHII

A.W. Clay II
Thomas and Ed II

SHEET NO. 16027 DATE 2/3/81 NOZZLE ID N4 E

CAL. NO. 16021

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW / CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Hartman DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL: II

R.W. Whatley 2/4/81 GE-QC

S.A. Felton 2/4/81 AMFE

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

A.W. Clay II
Thang mil 6 II

SHEET NO. 16028 DATE 2/3/81 NOZZLE ID N4-F

CAL. NO. 16021

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
45	150 +2 3/4"	1 5/8"	40	4.4"	CW	* See EDS 16024 for explanation Slm 2-4-81
					CCW	No Recordable Indications.

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Morlen DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL: A

L.W. Vinathy 2/4/81 CE-QC

S.A. Felton 2/4/81 ANSI

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZZ-S751

Revision No. 0

No. 16022

Date 2/3/81

Nozzle Inner Radius UT Calibration

ZONE 1 (2)

SITE La Salle I

PROCEDURE NO. NIRZZ-S751 EXAMINER A.W. Clay ASNT II

REV. 0 RECORDER Thang Tuan a ASNT II

CAL. BLOCK NO. MP-1 COUPLANT Glycerine

EQUIPMENT DATA: INSTRUMENT MODEL NO. KK-USM2 SERIAL NO. 811368

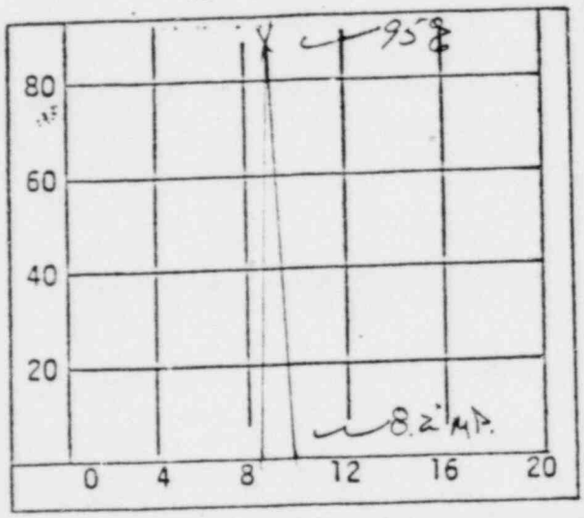
Transducer S/N B1071L

CALIBRATION EXP. DATE 7/21/81

TRANSDUCER TYPE Aerotech ; SIZE 1.0" ø FREQ. 1.0 MHz

WEDGE ID NO. LS-N4-22-CW & CCW

CABLE TYPE RG-174 ; LENGTH 10'



INSTRUMENT SETTINGS:

GAIN @ CTB	38	38
dB INCREASE	26	26
GAIN @ 1 X	64	64
GAIN @ 2 X	70	70
SWEEP COURSE	10	10
SWEEP FINE	N/A	N/A
DELAY COURSE	802	802
DELAY FINE	N/A	N/A
FREQ.	N/A	N/A
PULSE REP.	Auto	Auto
PULSE LEVEL	N/A	N/A
PULSE DAMPING	off	off
REJECT	OFF	off

NA = NOT APPLICABLE TO THIS INSTRUMENT

INITIAL CALIBRATION TIME 0850 0-24 HR.

VERT LIN

A	B
100	50
90	45
80	40
70	35
60	30
50	25
40	20
30	15
20	10

B = 50% A
±5% FSH

CONT. LIN.

SET	dBΔ		LIMITS
80	-6	42	32-48
80	-12	22	16-24
40	+6	78	64-96
20	+12	75	64-96

B-NOTCH AMP.	METAL PATH	TIME
95	8.2"	1208
95	8.2"	1403
95	8.2"	1715
Final	LAST PHOTO NO.	

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: [illegible] DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL II

[illegible] 2-4-81 GE-QC

S.A. Fetter 2/4/81 ANII

A. W. Clay II
Viewing and Ex II

SHEET NO. 16029 DATE 2/3/81 NOZZLE ID N4-A

CAL. NO. 16022

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW/CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Mostaan DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL: II

2/4/81 CEQC

2/4/81 ANDE

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

A.W. Clay II

SHEET NO. 16030 DATE 2/3/81 NOZZLE ID N4-B

CAL. NO. 16022

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW / CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: [illegible] DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL: 1

[illegible] 2/4/81 GE QC

S.A. [illegible] 2/4/81 ANII

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751

Revision No. 0

A.W. Clay II

SHEET NO. 16031 DATE 2/3/81 NOZZLE ID N4-C

CAL. NO. 16022

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW / CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Mardeson DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL: II

L.D. Whitley 2/4/81 GE QC

G.A. Felton 2/4/81 ANII

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-5751

Revision No. 0

A.W. Clay II
Shaw and C II

SHEET NO. 16032 DATE 2/3/81 NOZZLE ID N4-D

CAL. NO. 16022

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW / CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Mordenson DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL: II

L.D. Wheatley 2/4/81 GE QC

S.A. Felton 2/4/81 ANII

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751
Revision No. 0

A.W. Clay II

SHEET NO. 16033 DATE 2/3/81 NOZZLE ID N4 - E

CAL. NO. 16022

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW / CCW	No Recordable Indications

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: [illegible] DATE: 2-4-81

GENERAL ELECTRIC CO. LEVEL: II

[illegible] 2/4/81 CE-QC

[illegible] 2/4/81 ANDE

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751

Revision No. 0

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751

Revision No. 0

No. 73005

Date 2/4/81

Nozzle Inner Radius UT Calibration

ZONE 1 (2)

SITE LASALLE I

PROCEDURE NO. NIRZ2-S751 EXAMINER Bud Durham ASNT II

REV. 0 RECORDER Robert Lingo ASNT II

CAL. BLOCK NO. MP-1 COUPLANT GLYCERINE

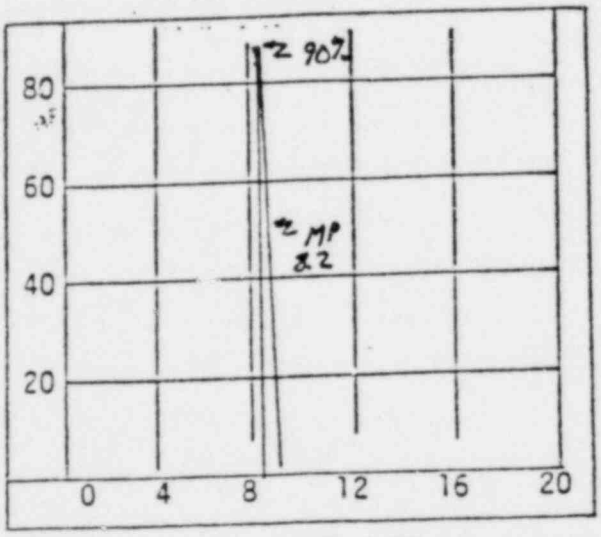
EQUIPMENT DATA: INSTRUMENT MODEL NO. SONIC MARK I SERIAL NO. 732203

CALIBRATION EXP. DATE 4/28/81

S/N # K02612 TRANSDUCER TYPE AERITECH ; SIZE 1.0" Ø FREQ. 1.0 MHz

WEDGE ID NO. LS-N5-Z2-CW & CCW

CABLE TYPE RG-174 ; LENGTH 6'



INSTRUMENT SETTINGS:

GAIN @ CTB	46	46
dB INCREASE	30	30
GAIN @ 1 X	76	76
GAIN @ 2 X	82	82
SWEEP COURSE	50	50
SWEEP FINE	1.11	1.11
DELAY COURSE	2.54	2.54
DELAY FINE	N/A	N/A
FREQ.	B	B
PULSE REP.	3K	3K
PULSE LEVEL	N/A	N/A
PULSE DAMPING	N/A	N/A
REJECT	OFF	OFF

NA = NOT APPLICABLE TO THIS INSTRUMENT

VERT LIN

A	B
100	50
~~90~~ 89	44
80	40
~~70~~ 72	36
~~60~~ 58	28
50	24
40	18
30	13
20	8

B = 50% A
±5% FSH

CONT. LIN.

SET	dBΔ		LIMITS
80	-6	42	32-48
80	-12	22	16-24
40	+6	82	64-96
20	+12	76	64-96

INITIAL CALIBRATION TIME 0845 0-24 HR.

B-NOTCH AMP.	METAL PATH	TIME
90%	8.2	1220

LAST PHOTO NO.

REVIEWED BY: [signature] DATE: 2-5-81

GENERAL ELECTRIC CO. LEVEL II

L.D. Whatley 2/4/81 GE-QC

S.A. Fetter 2/4/81 ANII

FIGURE 8 CALIBRATION SHEET

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

SHEET NO. 75 006 DATE 2/4/81 NOZZLE ID NS-A

CAL. NO. 75 005

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW & CCW	NO RECORDABLE INDICATION

EXAMINER Brad Dummer LEVEL II

RECORDER Robert Langer LEVEL II

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Martenson DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL: 4

2/4/81 GE-QC

S.A. Fetta 2/4/81

Procedure No. NIRZ2-5751

Revision No. 0

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

SHEET NO. 78 002 DATE 2/4/81 NOZZLE ID N14-A

CAL. NO. 78 005

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW & CCW	No Recordable Indications

Examiner Brad Dummer Level II

Recorder Robert Singer Level II

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Mc[illegible] DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL: II

[illegible] 2/4/81 CE QC

[illegible] 2/4/81 ANIS

Procedure No. NIRZ2-S751

Revision No. 0

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751

Revision No. 0

No. 7300E

Date 2/4/81

Nozzle Inner Radius UT Calibration

ZONE 1 (2)

SITE LA SALLE I

PROCEDURE NO. NIRZ2-S751 EXAMINER Bud Dummer ASNT II

REV. 0 RECORDER Robert Smith ASNT II

CAL. BLOCK NO. MP-1 COUPLANT GLYCERINE

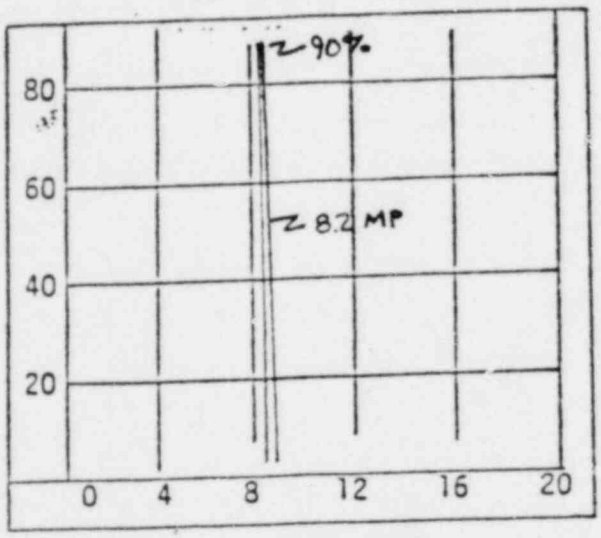
EQUIPMENT DATA: INSTRUMENT MODEL NO. SONIC MARK I SERIAL NO. 732203

CALIBRATION EXP. DATE 4/28/81

S/N # K02612 TRANSDUCER TYPE AEROTECH ; SIZE 1.0" Ø FREQ. 1.0 MHz

WEDGE ID NO. LS-N3-Z2-CW & CCW

CABLE TYPE RG-174 ; LENGTH 6'



INSTRUMENT SETTINGS:

GAIN @ CTB	46	46
dB INCREASE	26	26
GAIN @ 1 X	72	72
GAIN @ 2 X	78	78
SWEEP COURSE	50	50
SWEEP FINE	1.11	1.11
DELAY COURSE	2.54	2.54
DELAY FINE	N/A	N/A
FREQ.	B	B
PULSE REP.	3K	3K
PULSE LEVEL	N/A	N/A
PULSE DAMPING	N/A	N/A
REJECT	OFF	OFF

NA = NOT APPLICABLE TO THIS INSTRUMENT

INITIAL CALIBRATION TIME 0845 0-24 HR.

B-NOTCH AMP.	METAL PATH	TIME
90%	8.2	1220 FINAL

LAST PHOTO NO.

VERT LIN

A	B
100	50
~~90~~ 89	44
80	40
~~70~~ 72	36
~~60~~ 58	28
50	24
40	18
30	13
20	8

B = 50% A
±5% FSH

CONT. LIN.

SET	dBΔ		LIMITS
80	-6	42	32-48
80	-12	22	16-24
40	+6	82	64-96
20	+12	76	64-96

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: [signature] DATE: 2-9-81

GENERAL ELECTRIC CO. LEVEL II

[signature] 2/4/81 GE-QC

S.A. Felton 2/4/81 ANII

SHEET NO. 73004 DATE 2/3/81 NOZZLE ID N3-A

CAL. NO. 73008

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW + CCW	No Recordable Indications

EXAMINER Brad Dummer LEVEL II

RECORDER Robert Surgin LEVEL II

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: [signature] DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL: II

L.D. Whatley 2/4/81 GE-QC

S.A. Felton 2/4/81 ANII

GENERAL ELECTRIC CO. LEVEL: II

L.D. Whatley 2/4/81 GE-QC

S.A. Felton 2/4/81 ANII

GENERAL ELECTRIC

ALLOCATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751

Revision No. 0

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

SHEET NO. 73011 DATE 2/3/81 NOZZLE ID N3-C

CAL. NO. 73008

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW + CCW	NO Recordable Indications

EXAMINER Brad Dunman LEVEL II

RECORDER Robert Sayer LEVEL II

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steve C Morton DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL: II

L.D. Whatley 2/4/81 GE-QC

S.A. Pelton 2/4/81 AMSE

Procedure No. NIRZ2-S751

Revision No. 0

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

SHEET NO. 75012 DATE 2/3/81 NOZZLE ID N3:D

CAL. NO. 75008

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW + CCW	No Recordable Indications

EXAMINER Brad Dummer LEVEL II

Recorder Robert Sayer LEVEL II

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: [signature] DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL: II

R D Whatley 2/4/81 GE-QC

[signature] 2/4/81 ANI-I

Procedure No. NIRZ2-S751

Revision No. 0

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

Procedure No. NIRZ2-S751

Revision No. 0

No. 73013

Date 2/4/81

Nozzle Inner Radius UT Calibration

ZONE 1 (2)

SITE LASALLE I

PROCEDURE NO. NIRZ2-S751 EXAMINER Bud Dummer ASNT II

REV. 0 RECORDER Robert [illegible] ASNT II

CAL. BLOCK NO. MP-1 COUPLANT GLYCERINE

EQUIPMENT DATA: INSTRUMENT MODEL NO. SONIC MARK I SERIAL NO. 732203

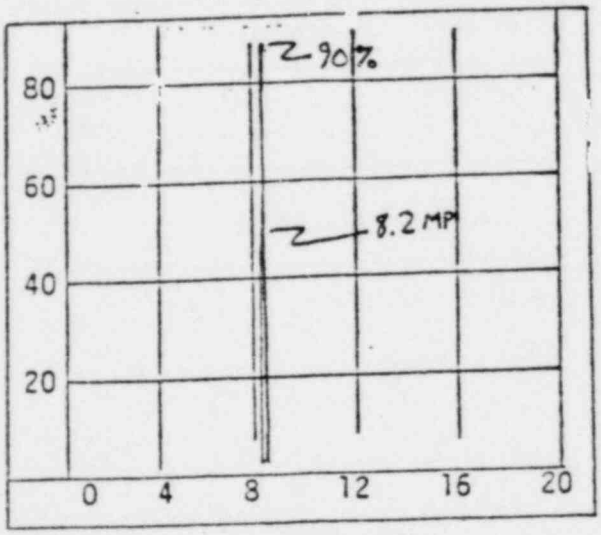
CALIBRATION EXP. DATE 4/28/81

TRANSDUCER TYPE AEROTECH ; SIZE 1.0" Ø FREQ. 1.0 MHz

S/N# K02612

WEDGE ID NO. LS-N4-22-CW & CCW

CABLE TYPE RG-174 ; LENGTH 6'



INSTRUMENT SETTINGS:

GAIN @ CTB	46	46
dB INCREASE	26	26
GAIN @ 1 X	72	72
GAIN @ 2 X	78	78
SWEEP COURSE	50	50
SWEEP FINE	1.11	1.11
DELAY COURSE	2.54	2.54
DELAY FINE	N/A	N/A
FREQ.	8	8
PULSE REP.	3K	3K
PULSE LEVEL	N/A	N/A
PULSE AMPING	N/A	N/A
REJ	OFF	OFF

N APPLICABLE TO THIS INSTRUMENT

AL CALIBRATION TIME 0845 0-24 HR.

VERT LIN

A	B
100	50
~~90~~ 89	44
80	40
~~70~~ 72	36
~~60~~ 58	28
50	24
40	18
30	13
20	8

B = 50% A
±5% FSH

CONT. LIN.

SET	dBΔ		LIMITS
80	-6	42	32-48
80	-12	22	16-24
40	+6	82	64-96
20	+12	76	64-9[illegible]

NOTCH AMP.	METAL PATH	TIME
90%	8.2	1220
90%	8.2	1500
90%	8.2	1550 FINAL

LAST PHOTO NO.

FIGURE 8 CALIBRATION SHEET

REVIEWED BY: [signature] DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL II

[signature] 2/4/81 GE-QC

S.A. Fo[illegible] 2/4/81 ANSI

GENERAL ELECTRIC
INSTALLATION & SERVICE ENGINEERING DIVISION

SHEET NO. 73014 DATE 2/4/81 NOZZLE ID N4-F

CAL. NO. 73013

ANGLE REF.	AZIMUTH CW	D DIST.	AMP % FSH	METAL PATH	SCAN CW OR CCW	COMMENTS
					CW & CCW	NO RECORDABLE INDICATIONS.

EXAMINER Bud Dummer LEVEL II

Recorder Robert Singer Level II

FIGURE 10 DATA RECORD SHEET

REVIEWED BY: Steven C. Mortensen DATE: 2-3-81

GENERAL ELECTRIC CO. LEVEL: II

R.W. Whatley 2/4/81

S.A. Pelton 2/4/81 ANII

Procedure No. NIRZ2-S751

Revision No. 0

GENERAL ELECTRIC

GENERAL ELECTRIC COMPANY, 814 COMMERCE DR., OAK BROOK, ILL. 60521

INSTALLATION AND
SERVICE ENGINEERING
DIVISION

June 24, 1980

cc: N. R. Casey
S. D. Connelly
L. W. Wheatley
M. E. Williams
D. W. Zebrauskas

Mr. G. E. Groth
Station Construction Department
Commonwealth Edison Company
LaSalle County Nuclear Station
R. R. #1, Box 240
Marseilles, Illinois 61341

SUBJECT: EXEMPTION CLARIFICATION OF CONTROL ROD DRIVES (CRD) FROM ASME SECTION XI CATEGORY B-O EXAMINATIONS.

Reference:
1. LaSalle County Station's Final Safety Analysis Report (FSAR), 4.6.2.3.1 Control Rod Drives (Safety Evaluation), specifically 4.6.2.3.1.2.5 Housing Wall Ruptures Page 4.6-22.
2. R. C. Hooper, GE letter of March 7, 1979 to T. E. Watts, CECo, re: Pipe Size Exclusions.

Dear Mr. Groth:

The CRD's are exempted from ASME Section XI Category B-O (Volumetric) Examinations by Section XI IWB-1220 (b) (1). The CRD nominal pipe size is 6" diameter; however, the effective cross-sectional area is 1.81" in diameter using Reference 1 of 1030 gpm maximum leak rate, and Reference 2, the water analysis. The maximum allowable pipe size excluded is 2.23" in diameter as calculated in Reference 2. Thus, the CRD's are exempt from Category B-O.

If you have any questions or comments, please don't hesitate to call or write.

Sincerely yours,

R. C. Hooper
NDE Supervisor
Central Nuclear Service Operation

RCH:ck

PSI Ref. No. RPV-3

6-24-80

GENERAL ELECTRIC

INSTALLATION AND SERVICE ENGINEERING DIVISION

GENERAL ELECTRIC COMPANY, 814 COMMERCE DR., OAK BROOK, ILL. 60521

March 7, 1979

Mr. T. E. Watts
Project Engineer
Commonwealth Edison Company
Post Office Box 767
Chicago, IL 60690

SUBJECT: Pipe Sizes Excluded Under Paragraph IWB-1220(b)(1) of ASME B&PV Code Section XI of LaSalle County Station Unit 1 Reactor Coolant Systems

Dear Mr. Watts:

This letter is to clarify the basis for, and the results of, the analysis of pipe sizes excludable from examination by paragraph IWB-1220(b)(1) of the 1974 Edition through Summer, 1975 Addendum of Section XI ASME B&PV Code.

The criteria used in the analysis is as follows:

1. The leak rate at 1000 psi is

   liquid - 8000 lb/sec/ft^2
   steam - 2000 lb/sec/ft^2

2. If the core remains covered for a complete circumferential rupture of a given pipe (assuming AC power is available, but with no credit for ECCS) then the pipe may be excluded from examination.

3. The vessel design cooldown rate of 100°F/hr may be exceeded under emergency conditions.

The core will remain covered for a given break provided the flow rate from the make-up systems (RCIC, cycled condensate and feedwater) exceed the leak rate through the break. However, because shutdown following a break will take a substantial length of time, credit for the feedwater system is limited to (1) the capacity of the transfer pump supplying water from the condensate storage tanks to the feedwater system (2) RCIC pump and (3) the cycled condensate make-up pump.

PSI Ref. No. RPV-4
Page 1 of 4
3-7-79

With the above consideration, the pipe size for which examination is not required is that size which will leak at a rate just equal to the combined flow rates of the RCIC, condensate make-up, and transfer pumps.

LaSalle Unit 1 Leakage Analysis

1. Normal Make-Up Calculation:

1 RCIC pump @ 625 gpm	625 gpm
1 Cycled condensate make-up pump @ 450 gpm	450 gpm
1 Cycled condensate transfer pump @ 500 gpm	500 gpm
Total Make-Up	1575 gpm

2. Maximum Break Size Calculation for H_2O:

2.1 Leakage rate at 1000 psi for H_2O = 8000 lbs/sec/ft^2

2.2 H_2O = 8.33 lbs/gal

2.3 Leakage rate in gpm/in^2

$$\frac{8000 \text{ lbs/sec/ft}^2}{8.33 \text{ lbs/gal}} \times \frac{60 \text{ sec/min}}{\text{sec}} \times \frac{1}{\text{ft}^2 \times 144 \text{ in}^2/\text{ft}^2}$$

$$= 400 \text{ gpm/in}^2$$

2.4 Maximum area (in^2) leakage that can be handled by normal make-up of 1575 gpm:

$$\frac{1575 \text{ gpm}}{400 \text{ gpm/in}^2} = 3.94 \text{ in}^2 \text{ } H_2O$$ 3.9375"

2.5 Pipe size calculation - H_2O:

$$\frac{\pi D^2}{4} = \text{pipe area}$$

$$\frac{\pi D^2}{4} = 3.94 \text{ in}^2$$

$$D^2 = 5.02 \text{ in}^2$$

$$D = 2.23" \text{ in diameter}$$

3. Maximum Break Size Calculation for Steam:

3.1 Leakage rate at 1000 psi for steam = 2000 lbs/sec/ft^2

3.2 H_2O = 8.33 lbs/gal

3.3 Leakage rate in gpm/in^2:

$$\frac{2000 \text{ lbs/sec/ft}^2}{8.33 \text{ lbs/gal}} \times \frac{60 \text{ sec/min}}{\text{sec}} \times \frac{1}{\text{ft}^2 \times 144 \text{ in}^2/\text{ft}}$$

$$= 100 \text{ gpm/in}^2$$

3.4 Maximum area (in^2) leakage that can be handled by normal make-up of 1575 gpm:

$$\frac{1575 \text{ gpm}}{100 \text{ gpm/in}^2} = 15.75 \text{ in}^2 \text{ steam}$$

3.5 Pipe size calculation - steam:

$$\frac{\pi D^2}{4} = \text{pipe area}$$

$$\frac{\pi D^2}{4} = 15.75 \text{ in}^2$$

$$D^2 = 20.05 \text{ in}^2$$

$$D = 4.47'' \text{ in diameter}$$

Condensate Storage Tanks = 550,000 gallons

For a break 5.02 inches^2 at a leak rate of 1575 gpm, 318,150 gallons of make up water is required for 202 minutes, the time needed to cool down from 545°F to 210°F at a rate of 100°F per hour. The LaSalle County Station Unit 1 system has over 550,000 gallons in the condensate storage tanks alone.

If you have any questions or comments, please don't hesitate to call or write.

Sincerely yours,

R. C. Hooper
LaSalle Units 1&2
Site Project Supervisor
Central Region NSO

ak

cc: N. R. Casey GE, Oak Brook
R. H. Holyoak CECo, LaSalle
D. W. Zebrauskas CECo, LaSalle
J. Groth CECo, LaSalle

3-7-79

Client: Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site: La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit: (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 0817

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	G3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			KZ 10/5/78		
FIT-UP AND/OR ALIGNMENT	✓			KZ 10/5/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			KZ 10/5/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			KZ 10/5/78		
NDE OF ROOT:			X			
						Reviewed - pages 1 thru 55 W.J. Caldwell ANSI 3-13-81
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			BW Level II 10/9/78		PE-1 Rev. 5
Visual Exam	✓			BW Level II 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS			X	PSI	Ref. No.	RPV-8 Page 1 of 55
POST WELD CLEANLINESS	✓			BW 10/9/78		

RCI QC 10/9/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 0825

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue		
1	11/2/77	Changed per G.E. comments		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	93-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RZ 10/4/78		
FIT-UP AND/OR ALIGNMENT	✓			RZ 10/4/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RZ 10/4/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RZ 10/4/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II BW. 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II BW. 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X			
POST WELD CLEANLINESS	✓			BW. 10/9/78		

QC APPROVED 10/17/78

PSI Ref. No. RPV-8

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 0833

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	93-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RL 10/4/78		
FIT-UP AND/OR ALIGNMENT	✓			RL 10/4/78		SW-1 △1 Rev.0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RL 10/4/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RL 10/4/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II B.W. 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II B.W. 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	RPV-8 10/17/78
						Page 3 of 55
POST WELD CLEANLINESS	✓			B.W. 10/9/78		

N.C.L.Q.C. APPROVAL 10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 0841

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			SLL 10/7/78		
FIT-UP AND/OR ALIGNMENT	✓			SLL 10/7/78		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			SLL 10/7/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			SLL 10/7/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II BW. 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II BW. 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	RPV-8
						Page 4 of 55
POST WELD CLEANLINESS	✓			BW. 10/9/78		

ATLG APPROVAL SMITH 10/9/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 0849

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RR 10/2/78		
FIT-UP AND/OR ALIGNMENT	✓			RR 10/2/78		SW-1 △1 Rev.0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RR 10/2/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RR 10/2/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			BW Level II 10/9/78		PE-1 Rev. 5
Visual Exam	✓			BW Level II 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	RPV-8 10/17/78
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POST WELD CLEANLINESS	✓			BW 10/9/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1609

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue		
1	11/2/77	Changed per G.E. comments		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Ø3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	B	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			10/5/78		
FIT-UP AND/OR ALIGNMENT	✓			10/5/78		SW-1 1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			10/5/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			10/5/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	RPV-8
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POST WELD CLEANLINESS	✓			10/9/78		

10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1613

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			KR 10/5/78		
FIT-UP AND/OR ALIGNMENT	✓			KR 10/5/78		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			KR 10/5/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			KR 10/5/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II EW 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II EW 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.		RPV-8
POST WELD CLEANLINESS	✓			EW 10/9/78		

RCI QC 10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1617

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	93-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RL 10/5/78		
FIT-UP AND/OR ALIGNMENT	✓			RL 10/5/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RL 10/5/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RL 10/5/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II BW. 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II BW. 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.		RPV-8
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POST WELD CLEANLINESS	✓			BW. 10/9/78		

RCI QC APPROVED 10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1621

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per C.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RZ 10/4/78		
FIT-UP AND/OR ALIGNMENT	✓			RZ 10/4/78		SW-1 (1) Rev. C
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RZ 10/4/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE						
NDE OF ROOT:			X			
	✓			RZ 10/4/78		
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			BW Level II 10/9/78		PE-1 Rev. 5
Visual Exam	✓			BW Level II 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No 1	RPV-8
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POST WELD CLEANLINESS	✓			BW 10/9/78		

10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1625

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JDZ 10/4/78		
FIT-UP AND/OR ALIGNMENT	✓			JDZ 10/4/78		SW-1 /1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JDZ 10/4/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JDZ 10/4/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II BW 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II BW 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X			
POST WELD CLEANLINESS	✓			BW 10/9/78		

PSI Ref. No. RPV-8 10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1633

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	93-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER-308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			SLD 10/4/78		
FIT-UP AND/OR ALIGNMENT	✓			SLD 10/4/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			SLD 10/4/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			SLD 10/4/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Seal I BW. 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Seal II BW. 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PS. Ref. No		RPV-8 10/12/78
POST WELD CLEANLINESS	✓			B.W. 10/9/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1641

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	03-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			SDR 10/3/78		
FIT-UP AND/OR ALIGNMENT	✓			SDR 10/3/78		SW-1 /1\ Rev. C
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			SDR 10/3/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			SDR 10/3/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II BW. 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II BW. 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS			X			
POST WELD CLEANLINESS	✓			BW. 10/9/78		

CLCC APPROVED K. SMITH 10/13/78

PSI Ref. No. RPV-8

FOR RESOLUTION OF DEFICIENCIES – COMPLETE BACK SIDE OF SHEET

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1645

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JLL 10/9/78		
FIT-UP AND/OR ALIGNMENT	✓			JLL 10/9/78		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JLL 10/9/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JLL 10/9/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II BW. 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II BW. 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	RPV-8
POST WELD CLEANLINESS	✓			BW. 10/9/78		

RCI-QC APPROVED R. POYNTER SMITH 10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1649

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	83-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 59	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			SJV 10/3/78		
FIT-UP AND/OR ALIGNMENT	✓					SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JJL 10/7/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JJL 10/7/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			BW Level II 10/19/78		PE-1 Rev. 5
Visual Exam	✓			BW Level II 10/19/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8 Page 14 of 78
POST WELD CLEANLINESS	✓			BW. 10/9/78		

RECEIVED 10/24/78 SMITH

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1653

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	~~3/32~~	~~741106~~	SANDVIK
			1/16	760105	

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RZ 10/2/78		
FIT-UP AND/OR ALIGNMENT	✓			RZ 10/2/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RZ 10/2/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RZ 10/2/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II BW 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II BW 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	RPV-8 10/12/78
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POST WELD CLEANLINESS	✓			BW 10/9/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 1657

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	G3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16"	~~741101~~	SANDVIK
			1/16	760105	

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			10/2/78 [illegible]		
FIT-UP AND/OR ALIGNMENT	✓			10/2/78 [illegible]		SW-1 /1\ Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 10/2/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			10/2/78 [illegible]		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II [illegible] 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II [illegible] 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8
POST WELD CLEANLINESS	✓			[illegible] 10/9/78		

RCI-QC [illegible] SMITH 10/10/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2409

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308L	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 9/29/78		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 9/29/78		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 9/29/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			[illegible] 9/29/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/10/78 level II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/10/78 level II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.		RPV-8
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POST WELD CLEANLINESS	✓			[illegible] 10/10/78		

10/17/78

Client: Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site: La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit: 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2417

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
519	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
E308	SFA5.9	ER308	1/16	76.0105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RL 10/9/78		
FIT-UP AND/OR ALIGNMENT	✓			RL 10/9/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RL 10/9/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RL 10/9/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/10/78 Level II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/10/78 Level II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	RPV-8
						Page 18 of [illegible]
POST WELD CLEANLINESS	✓			[illegible] 10/10/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2425

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue		
1	11/2/77	Changed per G.E. comments		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RZ 9/21/78		
FIT-UP AND/OR ALIGNMENT	✓			RZ 9/27/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RZ 9/27/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RZ 9/27/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			10/11/78 Lev II		PE-1 Rev. 5
Visual Exam	✓			10/11/78 Lev II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X			
POST WELD CLEANLINESS	✓			10/11/78		

10/12/78

PSI Ref. No. RPV-8

Client: Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site: La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit: 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2429

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308X Weld	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓	✓		RDZ 9/26/78		
FIT-UP AND/OR ALIGNMENT	✓	✓		RDZ 9/26/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RDZ 9/26/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RDZ 9/26/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/6/78 Lev II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/6/78 Lev II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No		RPV-8 10/17/78
POST WELD CLEANLINESS	✓			[illegible] 10/6/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2433

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue		
1	11/2/77	Changed per G.E. comments		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RR 10/10/78		
FIT-UP AND/OR ALIGNMENT	✓			RR 10/10/78		SW-1 1 Rev.0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RR 10/10/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RR 10/10/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			10/11/78		PE-1 Rev. 5
Visual Exam	✓			10/11/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8 10/17/78
POST WELD CLEANLINESS	✓			10/11/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2437

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JCL 10/10/78		
FIT-UP AND/OR ALIGNMENT	✓			JCL 10/10/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JCL 10/10/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JCL 10/10/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] for II 10/11/78		PE-1 Rev. 5
Visual Exam	✓			[illegible] for II 10/11/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8
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POST WELD CLEANLINESS	✓			[illegible] 10/11/78		

[illegible] 10/12/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2441

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JDZ 10/6/78		
FIT-UP AND/OR ALIGNMENT	✓			JDZ 10/6/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JDZ 10/6/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JDZ 10/6/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/11/78 Rev II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/11/78 Rev II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X			
POST WELD CLEANLINESS	✓			[illegible] 10/11/78		

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Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2449

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue		
1	11/2/77	Changed per G.E. comments		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	93-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RR 10/3/78		
FIT-UP AND/OR ALIGNMENT	✓			RR 10/7/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RR 10/3/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RR 10/3/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II BW 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II BW 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No		RPV-8 10/17/78
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POST WELD CLEANLINESS	✓			RR 10/9/78		

Client: Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site: La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit: 1 & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 2457

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	φ3 - 12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	~~1/8~~	~~741106~~	SANDVIK
			1/16	760105	

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			10/2/78 [illegible]		
FIT-UP AND/OR ALIGNMENT	✓			10/2/78 [illegible]		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			10/2/78 [illegible]		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			10/2/78 [illegible]		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II BW 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II BW 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	RPV-8 10/12/78
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POST WELD CLEANLINESS	✓			BW 10/9/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3209

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			KL 10/9/78		
FIT-UP AND/OR ALIGNMENT	✓			KL 10/9/78		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION	✓		X			
PRE-HEAT TEMPERATURE	✓			KL 10/9/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			KL 10/9/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/10/78 Lev II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/10/78 Lev II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8
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POST WELD CLEANLINESS	✓			[illegible] 10/10/78		

[illegible] 10/10/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3217

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RR 9/29/78		
FIT-UP AND/OR ALIGNMENT	✓			RR 9/29/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RR 9/29/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RR 9/29/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/10/78 Lev II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/10/78 Lev II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No		RPV-8
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POST WELD CLEANLINESS	✓			[illegible] 10/10/78		

[illegible] 10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3225

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue		
1	11/2/77	Changed per G.E. comments		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308A	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RZ 9/27/78		
FIT-UP AND/OR ALIGNMENT	✓			RZ 9/27/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RZ 9/27/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RZ 9/27/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/4/78 Lev II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/4/78 Lev II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No		RPV-8
POST WELD CLEANLINESS	✓			[illegible] 10/4/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3229

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue		
1	11/2/77	Changed per G.E. comments		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308X	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			SLZ 9/26/78		
FIT-UP AND/OR ALIGNMENT	✓			SLZ 9/26/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			SLZ 9/26/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			SLZ 9/26/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/11/78 Level II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/11/78 Level II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8
POST WELD CLEANLINESS	✓			[illegible] 10/11/78		

10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3233

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue		
1	11/2/77	Changed per G.E. comments		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JLZ 9/21/78		
FIT-UP AND/OR ALIGNMENT	✓			JLZ 9/25/78		SW-1 /1\ Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JLZ 9/21/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JLZ 9/25/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			10/6/78		PE-1 Rev. 5
Visual Exam	✓			10/6/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No		RPV-8
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POST WELD CLEANLINESS	✓			10/11/78		

RCI QC APPROVAL 10/12/78

Client: Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - 335 SHEET 1 OF 1
Site: La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit: 1 & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3237

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	John Miles	L.P. Gen
1	11/2/77	Changed per G.E. comments	John Miles	RK Cunningham

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308L	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JVZ 10/10/78		
FIT-UP AND/OR ALIGNMENT	✓			RK 10/10/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RK 10/10/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RK 10/10/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Rev II 10/11/78		PE-1 Rev. 5
Visual Exam	✓			Rev II 10/11/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8
POST WELD CLEANLINESS	✓			10/11/78		

RCI-QC SMITH 10/11/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3341

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue		
1	11/2/77	Changed per G.E. comments		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JLZ 10/9/78		
FIT-UP AND/OR ALIGNMENT	✓			JLZ 10/9/78		SW-1 △1 Rev.0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JLZ 10/9/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JLZ 10/9/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			LLD Level II 10/11/78		PE-1 Rev. 5
Visual Exam	✓			LLD Level II 10/11/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.		RPV-8
POST WELD CLEANLINESS	✓			LLD 10/11/78		

APPROVED 10/12/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS - 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3249

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	76010S	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			SLL 10/7/78		
FIT-UP AND/OR ALIGNMENT	✓			SLL 10/7/78		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			SLL 10/7/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			SLL 10/7/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			B.W. 10/9/78 Level II		PE-1 Rev. 5
Visual Exam	✓			B.W. 10/9/78 Level II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No		RPV-8
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POST WELD CLEANLINESS	✓			B.W. 10/9/78		

QC DATA SHEET APPROVAL 10/12/78

Client: Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site: La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit: 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 3257

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER308	1/8	~~741106~~	SANDVIK
			1/16	760105	

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JLL 10/2/78		
FIT-UP AND/OR ALIGNMENT	✓			JLL 10/2/78		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JLL 10/2/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JLL 10/2/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II BW 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II BW 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8
POST WELD CLEANLINESS	✓			BW 10/9/78		

APPROVAL 10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4017

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308L	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RL 9/28/78		
FIT-UP AND/OR ALIGNMENT	✓			RL 9/28/78		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RL 9/28/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RL 9/28/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/10/78		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/10/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8
POST WELD CLEANLINESS	✓			[illegible] 10/10/78		

[illegible] 10/17/78

Client: Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site: La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4021

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 9/27/78		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 9/27/78		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 9/27/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			[illegible] 9/27/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/1/78 Lev II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/1/78 Lev II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8
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POST WELD CLEANLINESS	✓			[illegible] 10/1/78		

[illegible] 10/5/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4025

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE WELD CLEANLINESS	✓			RZ 9/27/78		
FIT-UP AND/OR ALIGNMENT	✓			RZ 9/27/78		SW-1 1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RZ 9/27/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RZ 9/27/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/10/78 Level II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/10/78 Level II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.		RPV-8 10/17/78
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POST WELD CLEANLINESS	✓			[illegible] 10/11/78		

FOR RESOLUTION OF REJECTIONS – COMPLETE BACK SIDE OF SHEET

Client Commonwealth Edison Co	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4033

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	7L0105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓		✓	JLL 9/25/78		
FIT-UP AND/OR ALIGNMENT	✓			JLL 9/25/78		SW-1 (1) Rev 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JLL 9/25/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JLL 9/25/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/4/78 Lvl II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/4/78 Lvl II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X			
POST WELD CLEANLINESS	✓			[illegible] 10/4/78		

PSI Ref. No

RPV-8 10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4041

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue		
1	11/2/77	Changed per G.E. comments		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JLZ 10/9/78		
FIT-UP AND/OR ALIGNMENT	✓			JLZ 10/9/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JLZ 10/9/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JLZ 10/9/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			LEVEL II 10/11/78		PE-1 Rev. 5
Visual Exam	✓			LEVEL II 10/11/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	RPV-8 10/17/78
POST WELD CLEANLINESS	✓			10/11/78		

Client: Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site: La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit: 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4045

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JLR 10/6/78		
FIT-UP AND/OR ALIGNMENT	✓			JLR 10/6/78		SW-1 △1 Rev. C
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JLR 10/6/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JLR 10/6/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/16/78		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/16/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No		RPV-8 10/17/78
POST WELD CLEANLINESS	✓			[illegible] 10/16/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4049

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-19	Ø3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	1/16	760105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 10/7/78		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 10/7/78		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 10/7/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			[illegible] 10/7/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/9/78 final I		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/9/78 final II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	RPV-8
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POST WELD CLEANLINESS	✓			[illegible] 10/9/78		

RCI-QC APPROVED SMITH 10/12/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4057

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
9-19	Q3-12	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER 308	SFA 5.9	ER 308	~~3/8~~	~~741106~~	SANDVIK
			1/16	760105	

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 10/2/78		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 10/2/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 10/2/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			[illegible] 10/2/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Level II [illegible] 10/9/78		PE-1 Rev. 5
Visual Exam	✓			Level II [illegible] 10/9/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8
POST WELD CLEANLINESS	✓			[illegible] 10/9/78		

R.T.S. APPROVAL 10/12/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 486

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	93-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			SLR 10/10/78		
FIT-UP AND/OR ALIGNMENT	✓			SLR 10/10/78		SW-1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			SLR 10/10/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			SLR 10/10/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] Lev II		PE-1 Rev. 5
Visual Exam	✓			[illegible] Lev II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. NO	RPV-8
			—			Page 44 of 55
POST WELD CLEANLINESS	✓			[illegible]		

10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4813

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
819	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	1/16	76D105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			KL 9/29/78		
FIT-UP AND/OR ALIGNMENT	✓			KL 9/29/78		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			KL 9/29/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			KL 9/29/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/11/78 Level II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/11/78 Level II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8
POST WELD CLEANLINESS	✓			[illegible] 10/11/78		

QC APPROVED 10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4817

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-16	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			RR 9/29/78		
FIT-UP AND/OR ALIGNMENT	✓			RR 9/29/78		SW-1 (1) Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			RR 9/29/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			RR 9/29/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/4/78 Level II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/4/78 Level II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8 10/7/78
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POST WELD CLEANLINESS	✓			[illegible] 10/4/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4825

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue		
1	11/2/77	Changed per G.E. comments		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308X	1/16	761105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			KZ 9/27/78		
FIT-UP AND/OR ALIGNMENT	✓			KZ 9/27/78		SW-1 1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			KZ 9/27/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			KZ 9/27/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible]		PE-1 Rev. 5
Visual Exam	✓			[illegible]		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PS	Ref. No	RPV-8 10/17/78
POST WELD CLEANLINESS	✓			[illegible] 10/11/78		

Client *Commonwealth Edison Co.* Site *La Salle County Station* Unit *1 & 2*	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – *335* SHEET *1* OF *1* ☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER

WELD DESCRIPTION: *Incore Housing to Guide Tube* LOCATION: *4833*

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue		
1	11/2/77	Changed per G.E. comments		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
1519	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	B	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			KS 9/25/78		
FIT-UP AND/OR ALIGNMENT	✓			KS 9/25/78		SW-1 △1 Rev 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			KS 9/25/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			KS 9/25/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/1/78 Level II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/1/78 Level II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	RPV-8
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POST WELD CLEANLINESS	✓			[illegible] 10/1/78		

10/13/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4841

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JCR 10/9/78		
FIT-UP AND/OR ALIGNMENT	✓			JCR 10/9/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JCR 10/9/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JCR 10/9/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/11/78		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/11/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8 10/17/78
POST WELD CLEANLINESS	✓			[illegible] 10/11/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4849

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	P3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JDZ 10/6/78		
FIT-UP AND/OR ALIGNMENT	✓			JDZ 10/6/78		SW-1 1 Rev.0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JDZ 10/6/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JDZ 10/6/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			LEVEL II 10/11/78		PE-1 Rev. 5
Visual Exam	✓			LEVEL II 10/11/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.		RPV-8
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POST WELD CLEANLINESS	✓			LEVEL II 10/11/78		

RCI QC SMITH 10/11/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 4853

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308X	1/16	760105	Sandvik

WELDING CHECK POINTS	A	B	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 10/6/78		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 10/6/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 10/6/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			[illegible] 10/6/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] Lev II 10/11/78		PE-1 Rev. 5
Visual Exam	✓			[illegible] Lev II 10/11/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No.	RPV-8 10/17/78
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POST WELD CLEANLINESS	✓			[illegible] 10/11/78		

RCI QC APPROVAL

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 5617

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
819	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			JKD 10/9/78		
FIT-UP AND/OR ALIGNMENT	✓			JKD 10/9/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			JKD 10/9/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			JKD 10/9/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			Lev II 10/10/78		PE-1 Rev. 5
Visual Exam	✓			Lev II 10/10/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No		RPV-8
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POST WELD CLEANLINESS	✓			JKD 10/10/78		

ACCEPTED APPROVAL SMITH 10/17/78

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 5625

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	93-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 9/27/78		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 9/27/78		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 9/27/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			[illegible] 9/27/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/11/78 Lvl II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/11/78 Lvl II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No		RPV-8 10/17/78
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POST WELD CLEANLINESS	✓			[illegible] 10/11/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 5633

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308	1/16	760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 9/25/79		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 9/25/79		SW-1 △1 Rev. 0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 9/25/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			[illegible] 9/25/79		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 10/1/78 Lev II		PE-1 Rev. 5
Visual Exam	✓			[illegible] 10/1/78 Lev II		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8 10/17/78
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POST WELD CLEANLINESS	✓			[illegible] 10/1/78		

N.L.O. APPROVAL

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 335 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & ~~2~~		

WELD DESCRIPTION: Incore Housing to Guide Tube LOCATION: 5641

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	10/7/77	Initial Issue	[illegible]	[illegible]
1	11/2/77	Changed per G.E. comments	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B19	Q3-12	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308X	1/16	76010	all

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 10/10/78		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 10/10/78		SW-1 △1 Rev.0
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 10/10/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			[illegible] 10/10/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] Lev II 10/11/78		PE-1 Rev. 5
Visual Exam	✓			[illegible] Lev II 10/11/78		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI	Ref. No	RPV-8 10/11/78
						Page 55 of 55
POST WELD CLEANLINESS	✓			[illegible] 10/11/78		

APPROVAL

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 312 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Upper Pipe to Adapter (dp/LC Line) LOCATION: UNIT I

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	6/23/77	Initial Issue	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
P5	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA 5.9	ER308	3/32 T 1/16	481771 + 760105	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 2/22/78		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 2/22/78		Removed pages 1 thru 6
INSERT INSTALLATION						W J Caldwell ANII
BACKING RING INSTALLATION			X			3-13-81
PRE-HEAT TEMPERATURE	✓			[illegible] 2/22/78		
PRE-PURGE	✓			[illegible] 2/22/78		
PURGE	✓			[illegible] 2/22/78		
INTERPASS TEMPERATURE	✓			[illegible] 2/22/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
					PSI	Ref. No. RPV-9
						Page 1 of 6
NDE FINAL:						PT REPORT # 162-164
Penetrant Exam	✓			[illegible] 2/22/78	Level II	PE-1 Rev. 3
Visual Exam	✓			[illegible] 2/22/78	Level II	VE-1 Rev. 2
Radiography Exam		–		[illegible] 2/23/78	QC Hold #35 + 37	RE-1 Rev. 1
SPECIAL REQUIREMENTS:			X			See WDS-312 ACT for Completed weld.
POST WELD CLEANLINESS	✓			[illegible] 2/22/78		

R.C.I. QC APPROVAL PS H. Fr... 11/16/79

FOR RESOLUTION OF REJECTIONS – COMPLETE BACK SIDE OF SHEET

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 312/Alt SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1		

WELD DESCRIPTION: Upper Pipe to Adapter (dp/LC Line) LOCATION: UNIT I

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	2/27/78	Initial Issue	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
P-4	G3-11	n/a	n/a	ALL
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308L HP	3/32	481771	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			LKD 4/11/78		
FIT-UP AND/OR ALIGNMENT	✓			LKD 4/11/78		
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			LKD 4/11/78		
PRE-PURGE	✓			LKD 4/11/78		
PURGE	✓			LKD 4/11/78		
INTERPASS TEMPERATURE	✓			LKD 4/11/78		
NDE OF ROOT:			X			RCI-QA-QC APPROVAL 4/18/78
NDE INTERMEDIATE:			X			
					PSI Ref. No - RPV-9	
						Page 2 of 6
NDE FINAL:						
Visual Exam	✓			B.W. 4/14/78 Lev II		VE-1 Rev. 2
Penetrant Exam	✓			B.W. 4/14/78 Lev II		PE-1 Rev. 3
Radiography Exam	✓			4/12/78 LEVEL II		RE-1 Rev. 1
SPECIAL REQUIREMENTS:			X			RI REPORT # 174
POST WELD CLEANLINESS	✓			B.W. 4/14/78		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 318 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit ① & 2		

WELD DESCRIPTION: dp Line to Adapter Elbow LOCATION:

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	6/21/77	Initial Issue	[illegible]	RCW/[illegible]
1	6/24/77	Added Radiography Exam	[illegible]	[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
P4	Q3-12	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308L	SFA 5.9	ER308	1/16	76-0105	SANDVIK

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 2/22/78		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 2/22/78		
INSERT INSTALLATION	✓			[illegible] 2/22/78		
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 2/22/78		
PRE-PURGE	✓			[illegible] 2/22/78		
PURGE	✓			[illegible] 2/22/78		
INTERPASS TEMPERATURE	✓			[illegible] 2/22/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
					PSI	Ref. No. RPV-9
NDE FINAL:						Page 3 of 6
Penetrant Exam	✓			[illegible] 2/22/78 Level II		PE-1 Rev. 3
Visual Exam	✓			[illegible] 2/22/78 Level II		VE-1 Rev. 2
Radiography Exam		✓		[illegible] 2/23/78 Level II	See QC Log #36	RE-1 Rev. 1
SPECIAL REQUIREMENTS:			X			* See back of sheet for
						Corrective Action.
POST WELD CLEANLINESS	✓			[illegible] 2/22/78		RT Report #160

R.C.I.-Q.C. APPROVED H. PHILLIPS 10/10/79

FOR RESOLUTION OF REJECTIONS – COMPLETE BACK SIDE OF SHEET

RESOLUTION OF REJECTION

REASON FOR REJECTION	Incomplete Insert melt approximately 1/4" long at location marker #1

ACTION TAKEN		ACCEPTABLE	
LIST STEPS TAKEN TO RESOLVE REJECTION	PER DOC.	DATE	INITIAL
1. Grind down to root in unconsumed area	QC Hold #36	2/23/78	ACC [illegible]
2. Re-pull unconsumed insert	QC Hold #36	2/23/78	ACC [illegible]
3. Penetrant inspect re-pulled area	PE-1 Rev 3	2/23/78	ACC [illegible] Level II
4. Reweld area to completion	W15 318	2/23/78	ACC [illegible]
5. Penetrant Inspect final weld	PE-1 Rev 3	2/23/78	ACC [illegible] Level II
6. Radiograph final weld RT REPORT #163	RE-1 Rev 1	2/24/78	Acc [illegible] Level II
* Repair welder was S. Rexroat, P-4.			
Filler Material was ER308, SFA5.9 1/16" HT# 760105 manufactured by Sandvik. [illegible] QC Supervisor			

COMMENTS

PSI Ref. No. RPV-9

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 319 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & ~~2~~		

WELD DESCRIPTION: Cap to dp Line LOCATION: N/A

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	6/21/77	Initial Issue	[illegible]	RCW/[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
P4	Q.2 11	n/a	n/a	all
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
ER308	SFA5.9	ER308 LHP	3/32	431771	Sandvik

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 8/14/78		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 8/14/78		
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 8/14/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			[illegible] 8/14/78		
NDE OF ROOT:			X			RCI-QC APPROVAL H. Phillips 10/16/79
NDE INTERMEDIATE:			X			
NDE FINAL:						PSI Ref. No. RPV-9 Page 5 of 6
Penetrant Exam	✓			[illegible] Level II 4/4/79		PE-1 Rev. 5
Visual Exam	✓			[illegible] Level II 4/4/79		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X			
POST WELD CLEANLINESS	✓			[illegible] 4/4/79		

Client: Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 506-1 SHEET 1 OF 1
Site: La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit: 1		

WELD DESCRIPTION: Adapter to RPV Pen. Socket LOCATION: N/A

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	6/20/77	Initial Issue	[illegible]	RCW/[illegible]

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
P4	443/43 CT	n/a	n/a	All
		n/a	n/a	
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
Inco 82	SFA 5.14	ERNICR-3	3/3	NX8742D	Huntington

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 8/21/78		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 8/21/78		
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 8/21/78		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			[illegible] 8/21/78		
NDE OF ROOT:			X			
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 4/4/79		PE-1 Rev. 5
Visual Exam	✓			[illegible] 4/4/79		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X		PSI	Ref. No. RPV-9
						Page 6 of 6
POST WELD CLEANLINESS	✓			[illegible] 4/4/79		

N.C.I.-Q.C. APPROVAL 4/26/79

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 503 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit (1) & 2		

WELD DESCRIPTION: Backing Ring to Shroud LOCATION: N/A

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	3/18/77	Initial Issue	[illegible]	[illegible]
		Iri, f #1		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-1, B-6	Q43/43OTS-1	n/a	n/a	All
B-7, B-9	Q43/43OTS-1	n/a	n/a	All
		n/a	n/a	

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
Inco 82T	SFA5.14	ERNiCr-3	3/32"	NX8742D	Huntington

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			[illegible] 7/27/77		
FIT-UP AND/OR ALIGNMENT	✓			[illegible] 7/27/77		
INSERT INSTALLATION			X			
BACKING RING INSTALLATION			X			
PRE-HEAT TEMPERATURE	✓			[illegible] 7/27/77		
PRE-PURGE			X			
PURGE			X			Revised pages 1 + 2 w J Caldwell ANII 3-13-81
INTERPASS TEMPERATURE	✓			[illegible] 7/27/77		
NDE OF ROOT:			X			
						R.C.I.-QC APPROVED H PHILLIPS 10/18/77
NDE INTERMEDIATE:			X			
NDE FINAL:						
Penetrant Exam	✓			[illegible] 8/1/77		PE-1 Rev. 2
Visual Exam	✓			[illegible] LEVEL III 8/1/77		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PSI Ref. No.		RPV-10 Page 1 of 2
POST WELD CLEANLINESS	✓			[illegible] 8/1/77		

Client Commonwealth Edison Co.	Reactor Controls, Inc. Production Weld QC Data Sheet	WDS – 504 SHEET 1 OF 1
Site La Salle County Station		☒ RPV INTERNALS ☐ CRD SYSTEM ☐ OTHER
Unit 1 & 2		

WELD DESCRIPTION: Shroud to Shroud Support Ring LOCATION: N/A

REV	DATE	REVISION	ENGR. APPROVED	Q. A. APPROVED
0	3/21/77	Initial Issue	J. Williams	R. C. Wolstenstein
		Rev #1		

WELDER IDENT.	PERFORMANCE QUALIFICATION	MOCK-UP QUALIFICATION (IF REQUIRED)	RESTRICTIVE QUALIFICATION (IF REQUIRED)	PORTION OF WELD COMPLETED
B-1, B-7	Q43/43OTS-1	n/a	n/a	ALL
B-6, B-9	Q43/43OTS-1	n/a	n/a	ALL
B-10	Q43/43OTS-1	n/a	n/a	SMAW ONLY

FILLER MATERIAL	SPECIFICATION	CLASSIFICATION	SIZE	HEAT/LOT NUMBER	MANUFACTURER
Inco 82T	SFA5.14	ERNiCr3	3/32"	NX8742D	Huntington
Inco 182T	SFA5.11	ENiCrFe-3	5/32"	CONT 4725, 4850	Huntington
Inco 182T	SFA5.11	ENiCrFe-3	1/8"	CONT 1223	Huntington

WELDING CHECK POINTS	A	R	N/A	Q.C. INSP.	AUTH. INSP.	COMMENTS
PRE-WELD CLEANLINESS	✓			8/3/77		
FIT-UP AND/OR ALIGNMENT	✓			8/3/77		
INSERT INSTALLATION			X			
BACKING RING INSTALLATION	✓			8/3/77		
PRE-HEAT TEMPERATURE	✓			8/3/77		
PRE-PURGE			X			
PURGE			X			
INTERPASS TEMPERATURE	✓			8/3/77		
NDE OF ROOT:						
Penetrant Exam @	✓			8/8/77 LEVEL II		PF-1 Rev. 2
change of process						
NDE INTERMEDIATE:						
Penetrant Exam/½T	✓			8/19/77 LEVEL II		PE-1 Rev. 3
NDE FINAL:						
Penetrant Exam	✓			W. Nemeth Level II 9/19/77 MT Level II 9/19/77		PE-1 Rev. 3
Visual Exam	✓			W. Nemeth 9/20/77		VE-1 Rev. 2
SPECIAL REQUIREMENTS:			X	PS	Ref. No	RPV-10 Page 2 of 2 9/20/77
POST WELD CLEANLINESS	✓			W. Nemeth 9/20/77		

12.2 PIPING, PUMP AND VALVE COMPONENTS

12.2.5 PUMP & VALVE INTERNAL CONSTRUCTION DATA SHEETS

DESCRIPTION	TAB	PUMP OR VALVE NO.	PSI REF. NO.
FW - Feedwater System Valve	27	1B21-F010A	FWV-1
		1B21-F010B	FWV-2
		1B21-F011A	FWV-3
		1B21-F011B	FWV-4
		1B21-F032A	FWV-5
		1B21-F032B	FWV-6
HP - High Pressure Core Spray System Valve	28	1E22-F004	HPV-1
		1E22-F005	HPV-2
		1E22-F038	HPV-3
LP - Low Pressure Core Spray System Valve	29	1E21-F005	LPV-1
		1E21-F006	LPV-2
		1E21-F051	LPV-3
MS - Main Steam System Valve	30	1B21-F013A	MSV-1
		1B21-F013B	MSV-2
		1B21-F013C	MSV-3
		1B21-F013D	MSV-4
		1B21-F013E	MSV-5
		1B21-F013F	MSV-6
		1B21-F013G	MSV-7
		1B21-F013H	MSV-8
		1B21-F013J	MSV-9
		1B21-F013K	MSV-10
		1B21-F013L	MSV-11
		1B21-F013M	MSV-12
		1B21-F013N	MSV-13
		1B21-F013P	MSV-14
		1B21-F013R	MSV-15
		1B21-F013S	MSV-16
		1B21-F013U	MSV-17
		1B21-F013V	MSV-18
		1B21-F022A	MSV-19
		1B21-F022B	MSV-20
		1B21-F022C	MSV-21
		1B21-F022D	MSV-22
		1B21-F028A	MSV-23
		1B21-F028B	MSV-24
		1B21-F028C	MSV-25
		1B21-F028D	MSV-26
RH - Residual Heat Removal System Valve	31	1E12-F008	RHV-1
		1E12-F009	RHV-2
		1E12-F019	RHV-3
		1E12-F020	RHV-4

12.2 PIPING, PUMP AND VALVE COMPONENTS

12.2.5 Pump & Valve Internal Construction Data Sheets (Cont'd)

DESCRIPTION	TAB	PUMP OR VALVE NO.	PSI REF. NO.
RH - Residual Heat Removal System Valve (Continued)	31	1E12-F023	RHV-5
		1E12-F041A	RHV-6
		1E12-F041B	RHV-7
		1E12-F041C	RHV-8
		1E12-F042A	RHV-9
		1E12-F042B	RHV-10
		1E12-F042C	RHV-11
		1E12-F050A	RHV-12
		1E12-F050B	RHV-13
		1E12-F053A	RHV-14
		1E12-F053B	RHV-15
		1E12-F090A	RHV-16
		1E12-F090B	RHV-17
		1E12-F092A	RHV-18
		1E12-F092B	RHV-19
		1E12-F092C	RHV-20
RI - Reactor Core Isolation Cooling System Valve	32	1E51-F013	RIV-1
		1E51-F063	RIV-2
		1E51-F064	RIV-3
		1E51-F065	RIV-4
		1E51-F066	RIV-5
RR - Reactor Recirculation System Pump	33	1B33-C001A	RRP-1
		1B33-C001B	RRP-2
RR - Reactor Recirculation System Valve	34	1B33-F023A	RRV-1
		1B33-FC23B	RRV-2
		1B33-F060A	RRV-3
		1B33-F060B	RRV-4
		1B33-F067A	RRV-5
		1B33-F067B	RRV-6
RT - Reactor Water Clean Up System Valve	35	1G33-F001	RTV-1
		1G33-F004	RTV-2
		1G33-F012	RTV-3

GENERAL ELECTRIC

INSTALLATION & SERVICE ENGINEERING DIVISION

LIQUID PENETRANT EXAMINATION DATA SHEET

LASALLE COUNTY NUCLEAR STATION UNIT 1

E.D.S. NO. 77596

A. PROCEDURE NO. PP-S751 REV. 7

EXAMINATION PERSONNEL:

NAME C A Homler LEVEL II

NAME N/A LEVEL N/A

C. PENETRANT MATERIALS:

a. MANUFACTURER MAGNAFLUX-SPOTCHECK

b. PRE-CLEANING SOLVENT TYPE SKC-S BATCH NO. 79C014

c. PENETRANT TYPE SKL-HF /SKL-S BATCH NO. 79B109

d. PENETRANT REMOVER TYPE SKC-S BATCH NO. 79C014

e. DEVELOPER TYPE SKD-S BATCH NO. 79E033

f. POST EXAMINATION CLEANER TYPE SKC-S BATCH NO. 79C014

D. PRE-EXAMINATION REQUIREMENTS:

a. TEMPERATURE:

1. PENETRANT MATERIALS BETWEEN 60° F & 125° F - YES ☒ NO ☐
2. COMPONENT SURFACE BETWEEN 60° F & 125° F - YES ☒ NO ☐

b. SURFACE PREPARATION:

*1. GRINDING (*2.) FLAPPERING *3. NONE *4. OTHER

E. DATA: NOTE: All Exam components are ASME Sect. XI Category. CF

00 LINE NO.	01 DATE 1981	02 PRE-CLEAN EVAP. TIME	03 PEN. DWELL TIME	04 PEN. REM. EVAP. TIME	05 DEV. TIME	06 EXAMINATION COMPONENT I.D. NO.	07 MAT'L	08 SURF. PREP. *	RELEVANT INDICATION YES 09	RELEVANT INDICATION NO 10	ACCEPTABLE YES 11	ACCEPTABLE NO 12	13 RELEVANT INDICATION LOCATION/SIZE OR COMMENTS
1	2-19	5	10	5	15	1R1-1014-7	CS	2	X		X		9/64" RO IND-90° FROM V-SURF 1 TOE
2													
3													
4													
5													
6													
7													
8													
9													
10													
11													
12													
13													
14													
15													

NOTE: FOR EACH EXAM COMPONENT ID NO., PLACE THE APPLICABLE NUMBER(s) (1,2,3 etc) IN ITS APPROPRIATE COLUMN.

REVIEWED BY: NDE SUPERVISOR S D Connelly DATE 2/20/81

QC SUPERVISOR L D Whatley DATE 2/20/81

AUTHORIZED INSPECTOR W J Catherwood DATE 2-23-81

NUCLEAR ENERGY SERVICES, INC.
CONAM INSPECTION DIVISION
P. O. Box 160
Grand Ridge, Illinois 61325

REPORT OF NONDESTRUCTIVE EXAMINATION

TYPE OF EXAMINATION: MT ☒ PT ☐

Customer: COMMONWEALTH EDISON COMPANY	Project: LaSalle Station		Date: 3/1/78
Contractor: MCCO	Job No.: 2466	P. O. No.: —	Report No. – Request No.: 1836 - MT8 - 030
Examination Standard/Edition – Add: ASME V-7 '74 YR. Summer ☒ Winter ☐	Acceptance Standard/Edition – Add: ASME III NC '74 YR. ~~Summer~~ ☐ ~~Winter~~ ☐	N.D.E. Procedure No. – Rev.: MT-1-NP REV. 3	S & L Class: B
Line or Dwg. No.: IRH018B	Part No. or Description: PARTIAL FLUED HEAD WELD No. 813	Mat'l Thickness: 2.000	Type of Material: C/S
Type of Work: New ☒ Repair ☐	Surface Condition: AS WELDED	Temp. of Mat'l: AMBIENT	Heat No.: N/A
			Heat Treat: N/A Before ☐ After ☐

MAGNETIC PARTICLE TECHNIQUE DATA* N/A ☐

Equipment: MS-27 MAGNA MAGIC	Dry ☒ Wet ☐	Visible ☒ Flourescent ☐	AC ☐ DC ☒ Rectified ☒	Amperage: 45	Prod. Spacing: 4" Head ☐ Coil ☐ Yoke ☐	Particles Type: MAGNA FLUX Batch No.: 8-AREO 6MC24

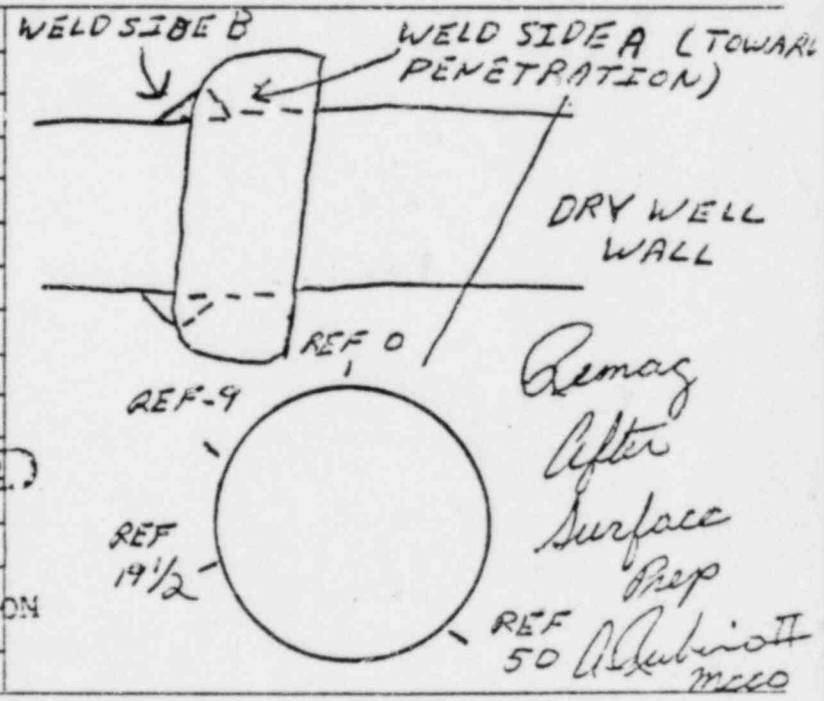
LIQUID PENETRANT TECHNIQUE DATA* N/A ☐

Type Liquid Penetrant Materials Used	Batch No.	Penetrant – Dwell Time: Water Washable ☐ Post Emulsified ☐ Visible ☐ Flourescent ☐ Solvent Removable ☐	Development – Time: Dry ☐ Wet ☐ Nonaqueous ☐

*Additional Data:

No. of Items Accepted: 0 No. of Items Rejected: 1

PC No. or SN No.	ACC	REJ	DEFECT CODE	REMARKS & DIAGRAM
IRH018B WELD No. 813		X		MT FULL COVER PASS ONLY ONE SIDE LINEAR INDICATIONS NOTED AT REF POINTS (9, 19 1/2, 50 IN WELD AS MARKED
T-47				



RECEIVED
MAR 07 1978
MORRISON CONSTRUCTION COMPANY

Conam Examiner: Gary [illegible] II — Signature — Level — Date 3/1/78
Conam Examiner: James Rizzo II — Signature — Level — Date 3-6-78
Contractor Review & Acceptance — Company — Signature — Date
Customer Acceptance — Signature — Date
CECO AI Review: W J Caldwell 2-18-81

PSI Ref. No. RH-2

ORIGINAL

Form No. 822.0 Rev. 1

NUCLEAR ENERGY SERVICES, INC.
CONAM INSPECTION DIVISIC
P. O. Box 160
Grand Hidge, Illinois 61325

REPORT OF NONDESTRUCTIVE EXAMINATION

TYPE OF EXAMINATION: MT ☒ PT ☐

Customer: COMMONWEALTH EDISON COMPANY	Project: LaSalle Station		Date: 4-28-77
Contractor: MCCO	Job No.: 2466	P. O. No.: N/A	Report No. – Request No.: 1281 M77-055
Examination Standard/Edition – Add: ASME Sec V-7 '74 YR. Summer ☒ Winter ☐	Acceptance Standard/Edition – Add: ASME Sec III NC '74 YR. Summer ☐ Winter ☐	N.D.E. Procedure No. – Rev.: MT-1-NP REV 3	S & L Class: B
Line or Dwg. No.: BF/M 844-7.4 1RI-17A	Part No. or Description: 8" Pipe to Closure Weld	Mat'l Thickness: 1.5"	Type of Material: CS
Type of Work: New ☒ Repair ☐	Surface Condition: As Welded.	Temp. of Mat'l: Ambient	Heat No.: N/A
			Heat Treat: N/A Before ☐ After ☐

MAGNETIC PARTICLE TECHNIQUE DATA* N/A ☐

Equipment: PARKE PROCE A210	Dry ☒ Wet ☐ Visible ☒ Flourescent ☐	AC ☒ DC ☐ Rectified ☐	Amperage: Perproc	Prod. Spacing 6" Head ☐ Coil ☐ Yoke ☒	Particles Type – Batch No.: Magnaglo 9A Red 62112

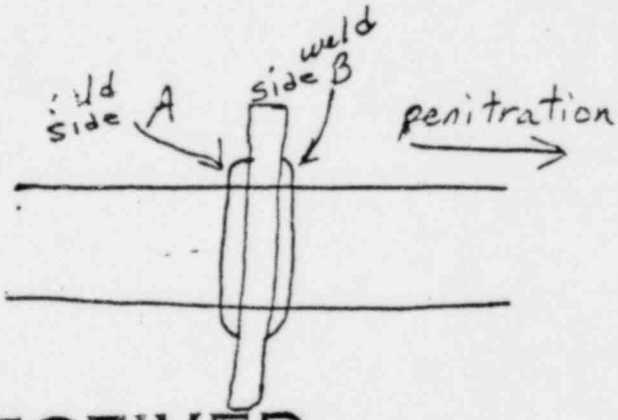
LIQUID PENETRANT TECHNIQUE DATA* N/A ☒

Type Liquid Penetrant Materials Used	Batch No.	Penetrant – Dwell Time: Water Washable ☐ Post Emulsified ☐ Visible ☐ Flourescent ☐ Solvent Removable ☐	Development – Time: Dry ☐ Wet ☐ Nonaqueous ☐

*Additional Data:

No. of Items Accepted: 1 No. of Items Rejected: Ø

PC No. or SN No.	ACC	REJ	DEFECT CODE	REMARKS & DIAGRAM
1RI-17A				Full cover pass only.
W-210	✓			
-15				



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APR 28 1977
MORRISON CONSTRUCTION COMPANY

Conam Examiner: Rod Pierling (Signature) II (Level) 4-28-77 (Date)

Contractor Review & Acceptance: MCCO (Company) Alex Zuraw (Signature) Level III (Level) 6-8-77 (Date)

Conam Examiner: (Signature) (Level) (Date)

Customer Acceptance: (Signature) (Date)

CECO AI Review: W. J. Caldwell 2-18-81

PSI Rev. No. RI-1

ORIGINAL

Form No. 822.0 Rev. 1

NUCLEAR ENERGY SERVICES, INC.
CONAM INSPECTION DIVISIO
P. O. Box 160
Grand Ridge, Illinois 61325

REPORT OF NONDESTRUCTIVE EXAMINATION

TYPE OF EXAMINATION: MT ☒ PT ☐

Customer	Project	Date
COMMONWEALTH EDISON COMPANY	LaSalle Station	6/1/78

Contractor	Job No.	P. O. No.	Report No. – Request No.
MCCO	2466	—	2124 M78-089

Examination Standard/Edition – Add	Acceptance Standard/Edition – Add	N.D.E. Procedure No. – Rev.	S & L Class
ASME V-7 74 YR. Summer ☒ Winter ☐	ASME III NC 74 YR. ~~Summer~~ ☐ ~~Winter~~ ☐	MT-1-NP REV 3	B

Line or Dwg. No.	Part No. or Description	Mat'l Thickness	Type of Material
IRI4.1B	6" CLOSURE PLATE TO PIPE	844	C/S

Type of Work	Surface Condition	Temp. of Mat'l	Heat No.	Heat Treat
New ☒ Repair ☐	AS WELDED	AMBIENT	N/A	N/A Before ☐ After ☐

MAGNETIC PARTICLE TECHNIQUE DATA* N/A ☐

Equipment				Amperage	Prod. Spacing	Particles Type – Batch No.
A-210 PARKER PROBE	Dry ☒ Wet ☐	Visible ☒ Flourescent ☐	AC ☒ DC ☐ Rectified ☐	PER PROC	6" Head ☐ Coil ☐ Yoke ☒	MAGNA FLUX 8-AREO 7H117

LIQUID PENETRANT TECHNIQUE DATA* N/A ☒

Type Liquid Penetrant Materials Used	Batch No.	Penetrant – Dwell Time		Development – Time
		Water Washable ☐ Post Emulsified ☐	Visible ☐ Flourescent ☐	Solvent Removable ☐	Dry ☐ Wet ☐ Nonaqueous ☐

*Additional Data: LIFTED 10 lb WEIGHT NO #4

No. of Items Accepted: 1
No. of Items Rejected: 0

PC No. or SN No.	ACC	REJ	DEFECT CODE	REMARKS & DIAGRAM
IRI40B				
WELD NO #277	✓			MT FULL COVER PASS ONLY
T 228				

RECEIVED
JUN 0 2 1978
MORRISON CONSTRUCTION COMPANY

Conam Examiner: Gary Hoffman II 6/1/78 (Signature / Level / Date)

Contractor Review & Acceptance: MCCO Steve Hamilton II 6-2-78 (Company / Signature / Date)

Conam Examiner: (Signature / Level / Date)

Customer Acceptance: (Signature / Date)

CECO AI Review: W J Caldwell 2-18-81

ORIGINAL PSI Ref. No. RI-2

Form No. 822.0 Rev. 1

NUCLEAR ENERGY SERVICES, INC.
CONAM INSPECTION DIVISION
P. O. Box 160
Grand Ridge, Illinois 61325

REPORT OF NONDESTRUCTIVE EXAMINATION

TYPE OF EXAMINATION: MT ☒ PT ☐

Customer: COMMONWEALTH EDISON COMPANY	Project: LaSalle Station		Date: 3-18-77
Contractor: MCCC	Job No.: 2466	P. O. No.: —	Report No. – Request No.: 1241 M77-035
Examination Standard/Edition – Add: ASME SEC V-1 74 YR. Summer ☒ Winter ☐	Acceptance Standard/Edition – Add: ASME SEC III NC 74 YR. Summer ☐ Winter ☐	N.D.E. Procedure No. – Rev.: MEI-NP REV 3	S & L Class: B
Line or Dwg. No.: IR141BB	Part No. or Description: 10" CLOSURE PLATE	Mat'l Thickness: N/A	Type of Material: CS
Type of Work: New ☒ Repair ☐	Surface Condition: AS WELDED	Temp. of Mat'l: AMBIENT	Heat No.: N/A
			Heat Treat: Before ☐ After ☐

MAGNETIC PARTICLE TECHNIQUE DATA* N/A ☐

Equipment: PARKER PROBE A210	Dry ☒ Wet ☐	Visible ☒ Flourescent ☐	AC ☒ DC ☐ Rectified ☐	Amperage: PORPROC	Prod. Spacing 6" Head ☐ Coil ☐ Yoke ☒
Particles Type – Batch No.: MAGNAFLUX BARED 6L112					

LIQUID PENETRANT TECHNIQUE DATA* N/A ☒

Type Liquid Penetrant Materials Used	Batch No.	Penetrant – Dwell Time: Water Washable ☐ Post Emulsified ☐ Visible ☐ Flourescent ☐ Solvent Removable ☐	Developer – Time: Dry ☐ Wet ☐ Nonaqueous ☐

*Additional Data:

No. of Items Accepted: 2 No. of Items Rejected: 0

PC No. or SN No.	ACC	REJ	DEFECT CODE	REMARKS & DIAGRAM
IR141BB				
W-296	✓			
T-25				

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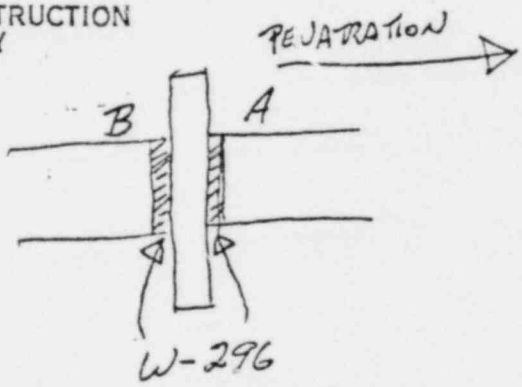
MAR 21 1977
MORRISON CONSTRUCTION COMPANY



Conam Examiner: R. Lebas (Signature) II (Level) 3-18-77 (Date)

Conam Examiner: Rod Rawling (Signature) II (Level) 3-18-77 (Date)

Contractor Rep. Acceptance: Bob Butler (Company) (Signature) Level III 3/21/77 (Date)

Customer Acceptance: (Signature) (Date)

CECO AI Review: W J Caldwell 2-18-81

PSI Ref. No. RI-3

ORIGINAL

NUCLEAR ENERGY SERVICES, INC.
CONAM INSPECTION DIVISIO
P. O. Box 160
Grand Ridge, Illinois 61325

REPORT OF NONDESTRUCTIVE EXAMINATION

TYPE OF EXAMINATION: MT ☒ PT ☐

Customer	Project	Date
COMMONWEALTH EDISON COMPANY	LaSalle Station	8-5-77

Contractor	Job No.	P. O. No.	Report No. – Request No.
MCCO	2466	N/A	1363 M77-079

Examination Standard/Edition – Add	Acceptance Standard/Edition – Add	N.D.E. Procedure No. – Rev.	S & L Class
Asme Sec V-7 '74 YR. Summer ☒ Winter ☐	Asme Sec III NC '74 YR. ~~Summer~~ ☐ ~~Winter~~ ☐	MT-1-NP REV. 3	B

Line or Dwg. No.	Part No. or Description	Mat'l Thickness	Type of Material
BF-844-3 1RI41BA	10" Pipe to Plate	1.5	C. S.

Type of Work	Surface Condition	Temp. of Mat'l	Heat No.	Heat Treat
New ☒ Repair ☐	As Welded	Ambient	N/A	N/A Before ☐ After ☐

MAGNETIC PARTICLE TECHNIQUE DATA* N/A ☐

Equipment				Amperage	Prod. Spacing	Particles Type – Batch No.
Parker Probe A210	Dry ☒ Wet ☐	Visible ☒ Flourescent ☐	AC ☒ DC ☐ Rectified ☐	Per Proc	6" Head ☐ Coil ☐ Yoke ☒	magnaflux 7A Red 62112

LIQUID PENETRANT TECHNIQUE DATA* N/A ☒

Type Liquid Penetrant Materials Used	Batch No.	Penetrant – Dwell Time			Development – Time
		Water Washable ☐ Post Emulsified ☐	Visible ☐ Flourescent ☐	Solvent Removable ☐	Dry ☐ Wet ☐ Nonaqueous ☐

*Additional Data:

No. of Items Accepted: 1
No. of Items Rejected: 0

PC No. or SN No.	ACC	REJ	DEFECT CODE	REMARKS & DIAGRAM
1RI41BA	✓			Full weld cover pass only. Both sides
287				
T-24				

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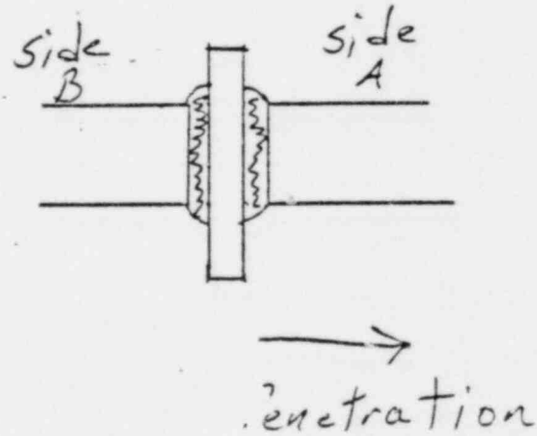
AUG 15 1977
MORRISON CONSTRUCTION COMPANY



Conam Examiner: Paul Renaling II (Signature) Level 9-5-77 Date

Contractor Review & Acceptance: MCCO (Company) (Signature) 8-15-77 (Date)

Conam Examiner: Signature Level Date

Customer Acceptance: Signature Date

CEO AI Review: W. J. Caldwell 2-18-81

PSI Ref. No. RI-4

ORIGINAL

NUCLEAR ENERGY SERVICES, INC.
CONAM INSPECTION DIVISIO
P. O. Box 160
Grand Ridge, Illinois 61325

REPORT OF NONDESTRUCTIVE EXAMINATION

TYPE OF EXAMINATION: MT ☒ PT ☐

Customer: COMMONWEALTH EDISON COMPANY	Project: LaSalle Station		Date: 8-4-77
Contractor: MCCO	Job No.: 2466	P. O. No.: N/A	Report No. – Request No.: 1360 M77-078
Examination Standard/Edition – Add: ASME Sec V-7 74 YR. Summer ☒ Winter ☐	Acceptance Standard/Edition – Add: ASME Sec III NC 74 YR. Summer ☐ ~~Winter~~ ☐	N.D.E. Procedure No. – Rev.: MT-1-NP REV. 3	S & L Class: B
Line or Dwg. No.: 1RI02A	Part No. or Description: 10" Pipe to Plate	Mat'l Thickness: 2"	Type of Material: C.S.
Type of Work: New ☒ Repair ☐	Surface Condition: As Welded	Temp. of Mat'l: Ambient	Heat No.: N/A; Heat Treat: N/A Before ☐ After ☐

MAGNETIC PARTICLE TECHNIQUE DATA* N/A ☐

Equipment						
PARKER PROBE A210	Dry ☒ Wet ☐	Visible ☒ Flourescent ☐	AC ☒ DC ☐ Rectified ☐	Amperage: Per Proc.	Prod. Spacing: 6" Head ☐ Coil ☐ Yoke ☒	Particles Type – Batch No.: magnaflux 8A Red 6L112

LIQUID PENETRANT TECHNIQUE DATA* N/A ☒

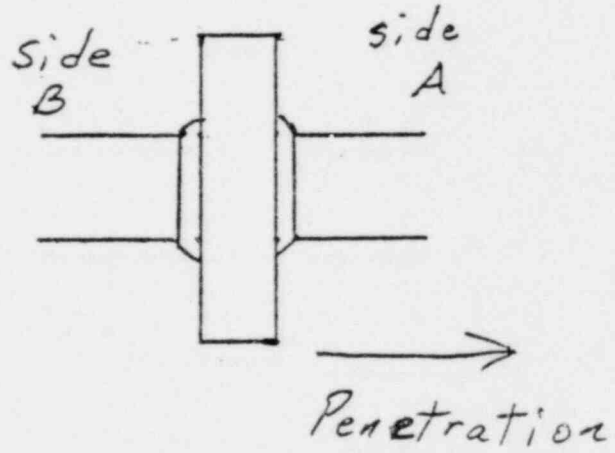
Type Liquid Penetrant Materials Used	Batch No.	Penetrant – Dwell Time			Development – Time
		Water Washable ☐ Post Emulsified ☐	Visible ☐ Flourescent ☐	Solvent Removable ☐	Dry ☐ Wet ☐ Nonaqueous ☐

*Additional Data:

No. of Items Accepted: 1 No. of Items Rejected: 0

PC No. or Sh No.	ACC	REJ	DEFECT CODE	REMARKS & DIAGRAM
1RI02A				Full weld cover pass only.
[illegible]-197	✓			
T-13				

RECEIVED
AUG 05 1977
MORRISON CONSTRUCTION COMPANY



Conam Examiner: Rod Rawlings II 8-5-77 (Signature / Level / Date)

Contractor Review & Acceptance: MCCO A Gabrielli 8-15-77 (Company / Signature / Date)

Conam Examiner: (Signature / Level / Date)

Customer Acceptance: (Signature / Date)

CECO AI Review: W J Caldwell 2-18-88

ORIGINAL

PSI Ref. No. RI-5

Appendix A

MORRISON CONSTRUCTION COMPANY
LaSalle County Station
Job No. 2466

REPORT OF LIQUID PENETRANT EXAMINATION

P.T. PROCEDURE NO. NDE-L/2 REV. 7 P.T. REPORT NO. 869

LINE NO. RI-1 DRAWING NO. BFM 844-1-5 S & L CLASS A

DESCRIPTION OF PARTS Closure Plate TYPE OF MATERIAL SS. TRAVELLER NO. 7-218

PENETRANT TYPE SKL-HF Skl-5 Formula B DEVELOPER TYPE SKD-NF Formula B CLEANER TYPE SKC-NF Formula B

BATCH NO. 5H059 BATCH NO. 78A017 BATCH NO. 78E068

WELD/PIECE NUMBER(S)	ACCEPT	REJECT	REMARKS
W-RI-102B	✓		Final

EXAMINER Carl Rubini LEVEL II DATE 7-11-78

INTERPRETER Carl Rubini LEVEL II DATE 7-11-78

ACCEPTANCE [illegible] LEVEL III DATE 7-17-78
Quality Control Department

PSI Ref. No. RI-6

reviewed
W J Caldwell CSEO ANII
2-18-81

Liquid Penetrant NDE
Report NDE/L-2/2, Rev. 3
(3/78)