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USNRC REGION  
ATLANTA, GEORGIA

31 SEP 9 1981



## Vogtle Project

September 2, 1981

United States Nuclear Regulatory Commission  
Office of Inspection and Enforcement  
Region II - Suite 3100  
101 Marietta Street  
Atlanta, Georgia 30303

Reference:  
ID: II: EHG  
50-424/81-08  
50-425/81-08

Attention: Mr. R. C. Lewis

File: X7BG10  
Log: GN-144

Gentlemen:

The Georgia Power Company wishes to submit the following information concerning the violations discussed in your inspection reports 50-424/81-08 and 50-425/81-08.

We concur with the finding identified concerning undersized welds on safety-related structural steel. Both welds in question were reinspected and found to be undersized by 1/16 of an inch and in excess of the 10% length as permitted by AWS D.1.1. These welds were found to be within the specification requirements of X2AP01 - Section C5.1.F.8.d, Revision 4, which states the following: "Undercut (underfill) not exceeding 3/32 inch shall be acceptable for the full length of the weld."

The general reasons these welds were accepted are that each weld was a borderline case on acceptance, the configuration of the weld made it difficult to weld and inspect, and the acceptance of the weld was made on a visual inspection rather than using a fillet gauge. The following are particular reasons for acceptance of these welds:

1. Clip Angle Weld in Room C-13: This weld is located between the top of the beam and the Q-Deck of the floor above which made this weld difficult to inspect. The inspector compared the size of the weld (5/16") to the thickness of the angle (3/8") to make visual acceptance of the weld size.
2. Stiffener Weld in Room C-80: This weld was shown on drawing M08G-S176 as a stitch weld, 2 inches in every 5 inches, but was made as a continuous weld. The inspector made his acceptance on the fact that more weld metal than required was present so the strength factor was greater than design requirements.

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Each weld in question has been repaired in accordance with AWS D1.1 and the design drawings. Each weld has been reinspected, noted as acceptable, and documented accordingly.

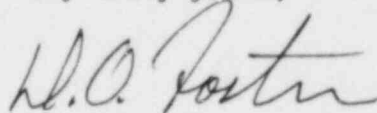
Corrective Action taken to prevent recurrence was to verbally inform each Structural Steel inspector of the critical nature of insuring that proper weld size is maintained in accordance with AWS D1.1 and Specification X2A.01, Section C5.1. The acceptance standards as outlined in these codes and specifications were explained. Each inspector shall have a fillet gauge when inspecting welds and shall measure all borderline cases to insure weld size compliance.

In order to fully evaluate the impact of this violation, a random sample of approximately five percent (5%) of the same type weld connections which have already been accepted shall be reinspected. An evaluation of the results shall determine the reliability of the previous inspection effort.

Full compliance will be achieved September 23, 1981.

Neither the inspection report nor this reply contains any proprietary information and may be placed in the NRC's Public Document Room.

Very truly yours,



D. O. Foster  
Project General Manager

CWH:sew

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D. O. Foster states that he is Project General Manager of Georgia Power Company's Vogtle Project and is authorized to execute this oath on behalf of Georgia Power Company and that to the best of his knowledge and belief the facts set forth in this letter are true.

GPC: *D. O. Foster*  
D. O. Foster

Sworn to and subscribed before me this 2<sup>nd</sup> day of September, 1981.

*Eric H. Bacchus*  
Notary Public, Georgia, State at Large  
My Commission Expires March 21, 1985

cc: U. S. Nuclear Regulatory Commission  
Attn: Victor J. Stello, Jr., Director  
Office of Inspection and Enforcement  
Washington, D.C. 20555

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