

Mr. Richard C. DeYoung, Director
Office of Inspection & Enforcement
U. S. Nuclear Regulatory Commission
Washington, D. C. 20555

Subject: ASME Code Requirements for Radiography of Safe End Welds

Dear Mr. DeYoung:

Combustion Engineering (C-E) has recently reviewed a portion of the ASME Code and has concluded that additional action will be required by C-E in order to fully comply with the Code requirements.

During fabrication of the safety injection tanks for C-E's System 80 units, the weld between the safety injection tank discharge nozzle and the safe end was radiographed in the shop prior to post weld heat treatment. As a result of the recent review of ASME Section III NC-5120, Paragraph (C), 1974 Edition, we have concluded that the code actually requires that radiography be performed after post weld heat treat.

It is currently C-E's intention to resolve this discrepancy by re-radiographing the affected welds of the 24 safety injection tanks which have been delivered to plant sites.

None of these C-E supplied tanks are located in currently operating plants and its our intention to complete the reinspections prior to cold hydro at the affected plants.

The affected safety injection tanks were fabricated for the following units:

Palo Verde 1, 2, & 3	12 524 539 530
Yellow Creek 1	4 568
WPPSS 3	4 508
Cherokee 1	4 491

In addition to these tanks, shipment of the first safety injection tank to WPPSS-5 is being delayed until the re-radiography is completed. Also four (4) tanks have been delivered to a site which does not have a construction permit (Pilgrim 2). Appropriate steps will be taken to ensure that these tanks will be re-radiographed prior to any use requiring the above ASME code compliance.

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Mr. Richard C. DeYoung
May 4, 1982

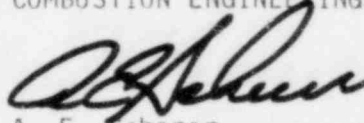
- 2 -

At the present time, C-E has not identified a significant safety issue associated with this condition.

If you have any questions on the above, please feel free to contact myself or Mr. E. H. Kennedy of my staff at (203)688-1911, Extension 2828.

Very truly yours,

COMBUSTION ENGINEERING, INC.



A. E. Scherer
Director
Nuclear Licensing

AES:ctk

cc: J. M. West (C-E)