

DUKE POWER COMPANY

POWER BUILDING

422 SOUTH CHURCH STREET, CHARLOTTE, N. C. 28242

WILLIAM O. PARKER, JR.
VICE PRESIDENT
STEAM PRODUCTION

March 31, 1982

TELEPHONE: AREA 704
373-4083

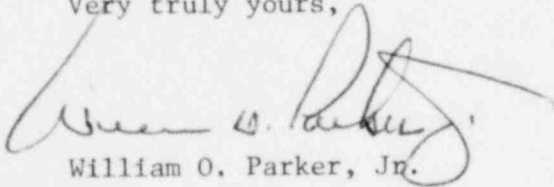
Mr. James P. O'Reilly, Regional Administrator
U. S. Nuclear Regulatory Commission
Region II
101 Marietta Street, Suite 3100
Atlanta, Georgia 30303

Re: Catawba Nuclear Station
Unit 2
Docket No. 50-414

Dear Mr. O'Reilly:

Pursuant to 10 CFR 50.55e, please find attached a Supplemental Response
to Significant Deficiency Report SD 414/81-30.

Very truly yours,



William O. Parker, Jr.

RWO/php
Attachment

cc: Director
Office of Inspection and Enforcement
U. S. Nuclear Regulatory Commission
Washington, D. C. 20555

P. K. Van Doorn
NRC Resident Inspector
Catawba Nuclear Station

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March 31, 1982

Report Number SD 414/81-30

Supplemental Response

This report is submitted to fulfill our obligation as prescribed under corrective action in Significant Deficiency Report SD 414/81-30.

A representative section of the pipe in question (Heat Number 181033) was sent to the manufacturer, Swepco Tube Corporation, Clifton, New Jersey for testing and analysis, and to ascertain the cause and to identify any corrective actions.

The minimum wall thickness was measured with panametric (ultrasonic testing unit Model #5222) using a five (5) megahertz transducer. Minimum wall thickness requirements for 8" schedule 40 SA312 Type 304 pipe is 0.282". The thickness of the pipe in the weld area was a maximum of 0.280" and a minimum of 0.275". The thickness of the pipe outside of the weld area (parent metal) was a maximum of 0.294" and a minimum of 0.286".

The apparent cause of the low readings in the weld area was due to excessive grinding of the O.D. surface of the finished pipe. Grinding the O.D. surface of the pipe in the area of the weld was necessary due to purchase order requirements that the weld be ultrasonically examined. In this case, grinding was excessive due to operator error. The outside surface of this pipe was sanded by an Automatic Belt Sander with a continuous 4" wide x 90" circumference, 36 grit abrasive belt. Tension on the belt is adjusted by the operator through manipulation of air pressure regulators. In order to avoid excessively grinding the weld surface, the downward force and tension on the belt must be set within certain limits to produce a width of the belt ground area to a maximum wall condition. The manufacturer has reviewed this order and five (5) subsequent orders, through their Quality Control documentation for indications that would lead them to believe a similar condition may have existed. Based on the review of these orders, they could find no indication that minimum wall thickness was infringed upon.

To provide for additional in-process Quality Control, the manufacturer is requiring their QC inspector to ultrasonically check the weld and heat affected zone on both sides of the initial piece of pipe on every production run that requires O.D. flush grinding to assure that minimum wall thickness is not infringed upon. A Quality Control Procedure QA3015, Rev. 0 has been prepared to cover this operation.

Based on the manufacturer's investigation, corrective actions taken and Swepco's commitment to replace any pipe manufactured by them with this condition, Duke Power Company considers the investigation into this matter closed.