

## Attachment A

WASHINGTON PUBLIC POWER SUPPLY SYSTEM  
NUCLEAR PROJECT NO. 2  
DOCKET NO. 50-397  
LICENSE NO. CPPR-93  
NON-REPORTABLE 10CFR50.55(e) CONDITION #215  
SKEWED T JOINT WELDS

### FINAL REPORT

#### Description of Noncompliance

When members are welded with a fillet weld at other than 90° to each other, the AWS D1.1 welding code, and Burns and Roe drawing H501, Rev. 0, specify an increased leg length over that specified on the hanger details. On the acute angle, the increased leg length is specified to account for less than full penetration at the base of the weld. On the obtuse side, it is specified to assure the effective throat that is required is present.

Bechtel installed skewed T-Joint welds have been determined to be lacking the additional leg length as required.

#### Safety Implication

None

#### Corrective Action

An inspection sampling plan was established to randomly select and verify the weld size of skewed angle welds performed by Bechtel Power Corporation (Contract 250) and WBG (Contract 215) prior to November 2, 1982. Newly designed welds (after November 2, 1982 will have the additional leg length specified).

A random sample of hangers were selected as follows:

- 60 WBG large piping hangers with skewed welds
- 60 Bechtel large piping hangers with skewed welds
- 60 WBG small piping welds with skewed welds
- 60 Bechtel small piping welds with skewed welds

Each of the above four samples represent groups of hangers done by the same design methods, fabrication procedures and management; and were measured using the Nuclear Project WNP-2 Skewed Weld Joint Evaluation Program. Using these field measurements, hanger loads were used to ascertain whether or not the welded joint was adequate to carry the load within code allowable stresses. In all cases, the 240 welds were determined to be adequate. Consequently, the Architect Engineer has accepted all large bore and small bore hangers with skewed angle welds performed by WBG and Bechtel prior to November 2, 1982, that meet the weld size specified on the hanger detail, but did not have the additional leg length required by AWS D1.1.

#### Status of Corrective Action

The sampling program has been completed and based on the above discussed results, the Project has determined this item to be non-reportable under the provisions of 10CFR50.55(e).