



**LOUISIANA**  
**POWER & LIGHT**

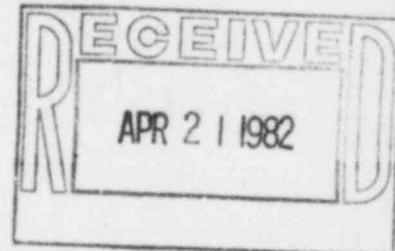
142 DELARONDE STREET  
P. O. BOX 6008 • NEW ORLEANS, LOUISIANA 70174 • (504) 366-2345

April 19, 1982

G. D. McLENDON  
Senior Vice President

W3K-82-0239  
Q-3-A35.07.28

Mr. John T. Collins, Regional Administrator, Region IV  
U. S. Nuclear Regulatory Commission  
611 Ryan Plaza Drive, Suite 1000  
Arlington, Texas 76012



SUBJECT: Waterford SES Unit No. 3  
Docket No. 50-382  
Final Report of Significant Construction Deficiency No. 28  
Two-Inch and Below Schedule 160 Socket Welds Undersize

Reference: LP&L Letter W3K-82-0136 dated March 5, 1982 to USNRC

Dear Mr. Collins:

In accordance with the requirements of 10CFR50.55(e), we are hereby providing two copies of the Final Report of Significant Construction Deficiency No. 28, "Two-Inch and Below Schedule 160 Socket Welds Undersize."

If you have any questions, please advise.

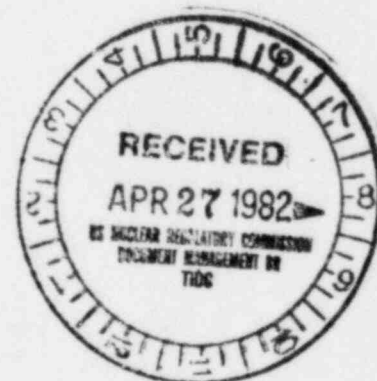
Very truly yours,

*G. D. McLendon*

GDMcL/LLB/grf

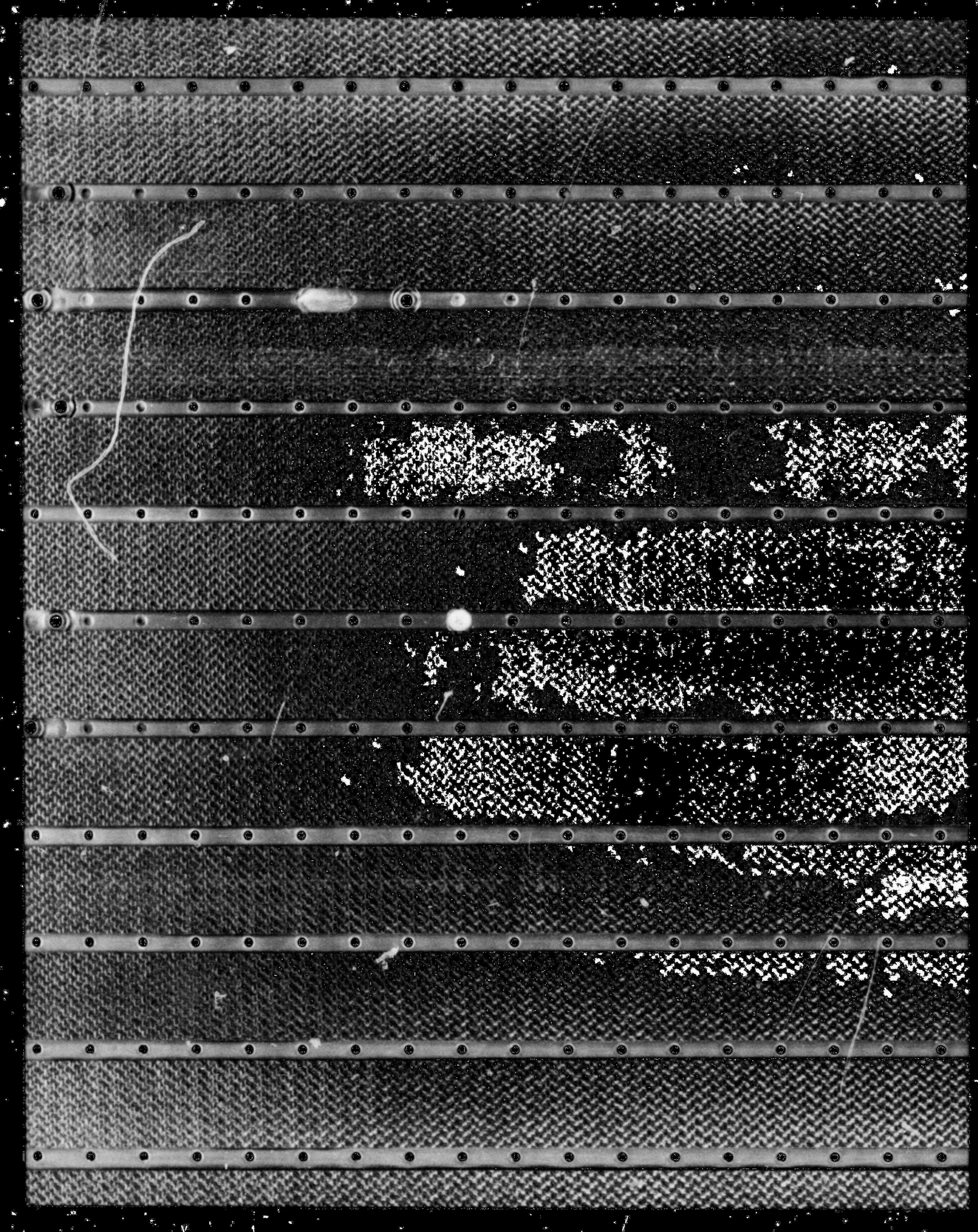
Attachment

- cc: 1) Director  
Office of Inspection & Enforcement  
U. S. Nuclear Regulatory Commission  
Washington, D. C. 20555  
(with 15 copies of report)
- 2) Director  
Office of Management  
Information and Program Control  
U. S. Nuclear Regulatory Commission  
(with 1 copy of report)



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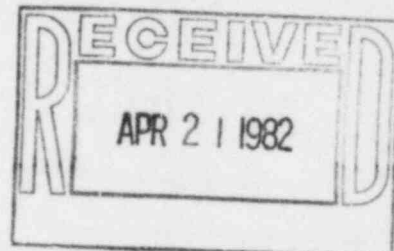
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LOUISIANA POWER & LIGHT COMPANY

WATERFORD SES UNIT NO. 3

Final Report of  
Significant Construction Deficiency No. 28

Two-Inch and Below Schedule 160 Socket Welds Undersize

Reviewed by *R. J. Milwiser* *4/16/82*  
R. J. Milwiser - Site Manager Date

Reviewed by *J. L. Wills* *4/16/82*  
J. Wills - Project Superintendent Date

Reviewed by *Darryl L. Harris, Jr.* *4-15-82*  
J. Hart - Project Licensing Engineer Date

Reviewed by *Douglas W. Hoff for J.D.* *4/16/82*  
J. DeBruin - ESSE Project Engineer Date

Reviewed by *J. Gutierrez* *4-16-82*  
J. Gutierrez - Q. A. Site Supervisor Date

April 14, 1982

FINAL REPORT  
SIGNIFICANT CONSTRUCTION DEFICIENCY NO. 28  
TWO-INCH AND BELOW SCHEDULE 160 SOCKET WELDS UNDERSIZE

Introduction

This report is submitted pursuant to 10CFR50.55(e). It describes a welding deficiency identified in ASME Subsections NB, NC and ND Socket Welds. This problem is considered reportable under the requirements of 10CFR50.55(e). To the best of our knowledge, this problem has not been identified to the Nuclear Regulatory Commission pursuant to 10CFR21.

Description

A sample of 2" Schedule 160 socket welds made by Tompkins-Beckwith was reinspected during the fall of 1980 following a report of problems at another facility and Ebasco Quality Assurance Surveillance Report SRW-80-8-2. This inspection and others made subsequently disclosed that a significant number of the 2" Schedule 160 socket welds were in the  $\frac{1}{4}$ " to 5/16" range rather than 3/8" as required by Code criteria (ASME Section III, Subsections NB, NC and ND). An Interim Report dated May 4, 1981 submitted by Louisiana Power & Light Company to the U. S. Nuclear Regulatory Commission stated that approximately 1600 2" Schedule 160 socket welds were affected. In response to the above Ebasco Quality Assurance Surveillance Report, Tompkins-Beckwith committed to corrective action which would reduce the number of welds requiring reinspection from 1601 to 801. Of the 801 welds, 394 were identified by Tompkins-Beckwith as requiring additional weld metal. Corrective action on these 394 welds is complete and has been verified by Ebasco. Due to questions raised by an Ebasco sampling inspection of welds designated acceptable by Tompkins-Beckwith, the remaining 407 welds, plus the 800 welds previously eliminated as not requiring reinspection, were all reinspected. Later, 1044 additional socket welds comprised of 261 2" and 783 under 2" were reinspected. In all, a total of 2645 2" and under socket welds were reinspected.

Safety Implications

These welds were significantly below the size required by the ASME Code which reduced the safety margin of the original design considerably. Thus, the possibility existed that these socket welds could fail during plant operation.

Corrective Action

A total of 2645 2" and under Schedule 160 socket welds were reinspected by Tompkins-Beckwith. In all, 794 of 1862 2" socket welds and 460 of 783 under 2" socket welds required additional weld metal. Corrective action was completed and verified by Ebasco on April 15, 1982.