



**Commonwealth Edison**  
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December 20, 1982

Mr. James G. Keppler, Regional Administrator  
Directorate of Inspection and  
Enforcement - Region III  
U.S. Nuclear Regulatory Commission  
799 Roosevelt Road  
Glen Ellyn, IL 60137

PRINCIPAL STAFF			
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Subject: Quad Cities Station Unit 1  
Feedwater Nozzle and CRD Return  
Line Nozzle Reports Associated  
With NUREG 0619  
NRC Docket No. 50-254

- References (a): T. Rausch letter to J. G. Keppler  
dated November 20, 1981.
- (b): R. Janecek letter to D. G. Eisenhut  
dated February 23, 1981.
- (c): T. Rausch letter to J. G. Keppler  
dated February 23, 1982.

Dear Mr. Keppler:

In accordance with NUREG-0619 and our reporting commitments summarized in Reference (a), this letter documents the activities and inspections performed on the Feedwater and CRD Return Line nozzles during the Quad Cities Unit 1 Fall 1982 Refuel Outage.

Reactor Feedwater Sparger Replacement and Clad Removal

As described in NUREG 0619 and as committed in Reference (b), by the old feedwater spargers were replaced and the feedwater nozzle cladding was removed. The activities involved are summarized as follows:

1. The old feedwater spargers were removed.
2. The nozzle bore and radius stainless steel cladding on all four feedwater nozzles was machined out.
3. The nozzle bore, radius, and machined areas were PT examined. No relevant indications were present.
4. New triple sleeve-double piston ring spargers were installed.

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5. A baseline UT examination was performed on all four nozzle bore and radius areas. The safe-end-to-nozzle welds in the drywell were also UT examined.
6. Thermocouples have been installed on the outside surface of the feedwater nozzles. This constitutes the on-line leakage monitoring system described in Reference (c).

The above items complete our commitment to NUREG-0619 and the reporting requirements of section 4.4.3.1(1) for the feedwater nozzles on both Units 1 and 2 (and Dresden 2 and 3). The inspections required by Table 2 of NUREG-0619 will be performed as indicated.

#### Control Rod Drive Return Line Thermal Sleeve Removal and Inspection

The following completes our commitment detailed in Reference (a) to provide reports associated with CRD return line nozzles (see section 8.3 of NUREG-0619). The Quad Cities 1 CRD Return Line nozzle thermal sleeve was removed and the nozzle was PT examined. This work is documented by Modification M-4-1-75-5. The nozzle radius, bore, and face were cleaned and flapper-wheel ground prior to information PT. Several circumferential and axial indications on the welded ring were present, as were some axial indications on the radius. Following grinding operations a second PT was performed. Small axial indications on the radius and several small indications on the bottom section of the ring remained. Following further grinding, the nozzle was PT examined by the Commonwealth Edison Company Level III, and evaluated. The remaining relevant indications were a small nozzle radius indication which was removed by grinding, and an axial indication on the ring. The latter indication has been analyzed and evaluated by the Station Nuclear Engineering Department to allow it to remain in-place. A final PT was performed to verify removal of the nozzle radius indication.

A UT examination of the CRD Return Line nozzle inner radius and adjacent vessel plate was performed, and no crack indications were detected.

An augmented ISI of the high-stress weld joints on the CRD Return Line in the drywell was performed by UT. No crack indications were detected.

Prior to unit startup, both of the CRD Return Line manual valves located outside the drywell will be shut and locked. This is the present arrangement for Unit 2.

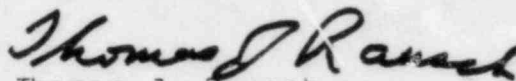
J. G. Keppler

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Please direct any questions you may have concerning this matter to this office.

Very truly yours,



Thomas J. Rausch  
Nuclear Licensing Administrator

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cc: Director, Office of I.E.  
Director, Office of NRR  
Region III Inspector - Quad Cities

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