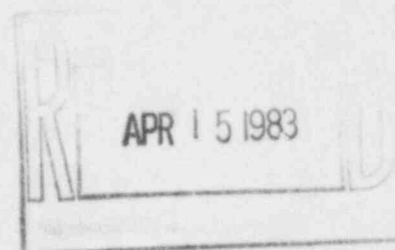


## Nebraska Public Power District

GENERAL OFFICE  
P.O. BOX 499, COLUMBUS, NEBRASKA 68601-0499  
TELEPHONE (402) 564-8561

April 13, 1983

Mr. John T. Collins  
Regional Administrator  
U.S. Nuclear Regulatory Commission  
Region IV  
611 Ryan Plaza, Suite 1000  
Arlington, Texas 76011



Subject: Mark I Modification  
Welds Performed by Unqualified Welders

Dear Mr. Collins:

In the course of reviewing the QA documentation and work packages provided by Dravo Utility Constructors Incorporated for the Mark I work that they did during 1982 and early 1983, we found that some penetration welds were done with unqualified welders. The evidence we found indicated that this may exist in more than one location so we instructed our contractor to come back, review their data, and inform us of the areas affected. Subsequent to their review, which indicated a number of welds, we have performed an in depth review of the data and find that an additional number of penetration welds were in fact done by welders that were only qualified for fillet welds.

These welds consist of full penetration, partial penetration, and flare bevel welds most of which are installed on Torus Attached Piping supports. A few welds are in the drywell and under the water line in the torus. We are also investigating a number of welds on the torus catwalks which since they are fillet welds to structural tubing become flare bevel welds. We expect the results of an engineering analysis to show that these welds need to only meet the requirements of a fillet weld and therefore expect to not require any additional work on them. Upon review of the various codes and discussions with EDS Nuclear and General Electric, we have subsequently decided to use ultrasonic examination to examine the individual welds and determine the acceptability of the welds.

Qualified NDT personnel from General Electric will be on site beginning April 18, 1983 to examine the welds. If the results of the examinations indicate unacceptable welds, we will then repair the welds.

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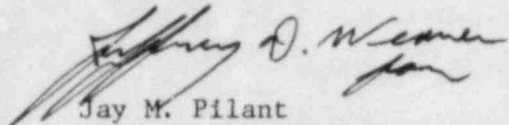
110

Mr. John T. Collins  
April 13, 1983  
Page Two

We expect to complete this work by the end of the upcoming outage and will forward a summary report to you after we have finished.

If you have any questions, please advise.

Sincerely,

  
Jay M. Pilant  
Division Manager of  
Licensing and Quality Assurance

JMP/TEH/ck