

GEORGIA POWER COMPANY
INSERVICE INSPECTION PROGRAM
(ISI-P-014)

FOR

VOGTLE ELECTRIC GENERATING PLANT
UNIT 2

PREPARED BY

SOUTHERN NUCLEAR OPERATING COMPANY
INSPECTION AND TESTING SERVICES GROUP

REV.	DATE	DESCRIPTION	SNC				GPC	
			PREP'D BY (ITS)	REV'D BY (ITS)	APPV. DEPT. MGR. (ITS)	APPV. VOGTLE PROJECT NMS	APPV. MGR. TECH. SUPP.	APPV. GEN MGR.
0	10/25/88	ORIGINAL ISSUE						
1	4/10/89	ADD REL. REQ'S 54, 55, 56						
2	5/18/89	REVISED REL. REQ'S 32 & 52						
3	6/11/90	DELETE RELIEF REQUESTS RR-45,47,48,54. REV. RR-32						
4	6/10/91	INCORPORATES COMMENTS PER GPC Ltr. MSV-00318, 9/13/90	WLV 6/10/91	6-09 6-10-91	5-10 6-13-91	P.A. Ward 7-10-91	9-3-91	9/13/91

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Vogtle Electric Generating Plant - Unit 2 (VEGP-2)
Inservice Inspection (ISI) Program
First 10-Year Interval
(ISI-P-014)

Revision 4 Summary of Changes

Affected ISI Program
Document Pages

Change

6-3	This editorial change is being made to reflect the withdrawal of Relief Request RR-51.
6-31, 6-32, and 6-33	Revised Relief Request RR-21 and Attachment 1 thereto to reflect present examination techniques and receipt of new calibration blocks.
6-43 and 6-44	Editorial revision of Relief Request RR-26.
6-72	Typographical error is being corrected.
6-95 and 6-96	The portion of Auxiliary Component Cooling Water System piping covered by Relief Request RR-51 is not in the scope of Regulatory Guide 1.26, Quality Group Classifications for Water-, Steam-, and Radioactive Waste Containing Components of Nuclear Power Plants. Therefore, Relief Request RR-51 is being withdrawn.
6-97	Typographical error is being corrected. Two 6-96 pages existed. This page is being corrected in this program revision to 6-97.
7-1	Revised the section scope statement to indicate the Line Designation List contained in this program document is for information only.
8-1	Revised the section scope statement to indicate the Equipment Designation List contained in this program document is for information only.

VEGP-2 ISI-P-014

List of Effective Pages

Distribution List, Rev. 4

Table of Contents, Rev. 0

Introduction

Page 1-1, Rev. 0
Page 1-2, Rev. 0
Page 1-3, Rev. 0
Page 1-4, Rev. 0
Page 1-5, Rev. 0
Page 1-6, Rev. 0

Class 1

Page 2-1, Rev. 0
Page 2-2, Rev. 0
Page 2-3, Rev. 0
Page 2-4, Rev. 0
Page 2-5, Rev. 0
Page 2-6, Rev. 0
Page 2-7, Rev. 0
Page 2-8, Rev. 0
Page 2-9, Rev. 0
Page 2-10, Rev. 0
Page 2-11, Rev. 0
Page 2-12, Rev. 0
Page 2-13, Rev. 0
Page 2-14, Rev. 0
Page 2-15, Rev. 0
Page 2-16, Rev. 0
Page 2-17, Rev. 0
Page 2-18, Rev. 0
Page 2-19, Rev. 0
Page 2-20, Rev. 0
Page 2-21, Rev. 0
Page 2-22, Rev. 0
Page 2-23, Rev. 1
Page 2-24, Rev. 0
Page 2-25, Rev. 0
Page 2-26, Rev. 0
Page 2-27, Rev. 0
Page 2-28, Rev. 0
Page 2-29, Rev. 0
Page 2-30, Rev. 0
Page 2-31, Rev. 0
Page 2-32, Rev. 0
Page 2-33, Rev. 3
Page 2-34, Rev. 3
Page 2-35, Rev. 0

Class 2

Page 3-1, Rev. 0
Page 3-2, Rev. 0

Class 2 (continued)

Page 3-3, Rev. 0
Page 3-4, Rev. 2
Page 3-5, Rev. 0
Page 3-6, Rev. 0
Page 3-7, Rev. 0
Page 3-8, Rev. 0
Page 3-9, Rev. 0
Page 3-10, Rev. 0
Page 3-11, Rev. 0
Page 3-12, Rev. 0
Page 3-13, Rev. 0
Page 3-14, Rev. 0
Page 3-15, Rev. 0
Page 3-16, Rev. 3
Page 3-17, Rev. 3
Page 3-18, Rev. 0

Class 3

Page 4-1, Rev. 0
Page 4-2, Rev. 3
Page 4-3, Rev. 0
Page 4-4, Rev. 3
Page 4-5, Rev. 0
Page 4-6, Rev. 3
Page 4-7, Rev. 0

Component Supports

Page 5-1, Rev. 0
Page 5-2, Rev. 0
Page 5-3, Rev. 3
Page 5-4, Rev. 3
Page 5-5, Rev. 0
Page 5-6, Rev. 0
Page 5-7, Rev. 0

Relief Requests

Page 6-1, Rev. 0
Page 6-2, Rev. 0
Page 6-3, Rev. 4
Page 6-4, Rev. 3
Page 6-5, Rev. 0
Page 6-6, Rev. 0
Page 6-7, Rev. 0
Page 6-8, Rev. 0
Page 6-9, Rev. 0
Page 6-10, Rev. 0
Page 6-11, Rev. 0
Page 6-12, Rev. 0
Page 6-13, Rev. 0
Page 6-14, Rev. 0
Page 6-15, Rev. 0
Page 6-16, Rev. 0
Page 6-17, Rev. 0

Relief Requests (continued)

Page 6-18, Rev. 0
Page 6-19, Rev. 1
Page 6-20, Rev. 0
Page 6-21, Rev. 0
Page 6-22, Rev. 0
Page 6-23, Rev. 1
Page 6-24, Rev. 0
Page 6-25, Rev. 0
Page 6-26, Rev. 0
Page 6-27, Rev. 0
Page 6-28, Rev. 0
Page 6-29, Rev. 0
Page 6-30, Rev. 0
Page 6-31, Rev. 4
Page 6-32, Rev. 4
Page 6-33, Rev. 4
Page 6-34, Rev. 0
Page 6-35, Rev. 0
Page 6-36, Rev. 0
Page 6-37, Rev. 0
Page 6-38, Rev. 0
Page 6-39, Rev. 0
Page 6-40, Rev. 0
Page 6-41, Rev. C
Page 6-42, Rev. 0
Page 6-43, Rev. 4
Page 6-44, Rev. 4
Page 6-45, Rev. 0
Page 6-46, Rev. 1
Page 6-47, Rev. 0
Page 6-48, Rev. 0
Page 6-49, Rev. 0
Page 6-50, Rev. 0
Page 6-51, Rev. 0
Page 6-52, Rev. 0
Page 6-53, Rev. 0
Page 6-54, Rev. 0
Page 6-55, Rev. 0
Page 6-56, Rev. 0
Page 6-57, Rev. 0
Page 6-58, Rev. 0
Page 6-59, Rev. 3
Page 6-59a, Rev. 3
Page 6-60, Rev. 3
Page 6-61, Rev. 0
Page 6-62, Rev. 0
Page 6-63, Rev. 0
Page 6-64, Rev. 0
Page 6-65, Rev. 0
Page 6-66, Rev. 0
Page 6-67, Rev. 0
Page 6-68, Rev. 0

Relief Request (continued)

Page 6-69, Rev. 0
Page 6-70, Rev. 0
Page 6-71, Rev. 0
Page 6-72, Rev. 4
Page 6-73, Rev. 0
Page 6-74, Rev. 0
Page 6-75, Rev. 0
Page 6-76, Rev. 0
Page 6-77, Rev. 0
Page 6-78, Rev. 0
Page 6-79, Rev. 0
Page 6-80, Rev. 0
Page 6-81, Rev. 0
Page 6-82, Rev. 0
Page 6-83, Rev. 0
Page 6-84, Rev. 0
Page 6-85, Rev. 0
Page 6-86, Rev. 0
Page 6-87, Rev. 0
Page 6-88, Rev. 3
Page 6-89, Rev. 0
Page 6-90, Rev. 3
Page 6-91, Rev. 3
Page 6-92, Rev. 3
Page 6-93, Rev. 0
Page 6-94, Rev. 0
Page 6-95, Rev. 4
Page 6-96, Rev. 4
Page 6-97, Rev. 4
Page 6-98, Rev. 0
Page 6-99, Rev. 3
Page 6-100, Rev. 1
Page 6-101, Rev. 1

Line Designation List

Page 7-1, Rev. 4
Page 7-2, Rev. 0
Page 7-3, Rev. 0
Page 7-4, Rev. 0
Page 7-5, Rev. 0
Page 7-6, Rev. 0
Page 7-7, Rev. 0
Page 7-8, Rev. 0
Page 7-9, Rev. 0
Page 7-10, Rev. 0
Page 7-11, Rev. 0
Page 7-12, Rev. 0
Page 7-13, Rev. 0
Page 7-14, Rev. 0
Page 7-15, Rev. 0
Page 7-16, Rev. 0

Line Designation List (continued)

Page 7-17,	Rev. 0
Page 7-18,	Rev. 0
Page 7-19,	Rev. 0
Page 7-20,	Rev. 0
Page 7-21,	Rev. 0
Page 7-22,	Rev. 0
Page 7-23,	Rev. 0
Page 7-24,	Rev. 0
Page 7-25,	Rev. 0
Page 7-26,	Rev. 0
Page 7-27,	Rev. 0
Page 7-28,	Rev. 0
Page 7-29,	Rev. 0
Page 7-30,	Rev. 0
Page 7-31,	Rev. 0
Page 7-32,	Rev. 0
Page 7-33,	Rev. 0
Page 7-34,	Rev. 0
Page 7-35,	Rev. 0
Page 7-36,	Rev. 0
Page 7-37,	Rev. 0
Page 7-38,	Rev. 0
Page 7-39,	Rev. 0
Page 7-40,	Rev. 0
Page 7-41,	Rev. 0
Page 7-42,	Rev. 0
Page 7-43,	Rev. 0
Page 7-44,	Rev. 0
Page 7-45,	Rev. 0
Page 7-46,	Rev. 0
Page 7-47,	Rev. 0
Page 7-48,	Rev. 0
Page 7-49,	Rev. 0
Page 7-50,	Rev. 0
Page 7-51,	Rev. 0
Page 7-52,	Rev. 0
Page 7-53,	Rev. 0
Page 7-54,	Rev. 0
Page 7-55,	Rev. 0
Page 7-56,	Rev. 0
Page 7-57,	Rev. 0
Page 7-58,	Rev. 0
Page 7-59,	Rev. 0
Page 7-60,	Rev. 0
Page 7-61,	Rev. 0
Page 7-62,	Rev. 0
Page 7-63,	Rev. 0
Page 7-64,	Rev. 0
Page 7-65,	Rev. 0

Line Designation List (continued)

Page 7-66, Rev. 0
Page 7-67, Rev. 0
Page 7-68, Rev. 0
Page 7-69, Rev. 0
Page 7-70, Rev. 0
Page 7-71, Rev. 0
Page 7-72, Rev. 0
Page 7-73, Rev. 0
Page 7-74, Rev. 0
Page 7-75, Rev. 0
Page 7-76, Rev. 0
Page 7-77, Rev. 0
Page 7-78, Rev. 0
Page 7-79, Rev. 0
Page 7-80, Rev. 0
Page 7-81, Rev. 0
Page 7-82, Rev. 0
Page 7-83, Rev. 0
Page 7-84, Rev. 0
Page 7-85, Rev. 0
Page 7-86, Rev. 0
Page 7-87, Rev. 0
Page 7-88, Rev. 0
Page 7-89, Rev. 0
Page 7-90, Rev. 0
Page 7-91, Rev. 0
Page 7-92, Rev. 0
Page 7-93, Rev. 0
Page 7-94, Rev. 0
Page 7-95, Rev. 0
Page 7-96, Rev. 0
Page 7-97, Rev. 0
Page 7-98, Rev. 0
Page 7-99, Rev. 0
Page 7-100, Rev. 0
Page 7-101, Rev. 0
Page 7-102, Rev. 0
Page 7-103, Rev. 0
Page 7-104, Rev. 0
Page 7-105, Rev. 0
Page 7-106, Rev. 0
Page 7-107, Rev. 0
Page 7-108, Rev. 0
Page 7-109, Rev. 0
Page 7-110, Rev. 0
Page 7-111, Rev. 0
Page 7-112, Rev. 0
Page 7-113, Rev. 0
Page 7-114, Rev. 0
Page 7-115, Rev. 0
Page 7-116, Rev. 0
Page 7-117, Rev. 0

Line Designation List (continued)

Page 7-118, Rev. 0
Page 7-119, Rev. 0
Page 7-120, Rev. 0
Page 7-121, Rev. 0
Page 7-122, Rev. 0
Page 7-123, Rev. 0
Page 7-124, Rev. 0
Page 7-125, Rev. 0
Page 7-126, Rev. 0
Page 7-127, Rev. 0
Page 7-128, Rev. 0
Page 7-129, Rev. 0
Page 7-130, Rev. 0
Page 7-131, Rev. 0
Page 7-132, Rev. 0
Page 7-133, Rev. 0
Page 7-134, Rev. 0
Page 7-135, Rev. 0
Page 7-136, Rev. 0
Page 7-137, Rev. 0
Page 7-138, Rev. 0
Page 7-139, Rev. 0
Page 7-140, Rev. 0

Equipment Designation Li

Page 8-1, Rev. 4
Page 8-2, Rev. 0
Page 8-3, Rev. 0
Page 8-4, Rev. 0
Page 8-5, Rev. 0
Page 8-6, Rev. 0
Page 8-7, Rev. 0
Page 8-8, Rev. 0
Page 8-9, Rev. 0
Page 8-10, Rev. 0
Page 8-11, Rev. 0
Page 8-12, Rev. 0
Page 8-13, Rev. 0
Page 8-14, Rev. 0
Page 8-15, Rev. 0
Page 8-16, Rev. 0
Page 8-17, Rev. 0
Page 8-18, Rev. 0
Page 8-19, Rev. 0
Page 8-20, Rev. 0
Page 8-21, Rev. 0
Page 8-22, Rev. 0
Page 8-23, Rev. 0
Page 8-24, Rev. 0
Page 8-25, Rev. 0
Page 8-26, Rev. 0

RR-36	Volumetric exam of Class 2 thin-wall piping
RR-37	Volumetric exam of small-diameter Class 2 piping
RR-38	ASME Section XI; Subsection IWE
RR-39	Mechanized volumetric examination of pressure-retaining shell and head welds in reactor vessel outside the beltline region
RR-40	Notch length in Basic Ultrasonic Calibration Blocks for examination of vessel welds
RR-41	Use of a centrifugally-cast stainless steel (SA-351 CF8A) piping calibration block for the mechanized examination of the reactor vessel nozzle to safe-end welds
RR-42	Volumetric examination of nozzle inner radius section for steam generator inlet and outlet nozzles
RR-43	VT-4 visual examination of snubbers
RR-44	Class 2 piping hydrostatically tested to Class 1 requirements
RR-45	Relief Request withdrawn
RR-46	System pressure test on Class 2 components
RR-47	Relief Request withdrawn
RR-48	Relief Request withdrawn
RR-49	System pressure test on Class 3 vertical pit type pumps
RR-50	System pressure test on Class 3 components
RR-51	Relief Request withdrawn

Component or Relief Area

Volumetric examination of pressure retaining branch pipe connection welds for nominal pipe size 4-inches and greater in Class 1 systems. Affected welds are listed in Attachment 1.

Requirement from which Relief is Requested

Item No. B9.31, Category B-J, Table IWB-2500-1 of ASME Section XI requires a surface and volumetric examination to be performed on branch pipe connection welds. The examination areas are shown in Figures IWB-2500-9, -10 and -11.

Basis for Relief

Examination of branch connection welds is typically difficult due to the configuration of the branch connection fitting and the weld design. For branch connection welds in the VEGP main loop piping, these problems exist in addition to the problems of examining cast stainless steel pipe material.

Two basic weld configurations are used for the branch connection welds on the main loop piping. The 4-inch branch connections were installed using a "set-on" weld design, while the 6-, 10-, 12-, and 16-inch branch connections were installed using a "set-in" design. (See Attachment 2 for configuration.)

Typically, examination coverage of branch connection welds can be obtained by scanning from the main run of pipe using a 45 degree shear wave technique. In this case, due to the cast stainless steel material used in the main loop piping, the examination is limited to a 1/2 node examination using a 45 degree refracted longitudinal (RL) wave technique developed for this piping material.

Examination of the 4-inch branch connection welds from the main run of piping using the 1/2 node RL wave is not possible due to the geometry of the "set-on" configuration. However, partial coverage of the 6-, 10-, 12-, and 16-inch branch connection welds from the main run using the 1/2 node RL technique is possible because of the "set-in" configuration. Approximately 40 percent of the Code-required volume (one beam direction only) for the 6-, 12-, and 16-inch branch connection welds can be examined using this technique. Approximately 100 percent of the Code-required volume can be examined on the 10-inch branch connection welds from the pipe side by scanning across the weld (one beam direction only) using the 1/2 node RL technique.

VEGP-2

RR-21 (Cont'd)

To increase examination coverage and provide a two-directional examination, scanning from the branch connection side will also be used where possible. The forged stainless steel material used in all but the 10-inch branch connections allows the use of shear wave ultrasonic techniques, however the geometry of the fittings still presents problems in obtaining Code-required examination coverage.

Alternate Examination

Based on plots and calculations, it was determined that the only feasible examination from the branch connection side would be a refracted shear wave technique from the taper of the fitting. This technique relies on the ability of the shear wave to reflect off of the inner wall of the fitting bore. Calibration blocks were built with a 10% notch for sensitivity and 3/16 inch side drilled holes for establishing a DAC curve. Use of this technique should result in approximately 85 percent of the Code-required volume being examined on the 4-inch branch connections and approximately 50 percent of the Code-required volume in one direction for the 6-, 12-, and 16 inch branch connections.

The fitting side of the 10-inch branch connection is cast stainless steel which precludes the use of a shear wave technique. Also, due to the geometry of the part, examination from the branch connection side using the 1/2 node RL technique is not feasible.

Attachment 1 lists each weld for which relief is requested and delineates the expected coverage using the techniques discussed above in conjunction with the applicable calibration block. The Code-required surface examination will be performed.

VECP-2, RR-21
ATTACHMENT 1

<u>Identification No.</u>	<u>Code Category</u>	<u>Description</u>	<u>Calibration Block</u>	<u>ISI Limitations</u>
21201-001-2	B-J	12" Branch Connection	353A	40% Exam from pipe side 50% Exam from branch side (Note 1)
21201-002-2	B-J	6" Branch Connection	350A	40% Exam from pipe side 50% Exam from branch side (Note 1)
21201-003-2	B-J	6" Branch Connection	350A	40% Exam from pipe side 50% Exam from branch side (Note 1)
21201-004-2	B-J	16" Branch Connection	352A	40% Exam from pipe side 50% Exam from branch side (Note 1)
21201-004-3	B-J	12" Branch Connection	353A	40% Exam from pipe side 50% Exam from branch side (Note 1)
21201-009-4	B-J	4" Branch Connection	351A	0% Exam from pipe side, 85% Exam from branch connection taper
21201-009-6	B-J	10" Branch Connection	331A	100% Exam from pipe side 0% Exam from branch side
21201-010-4	B-J	10" Branch Connection	331A	100% Exam from pipe side 0% Exam from branch side
21201-011-5	B-J	10" Branch Connection	331A	100% Exam from pipe side 0% Exam from branch side
21201-012-4	B-J	4" Branch Connection	351A	0% Exam from pipe side, 85% Exam from branch connection taper
21201-012-6	B-J	10" Branch Connection	331A	100% Exam from pipe side 0% Exam from branch side

Note 1: Examination unidirectional.

Component or Relief Area

Volumetric examination of pressure-retaining circumferential welds in 10-inch diameter Safety Injection piping made of SA-376 and SA-312 grade material. Affected welds and any limitations are listed in Attachment 1.

Requirements from which Relief is Requested

Item No. B9.11, Category B-J, Table IWB-2500-1 and Item No. C5.21, Category C-F, Table IWC-2500-1 of ASME Section XI require a surface and volumetric examination of circumferential piping welds. The required examination volume is shown in Figure IWB-2500-8(b) and IWC-2500-7(b). Article III-4420 requires that the examinations shall be performed using a sufficiently long examination beam path to provide coverage of the required examination volume in two beam-path directions. The examination shall be performed from two sides of the weld, where practicable, or from one side of the weld as a minimum. Article III-4430 requires that the angle beam examination for reflectors transverse to the weld shall be performed on the weld crown on a single scan path to examine the weld root by one-half v-path in two directions along the weld. Article III-2430 requires that manual scanning shall be done at twice (+6dB) the primary reference at a minimum. A meaningful ultrasonic examination could not be accomplished on the SA-376 and SA-312 material using conventional shear-wave techniques. Since a 1/2 node examination using a refracted 45 degree longitudinal wave was found to be the superior technique, relief is requested from the above requirements.

Basis for Relief

Physical limitations exist due to the geometric configuration of some joints. Additionally, the SA-376 and SA-312 material exhibits severe angular variations and significant attenuation problems during a typical shear-wave ultrasonic examination. This was determined to be caused by a severely banded microstructure. However, a refracted-longitudinal wave, which is a 1/2-node examination technique, was found to be the best technique during PSI. During calibration for the refracted L-wave examination, the primary reference level will be set using side-drilled holes. Scanning was possible only at the primary reference level due to the excessive noise associated with the metallurgical structure of the material. On pipe to valve configurations, the weld was examined on the pipe side using the half-node technique. Scanning from the valve side was not possible due to valve geometry. On pipe to tee configurations, the weld was examined on the pipe side using the half-node technique. Only partial scanning from the tee was possible due to geometry.

Alternate Examination

The Code-required surface examination will be performed. A refracted longitudinal wave examination, as described in the "Basis for Relief", will be performed to the extent practical as listed in Attachment 1.

VEGP-2

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VEGP-2, RR-36
Attachment 1

<u>Identification No.</u>	<u>Description</u>	<u>Percentage Examined During PSI</u>	<u>Restriction</u>
21206-001-29	12" Pipe to Elbow	96%	100% Exam from pipe side 92% Exam from Elbow side Restricted Access due to Branch Connection
21206-001-37	10" Reducer to Flange	50%	100% Exam from reducer side 0% Exam from Flange side
21206-004-4	10" Valve to Reducer	50%	100% Exam from reducer side 0% Exam from Valve side
21206-004-11	12" Flange to Reducer	50%	100% Exam from reducer side 0% Exam from Flange side
21206-004-12	10" Reducer to Flange	50%	100% Exam from reducer side 0% Exam from Flange side
21206-005-1	8" Flange to Pipe	50%	100% Exam from pipe side 0% Exam from Flange side
21206-006-1	8" Flange to Pipe	50%	100% Exam from pipe side 0% Exam from Flange side
21208-137-12	8" Pipe to Valve	50%	100% Exam from pipe side 0% Exam from Valve side
21208-411-2	8" Pipe to Valve	50%	100% Exam from pipe side 0% Exam from Valve side
21208-411-48	8" Pipe to Tee	83%	100% Exam from pipe side 65% Exam from Tee side

VEGP-2

RR-51

RELIEF REQUEST WITHDRAWN

VEGP-2

RR-51

Attachment 1

RELIEF REQUEST WITHDRAWN

VEGP-2

RR-52

Component or Relief Area

Surface examination of Integrally Welded Attachments on the Reactor Vessel Closure Head.

Examination ID No. - 21201-V6-001-W204
21201-V6-001-W205
21201-V6-001-W206

Requirement from which Relief is Requested

Item No. B8.10, Category B-H, Table IWB-2500-1 of ASME Section XI requires a surface examination of integrally welded attachments on the reactor vessel. Applicable examination area is shown in Figure IWB-2500-15.

Basis for Relief

Geometric configuration and location of the CRD support braces presents physical limitations that prevent complete coverage of the RPV Closure Head lifting lugs required for the surface examination.

For the reasons described above, GPC has determined that implementation of the Code requirements is impractical. Accordingly, relief from the Code requirements is sought from the NRC as allowed by 10 CFR 50.55a (g)(5)(iii).

Alternate Examination

Due to physical limitations discussed above, approximately 50% of the weld length of the RPV Closure Head lifting lugs will be examined as during the Preservice Inspection.

7.0 LINE DESIGNATION LIST

7.1 Scope

The lines listed in the Line Designation List are within the scope of the ASME Code, Section XI. The examination method for each individual line also is designated. (Note: The Line Designation List contained in this document is for information only.)

7.2 Systems

The Line Designation List includes the following systems:

<u>System</u>	<u>System No.</u>
Reactor Coolant	1201
Nuclear Service Cooling Water	1202
Component Cooling Water	1203
Safety Injection	1204
Residual Heat Removal	1205
Containment Spray	1206
Chemical and Volume Control	1208
Nuclear Sampling-Liquid	1212
Spent Fuel Cooling and Purification	1213
Containment and Auxiliary Building Drains - Radioactive	1214
Auxiliary Building and Misc. Drains	1215
Auxiliary Component Cooling Water	1217
Miscellaneous Leak Detection	1222
Reactor Make-Up Water Storage Tank	1228
Main Steam	1301
Auxiliary Feedwater	1302
Condensate and Feedwater	1305
Condensate Chemical Injection	1411
Plant Demineralized Water	1418

8.0 EQUIPMENT DESIGNATION LIST

8.1 Scope

The equipment listed in the Equipment Designation List are within the scope of ASME, Section XI. The examination method for each piece of equipment also is designated. (Note: The Equipment Designation List contained in this document is for information only.)

8.2 System

The Equipment Designation List includes the following systems:

<u>System</u>	<u>System No.</u>
Reactor Coolant	1201
Nuclear Service Cooling Water	1202
Component Cooling Water	1203
Safety Injection	1204
Residual Heat Removal	1205
Containment Spray	1206
Chemical and Volume Control	1208
Spent Fuel Cooling and Purification	1213
Auxiliary Component Cooling Water	1217
Auxiliary Feedwater	1302
Containment Heat Removal	1501
Containment CRDM Cavity and Reactor Support Cooling	1511
Containment Heat Removal	1515
Control Building, Control Room Heating, Ventilation, and Air-Conditioning	1531
Control Building Safety Feature Electric Equipment Room HVAC	1532
Containment Building Cable Spreading Room HVAC	1539
Engineered Safety Features Room Cooler	1555