

**DUKE POWER COMPANY**

P.O. BOX 33189  
CHARLOTTE, N.C. 28242

HAL B. TUCKER  
VICE PRESIDENT  
NUCLEAR PRODUCTION

TELEPHONE  
(704) 373-4531

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December 15, 1983

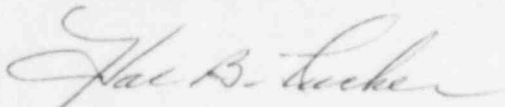
Mr. James P. O'Reilly, Regional Administrator  
U. S. Nuclear Regulatory Commission  
Region II  
101 Marietta Street, NW, Suite 2900  
Atlanta, Georgia 30303

Re: Catawba Nuclear Station  
Unit 2  
Docket No. 50-414

Dear Mr. O'Reilly:

Pursuant to 10 CFR 50.55e, please find attached a supplement to Significant Deficiency Report SD 414/82-25.

Very truly yours,



Hal B. Tucker

LTP/php

Attachment

cc: Director  
Office of Inspection & Enforcement  
U. S. Nuclear Regulatory Commission  
Washington, D. C. 20555

NRC Resident Inspector  
Catawba Nuclear Station

Palmetto Alliance  
2135½ Devine Street  
Columbia, South Carolina 29205

INPO Records Center  
Suite 1500  
1100 Circle 75 Parkway  
Atlanta, Georgia 30339

Mr. Robert Guild, Esq.  
Attorney-at-Law  
P. O. Box 12097  
Charleston, South Carolina 29412

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Duke Power Company  
Catawba Nuclear Station

Report Number: SD 414/82-25, Supplemental Response

Report Date: December 15, 1983

Facility: Catawba Nuclear Station  
Unit 2

The following is a supplement to the corrective action as described in the initial report of January 28, 1983 and final report of September 2, 1983.

- 1) A communication error resulted in one Class 3 open butt weld by Welder M59 being radiographed during the radiographic investigation to determine the extent of Welder #600's lack of penetration problem. This weld was found to have lack of penetration in isolated areas. An additional fifteen (15) of M59's Class 3 open butt welds were selected at random and radiographed. Only 4.3% of this weld length had any lack of penetration. Most of this was minor (less than .030" in depth). The largest indications of lack of penetration by M59 were evaluated by Design, Construction and QA and were found to be insignificant.
- 2) A review of Class 3 open butt root passes, made accessible for I.D. inspection by an adjacent cut out, was conducted in 1982. This revealed only one (1) occurrence of lack of penetration being documented during the period January 1, 1982 to December 31, 1982. The welds that were cut out were made originally at various times dating back to the early stages of our construction (1976-1977). The one (1) occurrence documented (NCI 14468) was of a minor nature.

QA Procedure M-4 presently requires visual inspection of all Class 1, 2, and 3 weld root passes made visually accessible by an adjacent cut out. Discrepancy Reports (R-2As) are generated on root problems when identified. This inspection/trending will continue throughout the construction phase.

- 3) A Construction Procedure (CP-823) has been generated for the Welding Superintendent to use as an administrative tool in assuring complete penetration on Class 3 welds. Periodically, randomly selected Class 3 open butt closure welds are radiographed. Duke Power Company's Level III Inspector evaluates these radiographs and forwards his evaluation to the Welding Superintendent.