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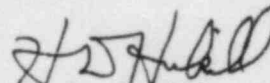
Mr. R. C. Haynes
Region I, Regional Administrator
U. S. Nuclear Regulatory Commission
631 Park Avenue
King of Prussia, PA. 19406

Dear Mr. Haynes:

Three Mile Island Nuclear Station, Unit I, (TMI-1)
Operating License No. DPR-50
Docket No. 50-289
IE Bulletin 83-07

This letter is in response to your letter of July 22, 1983 forwarding IE Bulletin 83-07 concerning apparently fraudulent products sold by Ray Miller, Inc. This letter is being submitted 3 days late as discussed with R. Conte.

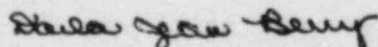
Sincerely,


H. D. Hukill,
Director, TMI-1

HDH:RAS:mle
Enclosures

cc: R. Conte

Sworn and Subscribed to
Before me this 29th day
of March, 1984.



DARLA JEAN BERRY, NOTARY PUBLIC
MIDDLETOWN BORO, DAUPHIN COUNTY
MY COMMISSION EXPIRES JUNE 17, 1985
Member, Pennsylvania Association of Notaries

8404170096 840328
PDR ADOCK 05000289
Q PDR

GPU Nuclear Corporation is a subsidiary of the General Public Utilities Corporation

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RESPONSE TO IE BULLETIN 83-07

1. GPUN has contacted, via certified letter, those companies listed in the fraudulent data file of IE Bulletin 83-07 which may have supplied suspect Ray Miller, Inc., materials to TMI-1. Of these inquiries, only one company, RECO Industries, Inc., has identified itself as having supplied Ray Miller material, to TMI-1. This material was supplied through Babcock and Wilcox Company, and purchased under purchase order B&W P.O. 81259LT. A list of companies contacted is enclosed as Attachment 3. Responses from companies contacted by GPUN are maintained onsite.

GPUN has identified by its own initiative three (3) purchase orders for material procured directly from Ray Miller, Inc. This material was purchased under Metropolitan Edison Company purchase orders: P.O. 32765, P.O. 44816, and P.O. 17247.

2. For Material purchased under B&W P.O. 81259LT end-use has been identified. A description and evaluation of material used in safety related systems is enclosed as Attachment 1.

Of material purchased directly, only P.O. 17247 was ordered for use in safety related systems. A description and evaluation of this material is enclosed as Attachment 2.

3. As stated in response to Item 2 above, end-use of material purchased under P.O. 17247, designated for use in safety-related systems, could not be determined. This material was specifically ordered as spare tubing. Quality Control designation precludes use of non-qualified material in safety-related systems. However, Q.C. designated material, such as that purchased under P.O. 17247, may be used in systems which are not safety-related. In any event, the 'worst case' analysis performed in Attachment 2 concludes that safety or pressure integrity is not adversely affected.

Material purchased under P.O. 32756 and P.O. 44816 was designated as non-QC and would not have been used in safety-related systems.

ATTACHMENT 1

Purchase Order No: 81259.LT
Item: Make-Up Tank
Item No: 5
B&W Drawing: 75 235A
RECO Job No: L8802
Shipped To: Three Mile Island

Description of Material:

<u>Service</u>	<u>Description</u>
Nozzle D Pressure	1" S.W. Half Cplg 2000# T-304
Nozzle E Vent	1" S.W. Half Cplg 2000# T-304
Nozzle F Sample	1" S.W. Half Cplg 2000# T-304
Nozzle G Level	1" S.W. Half Cplg 2000# T-304
Nozzle J Gas Inlet	1" S.W. Half Cplg 2000# T-304
Nozzle H Temp	3/4" Thd Cplg 2000# T-304
Nozzle C Relief	1" 150# WNF Sch 80 T-304, HT #HE934
Nozzle C Relief	1" Sch 80 Smls Pipe T304, HT #E15022
Nozzle B Inlet	4" Sch 40 Smls Pipe T304, HT #E14742
Nozzle K Outlet	4" Sch 40 Smls Pipe T304, HT E#14742

The material supplied for the make-up tank nozzles was specified to be Type 304, austenitic stainless steel. Extra low carbon content was not specified and while the use of seamless pipe for these nozzles may be preferred the low pressure and temperature conditions indicate that the potential substitution of welded and drawn pipe should not present a significant safety hazard. Additionally, this material was not supplied during the time-frame in which NRC identified fraudulent practices took place.

Flange

The design pressure of the TMI-1 Make-Up Tank is 100 psig at 200°F. Assuming that the 1" - 150# welding neck flange was made of "L" grade stainless steel in lieu of the specified straight 304 grade, (the most plausible postulated fraudulent action by Ray Miller Inc. on this item) the pressure rating for the flange at 200°F is 195 psig, much greater than the required 100 psig.

Couplings

The couplings and half couplings supplied are Ladish 2000# rated. Ray Miller, Inc. was accused of fraudulently certifying low rated pipe plugs as high pressure items. No evidence of fraud involving couplings is referenced; furthermore, these couplings are dimensionally identical to 3000# ratings per ANSI-B16.11.

ATTACHMENT 1 (CONT.)

Pipe Nozzles

The required pipe material is ASTM-A312 TP 304 seamless. Ray Miller, Inc., was accused of fraudulently certifying welded pipe as seamless pipe. By inspection of the ASME Section III Appendices for Class 2 pipings, the allowable stress values for ASTM-A312 Gr. 304 is identical for both seamless or welded pipe. Therefore, even if welded pipe was supplied as opposed to the required seamless pipe, there is no impact on safety or pressure integrity.

Based on the above, it is concluded that the fraudulent practices of Ray Miller have no impact on safety or pressure integrity in the case of the TMI-1 Make-Up Tank.

ATTACHMENT 2

Purchase Order No. 17247

Material purchased was specified as spare stainless steel tubing for use in N2 and N3 QC systems. This material was purchased from Ray Miller, Inc., W. Cladwell, New Jersey, not the Charleston, West Virginia office where fraudulent practices, identified in the subject Bulletin, took place. This material was QC receipt inspected at TMI-1 on 9-15-75 and associated traceable chemical and physical mill test reports approved on 10-14-75.

During the time period in question end-uses of material were not identified on stores issuance records. Therefore the material was evaluated for worst service conditions.

Description of Material

Tubing	-1/4"	O.D. x .049 wall, A-213 TF 304 Seamless
Tubing	-3/8"	O.D. x .065 wall, A-213 TP 304 Seamless
Tubing	-1/2"	O.D. x .083 wall, A-213 TP 304 Seamless

The tubing in question was assumed for installation in TMI-1 systems where pressures and temperatures are highest, (i.e.; Pressure = 2500 psi, temperature - 670⁰ F).

Engineering computations for pressure integrity indicates that the tubing supplied is adequate for the above mentioned service conditions, even if "L" grade and welded stainless tubing was supplied. Therefore, it is concluded that the fraudulent practices by Ray Miller, Inc. have no impact on safety or pressure integrity in the case of TMI-1 Pressure Systems.

COMPANIES LISTED IN IE BULLETIN 83-07 WHICH HAVE SUPPLIED
MATERIALS OR SERVICES TO TH-1

ABBE, PAUL O. 139 CENTER AVENUE LEFALLS, NJ 07424	* CAPITAL P&H SUPPLY 1900 SOUTH 8TH STREET SPRINGFIELD, IL 62703
AIR PREHEATER CO. PLANT #5 WELLSVILLE, NY 14895	CHEM FLOW INC. 707 LYNDON AVENUE ROSEMONT, IL 60018
* AIR PRODUCTS AND CHEMICALS 2500 YANKEE ROAD MIDDLETON, OH 45042	* CHEMETRON CORP. PIGMENTS DIV., P.O. BOX 2166 HUNTINGTON, WV 25722
AMCHEM PRODUCTS INC. AMBLER, PA 19002	CINCINNATI FASTENERS CO. 16 E. 73RD STREET CINCINNATI, OH 45216
ANCHOR PRECISION PRODUCTS, INC 26 ESSEX STREET HACKENSACK, NJ 07601	CRANE SUPPLY CO. 207 S. CENTRAL AVENUE LIMA, OH 45802
AQUA CHEMICAL INC. 240 W. CAPITOL DRIVE MILWAUKEE, WI 53212	DOLLINGER CORP. 1 TOWNLINE CIRCLE ROCHESTER, NY 14603
* ARGO WELDED PRODUCTS ALPHA INDUSTRIAL PARK PHILLIPSBURG, NJ 08865	DRAVO CORP. P. O. BOX 488 BELPRE, OH 45714
BABCOCK AND WILCOX CO. 609 WARREN AVENUE APOLLO, PA 15613	DRAVO CORP. P.O. BOX 1669 LIMA, OH 45802
BAKER, J. T. CHEMICALS CO. 600 NORTH BROAD STREET PHILLIPSBURG, NJ 08865	DRESSER INDUSTRIES, IN.C N. 8TH STREET OLEAN, NY 14760
BENDIX CORP. U.S. 219 N LEWISBURG, WV 25901	EMERSON ELECTRIC CO. BROOKS INSTRUMENT DIV. HATFIELD, PA 19440
BETHLEHEM STEEL CORP. JOHNSTOWN, PA 15907	GENERAL ELECTRIC CO. 5338 WEST 16TH STREET CICERO, IL 60650
BRIGHTON CORP. 11861 MOSTELLER ROAD CINCINNATI, OH 45241	GENERAL ELECTRIC CO. 6071 ST. ANDREWS ROAD COLUMBIA, SC 29210
BUFFALO TANK 5349 HIGHWAY AVENUE JACKSONVILLE, FL 32205	

* - No Response Received

COMPANIES LISTED IN IE BULLETIN 83-07 WHICH HAVE SUPPLIED
MATERIALS OR SERVICES TO TMI-1

GENERAL ELECTRIC CO.
HWY 69 WEST - CONST. GATE #A
MT. VERNON, IN 47620

GOULD, INC.
FLORAL DIV., OHIO ST. RTE 60
MCCONNELLSVILLE, OH 43956

GTE SYLVANIA
TOWANDA, PA 18848

GULF & WESTERN ENERGY PRODUCTS
READING ROAD
NORTH BRANCH, NJ 08876

* HAJOCA CORP.
515 EAST 11TH STREET
CHATTANOOGA, TN 37403

HAJOCA CORP.
BOX 147
KINGSPORT, TN 37662

HUNTINGTON ALLOYS, INC.
RIVERSIDE DRIVE
HUNTINGTON, WV 25720

JOY MANUFACTURING COMPANY
3101 BROADWAY
BUFFALO, NY 14225

KEYSTONE TUBULAR SERV. CORP.
BOX 992
BUTLER, PA 16001

LESLIE & ELLIOT
EAST RAILWAY & IOWA AVENUE
PATTERSON, NJ 07503

LESLIE & ELLIOT CO.
GRANITE & WEST STREET
MIDLAND PARK, NJ

MIDCO PIPE & TUBE
370 FERRY STREET
MARTINEZ, CA 94553

MURRAY, A. B.
GREEN LANDE
UNION, NJ 07083

NATIONAL PIPE BENDING
110 RIVER STREET
NEW HAVEN, CT 06573

NAZARETH STEEL FABRICATORS
539 S. MAIN STREET
NAZARETH, PA 18064

OHIO PIPE & SUPPLY CO., INC.
14615 LORAIN AVENUE
CLEVELAND, OH 44111

PARAMUS METAL FABRICATORS
ROUTE 11, OFF ROUTE 4
PARAMUS, NJ 07652

PEC - ATTN: D. A. CARLSON
WARREN C. T. STATION
WARREN, PA 16365

PER MUTIT
1915 OLD PHILADELPHIA PIKE
LANCASTER, PA 17604

PERSINGERS INC.
P.O. BOX 1866 - ELIZABETH ST.
CHARLESTON, WV 25327

PITTSBURGH - DES MOINES STEEL
1420 LEXINGTON AVENUE
WARREN, PA 16365

PULLMAN SHEET METAL
1400 EAST 97TH PLACE
CHICAGO, IL 60628

RARITAN SUPPLY CO.
MEADOW ROAD
EDISON, NJ 0881

RECO
BOX 25189
RICHMOND, VA 23260

* SOUTHERN HEAT EXCHANGER
HIGHWAY 82-SOUTH
TUSCALOOSA, AL 35401

COMPANIES LISTED IN IE BULLETIN 83-07 WHICH HAVE SUPPLIED
MATERIALS OR SERVICES TO TMI-1

SOUTHWEST STAINLESS OF GA INC.
P.O BOX 587
NORCROSS, GA 30071

- * STAINLESS & ALLOY
READING ROAD OFFICE, ROUTE 22
NORTH BRANCH, NJ 08876

STAUFFER CHEMICAL CO.
GALLIOPOLIS FERRY, WV 25515

TURBODYNE CORP.
WELLSVILLE, NY 14895

- * VULCAN MFG. CO.
P.O. BOX 46465
CINCINNATI, OH 45246

VULCAN SUPPLY & METALS CO.
535 READING ROAD
CINCINNATI, OH 45202

WEIRTON STEEL
DIV. NAT'L STEEL CORP.
WEIRTON, WV 26062

WIDES PIPE AND SUPPLY CO.
1728 JOHN STREET
CINCINNATI, OH 45217