

CONSUMERS POWER COMPANY
MIDLAND ENERGY CENTER

DmB

Transmittal No: CSC-7732

Date: May 9, 1984

To: Stone & Webster
P O Box 1963
Midland, MI 48640

Attached Is: ☐ Partial Response To
☒ Complete Response To
☐ For Your Information
☐ Other

PRINCIPAL STAFF		
✓ PA	✓ DE	
D/RA	DE	
A/RA	DRMSH	
RC	DPMA	
PAO	SCS	<i>Aug +3 ✓</i>
SGA	ML	
ENF	File	<i>✓</i>

Description:

Tracked Information Item 072.

Signature: *NI Reichel*

cc: JGKeppler, NRC Region III w/a
JJHarrison, NRC Region III w/a
RJCook, NRC Site w/a
RAWells, MPQAD w/a
BHreck, MEC w/a
NIReichel, MEC w/a
DDJohnson, MEC w/a

8405210224 840509
PDR ADOCK 05000329
A PDR

IEO!
MAY 14 1984

ITEM/HOLD POINT NOTIFICATION FORM

Sheet 1 of 1

STONE & WEBSTER
CONSTRUCTION IMPLEMENTATION
OVERVIEW

MIDLAND NUCLEAR PLANT J.O. NO. 14509

ITEM NUMBER

072

HOLD POINT NUMBER

☐ TRACKED ACTION ITEM☒ TRACKED INFORMATION ITEM☐ TRACKED RECOMMENDATION ITEM☐ UNTRACKED ITEM☐ HOLD POINT NOTIFICATION

REFERENCE(S)

ANSI N45.2 Section 7

CONDITION DETAILS

The following approved B&W NDE procedures lack consistency in specifying the procedure, page and revision number as applicable.

- A) Procedure NDE PQ-RT - 200 Δ consist of 3 pages
Page 1 of 3 reads: NDE-PQ-RT-200 Page 1 of 3 Revision 1
Page 2 of 3 reads: 9T-RT-200 Page 2 of 3 No Revision specified
Page 3 of 3 reads: 9T-RT-200 Page 3 of 3 No Revision specified
- B) Procedure NDE-PQ-RT-201 Δ consist of 3 pages
Pages 2 of 3 and 3 of 3 lack procedure number and revision
- C) Procedure NDE-PQ-RT-202 Δ consist of two pages
Pages 1 & 2 lack page number

What action is being taken to resolve the identified inconsistencies?

☐ YES (PAGE NO'S)☒ NO

ATTACHMENTS

DATE RESPONSE REQ'D.

4-23-84

INITIATOR/DATE

Ronald E. Horne 04-11-84

INITIATION APPROVED/DATE

Not Acting for JEC 4-11-84

RESPONSE (SEE NOTE)

Attached Bechtel Letter BCCC-9287 dated April 30, 1984 has been reviewed by CPCo SMO and determined to provide a complete response to this item.

☐ YES (PAGE NO'S)☐ NO

ATTACHMENTS

EST. CORRECTIVE ACTION
COMPLETION DATE

NA

RESPONDENT

M. I. Reichel

TITLE

Hest. Const. Spt.

DATE

5/9/84

RESPONSE ACCEPTED

DATE

RESPONSE VERIFIED/CLOSED

DATE

NOTE - FOR TRACKED ACTION ITEMS ONLY. EXPLAIN CLEARLY OR REFERENCE ATTACHMENTS FOR:

1) CAUSE OF OBSERVED CONDITION 2) CORRECTIVE ACTION TAKEN 3) PREVENTIVE ACTION TAKEN

(KA)

#84

Bechtel Power Corporation

Post Office Box 2167
Midland, Michigan 48640



April 30, 1984

Consumers Power Company
P.O. Box 1963
Midland, Michigan 48640

Attention: D. L. Quamme
Site Manager

Midland Plant Units 1 & 2
Bechtel Job 7220
STONE & WEBSTER OVERVIEW
ITEM NO. 072
BCCC-9287

Dear Mr. Quamme:

This is considered as Construction's final response to Stone and Webster Overview Item No. 072.

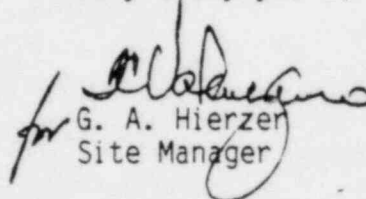
Procedure NDE-PQ-RT-200 Revision 1, Page 2 of 3 and Page 3 of 3, have been annotated with PQ-RT-200 Revision 1.

Procedure NDE-PQ-RT-201 Revision 1, Page 2 of 3 and Page 3 of 3, have been annotated with PQ-RT-201 Revision 1.

Procedure NDE-PQ-RT-202 Revision 0, Pages 1 and 2 have been page numbered.

If you have any questions, please contact John Russell at extension 7594.

Very truly yours,


G. A. Hierzen
Site Manager

GAH/JER/ajd

Attachments: 1) NDE-PQ-RT-200, Rev. 1
2) NDE-PQ-RT-201, Rev. 1
3) NDE-PQ-RT-202, Rev. 0

cc: N. Reichel

BABCOCK & WILCOX
B&W CONSTRUCTION COMPANY
NONDESTRUCTIVE EXAMINATION

RADIOGRAPHIC PROCEDURE QUALIFICATION

MATERIAL TYPE Carbon, Low Alloy & Stainless Steels

MATERIAL THICKNESS .150"

MATERIAL THICKNESS RANGE CERTIFIED .150" through 3-1/2"

TYPE OF RADIATION SOURCE Iridium-192

PHYSICAL SIZE OF ISOTOPE SOURCE .010 x .010 (effective source size .141)

MINIMUM SOURCE TO FILM DISTANCE See Attached Sketch

FILM DISTANCE TO OBJECT Intimate contact

FILM TYPE & BRAND Type 1, Dupont 45

NUMBER OF FILM IN CASSETTE Two

FILM TO BE VIEWED Single

TYPE & THICKNESS OF SCREENS & FILTERS .010 lead screens front and back.

BLOCKING & MASKING IF USED None

GEOMETRIC ARRANGEMENTS FOR THE RADIOGRAPHS (SKETCH) See Attached Sketch.

ORIENTATION OF LOCATION MARKERS See Attached Sketch

INTERNAL MARKERS None

WELDING PROCESS Manual Gas Tungsten Arc and/or Shielded Metal Arc Welding

APPROVED BY

C. D. Thompson
B&W CONSTRUCTION COMPANY

DATE

4-16-75

IDENTIFICATION:

NDE-PQ-RT-200

WITNESSED BY

H. M. Long
AUTHORIZED INSPECTOR

DATE

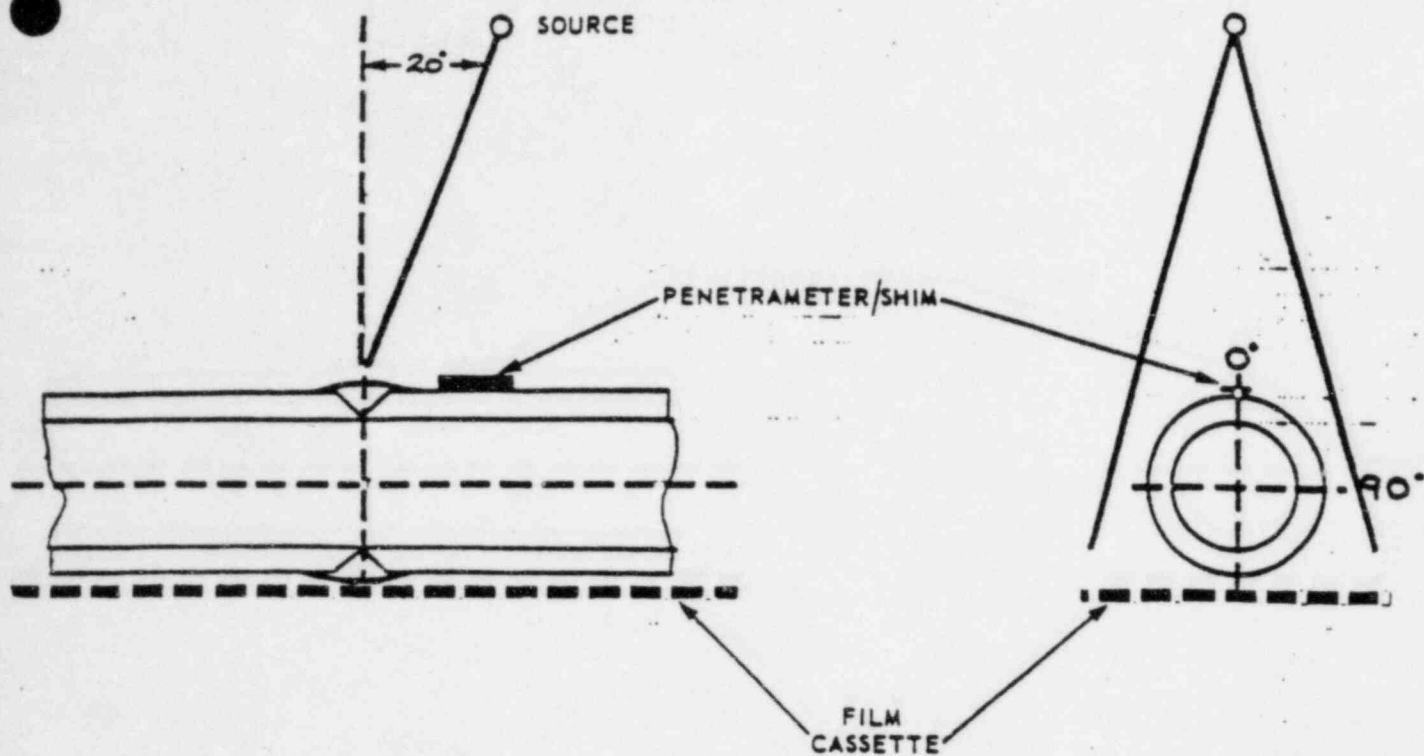
4-16-75

REV. 1

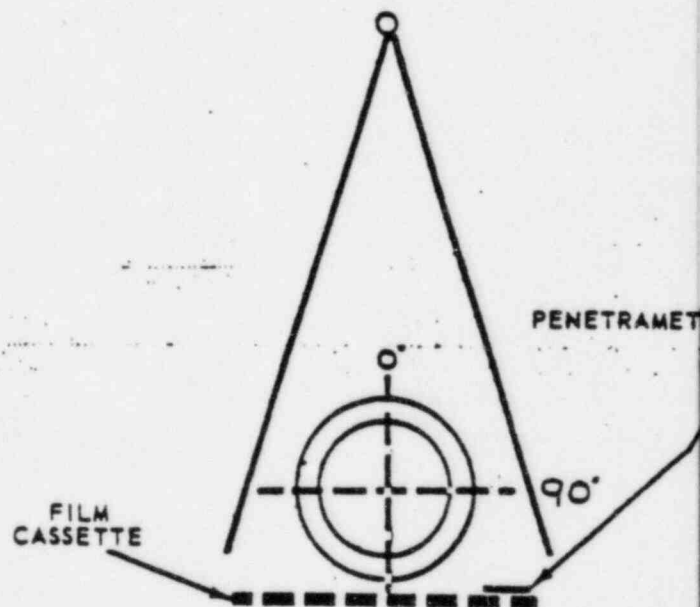
HSB - Ohio-1143
N.B. 2526

BABCOCK & WILCOX
B&W CONSTRUCTION COMPANY

INSPECTION SKETCH



PIPE DIAMETER: .841
WALL THICKNESS: .150
SOURCE TO FILM DISTANCE: 12"



Subject: RADIOGRAPHIC EXAMINATION OF
CIRCUMFERENTIAL BUTT WELDS
USING IRIIDIUM-192

Contract N/A

Sketch by R. C. SULZER

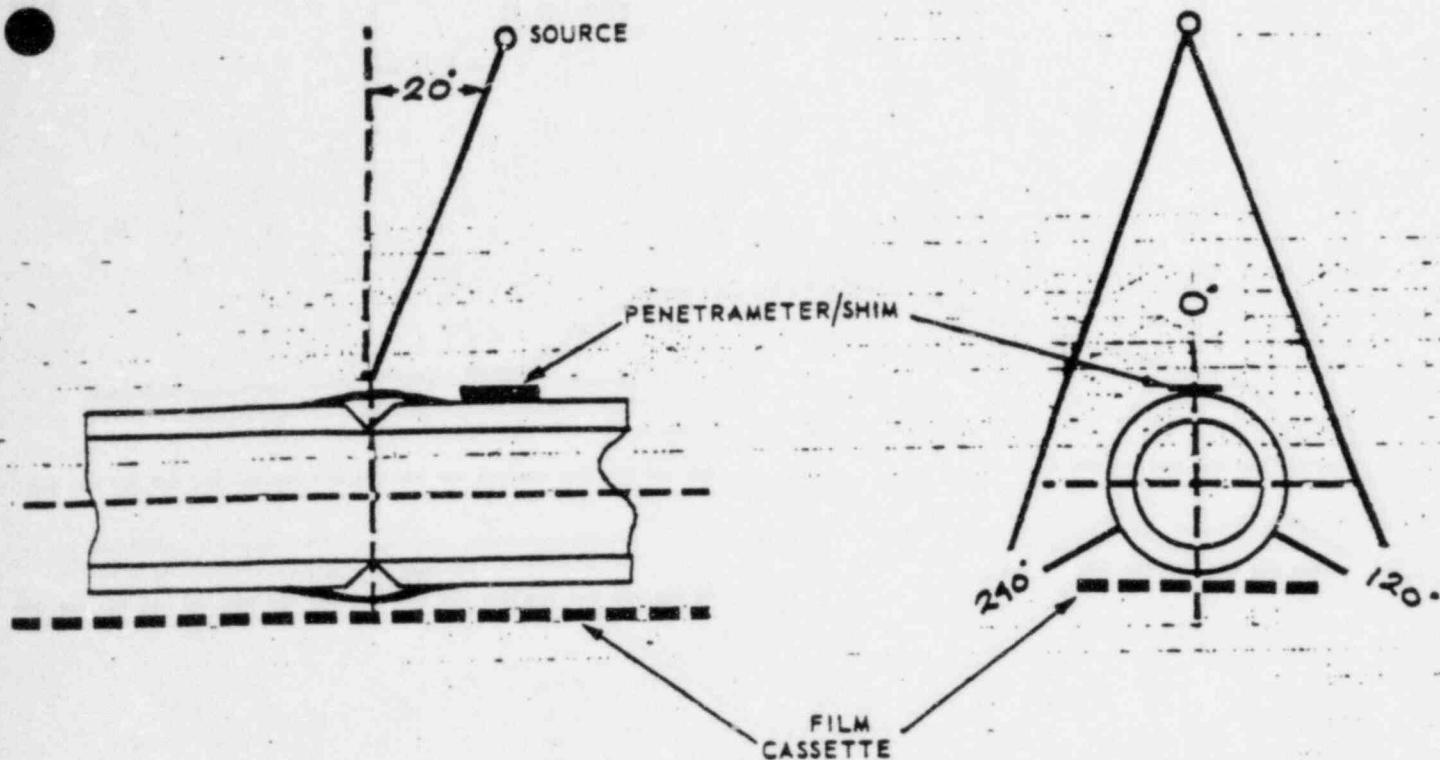
SUPPLEMENTS REPORT OF INSPECTION

Number NDE-PQ-RT-200, Rev. 1

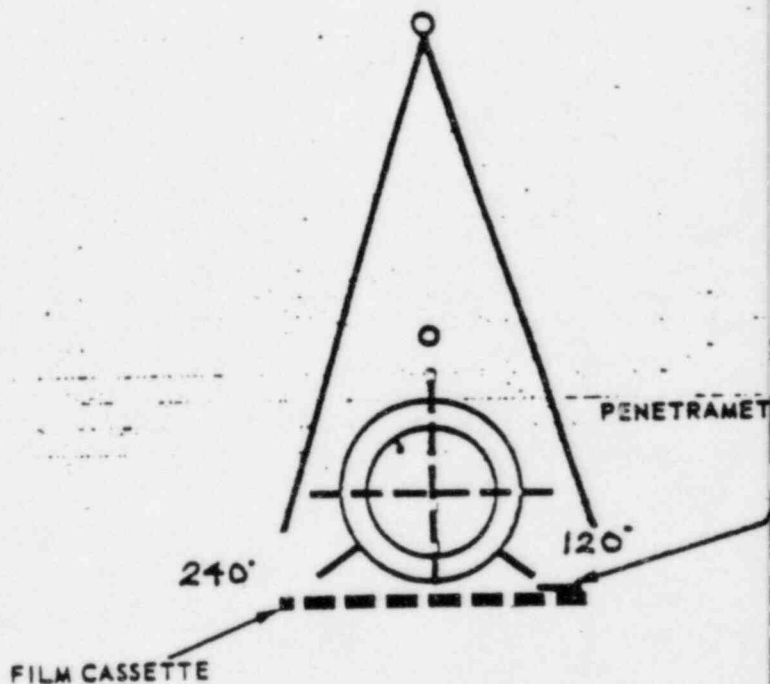
Sketch No. N/A

Revision N/A

INSPECTION SKETCH



PIPE DIAMETER: .841
WALL THICKNESS: .150
SOURCE TO FILM DISTANCE: 12"



Subject: RADIOGRAPHIC EXAMINATION OF
CIRCUMFERENTIAL BUTT WELDS
USING IRIIDIUM-192

Contract N/A

Sketch by R. C. SULZER

SUPPLEMENTS REPORT OF INSPECTION

Number NDE-PQ-RT-200, Rev. 1

Sketch No. N/A

Revision N/A

Page 3

BABCOCK & WILCOX
B&W CONSTRUCTION COMPANY
NONDESTRUCTIVE EXAMINATION

RADIOGRAPHIC PROCEDURE QUALIFICATION

MATERIAL TYPE Carbon, Low Alloy, & Stainless Steel

MATERIAL THICKNESS 2" thru 6", inclusive

MATERIAL THICKNESS RANGE CERTIFIED 2" to Maximum to be Radiographed

TYPE OF RADIATION SOURCE Cobalt 60

PHYSICAL SIZE OF ISOTOPE SOURCE .125 Diameter Sphere

MINIMUM SOURCE TO FILM DISTANCE 14"

FILM DISTANCE TO OBJECT Intimate Contact

FILM TYPE & BRAND Type 1, Dupont 55 Type II, Dupont 65

NUMBER OF FILM IN CASSETTE As required, two film min.

FILM TO BE VIEWED Single or composite, as required

TYPE & THICKNESS OF SCREENS & FILTERS .010 lead screens, front and back

BLOCKING & MASKING IF USED None

GEOMETRIC ARRANGEMENTS FOR THE RADIOGRAPHS (SKETCH) See Attached Sketch

ORIENTATION OF LOCATION MARKERS See Attached Sketch

INTERNAL MARKERS None

WELDING PROCESS Submerged Arc Welding

APPROVED BY

RCS
B&W CONSTRUCTION COMPANY

DATE

8-8-75

WITNESSED BY

W. M. Long
AUTHORIZED INSPECTOR

DATE

8-8-75

IDENTIFICATION:

NDE-PQ-RT-201

REV.

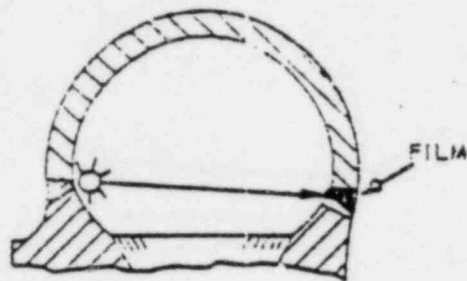
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RADIOGRAPHIC LAYOUT REACTOR COOLANT PUMPS

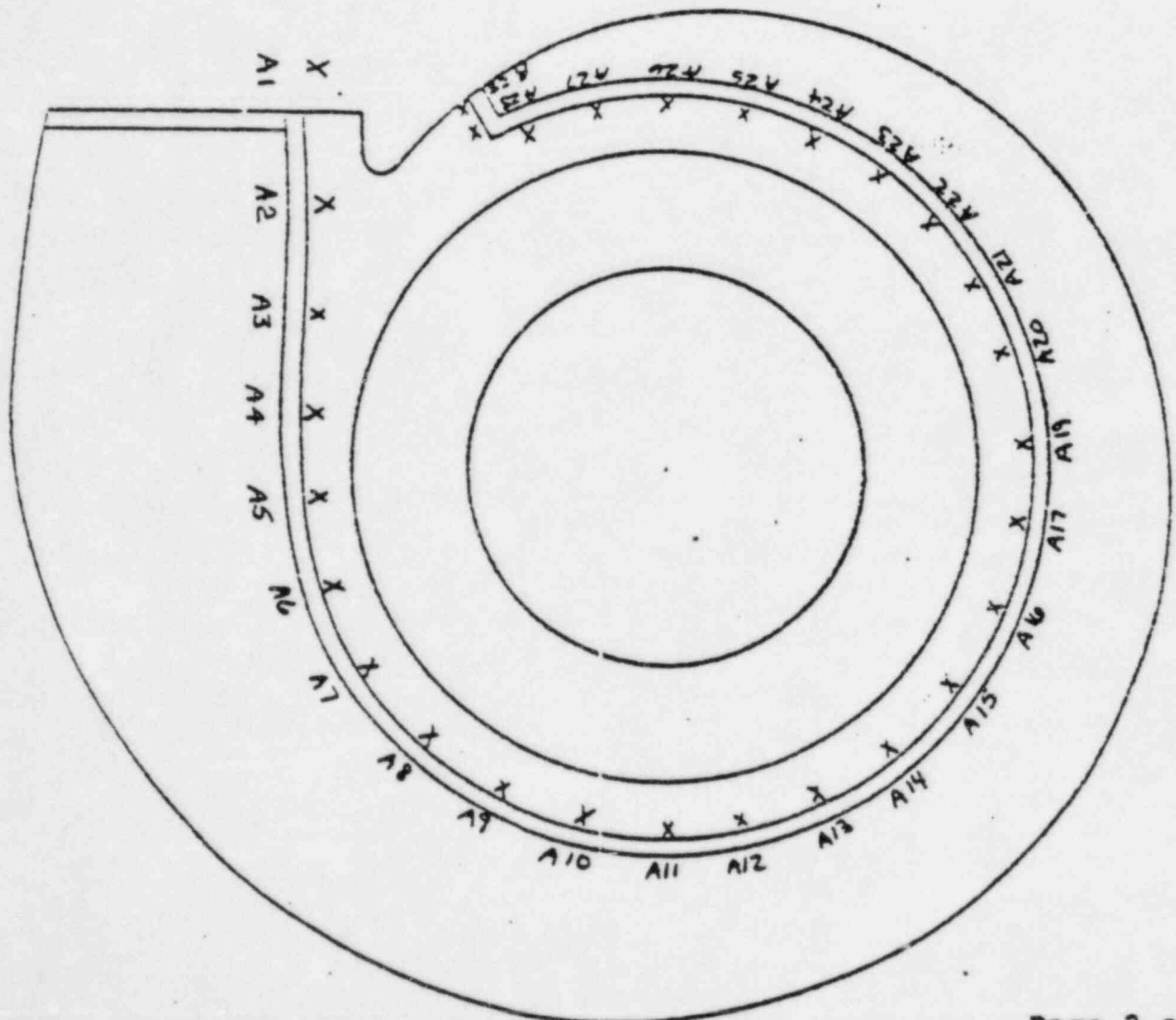
1B1

TOP WELD ☐

BOTTOM WELD ☒



The maximum geometric unsharpness for material thickness up to 4" is .027.

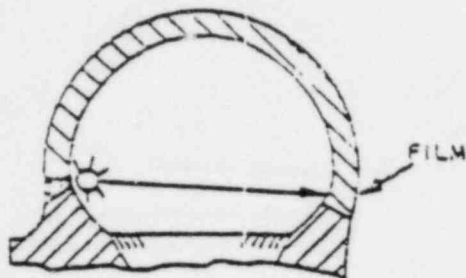


RADIOGRAPHIC LAYOUT REACTOR COOLANT PUMPS

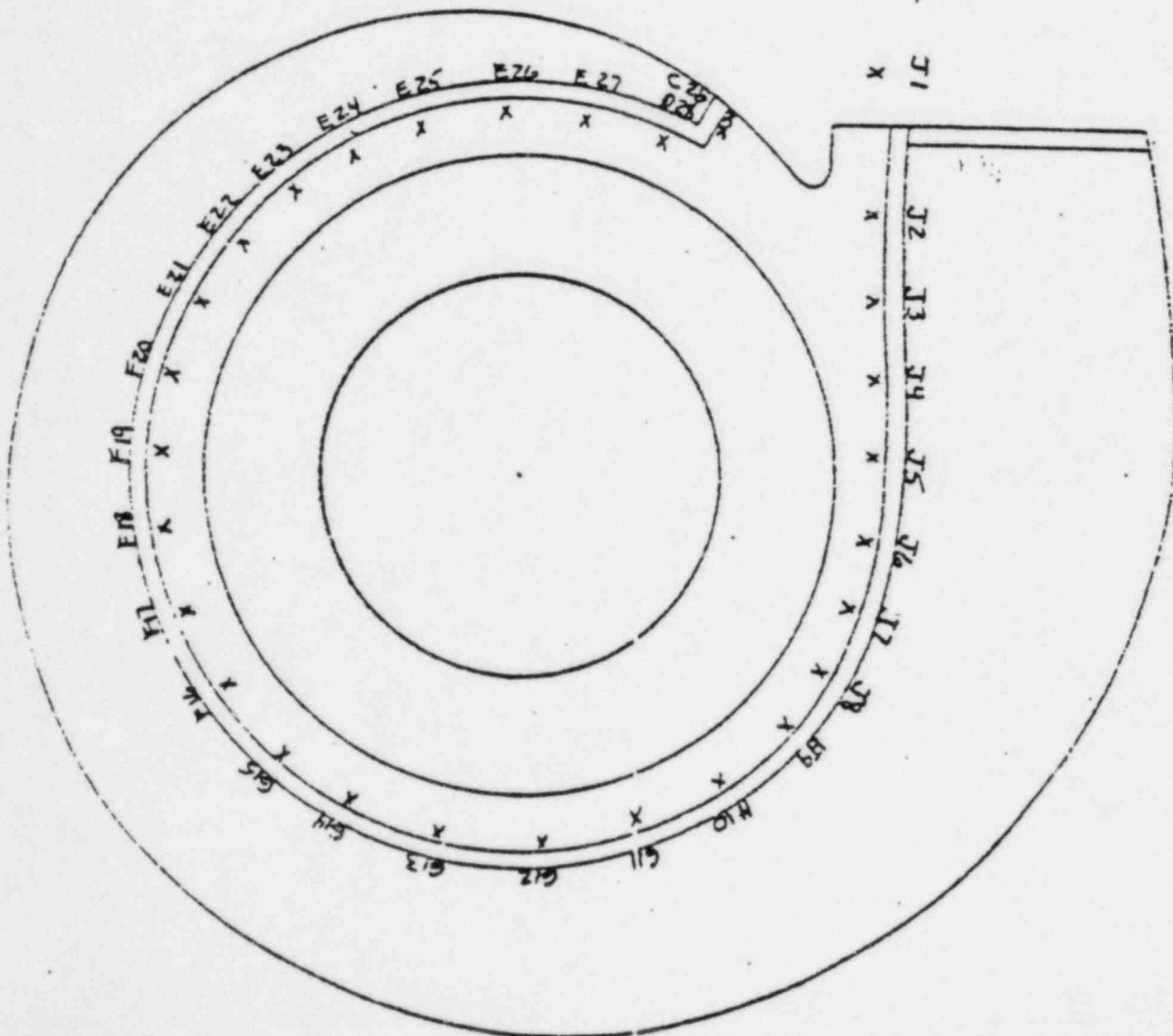
1B1

TOP WELD ☒

BOTTOM WELD ☐



The maximum geometric unsharpness for material thickness up to 4" is .027.



BABCOCK & WILCOX
B&W CONSTRUCTION COMPANY
NONDESTRUCTIVE EXAMINATION

RADIOGRAPHIC PROCEDURE QUALIFICATION

MATERIAL TYPE Carbon, Low Alloy & Stainless Steels

MATERIAL THICKNESS .300" to .425

MATERIAL THICKNESS RANGE CERTIFIED .300" through 3.500"

TYPE OF RADIATION SOURCE Iridium-192

PHYSICAL SIZE OF ISOTOPE SOURCE .100" x .100" (Effective source size .141)

MINIMUM SOURCE TO FILM DISTANCE 3.875" min. 4.250 max.

FILM DISTANCE TO OBJECT .500" max. Source to object 3.200" min.

FILM TYPE & BRAND Type 1, Kodak "M"

NUMBER OF FILM IN CASSETTE Two

FILM TO BE VIEWED Single

TYPE & THICKNESS OF SCREENS & FILTERS .010" lead screens front & back

BLOCKING & MASKING IF USED None

GEOMETRIC ARRANGEMENTS FOR THE RADIOGRAPHS (SKETCH) See attached sketch

ORIENTATION OF LOCATION MARKERS See attached sketch

INTERNAL MARKERS None

WELDING PROCESS Manual Gas Tungston Arc and/or Shielded Metal Arc welding

APPROVED BY

R. W. Shope
B&W CONSTRUCTION COMPANY

DATE 6-5-80

IDENTIFICATION:

WITNESSED BY

AFish
AUTHORIZED INSPECTOR

HSB

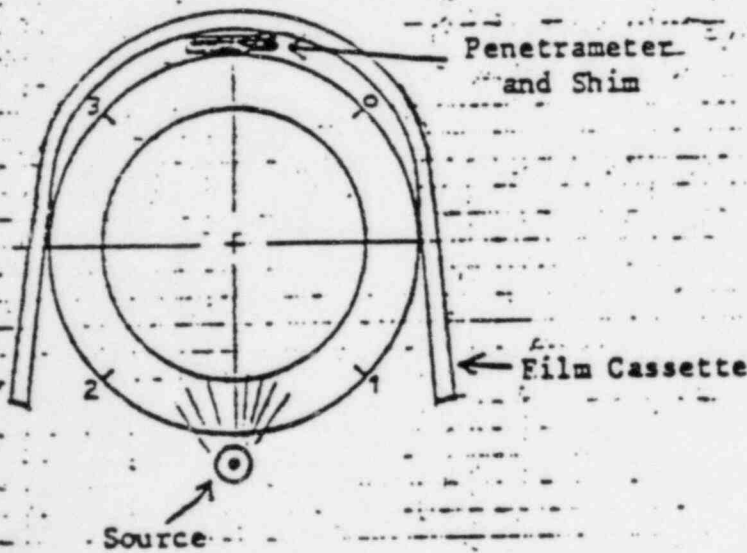
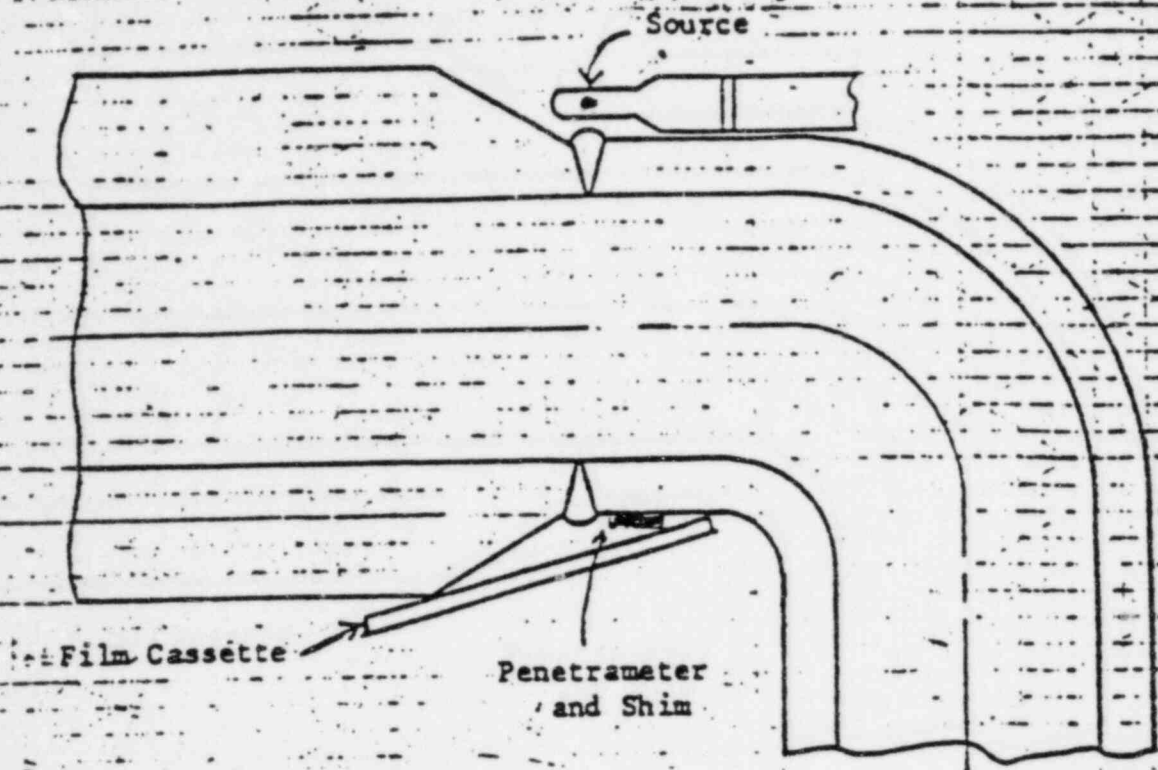
DATE 6.5.80

NDE-PQ-RT-202

REV. 0

NB 8524

INSPECTION SKETCH



Subject: Radiographic examination of circumferential butt welds joining pipe to nozzle with unequal O.D. using Iridium-192

Contract N/A

Sketch by R. W. Shope

SUPPLEMENTS REPORT OF INSPECTION

Number NDE-PQ-RT-202 Rev. 0

Sketch No. N/A

Revision N/A