

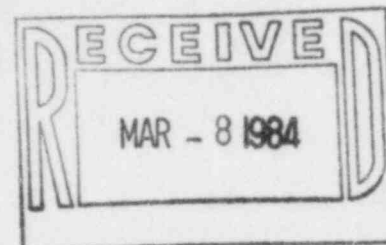


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March 1, 1984

W3K84-0454  
Q-3-A35.07.32



Mr. John T. Collins  
Regional Administrator, Region IV  
U. S. Nuclear Regulatory Commission  
611 Ryan Plaza Drive, Suite 1000  
Arlington, Texas 76012

REFERENCE: LP&L Letter W3K84-0246 dated February 3, 1984

Dear Mr. Collins:

SUBJECT: Waterford SES Unit No. 3  
Docket No. 50-382  
Significant Construction Deficiency No. 32  
"Stress Analysis For Welded Pipe Support Attachments Was Not  
Performed Prior To Fabrication"  
Final Report

In accordance with the requirements of 10CFR50.55(e), we are hereby providing two copies of the Final Report of Significant Construction Deficiency No. 32, "Stress Analysis For Welded Pipe Support Attachments Was Not Performed Prior To Fabrication".

If you have any questions, please advise.

Very truly yours,

*T. F. Gerrets*  
T. F. Gerrets

Corporate Quality Assurance Manager

TFG:CNH:SSTG

Attachments

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

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cc: Director  
Office of Management  
Information and Program Control  
U. S. Nuclear Regulatory Commission  
Washington, D.C. 20555

Mr. E. L. Blake  
Shaw, Pittman, Potts, & Trowbridge  
1800 M Street, N.W.  
Washington, D.C. 20036

Mr. W. M. Stevenson  
Monroe & Lemann  
1424 Whitney Building  
New Orleans, Louisiana 70130

FINAL REPORT OF  
SIGNIFICANT CONSTRUCTION DEFICIENCY NO. 32  
"STRESS ANALYSIS FOR WELDED PIPE SUPPORT ATTACHMENTS  
WAS NOT PERFORMED PRIOR TO FABRICATION"

INTRODUCTION

This report is submitted pursuant to 10CFR50.55(e). It describes a deficiency in the design of welded pipe attachments by Bergen-Patterson, (Designers). The local stress analysis at the point along the pipe where a welded attachment is required for pipe supports was not performed prior to fabrication. This problem is considered reportable pursuant to the requirements of 10CFR50.55(e). To the best of our knowledge, this problem has not been identified to the Nuclear Regulatory Commission pursuant to 10CFR21.

DESCRIPTION OF PROBLEM

In reviewing Bergen-Patterson feedback on local stress analysis, it was found that Bergen-Patterson had been active in this area but reduced their efforts to a minimum. Thus in many cases, the local stress analysis was not performed prior to fabrication.

The following systems were ultimately identified as being affected:

SAFETY RELATED

Blowdown  
Boron Management  
Component Cooling  
Chemical Volume Control  
Containment Spray  
Fuel Pool  
Safety Injection  
Main Steam

NON-SAFETY RELATED

Air Evacuation  
Condensate  
Extraction Steam  
Fire Protection  
Feedwater  
Heater Drain  
Instrument Air  
Station Air  
Turbine Cooling

SAFETY IMPLICATIONS

If this deficiency were left uncorrected, possible degradation of safety-related systems could occur due to the failure of welded pipe support attachments.

CORRECTIVE ACTION TAKEN

Bergen-Patterson performed the stress analysis, this analysis identified eighty-five (85) supports that required revision and/or rework. Nonconformance Report W3-2733 was issued to track this rework.

All corrective action has been completed, the supporting documentation has been reviewed and NCR W3-2733 has been closed.

This Report is being submitted as the Final Report.