

# SNUPPS

Standardized Nuclear Unit  
Power Plant System

5 Choke Cherry Road  
Rockville, Maryland 20850  
(301) 869-8010

April 9, 1984

SLNRC 84-0061 FILE: 0541/M-189  
SUBJ: Preservice Inspection Relief  
Request - Callaway Plant

✓ Mr. Harold R. Denton, Director  
Office of Nuclear Reactor Regulation  
U.S. Nuclear Regulatory Commission  
Washington, D.C. 20555

Docket Nos. STN 50-482 and STN 50-483

Ref: a) SLNRC 84-0026, dtd. 2/7/84: Subj. as Above  
b) SLNRC 84-0030, dtd. 2/13/84: " " "  
c) SLNRC 84-0036, dtd. 2/24/84: " " "  
d) SLNRC 84-0051, dtd. 3/26/84: " " "

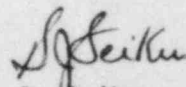
Dear Mr. Denton:

Attachments A-D provide details in support of a request for partial relief from preservice volumetric examination of four (4) weldments in the Callaway Reactor Pressure Vessel. Attachment E provides description of a partial relief request for volumetric examination of Callaway pressurizer safe end welds. These requests are in addition to relief requests for Callaway piping and component welds previously identified via References a) through d).

The preservice examination effort at Callaway is essentially complete and, to the best of our knowledge, no additional volumetric examination relief requests are anticipated. Weldments requiring relief from visual examination provisions of the SNUPPS/ Callaway PSI plan are currently being identified and will be forwarded to the NRC as soon as this effort is completed.

Please advise if additional information is needed in support of the attached relief requests.

Very truly yours,



S. J. Seiken, Manager  
Quality Assurance

SJS/dck/3b13

Attachments A-E

cc: J. Neisler/B. Little, USNRC/CAL  
W. Schum/K. Whittlesey, USNRC/WC  
J. Konklin, USNRC Region III  
G. L. Koester, KGE  
D. T. McPhee, KCPL  
D. F. Schnell, UE

8404130162 840409  
PDR ADOCK 05000482  
Q PDR

BOO1  
1/1

ATTACHMENT A

System: Reactor Pressure Vessel

Category: B-A

Component Description: Lower Head to Shell Weld,  
(I.D. # 2-RV-101-141

Code Requirement: 100% Volumetric Examination

Areas for Relief: The weld area immediately beneath the six RPV Core Support lugs, totalling approximately 15% of the total weld volume.

Basis for Relief: When performing the perpendicular scan of the weld, the search unit cannot reach the weld area below the core support lugs due to the obstruction created when the examination head contacts the outside edge of each lug. A slight loss of coverage, reflected in the 15% total loss figure, is also encountered due to the lug obstruction when performing the parallel scan.

Alternate Testing: None

ATTACHMENT B

System: Reactor Pressure Vessel

Category: B-A

Component Description: Lower Head to Dollar Plate Weld,  
(I.D. # 2-RV-102-ISI),  
Meridional Welds in Lower Head  
(I.D. # 2-RV-101-154A,  
# 2-RV-101-154B,  
# 2-RV-101-154C,  
# 2-RV-101-154D)

Code Requirement: 100% Volumetric Examination

Areas for Relief: A total of approximately 10% of the Lower Head to Dollar Plate Weld and 10% of the combined weld volumes of the four meridional welds.

Basis for Relief: Obstructions presented by the instrumentation nozzles when scanning the Lower Head to Dollar Plate Weld and meridional welds preclude complete volumetric coverage.

Alternate Testing: None

ATTACHMENT C

System: Reactor Pressure Vessel

Category: B-A

Component Description: Flange to Vessel Weld,  
(I.D. # 2-RV-101-121)

Code Requirement: 100% Volumetric Examination

Areas for Relief: 25% of Weld Volume

Basis for Relief: Parallel scan portion of examination can only be  
done from lower side due to presence of flange  
taper above the weld. Complete perpendicular scan was  
done from flange mating surface.

Alternate Testing: None

ATTACHMENT D

System: Reactor Pressure Vessel

Category: B-D

Component Description: Outlet Nozzle A to Vessel Weld,  
(I.D. # 2-RV-107-121-A),  
Outlet Nozzle D to Vessel Weld,  
(I.D. # 2-RV-107-121-B),  
Outlet Nozzle E to Vessel Weld,  
(I.D. # 2-RV-107-121-C),  
Outlet Nozzle H to Vessel Weld,  
(I.D. # 2-RV-107-121-D)

Code Requirement: 100% Volumetric Examination

Area for Relief: Approximately 10% of total weld volume for each nozzle.

Basis for Relief: Approximately 10% of the total weld volume for each outlet nozzle is obstructed by contact between the examination head and the nozzle knuckle extending from the nozzle opening through the plane of the Reactor Pressure Vessel Inner Diameter.

Alternate Testing: None

ATTACHMENT E

System: Pressurizer

Category: B-F

Component Description: 1(a) Relief Nozzle to Safe-end Weld,  
2-T-BB03-4-W  
1(b) Safety Nozzle to Safe-end Weld,  
2-TBB03-3-A-W  
1(c) Safety Nozzle to Safe-end Weld,  
2-TBB03-3-B-W  
1(d) Safety Nozzle to Safe-end Weld,  
2-TBB03-3-C-W  
2. Surge Nozzle to Safe-end Weld,  
2-TBB03-1-W  
3. Spray Nozzle to Safe-end Weld,  
2-TBB03-2-W

Code Requirement: 100% Volumetric Examination

Areas for Relief: 1(a) - 1(d) 20% of total weld volume  
2. 15% of total weld volume  
3. 5% of total weld volume

Basis for Relief: All examination limitations were due to a combination of weld geometry and metallurgical obstruction caused by Inconel buttering used in the components.

Alternate Testing: None