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ARTHUR E. LUNDVALL, JR.  
VICE PRESIDENT  
SUPPLY

May 25, 1984

U. S. Nuclear Regulatory Commission  
Region I  
631 Park Avenue  
King of Prussia, PA 19406

Docket Nos. 50-317  
50-318  
License Nos. DPR-53  
DPR-69

ATTENTION: Mr. T. T. Martin, Director  
Division of Engineering & Technical  
Programs

Gentlemen:

This refers to Inspection Report 50-317/84-06, 50-318/84-06; which transmitted one item of apparent noncompliance with NRC requirements. Enclosure (1) to this letter is a written statement in reply to that item noted in your letter of April 25, 1984.

Should you have further questions regarding this reply, we will be pleased to discuss them with you.

Very truly yours,

AEL/LOW/tlm

Enclosure

cc: D. A. Brune, Esquire  
G. F. Trowbridge, Esquire  
D. H. Jaffe, NRC  
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ENCLOSURE (1)

**REPLY TO APPENDIX A OF NRC INSPECTION  
REPORT 50-317/84-06; 50-318/84-06**

One item of noncompliance identified the failure to perform Non-Destructive Examination on certain Unit 1 and 2 electrical penetrations. Subsection NE of this code requires a 100% volumetric examination. The actual examinations performed on the penetrations complied with ASME Code, Section XI requirements. These examinations involved magnetic particle examination on the root and final weld passes and an ultrasonic examination of the inner one third of the thickness of all welds. Following these examinations, a full pressurization (10 CFR 50, Appendix J, Type A) Integrated Leak Rate Test (ILRT) was performed to verify the leak tightness of each penetration.

Although the ILRT's performed demonstrate the integrity of the welds for each penetration, an ASME Section III, Subsection NE-type Ultrasonic Examination will be performed. These examinations will occur during the next regularly scheduled outage for Unit 1 (March 1985) and Unit 2 (October 1986).

Subsequent to the noncompliance, a training program was developed and implemented for all welding coordinators at the Calvert Cliffs facility. This training emphasized the need to specify appropriate code requirements and reviewed certain codes, standards, and specifications applicable to the facility. All newly assigned welding coordinators must complete similar training.

Additionally, training has been scheduled for responsible engineers involved in specifying Non-Destructive Examination requirements for facility changes similar to those identified in the Inspection Report. This training will emphasize the appropriate code requirements and will review the codes, standards, and specifications applicable to the facility. These corrective actions will be completed by no later than September 1, 1984.