

**As required by the Provisions of the ASME Code Rules**

7. Components Inspected See attached documents.

[illegible]

This form (E00029) may be obtained from the Order Dept., ASME, 345 E. 47th St., New York, N.Y. 10017

**FORM NIS-1 (back)**

8. Examination Dates 3/12/84 to 7/11/84 9. Inspection Interval from 2/18/83 to 2/18/93

10. Abstract of Examinations. Include a list of examinations and a statement concerning status of work required for current interval. See note (1) below.

11. Abstract of Conditions Noted One (01) Recirculation weld inspected, per ISI schedule was found to have IGSCC. Additional 17 Recirculation welds inspected per NRC's requirements were also found to have IGSCC.

12. Abstract of Corrective Measures Recommended and Taken  
Crack evaluation was performed on the 18 cracked Recirc. welds. This resulted in weld overlay repair of 16 welds. Also, cracks were removed from one Recirc. weld by means of trepan samples and the weld was repaired.

We certify that the statements made in this report are correct and the examinations and corrective measures taken conform to the rules of the ASME Code, Section XI.

Date August 14 19 84 Signed Commonwealth Edison By Richard J. Bay S  
Owner

Certificate of Authorization No. (if applicable) \_\_\_\_\_ Expiration Date \_\_\_\_\_

**CERTIFICATE OF INSERVICE INSPECTION**

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of Illinois and employed by Spertus & Son, Inc. of Spertus & Son have inspected the components described in this Owners' Data Report during the period 07-12-84 to 07-11-84 and state that to the best of my knowledge and belief, the Owner has performed examinations and taken corrective measures described in this Owners' Data Report in accordance with the requirements of the ASME Code, Section XI.

By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the examinations and corrective measures described in this Owners' Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date Aug 14<sup>th</sup> 19 84

Floyd F. Rose  
Inspector's Signature

Commissions 5878 6-30  
National Board, State, Province and No.

- (1) Approximately 16% of the required inspections on ISI class 1,2,3 were completed for the Second 10 yr. inspection interval. (Refer to attached table I for list of examinations.) Additional ISI class I stainless steel welds were examined ultrasonically per NRC's requirements. A hydrostatic test was performed on the Reactor Pressure Vessel and on the Recirculation system at the end of the refueling outage.

ISI SUMMARY REPORT

August 14, 1984

COMMONWEALTH EDISON  
P.O. Box 767  
Chicago, Illinois 60690

QUAD CITIES NUCLEAR POWER STATION  
22710 206 Avenue North  
Cordova, Illinois 61242

UNIT 1  
Commercial operating date: February 18, 1973

## INTRODUCTION

Lambert, MacGill, Thomas, Inc. (LMT) was contracted by the Commonwealth Edison Company (CECO) to perform the first Inservice Inspection (ISI) of the second inspection interval on Unit 1 of the Quad Cities Nuclear Power Station. The scope of LMT activities included the performance of Liquid Penetrant, Magnetic Particle, and Ultrasonic Nondestructive Examinations. Visual examinations were performed by certified CECO inspectors. The examinations were performed on portions of the reactor pressure vessel and its associated coolant systems and components.

The Nondestructive Examinations were performed according to the requirements of the Quad Cities Nuclear Power Station Units 1 and 2 Inspection and Testing Program which complies with Section XI of the ASME Boiler and Pressure Vessel Code, 1980 Edition through 1980 Winter Addenda.

This report compiles the information pertaining to the Nondestructive Examinations conducted by LMT and Visual Examinations performed by CECO. It is divided into Discussion and Data sections.

The Discussion section addresses the scope, scheduling, and performance of NDE activities, personnel, calibration and examination report generation, and the methods used to interpret and evaluate the Nondestructive examination results.

The Data section contains tabular listings of LMT's equipment and personnel rosters (table II and III), procedures used (table IV) and summarized results of all ISI examinations (table I).

## DISCUSSION

### Scope of LMT Activities

Nondestructive Examinations were performed on portions of the Reactor Pressure Vessel and its associated coolant system piping and components as directed by Quad Cities personnel. The examinations were performed to meet the requirements of the Quad Cities Nuclear Power Station, Units 1 and 2 inspection and testing program. The procedures used were prepared and approved by Commonwealth Edison, and comply with the requirements of Section XI of the ASME 1980 Edition through 1980 Winter Addenda.

### Scheduling and Performance

The daily schedule of examinations activities was governed by the preparation and availability of the items to be examined, and the anticipated personnel exposure within the work area. The Inservice Inspection Schedule was designed to locate and correct detrimental conditions as early in the outage as possible, to minimize conflict with Critical Path Activities.

Ultrasonic examinations were generally performed by teams of two or more individuals. Liquid Penetrant, Magnetic Particle, and Visual Examinations were conducted by single individuals, or teams consisting of an examiner and an assistant or helper.



## Personnel

Personnel participating in the examination activities are certified in accordance with SNT-TC-1A 1975/1980 Edition. They are identified by name, level of certification, and function, on the report appropriate to each item examined. Table III lists LMT's personnel, their levels of certification, and job function. Certification records of all participating personnel are on files at Quad Cities Station.

## Calibration and Examination Report Generation

Prior to the start of an ultrasonic examination series, a system calibration was performed on the calibration block appropriate to the item to be examined. An ultrasonic calibration report was prepared, identifying the personnel, equipment, and materials, and used as an aid in the interpretation and evaluation of examination results. Each calibration report is uniquely identified by a number, and references the applicable examinations by examination report number and item identification.

An examination report, appropriate to the NDE method, was prepared for each examination. The examination reports identify the item examined, the procedure used, the examination results, and references the appropriate calibration report by number.

## Interpretation and Evaluation

The interpretation and evaluation of examination results were based on the location, shape, and apparent dimensions of the indication. Additional information obtained from other sources, such as radiography or ultrasonic thickness measurements, was used in the interpretation and evaluation process as circumstances and availability indicated. A portable microcomputer and plotter, used in conjunction with LMT developed software, was used to aid in the interpretation and evaluation of certain indications detected by ultrasonics. Recording and reporting levels, and acceptance criteria are as detailed in the examination procedures.

The results of all I.S.I.'s examinations are summarized in table I.

QUAD-CITIES UNIT 1  
SUMMARIZED ISI RESULTS

TABLE I

REPORT NO.	COMPONENT / WELD NO.	EXAM METHOD	REMARKS
R001	1006A-1	MT	Accept
R002	1008B-1	MT	Accept
R003	1008A-18	MT	Accept
R004	1003A-W-204	MT	Accept
R005	1403-1	MT	Accept
R006	10S-F18	PT	Accept
R007	10HV-F1	PT	Accept
R008	3204B-1	UT-0°, 45°	NRI
R009	3204B-1	MT	Accept
R010	3204B-4A	MT	Accept
R011	2304-31	MT	Accept
R012	2304-29	MT	Accept
R013	10HV-F1	UT-45°	NRI
R017	2304-29	UT-0°, 45°	ID Geometry
R018	2306-2	MT	Accept
R019	10S-F18 & L.S.	UT-45°	ID Geometry
R022	3953-M-301	VT-3	Accept
R023	3953-M-302	VT-3	Accept
R024	3953-M-303	VT-3	Accept
R025	3953-M-304	VT-3	Accept
R026	3953-M-305	VT-3	Accept
R027	3953-M-306	VT-3	Accept
R028	3953-M-307	VT-3	Accept
R029	3953-M-308	VT-3	Accept
R030	3953-M-309	VT-3	Accept
R031	203-2A Vlv Bolting	VT-1	Accept
R032	1013A-M-201	VT-4	Accept
R033	1010-M-201	VT-4	Accept
R034	0301-95 Vlv Bolting	VT-1	Accept
R035	2306-M-201	VT-4	Accept
R036	2306-M-202	VT-4	Accept
R037	2306-M-204	VT-4	Accept
R038	1006A-W-201	VT-4	Accept
R039	1403-W-201	VT-3	Accept
R040	203-2D Vlv Int	VT-1	Accept
R041	RPV Internals	VT-1	Accept
R042	12S-F2R	PT	Accept
R043	12S-F3R	PT	Accept
R044	12S-F2R	UT-45°	NRI
R045	12S-F3R	UT-45°	NRI
R046	10AD-S7	PT	Accept
R047	220-62B Vlv Int	VT-1	Accept
R048	10AD-S7 & L.S.	UT-0°, 45°	ID Geometry
R049	32A-F12	MT	Accept
R050	32A-S10	MT	Accept

REPORT NO.	COMPONENT / WELD NO.	EXAM METHOD	REMARKS
R051	3204A-W-102	MT	Accept
R052	32A-S10	UT-0°,45°	ID Geometry
R053	32A-F12	UT-0°,45°	ID Geometry
R054	30A-S2	MT	Accept
R055	30A-S2	UT-0°,45°	ID Geometry
R057	RPV-Shell to flange	UT-0°	Acceptable indication
R058	RPV-Shell to flange	UT-45°	NRI
R059	RPV-Shell to flange	UT-60°	NRI
R062	14A-F1	PT	Accept
R063	14A-S4AR	MT	Accept
R064	14A-F4AR	MT	Accept
R075	14A-S4AR	UT-0°,45°	NRI
R076	14A-F4AR	UT-0°,45°	NRI
R077	14A-F1	UT-0°,45°	NRI
R095	10HS-F9	UT-0°,45°	ID Geometry
R098	1403-M-101	VT-4	Accept
R099	203-2B Vlv Int	VT-1	Accept
R100	1011-W-103	VT-4	Accept
R101	1402-9A Vlv Bolting	VT-1	Accept
R102	1402-9B Vlv Bolting	VT-1	Accept
R103	1001-64 Vlv Bolting	VT-1	Accept
R107	220-62A Vlv Int	VT-1	Accept
R108	1002-M-304	VT-3	Accept
R109	1005A-M-301.1	VT-3	Accept
R110	1005A-M-301.2	VT-3	Accept
R111	1005A-M-301.3	VT-3	Accept
R112	1005A-M-301.4	VT-3	Accept
R113	1005A-M-301.5	VT-3	Accept
R114	1005A-M-301.6	VT-3	Accept
R115	3967-M-302	VT-3	Accept
R116	3967-M-303	VT-3	Accept
R117	3967-M-304	VT-3	Accept
R118	3967-M-305	VT-3	Accept
R119	3967-M-306	VT-3	Accept
R120	3967-M-307	VT-3	Accept
R121	3967-M-308	VT-3	Accept
R122	3967-W-309	VT-3	Accept
R140	"A" Recirc Pump Studs	VT-0°	NRI
R145, 151	02H-S3	UT-45°,60°	1 Circ IGSCC-3" long X 21% deep 3 Axial IGSCC-3/4" long X 100% deep
R149	02AS-F1	PT	Accept
R150	02H-F1	PT	Accept
R153	02H-S3	UT-0°	NRI
R155	02A-S8	UT-0°,45°	NRI
R157	1003A-W-301	VT-3	Accept
R158	203-4A Vlv bolting	VT-1	Accept
R159	203-4E Vlv bolting	VT-1	Accept
R190	NSA Nozzle-Vessel	UT-0°	NRI
R191	02AS-F1	UT-45°	NRI
R201	NSA Nozzle-Vessel	UT-45°	NRI

REPORT NO.	COMPONENT / WELD NO.	EXAM METHOD	REMARKS
R202	N5A Nozzle-Vessel	UT-60°	NRI
R204	3951-M-301	VT-3	Accept
R205	3953-M-301.1	VT-3	Accept
R206	0318-M-201	VT-1	NRI
R207	3950-M-302	VT-3	Accept
R208	3950-M-303	VT-3	Accept
R209	3950-M-304	VT-3	Accept
R210	3950-M-305	VT-3	Accept
R211	3950-M-307	VT-3	Accept
R212	3967-M-312	VT-3	Accept
R213	3967-M-311.1	VT-3	Accept
R214	3967-M-310	VT-3	Accept
R215	3967-M-302.1	VT-4	Accept
R218	02AS-S3	PT	Accept
R220	02AS-S3	UT-0°	NRI
R231,232,233	02AS-S3 LS	UT-0°	NRI
R235	02AS-S3	UT-45°	NRI
R236,237,238	02AS-S3 LS	UT-45°	NRI
R243	02H-F1	UT-45°	ID Geometry
R248	30A-S9	MT	Accept
R271	10S-S7	PT	Accept
R272	30A-S7	UT-0°	NRI
R273	30A-F8	UT-0°	NRI
R274	30A-S9	UT-0°	NRI
R275	30A-S4	UT-0°	NRI
R276	30A-S7	UT-45°	ID Geometry
R277	30A-F8	UT-45°	ID Geometry
R278	30A-S4	UT-45°	ID Geometry
R279	30A-S9	UT-45°	ID Geometry
R280	30A-S11	UT-45°	ID Geometry
R281	10S-S7 & L.S.	UT-0°,45°	ID Geometry
R285	30A-S7	MT	Accept
R286	30A-F8	MT	Accept
R287	30A-S4	MT	Accept
R302	N5A Nozzle-Vessel	UT-IRS	NRI
R303	10S-S2A	PT	Accept
R304	12S-S1	PT	Accept
R309	3001A-W-101	MT	Accept
R314	3204A-W-101	VT-4	Accept
R315	3001A-W-102	VT-4	Accept
R316	3001A-W-103	VT-4	Accept
R317	3204A-W-102	VT-4	Accept
R318	203-1A Vlv Bolting	VT-1	Accept
R319	3001A-M-102.1	VT-3	Accept
R323	23S-F4	MT	Accept
R327	23S-F4	UT-0°,45°	NRI
R330,337	02BD-F1 & L.S.	UT-45°	NRI
R333	02BD-F1	PT	Accept
R339	02BD-F1	UT-0°	NRI
R346	N1A Nozzle-Vessel	UT-0°	NRI
R347	N2A Nozzle-Vessel	UT-0°	NRI
R348	N1A Nozzle-Vessel	UT-45°	NRI



REPORT NO.	COMPONENT / WELD NO.	EXAM METHOD	REMARKS
R349	N2A Nozzle-Vessel	UT-45°	NRI
R350	N1A Nozzle-Vessel	UT-60°	NRI
R351	N2A Nozzle-Vessel	UT-60°	NRI
R352	N2A Nozzle-Vessel	UT-I RS	NRI
R353	N1A Nozzle-Vessel	UT-I RS	NRI
R354	10HS-F9	PT	Accept
R364	1403-M-202	VT-4	Accept
R365	0202-4A Vlv Int.	VT-1	Accept
R366	Rx Head Lugs @ 0° & 90°	MT	Accept
R367	N7-S1 Nozzle-SE	PT	Accept
R369	N7-S1 Nozzle-SE	UT-0°	NRI
R375	Rx Head-0° Merid	UT-0°	NRI
R376	Rx Head-180° Merid	UT-0°	NRI
R377	N7 Nozzle- Rx Head	UT-0°	NRI
R378	Rx Head-0° Merid	UT-45°	NRI
R379	Rx Head-180° Merid	UT-45°	NRI
R380	N7 Nozzle-Rx Head	UT-45°	NRI
R381	RPV Head-0° Merid	UT-60°	NRI
R382	RPV Head-180° Merid	UT-60°	NRI
R383	N7 Nozzle-Rx Head	UT-60°	NRI
R384	Rx Head-Flange	UT-0°	NRI
R385	Rx Head-Flange	UT-45°	NRI
R386	Rx Head-Flange	UT-60°	NRI
R387	N7 Nozzle-Vessel	UT-IRS	NRI
R388	0200-M-105	VT-4	Accept
R389	0200-M-105	VT-3	Accept
R390	0200-W-108	VT-4	Accept
R391	0200-W-107	VT-4	Accept
R392	1202-W-101	VT-4	Accept
R393	0200-M-104	VT-3	Accept
R394	0202-4B Vlv Bolting	VT-1	Accept
R395	1025-W-101	VT-4	Accept
R396	1025-W-101	VT-3	Accept
R397	0200-M-104	VT-4	Accept
R398	3001A-M-101.1	VT-3	Accept
R399	3001A-M-101.2	VT-3	Accept
R400	3001A-M-101.2	VT-4	Accept
R401	220-58A Vlv Int.	VT-1	Accept
R402	Rx Head-Dollar Weld	UT-0°	NRI
R403	Rx Head Dollar Weld	UT-45°	NRI
R404	Rx Head Dollar Weld	UT-60°	NRI
R405	N7-S1 Nozzle-SE	UT-45°	NRI
R408	0200-W-108	VT-3	Accept
R409	0200-W-107	VT-3	Accept
R411	0202-4A Vlv Bolting	VT-1	Accept
R412	1403-M-101	VT-3	Accept
R413	1403-M-202	VT-3	Accept
R414	3204A-W-102	VT-3	Accept
R415	3204A-W-101	VT-3	Accept
R416	3001A-W-103	VT-3	Accept
R417	3001A-W-102	VT-3	Accept

REPORT NO.	COMPONENT / WELD NO.	EXAM	REMARKS
		METHOD	
R418	3967-M-302.1	VT-3	Accept
R419	1011-W-103	VT-3	Accept
R420	2306-M-202	VT-3	Accept
R421	2306-M-201	VT-3	Accept
R422	2306-M-204	VT-3	Accept
R423	1010-M-201	VT-3	Accept
R424	1006A-W-201	VT-3	Accept
R425	1013A-M-201	VT-3	Accept
R426	1202-W-101	VT-4	Accept
R434	2306-M-203	VT-4	Accept
R435	2306-M-203	VT-3	Accept
R444	1202-M-103	VT-3	Accept
R445	1202-M-103	VT-4	Accept
R446	1009A-W-201	VT-4	Accept
R447	1009A-W-201	VT-3	Accept
R448	203-3A Vlv Bolting	VT-1	Accept
R449	203-3A Vlv Bolting	VT-1	Accept
R450	1043B-M-301.1	VT-3	Accept
R451	N7 Noz. Flng. Bolting	VT-1	Accept
R452	Hd. Spray Hd. Flg. Bolting	VT-1	Accept
R453	Hd. Spray 680' Bolting	VT-1	Accept
R454	Hd. Spray 666' Bolting	VT-1	Accept
R455	Hd. Spray 676' Bolting	VT-1	Accept
R456	3001A-W-101	VT-4	Accept
R457	3001A-W-101	VT-3	Accept
R458	2305-W-101	VT-3	Accept
R459	2305-W-101	VT-4	Accept
R460	1012A-W-101	VT-3	Accept
R461	1012A-W-101	VT-4	Accept
R462	203-1C Vlv Int	VT-1	Accept
R464	203-1B Vlv Int	VT-1	Accept
R465	203-2C Vlv Int	VT-1	Accept
R466	0200-W-109	VT-4	Accept
R467	0200-M-170	VT-4	Accept
R468	0200-M-175	VT-4	Accept
R469	0200-M-175	VT-3	Accept
R470	0200-M-170	VT-3	Accept
R471	0200-W-109	VT-3	Accept

QUAD-CITIES UNIT 1 INSERVICE INSPECTION  
LMT'S EQUIPMENT ROSTER  
TABLE II

ULTRASONIC INSTRUMENTS

DESCRIPTION	MANUFACTURER	MODEL	SERIAL NO.
Scope	Nortec	131-D	167
Scope	Nortec	131-D	311
Scope	Nortec	131-D	291
Scope	LMT	SLAVE	2
Scope, Master	Nortec	131-D	409
Scope	Nortec	131-D	111
Scope	Nortec	131-D	126
Scope, Master	Nortec	131-D	273
Scope	Nortec	131-D	287
Scope	LMT	SLAVE	3
Scope, Master	Nortec	131-D	371

STRIP CHART RECORDERS

DESCRIPTION	MANUFACTURER	MODEL	SERIAL NO.
Recorder	Gulton	TR722	2091001
Recorder	Gulton	722J	2091002
Recorder	Gulton	722J	3011101
Recorder	Gulton	TR722	8082502

SEARCH UNTIS

DESCRIPTION	MANUFACTURER	MODEL	SERIAL NO.
Search Unit	Harisonic	.5"X2.25mHz	R2147
Search Unit	Aerotech		K17340
Search Unit	Krautkramer	70L/30S	56526

NOTE: Additional search units supplied by Commonwealth Edison.

QUAD-CITIES UNIT 1 INSERVICE INSPECTION  
LMT'S EQUIPMENT ROSTER  
TABLE II (CONTINUED)

REFERENCE BLOCKS

DESCRIPTION	MANUFACTURER	MODEL	SERIAL NO.
Ref Block, 1" CS	LMT	ROMPAS	017
Ref Block SS, 1"	LMT	ROMPAS	023
Ref Block, .5" SS	LMT	ROMPAS	027
Ref Block, 5" SS	LMT	ROMPAS	309

TEMPERATURE GAUGES

DESCRIPTION	MANUFACTURER	MODEL	SERIAL NO.
Temp Gauge	PTC	Surf	588
Temp Gauge	PTC	Surf	589
Temp Gauge	PTC	Surf	596
Temp Gauge	PTC	Surf	600
Temp Gauge	PTC	Surf	601
Temp Gauge	PTC	Surf	602
Temp Gauge	PTC	Surf	603
Temp Gauge	PTC	Surf	604
Temp Gauge	PTC	Surf	609
Temp Gauge	PTC	Surf	610
Temp Gauge	PTC	Surf	611



QUAD-CITIES UNIT 1 INSERVICE INSPECTION  
I.S.I. PERSONNEL  
TABLE III

The following LMT personnel participated in the inspection as indicated:

NAME	MT	PT	UT	IGSCC	FUNCTION
ADAMS, Gary R.	III	III	III	Y	Supervisor
ASMUS, Walter, A.		II	I	N	Examiner
BIGHAM, Joseph E.			I	N	AST Examiner
BURLINGAME, Richard	II	II	III	Y	Examiner
CAPPELL, Robert M.	II	II	I	N	Examiner
COMER, Kenneth A.			I	N	Examiner
EDGEL, Douglas J.	II	II	II	Y	Examiner
ELLIOTT, Jon D.	II	II	II	N	Examiner
FRENCH, Jessie Jr.		I	II	Y	Examiner
HARVEY, Donald E.	III	III	III	Y	Supervisor
JOHNSON, Raymond W.		II	II	N	Examiner
NELSON, Wesley H.	II	II	II	N	Examiner
PRAUGHT, Raymond A.	II	II	II	Y	Examiner
SCRIVNER, Vickie L.			I	N	AST Examiner
SEVERTSON, Robert J.			I	N	AST Examiner
SMITH, Kelly F.C.					Trainee
THOMPSON, Clyde W.		II	II	Y	Examiner
VILMER, Larry G.		II	I	N	Examiner
VOSS, Alton W.			I	N	AST Examiner
VAN DER LINDE, Jon	II	II	II	Y	Examiner
WOOD, Larry J.			I	N	AST Examiner

The following CECO personnel participated in the inspection as indicated:

NAME	VT-1	VT-2	VT-3	VT-4	FUNCTION
CARNEY, Gerald T.		II			Examiner
DO, Hien Q.	II	II	II	II	Lead Examiner
FORD, James R.	II				Examiner
HUIZENGA, Dave	II				Examiner
LEAVERTON, Warren		II	II	II	Examiner
MEDULAN, Kenneth K.	II	II	II	II	Examiner
OKLAND, Kenneth W.	II	II			Examiner
PHIPPEN, Robert	II	II			Examiner
TUCKER, Roger	II				Examiner
WARREN, Stanley	II				Examiner
WILGUS, Dan L.		II			Examiner

QUAD CITIES UNIT 1 INSERVICE INSPECTION  
NDE PROCEDURES  
TABLE IV

PROCEDURE	REV.	DESCRIPTION
NDT-B-1	2	Magnetic Particle Examination for ASME Section XI Class IWB and IWC Components for Nuclear Stations.
NDT-C-2	13	Preservice and Inservice Ultrasonic Inspection of Similar and Dissimilar Metal Pipe Welds at Nuclear Stations.
NDT-C-10	8	Ultrasonic Inspection of the Inner Radius of the Nozzle-to-Vessel Junction at Nuclear Stations.
NDT-C-14	7	Ultrasonic Inspection of Pressure Retaining Bolting two inches or greater in diameter at Nuclear Stations.
NDT-C-30-80	0	Ultrasonic Examination of Reactor Vessel Welds to NRC Reg. Guide 1.150 for Boiling Water Reactors.
NDT-C-31-80	0	Beam Spread and Refracted Angle Determination to NRC Reg. Guide 1.150 for Boiling Water Reactors.
NDT-D-2	5	Non-Aqueous Red Dye Liquid Penetrant Examination for Section XI class IWB and IWC components for Nuclear Stations.
VT-1-1	0	Visual examination - welds, pressure retaining bolting, and component internals.
VT-2-1	0	Visual examination - system hydrostatic and leak tests.
VT-3-1	0	Visual examination - component supports.
VT-4-1	0	Visual examination - snubbers, shock absorbers, spring and constant load type supports.