SNUPPS
Standardized Nuclear Unit
Power Plant System

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

Nicholas A. Petrick
Executive Director

December 3, 1984

SLNRC 84-0128 FILE: 0541
SUBJ: FSAR Requirements for Structural Steel Welding

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

Docket No.: STN 50-482

Reference: Letter, R. D. Martin, NRC Region IV to G.L. Koester, KGE, dated November 15, 1984: Enforcement Meeting October 29, 1984

Dear Mr. Denton:

Kansas Gas and Electric agreed in the reference meeting to review their FSAR commitment to the Structural Welding Code, AWS D 1.1-1975. As discussed with the NRC staff in the November 28, 1984 licensing status meeting, only one additional deviation from this commitment has been identified as shown on the attached revised FSAR page 3.8-53. The deviation is acceptable because convexity has no detrimental effect on the structural capacity of the weld provided that all other parameters of acceptable weld profile are maintained.

The attached change is submitted for your review and approval. Kansas Gas and Electric plans to include this change in Revision 17 to the SNUPPS FSAR, to be issued in late December, applicable to Wolf Creek only.

Very truly yours,

J. D. Cermak for

Nicholas A. Petrick

SLA/n1d6a9
Attachment
cc: See Page 2.

B001
1/1

cc:	G. L. Koester	KGE
	J. M. Evans	KCPL
	D. F. Schnell	UE
	J. Neisler/B. Little	USNRC/CAL
	H. Bundy	USNRC/WC
	W. L. Forney	USNRC/RIII
	D. R. Hunter	USNRC/RIV

3.8.3.6.3 Structural Steel

The following sections describe the basic materials, examination, and erection of structural steel items.

3.8.3.6.3.1 Materials

Structural steel shapes, plates, and bars conform to the requirements of the Specification for Structural Steel (ASTM A36).

High strength bolting materials conform to the requirements of the Specification for High Strength Bolts for Structural Steel Joints, Including Suitable Nuts and Plain Hardened Washers (ASTM A325) or the Specification for Quenched and Tempered Alloy Steel Bolts for Structural Steel Joints (ASTM A490). Other bolting materials conform to the requirements of the Standard Specification for Low-Carbon Steel Fasteners (ASTM A307).

Welding electrode materials are selected on the basis of the welding process used and the type of materials to be joined and in accordance with the requirements of AWS D1.1. Written welding material control procedures are required which define the measures used to control the use of the materials throughout all welding operations.

Certified material test reports are obtained for structural steel shapes, plates, and bars. All other structural steel materials are furnished with certificates of compliance.

3.8.3.6.3.2 Examination

Nondestructive examination of structural steel welds is performed in accordance with the requirements of AWS D1.1 and as augmented by design documents prepared for the SNUPPS project. Inspection of high strength bolted joints is performed in accordance with the requirements of the AISC Specification for Structural Joints Using ASTM A325 or A490 Bolts and as augmented by design documents prepared for the SNUPPS project.

3.8.3.6.3.3 Erection

Structural steel is erected to the following codes, to the extent described:

a. AWS D1.1 Structural Welding Code is used with the following exceptions: 1. Undercut of welds shall not exceed 1/32 inch.

   2) Fillet welds need not satisfy the convexity limitations of Section 3.6.1 provided that all other parameters of acceptable weld profile are maintained.

b. AISC Specification for the Design, Fabrication, and Erection of Structural Steel for Buildings, Sections 1.23 and 1.25, are used without exception.