



Commonwealth Edison

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Chicago, Illinois 60690

April 18, 1985

Mr. James G. Keppler
Regional Administrator
U. S. Nuclear Regulatory Commission
Region III
799 Roosevelt Road
Glen Ellyn, IL 60137

SUBJECT: Braidwood Station Units 1 and 2
10 CFR 50.55(e) No. 83-08 Interim Report
Duct Fitting Fabrication
NRC Docket Nos. 50-456/457

- References (a): E. D. Swartz letter to J. G. Keppler
dated July 29, 1983
- (b): E. D. Swartz letter to J. G. Keppler
dated October 20, 1983
- (c): E. D. Swartz letter to J. G. Keppler
dated August 30, 1984
- (d): D. H. Smith letter to J. G. Keppler
dated November 28, 1984

Dear Mr. Keppler:

References (a) thru (d) provided information concerning a deficiency reportable pursuant to 10 CFR 50.55(e) regarding fabrication of Pullman Sheet Metal duct fittings without approved design documents at our Braidwood Station. The purpose of this letter is to provide an updated status of the corrective actions taken to resolve this issue. This letter is considered to be an Interim Report.

Status of Corrective Action

On June 30, 1983 Commonwealth Edison issued NCR 540 and filed a 50.55(e) Report 456/83-08 to a document that Pullman Sheet Metal (PSM) had fabricated duct fittings without Sargent & Lundy (S&L) approved drawings. PSM had fabricated fittings based on their interpretation of the design specification and the use of standard industrial practices. This was acceptable for many of the fittings attributes such as sheet gauge, companion and stiffener angle size, companion angle joint details and sheet to stiffener and companion angle welding. However, the spacing and joint details of stiffeners was not clearly defined due to wide variations of fitting shapes. These attributes would require field verification.

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A stop work was issued to PSM to halt installation and fabrication of duct fitting not covered by S&L approved design drawings. PSM was directed to submit design drawings as a part of their Duct Brochure for S&L's review and approval.

Based on S&L's approval of the revised Duct Brochure, PSM was then asked to review all fittings fabricated prior to the stop work for acceptability. All fittings not covered by the approved Duct Brochure were to be identified for rework or submitted to S&L on a FCR for approval. This review activity was performed using PSM Engineering Personnel.

Pullman Field Engineering completed its review of all duct fittings for compliance with the PSM Duct Brochure or S&L Design Drawings on February 21, 1985. This review covered a total of 2823 fittings. Out of this total, 619 fittings required "as-builts" to be submitted to S&L for further evaluation. S&L has reviewed 552 of these with 67 requiring some modifications. These modifications will be completed and 100% inspected by December 15, 1985 for Unit 1 and June 15, 1986 for Unit 2. S&L's evaluation of the remaining 67 will be completed by June 1, 1985.

Of those not requiring as builts (2204 fittings), 331 fittings require some modification to meet design requirements. These modifications and 100% inspections by Pullman Q.C. are currently being made as dictated by the "system turn-over" schedule. All fittings required for Unit 1 and Unit 2 will be completed by 12/15/85 and 6/15/86 respectively.

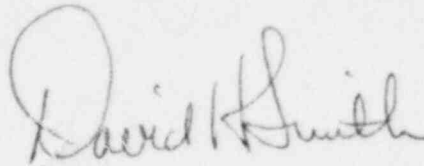
A random sampling review program will be conducted on the remaining 1873 fittings which already meet the requirement of S&L approved design documents. This sample program will be conducted in accordance with MIL-STD-105D. S&L will select the samples from this population and Pullman Q.C. will perform the actual inspection. The schedule start date for this activity is April 22, 1985. Completion is expected by June 1, 1985.

Results of Review

Total Fitting Population	2823
Production Review	
Fittings which comply with design documents	1873
Fitting which require modification to comply with design document	331
As builts requiring S&L Evaluation	619
S&L As Built Evaluation	
As builts submitted to S&L	619
As builts reviewed	552
As builts accepted as is	485
As builts requiring rework	67
As builts not reviewed	67

Please address any questions that you or your staff may have concerning this matter to this office.

Very truly yours,

A handwritten signature in cursive script, reading "David H. Smith". The signature is written in dark ink and is positioned above the typed name and title.

David H. Smith
Nuclear Licensing Administrator

/klj

cc: NRC Resident Inspector - Braidwood

Director of Inspection and Enforcement
U.S. Nuclear Regulatory Commission
Washington, D.C. 20555

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