



UNITED STATES
NUCLEAR REGULATORY COMMISSION
WASHINGTON, D. C. 20555

May 9, 1985

PDR-016
LPDR

Docket Nos. 50-440/441

Ms. Susan Hiatt
OCRE Representative
8275 Munson Road
Mentor, OH 44060

IN RESPONSE REFER
TO FOIA-85-234

Dear Ms. Hiatt:

This is in response to your letter dated April 1, 1985, in which you requested, pursuant to the Freedom of Information Act, all documents concerning deficiencies associated with the polar crane box girder of Units 1 and 2 of the Perry plant.

The documents listed on the enclosed appendices A and B are responsive to your request. Appendix A documents are enclosed.

Appendix B documents are inspection reports. As you are aware, these inspection reports are routinely placed in the Nuclear Regulatory Commission's Public Document Room and the Local Public Document Room for the Perry plant. The inspection reports listed on Appendix B are available for public inspection and copying at the LPDR which is located at the Perry Public Library, 3753 Main Street, Perry, Ohio 44081, telephone (216) 259-3200. Access to these inspection reports may be acquired by contacting the Reference Librarian, Mrs. Shirley Morgan, either in person or by phone, and giving her the accession numbers for these inspection reports.

Sincerely,



J. M. Felton, Director
Division of Rules and Records
Office of Administration

Enclosures: As stated

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PDR FOIA
HIATT85-234 PDR

APPENDIX A

1. October 17, 1981 Morning Report and evaluation sheet (2 pages)
2. November 12, 1981 Interim 50.55(e) report to Keppler from Davidson (2 pages)
3. November 20, 1981 Minutes from NRC Exit Meeting (1 page)
4. February 26, 1982 Final 50.55(e) report to Keppler from Davidson (2 pages)
5. April 23, 1982 Corrected 50.55(e) report to Keppler from Davidson (2 pages)

APPENDIX B

DOCUMENTS IN PDR/LPDR

Inspection Reports

No. 50-440/81017; 50-441/81017;
50-440/82006; 50-441/82006;
50-440/83010; 50-441/83009

Accession Numbers

8204050165
8207200287
8304220568

38(81)

SECTION I - INFORMATION

FACILITY PERRY #2 TIME 1:20 PM DATE 10/17-81
 PERSON CALLING V. HIGAKI PERSON RECEIVING HQTRS. DUTY OFFICER
 EVENT DATE AND DETAILS DEFICIENCIES IDENTIFIED IN UNIT 2
POLAR CRANE RING GIRDER WELDS.

FINAL/INTERIM REPORT DUE 11-16-81 RECEIVED _____

SECTION II - NOTIFICATION

10-19-81
☒ MORNING REPORT ☐ PAO ☐ HQ ☐ PN ☐ LICENSING BOARD NOTIFICATION REQUIRED
☒ OTHER R III TRACKING SYSTEM FORM SUBMITTED 10-19-81
☐ INSPECTOR/TEAM DISPATCHED TO SITE

SECTION III - EVALUATION AND FOLLOWUP

☐ EVALUATE REPLY ☐ EVENT LATER DETERMINED NOT REPORTABLE
☐ CONDUCT VERIFICATION INSPECTION

OTHER INFORMATION/INSTRUCTIONS _____

ASSIGNED ☐ PROJECT ☐ ENGINEERING I ☒ ENGINEERING II

DATE _____ INSPECTOR _____

REQUIRED COMPLETION DATE _____

SECTION IV - CLOSEOUT

☐ ADEQUATE REPLY RECEIVED NO VERIFICATION INSPECTION
☐ VERIFICATION INSPECTION CONDUCTED ☒ LICENSING BOARD ACTION REQUIRED ☐ GENERIC
 COMPLETED BY _____ DATE _____ REPORT NO. _____
 SECTION CHIEF REVIEW _____

REGION III, OFFICE OF INSPECTION AND ENFORCEMENT

DAILY REPORT

DATE: 10-19-81

DIVISION DR + PI

/Licensee	Notification	Item or Event	Regional Action
UNIT 2	LICENSEE TELECON TO HQT. DUTY OFFICER ON 10/17/81	<p>LICENSEE IDENTIFIED DEFICIENCIES IN Unit 2 POLAR CRANE RING GIRDER WELDS. The polar crane ring girder has been is installed; however, the polar crane has not been installed.</p> <p>This item reported per the requirements of 10CFR 50.55(b)</p>	Per MC 2512

Submitted _____
Branch Chief



Halwyn R. Davidson
VICE PRESIDENT
SYSTEM ENGINEERING AND CONSTRUCTION

November 12, 1981

Mr. James G. Keppler
Director, Region III
Office of Inspection and Enforcement
U. S. Nuclear Regulatory Commission
799 Roosevelt Road
Glen Ellyn, Illinois 60137

RE: Perry Nuclear Power Plant, Docket Nos.
50-440; 50-441, Interim Report on
Unit II Polar Crane Girder Weld Deficiencies
(RDC 39(81))

Dear Mr. Keppler:

This letter serves as an Interim Report pursuant to 10CFR50.55(e) concerning weld defects in the Polar Crane Box Girder for the Unit II containment. This was first reported by Mr. V. Higaki of The Cleveland Electric Illuminating Company to your Operations Center, Bethesda, Maryland, on October 17, 1981.

This report includes a description of the deficiency and the method planned to complete our evaluation.

Description of Deficiency

The Polar Crane Box Girder which will support the Polar Crane in the Unit II containment was fabricated in ten sections by Newport News Industrial in their Greenville, Tennessee facility under procurement specification 660-4549-00.

Visual inspection of full penetration welds in these sections was performed during receipt inspection. Visual defects were identified and Nonconformance Report 17-136 was initiated. During excavation to prepare the unacceptable welds for repair by our Site contractor, Newport News of Ohio (NNICO), additional linear indications (lack of fusion) were discovered.

Evaluation Method

All major structural welds in the Unit II Polar Crane Girder are being ultrasonically inspected (UT) by NNICO. The Perry Project organization is monitoring the UT inspection. After Non-Destructive Examination is completed, all necessary repairs will be made to assure compliance with the specification requirements. Preliminary results of the UT reflect a high rate of rejectable welds.

Newport News Industrial of Virginia has been requested to conduct an analysis/study to determine the level of quality of the existing shop welds in the Unit II Polar Crane Box Girder. To accomplish this, a task force under the direction of Newport

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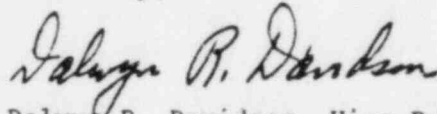
Mr. James Keppler
November 12, 1981
Page Two

News' Director of Engineering has reviewed manufacturing and field repair inspection reports. Additionally, they are duplicating in their Newport News, Virginia, facility the shop processes employed at their Greenville plant to study the effect of parameter variations for travel speed, amperage, etc.

Once Newport News has completed their investigation, a full report will be submitted to the Cleveland Electric Illuminating Company.

All evaluations should be completed by February 26, 1982, and we are presently planning to submit our Final Report at that time.

Sincerely,



Dalwyn R. Davidson, Vice President
System Engineering and Construction

DRD/llp

cc: NRC Site Office

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

U. S. Nuclear Regulatory Commission
c/o Document Management Branch
Washington, D.C. 20555

PERRY NUCLEAR POWER PLANT
U.S. NRC EXIT MEETING
NOVEMBER 20, 1981
11 o'clock

ATTENDEES:

U.S. NRC

C. M. Erb

PROJECT ORGANIZATION

R. L. Farrell
M. K. Edelman
J. P. Eppich
P. L. Gibson
C. F. Hubbuch
R. P. Jadgchew
T. P. Keaveney
J. S. Kerr
J. W. Mehaffey
S. P. Tuik
E. D. Walrath
M. K. Combs

COMMENTS:

Mr. Erb

The principal objective of this inspection was to review corrective action relative to the NNICO 10CFR21 report on covering up defective welds and to the Unit #2 Polar Crane Girder weld deficiencies. Other areas were also inspected and are discussed below.

Mr. Erb stated that he had identified no new items of noncompliance and the following two items would be reported as concerns:

- ... Resolution of the Unit 1 Containment floor plate weld problem; Mr. T. Bond of NNICO had presented their corrective action program to him and he stated that it appeared to be adequate. He understood that a UT investigation of the welds was in process.
- ... Protection of those Unit 2 Containment individual quencher floor plates which are installed. He commented that since Unit 2 is still open, some protection should be provided to avoid possible pitting of the stainless steel from water or snow.

He then commented on other areas which he covered.

- ... During his review of the Unit #2 Polar Crane box girder weld defect problem, he noted that the Unit #1 girder had also been identified on a nonconformance report. It was explained that they were fabricated in different shops, and while the problem with the Unit #1 girder was mainly surface weld defects, during fabrication of the Unit #2 girder the Greenville Shop had used a lower heat input during the MIG process which had caused lack of fusion.



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Dalwyn R. Davidson
VICE PRESIDENT
SYSTEM ENGINEERING AND CONSTRUCTION

February 26, 1982

Mr. James G. Keppler
Director, Region III
Office of Inspection and Enforcement
U. S. Nuclear Regulatory Commission
799 Roosevelt Road
Glen Ellyn, Illinois 60137

RE: Perry Nuclear Power Plant, Docket Nos.
50-440, 50-441; Final Report on Unit II
Polar Crane Girder Weld Deficiencies
(RDC [REDACTED])

Dear Mr. Keppler:

This letter serves as a Final Report pursuant to 10CFR50.55(e) concerning weld defects in the Polar Crane Box Girder for the Unit II Containment. This was first reported by Mr. V. Higaki of The Cleveland Electric Illuminating Company to your Operations Center, Bethesda, Maryland, on October 17, 1981.

This report includes a description of the deficiency, analysis of the safety implications, and corrective action.

DESCRIPTION OF DEFICIENCY

The Polar Crane Box Girder which will support the Polar Crane in the Unit II Containment was fabricated in ten sections by Newport News Industrial in their Greenville, Tennessee (GMM) facility under Procurement Specification SP-660-4549-00. During visual inspection prior to erection, a number of surface weld defects such as undercut, porosity, and insufficient leg were identified and documented on Nonconformance Report No. 17-136. The Perry Project Organization directed Newport News Industrial of Ohio (NNICO) to proceed with the repair of these nonconforming welds. During the repair of these weld defects, it was determined that a number of sub-surface linear defects existed in the shop welds.

ANALYSIS OF THE SAFETY IMPLICATIONS

Had the deficient welds in the Unit II Polar Crane Box Girder remained undetected and a section of this girder failed to perform its design function, it can be postulated that the safety of Polar Crane lifting operations might have been adversely affected.

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CORRECTIVE ACTION TAKEN TO DATE

In order to determine the extent of weld defects present, an information ultrasonic test examination was conducted on all welds identified as strength welds per the design basis utilized by Newport News Industrial of Virginia. These welds are as follows:

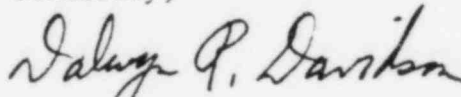
1. Face plate to top flange
2. Face plate to bottom flange
3. Tee stiffener weld to top flange

The only welds not UT examined were the excavated joints undergoing repair which were identified on Nonconformance No. 17-136.

Newport News Industrial has stated that approximately 90% of the total length of welds which were UT examined are rejectable and will be repaired and brought into full compliance with specification requirements. All rejectable areas shall be excavated in order to remove defects. The excavated areas shall be magnetic particle examined prior to welding. Once the repair weld is completed, it will be visually inspected and MT examined in accordance with approved procedures. All repair weld activities will be monitored by NNICO weld engineering section.

Anticipated completion of this activity is July 30, 1982.

Sincerely,



Dalwyn R. Davidson, Vice President
System Engineering and Construction

DRD/11p

cc: NRC Site Office

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

U. S. Nuclear Regulatory Commission
c/o Document Management Branch
Washington, D.C. 20555



Dalwyn R. Davidson
VICE PRESIDENT
SYSTEM ENGINEERING AND CONSTRUCTION

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April 23, 1982

Mr. James G. Keppler
Director, Region III
Office of Inspection and Enforcement
U. S. Nuclear Regulatory Commission
799 Roosevelt Road
Glen Ellyn, Illinois 60137

RE: Perry Nuclear Power Plant, Docket Nos.
50-440, 50-441; Unit II Polar Crane
Girder Weld Deficiencies
(RD [REDACTED])

REF: Final Report dated February 26, 1982
to Mr. James G. Keppler

Dear Mr. Keppler:

This letter serves to correct our Final Report of the Unit II Polar Crane girder weld deficiencies. Subject Final Report is dated February 26, 1982.

In the portion of the report entitled "Corrective Action Taken to Date", we described the following action to be taken:

"... Once the repair weld is completed, it will be visually inspected and MT examined in accordance with approved procedures"

This statement is incorrect.

Nonconformance Report No. 17-136 which identified the weld deficiencies was dispositioned to include a visual inspection and an ultrasonic examination (UT). The Final Report inadvertently specified a visual inspection with an MT examination. It is the intent of The Cleveland Electric Illuminating Company to perform a UT examination as specified in Nonconformance No. 17-136.

This matter was discussed with Mr. E. H. Nightingale of your office during his inspection conducted at the Perry Nuclear Power Plant on April 22 and 23, 1982.

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APR 29 1982

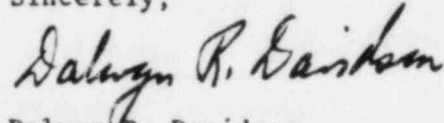
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April 23, 1982

The above information supplements our Final Report on this matter.

If you have any questions, please call.

Sincerely,



Dalwyn R. Davidson

Vice President

System Engineering and Construction

DRD/llp

cc: Mr. M. L. Gildner
NRC Site Office

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

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