NORTHEAST UTILITIES

THE CONNECTICUT LIGHT AND POWER COMPANY
WESTERN MASSACHUSETTS ELECTRIC COMPANY
HOLYOKE WATER POWER COMPANY
NORTHEAST UTILITIES SERVICE COMPANY
NORTHEAST NUCLEAR ENERGY COMPANY

General Offices • Selden Street, Berlin, Connecticut

P.O. BOX 270
HARTFORD, CONNECTICUT 06141-0270
(203) 665-5000

July 10, 1985

Docket No. 50-423
F0778A

Dr. Thomas E. Murley
Regional Administrator
U. S. Nuclear Regulatory Commission
Region I
631 Park Avenue
King of Prussia, PA 19406

Reference: (1) J. F. Opeka to T. E. Murley, F0755A dated May 10, 1985.

Dear Dr. Murley:

Millstone Nuclear Power Station, Unit No. 3
Reporting of Potential Significant Deficiencies
in Accordance with 10CFR50.55(e):
Skewed Angle Fillet Welds (SD-80)

In an April 12, 1985 telephone conversation between your Mr. T. Rebelowski and our Mr. P. J. Quinlan, Northeast Nuclear Energy Company (NNECO) report a potential significant deficiency in the construction of Millstone Unit No. 3 in accordance with 10CFR50.55(e). The potential significant deficiency involved the weld preparation on skewed fillet weld joints.

During the NRC Construction Appraisal Team (CAT) inspection at Millstone Unit No. 3, a concern was raised with respect to the dimensioning of fillet welds on tube steel connections where the skewed angle is less than 45°. Upon review of the weld documentation and a sampling of as-built welds, we were not able to determine whether the toe of the tube steel had been cut back as required by the weld joint design detail in order to accommodate the specified weld size on both weld legs. Failure to cut back the toe as designed could result in undersized welds.

To address this potential significant deficiency, we have separated this problem into two categories:

(1) 3 or 4-sided welds - skewed angle joints welded on the toe and two sides or welded all the way around.

(2) 2-sided welds - skewed angle joints with only toe and heel welded.

As noted in reference (1), our architect-engineer, Stone & Webster Engineering Corporation, has completed their review of the 3 or 4 sided welds and determined that this is not a significant deficiency and that the welds are acceptable as is.

40
IE 27

There are 133 2-sided welds that are currently being reviewed on a case by case basis for acceptability. A final determination on whether the 2-sided weld issue constitutes a significant deficiency is not available at this time.

As such, we are not able to provide a final report at this time. We will provide an update on this matter by August 22, 1985.

Very truly yours,

NORTHEAST NUCLEAR ENERGY COMPANY

J. F. Opeka

J. F. Opeka
Senior Vice President

W. F. Fee

By: W. F. Fee
Executive Vice President

cc: Mr. J. M. Taylor, Director
Division of Inspection and Enforcement
U. S. Nuclear Regulatory Commission
Washington, D. C. 20555