

SSER

Task No.: Allegation A-128d, A-212, A-275

Reference No.: 4-84-A-06/23d; 4-84-A-06/100; 4-84-A-06/157

Characterization: It is alleged in newspaper article of January 14, 1984 that there were undersized welds in work performed by the Mercury Construction Company.

Assessment of the Allegation: In its review of records, the NRC staff learned that undersized welds had been discovered by LP&L in Mercury socket weld fittings. Upon their discovery, LP&L issued Significant Construction Deficiency (SCD) No. 62, "Undersized welds on $\frac{1}{2}$ " schedule 160 pipe." Resolution of this SCD was controlled by Ebasco NCRs W3-4410 Revision 1, W3-4365, and W3-4366.

According to the ASME Code, the size of a weld is determined by the wall thickness of piping or tubing. The reason Mercury gave for the deficient welding and inspection was that both were based on criteria for $\frac{1}{2}$ " stainless tubing with a thinner wall thickness of 0.065", rather than for the Schedule 160 piping installed, which has a wall thickness of 0.188". A large share of Mercury's work involved the installation of the thinner tubing. The tubing required a 1/8" fillet weld rather than the 1/4" fillet required for Schedule 160 pipe. The SCD and NCRs resulted in a reinspection and rewelding of doubtful welds by Mercury. The rewelds were reinspected by LP&L and found adequate. SCD No. 62 was reported to the NRC in accordance with 10 CFR 50.55e requirements. The NRC staff reviewed and concurred in the need for SCD No. 62.

In assessing this allegation, the NRC staff visually inspected portions of 20 systems welded by Mercury and found unacceptable welds in tubing or support welding. Based on its review of the records and on a visual inspection of accessible portions of 20 systems, the staff believe that the allegation has neither safety significance nor generic implications. It may have been a concern at some time prior to the issuance of Significant Construction

Deficiency Report No. 62. Normal QA controls wereadequate to recognize and correct the problem. The NRC staff have discussed their findings with the allegor and he agreed and expressed satisfaction with our efforts and conclusions.

Potential Violation: None.

Action Required: None.

References

1. Significant Construction Deficiency No. 62.
2. NCR W3-4410.
3. NCR W3-4365.
4. NCR W3-4366.
5. List of systems inspected.

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