

Anchor/Darling

Valve Company

701 FIRST STREET
P.O. BOX 3428
WILLIAMSPORT, PA 17701-0428
(717) 327-4800
TELEX: 759953

December 19, 1985

Nuclear Regulatory Commission
Vendor Program Branch
Division of Quality Assurance, Vendor
and Technical Training Center Programs
Office of Inspection and Enforcement
Washington, DC 20555

Attention: Richard Kiessel

Gentlemen:

On 11/21/85, you requested that I keep you advised of our actions concerning check valves that may have missing lock welds on hinge supports or hinge support capscrews. Enclosed is a copy of one of the letters we sent to our customers and a list of customers who received the letter.

Please advise if additional information is needed.

Very truly yours,

ANCHOR/DARLING VALVE COMPANY


G. W. Knieser
Q. A. Manager

GWK:dz

Enclosures

8601230179 851219
PDR ADOCK 05000206
S PDR

IE19
1/1

- ✓ ARKANSAS POWER & LIGHT COMPANY
Arkansas Nuclear One
- ✓ BALDWIN ASSOCIATES
Illinois Power Company
Clinton Power Station
- ✓ BECHTEL CONSTRUCTION, INC.
Palo Verde Nuclear Generating Station
- ✓ BECHTEL CONSTRUCTION, INC.
Philadelphia Electric Company
Limerick Generating Station
- ✓ BECHTEL CONSTRUCTION, INC.
Public Service Electric & Gas Co.
Hope Creek Generating Station
- ✓ BECHTEL ENERGY CORPORATION
Houston Lighting and Power
South Texas Project
- ✓ BOSTON EDISON COMPANY
Bechtel Power Corporation
Pilgrim Station, Unit 2
- ✓ CAROLINA POWER & LIGHT COMPANY
Brunswick Steam Electric Plant
- ✓ CAROLINA POWER & LIGHT COMPANY
Shearon Harris Nuclear Power Plant
- ✓ COMMONWEALTH EDISON COMPANY
LaSalle County Station
- ✓ CONSUMERS POWER COMPANY
Palisades Generating Plant
- ✓ ~~ECODYNE-UNITED STATES DIVISION~~
- ✓ FLORIDA POWER & LIGHT COMPANY
St. Lucie Power Plant
- ✓ GEORGIA POWER COMPANY
Plant Vogtle
- ✓ IOWA ELECTRIC LIGHT & POWER COMPANY
Duane Arnold Energy Center
- ✓ LONG ISLAND LIGHTING COMPANY
Shoreham Nuclear Power Station
- ✓ LOUISIANA POWER & LIGHT COMPANY
Ebasco Services, Inc., Agent
Waterford SES Unit 3

- ✓ MAINE YANKEE ATOMIC POWER COMPANY
- ✓ NEBRASKA PUBLIC POWER DISTRICT
Cooper Nuclear Station
- ✓ NIAGARA MOHAWK POWER CORPORATION
Nine Mile Point
- ✓ NORTHERN STATES POWER COMPANY
Pioneer Service & Engineering
Prairie Island Nuclear Plant
- ✓ OVERSEAS BECHTEL, INCORPORATED
Korea Electric Company
Korea Nuclear Units 5, 6, 7 and 8
- ✓ OVERSEAS BECHTEL, INCORPORATED
Taiwan Power Company
Kuosheng Nuclear Power Station
- ✓ OVERSEAS BECHTEL, INCORPORATED
Taiwan Power Company
Maanshan Nuclear Power Station
- ✓ PENNSYLVANIA POWER & LIGHT COMPANY
Susquehanna SES
- ✓ PORTLAND GENERAL ELECTRIC COMPANY
Trojan Nuclear Plant
- ✓ POWER AUTHORITY OF THE STATE OF NEW YORK
James A. Fitzpatrick Nuclear Power Plant
- ✓ SACRAMENTO MUNICIPAL UTILITY DISTRICT
Rancho Seco Nuclear Generating Station
- ✓ SOUTH CAROLINA ELECTRIC & GAS COMPANY
V. C. Summer Nuclear Station
- ✓ SOUTHERN CALIFORNIA EDISON COMPANY
San Onofre Nuclear Station
- ✓ TAIWAN POWER COMPANY
Ebasco Service, Inc.
Chin Shan Units 1 & 2
- ✓ TENNESSEE VALLEY AUTHORITY
Browns Ferry Power Plant
- ✓ TENNESSEE VALLEY AUTHORITY
Stride Project
- ✓ Bechtel/Monticello

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December 10, 1985

BALDWIN ASSOCIATES
P.O. Box 306
Clinton, IL 61727

Attention: Duane Hupp/Engineering

Subject: Illinois Power Company
Clinton Power Station
P.O. C-2513
A/DV S.O. E-6214

RECEIVED

DEC 13 1985

Q.A. DEPT.

Reference: A/DV's Letter dated July 31, 1985

Gentlemen:

The above referenced letter described a problem with missing lock welds on hinge pin setscrews. During an investigation of this problem at the V.C. Summer Nuclear Station it was discovered that on some 150 & 300 class valves lock welds were also missing at the hinge support/hinge support capscrews interface and at the hinge support/bonnet interface.

As shown on the attached sketch, the hinge support capscrew is lock welded to prevent it from backing out and allowing the disc and hinge assembly to drop below the seat.

Additionally, in order to maintain the geometry necessary for tight shutoff, the hinge support is lock welded to the bonnet. If this weld is missing, the hinge support could conceivably shift, by an amount equal to the clearance between the hinge support and the hinge support capscrew, thus preventing the valve from seating properly.

Since both these problems could effect valve operability, we recommend that the subject valve(s) be inspected to verify that they have been lock welded.

Some carbon steel valves were originally furnished with alloy steel hinge support capscrews. If these capscrews have not been welded, we recommend they be replaced with carbon steel bolting and welded with a P1 weld procedure.

Attached, in addition to the aforementioned sketch, is a listing of those valves which our records indicate have been furnished for installation in your plant.

Continued

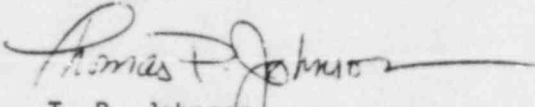
BALDWIN ASSOCIATES
Attention: Duane Hupp/Engineering

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December 10, 1985

Should you find this condition or if you have any questions or require additional information, please contact John Chappell at 717-327-4856 or Bill Knecht at 717-327-4811.

Very truly yours,

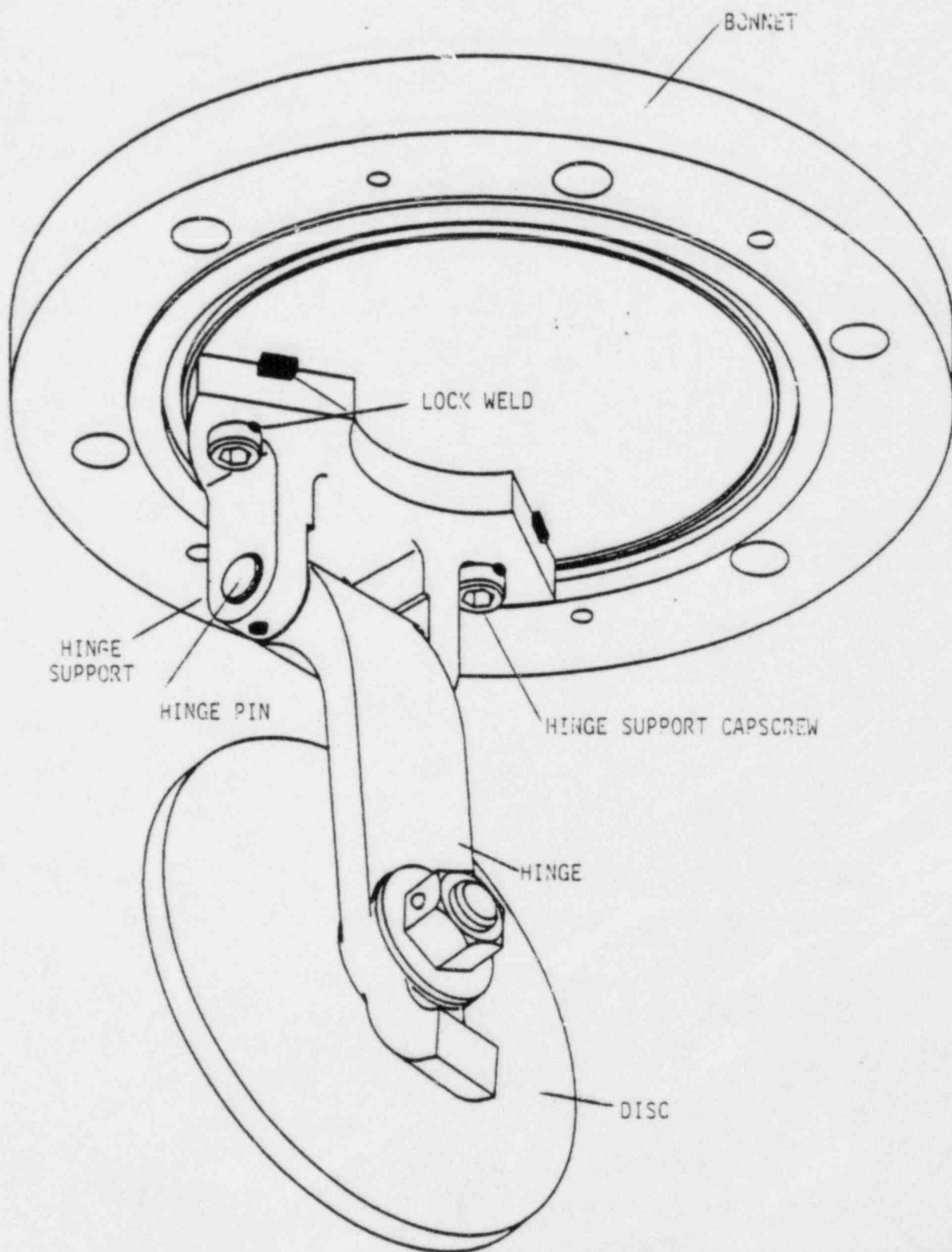
ANCHOR/DARLING VALVE COMPANY


T. P. Johnson
Contract Administrator

/eu

cc: R. O. Bowman)
J. J. Chappell)
G. W. Conlan)
W. G. Knecht) A/DV
G. W. Knieser)
R. H. Luhta)
H. L. Patterson)
J. P. Punch)

S.O. E-6214



PLANT SITE: CLINTON STATION UNITS 1 AND 2

A/DV SHOP ORDER	CUSTOMER PURCHASE ORDER	A/DV ASMBLY DWG.	VALVE QTY.	VALVE SIZE	PRESS. CLASS	VALVE IDENT. NO.	VALVE MATL.	HINGE SUPPORT MATL (1)	CAPSCREW MATERIAL	(2)
E6214-207	C2513	W7820096	2	3	150	15X106 A, B	C.S.	A216-WCB	X A574	X
E6214-219	C2513	W7820132	1	6	150	1FC096	S.S.	A351-CF8	X I 3/16	X
E6214-222	C2513	W7820133	1	4	150	1FC022A	S.S.	A351-CF8	X AISI 316	X
E6214-254	C2513	W8020980	1	4	300	145-305CP-4	C.S.	A216-WCB	X A574	X
E6214-135	C2513	93-14767	2	10	150	1/2SX001-C	C.S.	A216-WCB	X A574	-
E6214-183	C2513	93-15082	4	14	150	1/2FC075A, B	S.S.	A351-CF8	X AISI 316	X
E6214-184	C2513	93-15083	8	12	150	1/2FC018A, B 1/2FC020A, B	S.S.	A351-CF8	X AISI 316	X
E6214-185	C2513	93-15084	2	10	150	1/2FC022B	S.S.	A351-CF8	X AISI 316	X
E6214-188	C2513	93-15087	2	3	150	1/2FC039	S.S.	A351-CF8	X AISI 316	X
E6214-189	C2513	93-15088	4	4	150	1/2FC073 1/2FC077	S.S.	A351-CF8	X AISI 316	X

(1) X indicates Hinge Support is tackwelded to Cover.

(2) X indicates Capscrew is tackwelded to Hinge Support.

5 CS
22 SC