Case N-XXX

Alternative Examination Requirements for Class 1 Pressure Retaining Welds in Control Rod Drive Housings, Section XI, Division 1

Inquiry: What alternative rules to IWB-2200 and Table IWB-2500-1 Examination Category B-O, Examination Item Numbers B14.10 and B14.20 may be used for PSI and ISI of Welds in Control Rod Drive Housings?

Reply: It is the opinion of the Committee that the following requirements may be used in lieu of the requirements of IWB-2200 and Table IWB-2500-1 Examination Category B-O, Examination Item Numbers B14.10 and B14.20 for performing PSI and ISI of Welds in Control Rod Drive Housings.

1. Preservice Requirements

   (a) Initial Examination

   Examinations required by Table 1 shall be completed for 100% of the welds in all installed control rod drive housings (peripheral and non-peripheral) at least once prior to initial service.

   (b) Repair/Replacement Activities

   The first inservice examination performed in accordance with Table 1 shall serve as the preservice examination.

2. Inspection Program

   Examination of Welds in Control Rod Drive Housings shall be performed in accordance with Table 1
<table>
<thead>
<tr>
<th>Item No.</th>
<th>Parts Examined</th>
<th>Examination Requirements/ Figure No.</th>
<th>Examination Method</th>
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<td>Reactor Vessel-(BWR)</td>
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<td>IWB-2500-18</td>
<td>Volumetric or surface</td>
<td>IWB-3523</td>
<td>See [Note (1)]</td>
<td>Same as for first interval</td>
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<tr>
<td>Reactor Vessel-(PWR)</td>
<td>B14.20 Welds in Control Rod Drive (CRD) Housings</td>
<td>IWB-2500-18</td>
<td>Volumetric or surface</td>
<td>IWB-3523</td>
<td>See [Note (1)]</td>
<td>Same as for first interval</td>
</tr>
</tbody>
</table>

NOTES:
(1) Examination is required on 10% of peripheral CRD housings. Alternatively, 10% of the combined length of each weld configuration (e.g., housing-to-housing and housing-to-flange) of the peripheral CRD housing welds may be examined, provided each weld selected for examination is examined to the maximum extent practicable.
(2) The surface examination method shall be performed on the inside diameter of the penetration nozzle housing welds as shown in Figure IWB-2500-18 for examination surface area C-D.

Replace note 1 with the following:
(1) Examination is required on a population of welds equal to 10% of the peripheral CRD housings
   a. Examinations may be performed on any CRD housing, peripheral or non-peripheral.
   b. Each weld configuration (e.g., nozzle-to-flange, flange-to-housing, and housing-to-housing) shall be examined on all selected CRDs. Alternatively, 10% of the combined length of each weld configuration (e.g., nozzle-to-flange, flange-to-housing, and housing-to-housing) of the CRD housing welds shall be examined, provided each weld selected for examination is examined to the maximum extent practicable.