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10 CFR 50.73

January 27, 2016

U.S. Nuclear Regulatory Commission ATTN: Document Control Desk Washington, DC 20555

> Calvert Cliffs Nuclear Power Plant, Unit No. 2 Renewed Facility Operating License No. DPR-69 NRC Docket No. 50-318

Subject: Licensee Event Report 2015-001, Revision 00 Manual Reactor Trip Due to Steam Generator Feed Pump 22 Trip

The attached report is being sent to you as required by 10 CFR 50.73.

There are no regulatory commitments contained in this correspondence.

Should you have questions regarding this report, please contact Mr. Larry D. Smith at (410) 495-5219.

Respectfully,

MQD Ho

Mark D. Flaherty Plant Manager

MDF/KLG/bjm

Attachment: As stated

cc: NRC Project Manager, Calvert Cliffs NRC Regional Administrator, Region I NRC Resident Inspector, Calvert Cliffs S. Gray, MD-DNR

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	ABSTRACT (Limit to 1400 spaces, i.e., approximately 15 single-spaced typewritten lines) On December 1, 2015 at 1820, Unit 2 turbine driven Steam Generator Feed Pump (SGFP) 22 tripped. Operations attempted to reset SGFP 22 unsuccessfully. Facing lowering steam															
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22 tripped due to a failed coupling. This occurred because excessive misalignment developed																
between the pump and turbine due to insufficient tensioning of the pump's casing to pedestal stude thus causing SCEP 22 coupling to fail Investigation determined that the vender supplied																
studs thus causing SGFP 22 coupling to fail. Investigation determined that the vender supplied stud tensioning values used in tensioning the hold down studs on both Unit 2 SGFPs during the																
2015 refueling outage were incorrect and resulted in insufficient clamping force being applied to																
	all the studs. The root cause of the failure was that Engineering personnel did not rigorously															
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I. DESCRIPTION OF EVENT:

Energy Industry Identification System (EIIS) codes are identified in the text as [XX].

A. INITIAL CONDITIONS:

Unit 2 was operating at 100 percent power on December 1, 2015 prior to the event.

B. EVENT:

On December 1, 2015 at 1820, Unit 2 turbine driven Steam Generator Feed Pump [SJ] [P] (SGFP) 22 tripped. Operations attempt to reset SGFP 22, in accordance with the abnormal operating procedure, was unsuccessful. Facing lowering steam generator water level, Operations manually initiated a reactor trip. The unit experienced an uncomplicated trip as all systems operated as designed.

Following the reactor trip, the unit transitioned into an unscheduled outage. Upon inspection, SGFP 22 coupling was found failed. During disassembly, Maintenance discovered that one of the four pump casing hold-down nuts (southeast corner) had backed off from its bolting surface by 1-5/8 inches. Further investigation revealed that the vendor supplied stud tensioning values used in tensioning the hold down studs on both Unit 2 SGFPs during the March 2015 refueling outage were incorrect and resulted in insufficient clamping force being applied to all the studs. As a result, SGFP 22 pump became misaligned with the turbine to such an extent to exceed the maximum designed angular misalignment of its coupling and subsequently caused the coupling to fail. Although SGFP 21 also had insufficient tensioning applied during the refueling outage, it was found to still be within acceptable alignment. The root cause of the failure was that Engineering personnel did not rigorously follow Engineering standards and applicable site processes in evaluating the change that allowed the use of studs to hold down the SGFP pump casing to its pedestal. The investigation further determined that the southeast stud had been pulled out of perpendicular alignment to its base during the 2015 refueling outage due to the stud tensioner not having a flat surface to sit flush upon. This combined with the incorrect stud tensioning value used prevented sufficient clamping force to be applied and led to SGFP 22 failure.

The coupling on SGFP 22 was replaced and SGFP 22 was realigned. Corrected tensioning values were then applied to all the hold down studs on SGFP 21 and 22. To ensure proper clamping force had been applied, a hydraulic power high torqueing tool was subsequently used to verify required clamping force on both SGFP 21 and 22 studs had been achieved. In addition, anti-rotation nuts were installed as a measure to help ensure vibration will not cause the nuts to lose tension resulting in a loss of clamping force.

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NARRATIVE

Unit 2 was returned to Mode 1 operations at 1326 on December 6, 2015 and the unit reached 100 percent power at 0514 on December 7, 2015.

C. INOPERABLE STRUCTURES, COMPONENTS, OR SYSTEMS THAT CONTRIBUTED TO THE EVENT:

There were no structures, systems or components inoperable at the start of the event that contributed to the event.

D. DATES AND APPROXIMATE TIMES OF MAJOR OCCURRENCES:

December 1, 2015 1820 – Unit 2 manual reactor trip following trip of SGFP 22.

December 1, 2015 1830 – All EOP -0 (Post Trip Immediate Actions) completed. Entered EOP-1 (Reactor Trip) to perform post-trip recovery actions.

December 1, 2015 1840 – All EOP -1 Safety Functions completed satisfactorily.

December 6, 2015 1326 – Unit 2 returned to Mode 1.

December 7, 2015 0514 - Unit 2 reached 100 percent power.

E. FAILURE MODES:

The cause of SGFP 22 trip was a coupling failure due to excessive pump to turbine misalignment caused by inadequate torque force having been applied to SGFP 22 hold-down nuts. The root cause for the failure was that Engineering personnel did not rigorously follow Engineering standards and applicable site processes in evaluating the change that allowed the use of studs to hold down the SGFP pump casing to its pedestal.

F. METHOD OF DISCOVERY:

The failure of SGFP 22 was self-revealing. This event is documented in the site's Corrective Action Program under IR 02594406.

II. CAUSE OF EVENT

A switch to use stud tensioning technology on the SGFPs was first made during Unit 1 2014 refueling outage, however it was only used on SGFP 12. During the Unit 2 2015 refueling outage, the same stud tensioning technology was used on both SGFPs. Prior to the original use of this technology, Engineering performed an equivalency evaluation that allowed use of studs to hold down the SGFP pump casing to its pedestal in place of previously used

					Page 4 of 5
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Calvert Cliffs Nuclear Power Plant, Unit 2	05000 318		2015	001	00

NARRATIVE

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capscrews. However because the evaluation did not rigorously follow Engineering standards and applicable processes, the evaluation justified the use of the stud tensioning technology with insufficient technical basis. As a result, an opportunity to identify the vendor's incorrect hydraulic pressure values was missed. Additionally, the Engineering evaluation failed to ensure formal, systematic notification was made to Maintenance concerning the change. This resulted in a missed opportunity to incorporate Electric Power Research Institute bolted joint guidance into the applicable maintenance work practice that would have helped identify critical parameters that must be obtained or followed by Maintenance to ensure proper stud tensioning is applied.

A. SAFETY CONSEQUENCES:

The reactor protection system [JD] was manually initiated in response to SGFP 22 trip. No other safety systems were initiated following the trip.

The safety consequence of SGFP 22 trip was insufficient main feedwater flow to the steam generators. Facing decreasing water levels in the steam generators, Operations manually tripped the reactor prior to water levels reaching the low level setpoint for automatic reactor trip.

The subject condition satisfies the criteria in NUREG-1022, Revision 3, for an event that results in the actuation of the reactor protection system when the reactor is critical. Therefore, this event is reportable pursuant to 10 CFR 50.73(a)(2)(iv)(A). An immediate event notification report (51577) was also made pursuant to 10 CFR 50.72(b)(2)(iv)(B).

This event was reviewed for potential probabilistic risk assessment impact. The probabilistic risk assessment calculated a conditional Core Damage Frequency of less than 1E-7 and a Conditional Large Early Release Frequency of less than 1 E-8. Both these values result in this event as being of very low safety significance (Green) under the Nuclear Regulatory Commission's Significance Determination Process.

B. CORRECTIVE ACTIONS:

Following SGFP 22 failure, its coupling was replaced and SGFP 22 was realigned. Corrected tensioning values were then applied to all the hold down studs on SGFP 21 and 22. To ensure proper clamping force had been applied, a hydraulic power high torqueing tool was subsequently used to verify required clamping force on both SGFP 21 and 22 studs had been achieved. Additionally, anti-rotation nuts were installed as a precautionary measure to ensure the nuts do not lose tension during subsequent operation.

Although SGFP 12 used the same stud tensioning technology and tensioning values as used on Unit 2 SGFPs, SGFP 12 has exhibited normal operating parameters since the 2014 refueling outage. A determination was made to continue operation of SGFP 12 until its February 2016

						Page 5 of 5
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NARRATIVE

refueling outage at which time correct tensioning values will be applied. A robust adverse condition monitoring plan was developed for SGFPs 12, 21, and 22 to include the monitoring and recording of pump and turbine shaft and casing vibration, and the monitoring of thrust bearing temperatures.

Corrective actions to be taken include:

- Implement a process for when new tools/technology are introduced to single point vulnerable components for a critical parameter and scope review to be performed via an Engineering Evaluation
- Conduct critical parameters and rigor training
- Ensure proper barriers are in place to ensure tensioner seating surfaces are flat (perpendicular to stud) on all components where stud tensioning technology is used
- III. PREVIOUS SIMILAR EVENTS:

On May 21, 2013, Calvert Cliffs Unit 2 initiated a manual reactor trip following the trip of SGFP 22. The failure of SGFP 22 was due to the failure of its coupling. However, in this event, the coupling failure was subsequently determined to be due to areas of incomplete weld fusion on the turbine end of the coupling that occurred during initial component manufacture. This event was described in Calvert Cliffs Licensee Event Report 2013-004-00.

A. COMPONENT INFORMATION:

COMPONENT	IEEE 803 FUNCTION ID	IEEE 805 SYSTEM ID
Pump, Steam Generator Feed, (SGFP 22)	Р	SJ

SGFP 22 Pump is manufactured by Byron Jackson Pump Division – Borg Warner Corp. (Model DVSR).