



QA: QA

Mr. Terry O'Connell,  
Director of Quality Assurance  
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2400 Longhorn Industrial Drive  
New Braunfels, TX 78130

BECHTEL SAIC COMPANY, LLC (BSC) QUALITY ASSURANCE (QA) SUPPLIER AUDIT  
REPORT BSC-SA-02-009 OF SENIOR FLEXONICS, INC. PATHWAY DIVISION (SFIPD)

Enclosed is the Supplier Audit Report BSC-SA-02-009 of SFIPD that was performed on February 20-21, 2002 in New Braunfels, Texas. This was a follow-up audit to evaluate the implementation and effectiveness of the corrective actions for the seven Recommendations identified in the previous BSC Supplier Survey BSC-SFE-01-008. The audit also evaluated the Weld Flaw Analysis work being performed.

The audit revealed effective implementation of the corrective actions and quality requirements with the exception of a condition adverse to quality in the control of Nonconformances. This was also a repeat of a previous condition adverse to quality identified during the survey and both conditions are documented in Deficiency Report BSC(V)-02-D-077.

As a result of the audit, SFIPD was found to be effectively implementing its quality program and will remain on the Office of Civilian Radioactive Waste Management Qualified Suppliers List.

This audit is considered complete and closed as of the date of this letter.

If you have any questions, please contact either Robert F. Hartstern at (702) 295-2675 or Daniel A. Klimas at (702) 295-2665.

A handwritten signature in cursive script that reads 'D. T. Krisha'.

Donald T. Krisha, Manager  
Quality Assurance

3/22/02  
Date Signed

RFH:bw-0320021882

Enclosure:  
Supplier Audit Report BSC-SA-02-009

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Wm-11*

March 22, 2002

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cc w/encl:

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**BECHTEL SAIC COMPANY, LLC (BSC)  
QUALITY ASSURANCE**

**SUPPLIER AUDIT REPORT**

**OF**

**SENIOR FLEXONICS, INC.  
PATHWAY DIVISION**

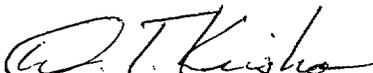
**NEW BRAUNFELS, TEXAS**

**REPORT NUMBER  
BSC-SA-02-009**

**FEBRUARY 20-21, 2002**

Prepared by:   
Robert F. Hartstern  
Audit Team Leader  
BSC Quality Assurance

Date: 3/19/02

Approved by:   
Donald T. Krisha, Manager  
BSC Quality Assurance

Date: 3/22/02

## **1.0 AUDIT SUMMARY**

BSC conducted a follow-up supplier audit of Senior Flexonics, Inc. Pathway Division (SFIPD) on February 20-21, 2002, at the New Braunfels facility. SFIPD provides Welding, Weld Flaw Analysis, Fabrication of Customer Supplied Design, Heat Treating, and Non Destructive Testing. The audit revealed effective implementation of the corrective actions and quality requirements with the exception of a condition adverse to quality in the control of Nonconformances. This was also a repeat of a previous condition adverse to quality identified during the survey and both conditions are documented in Deficiency Report BSC(V)-02-D-077. Details of the conditions adverse to quality are provided in Section 5.0 of this report.

None of the identified deficiencies are considered to have an immediate impact in the quality of the services provided as the condition adverse to quality was not related directly to YMP activities. As a result of this audit, SFIPD will remain on the Office of Civilian Radioactive Waste Management (OCRWM) Qualified Supplier List (QSL) on a triennial audit schedule. Audits or surveillances prior to the next scheduled audit may be performed based on QA program changes, scope of work changes and/or supplier performance as deemed necessary.

## **2.0 SCOPE**

This was a follow-up audit to previous Survey Report BSC SFE-01-008 to evaluate effective implementation of corrective action of the seven Recommendations resulting from the survey. The audit also evaluated Weld Flaw Analysis work in accordance with BSC Technical Service Agreement (TSA) No. 24540-860-TA-00889. The QA program elements determined to be applicable are: Control of Purchased Items and Services; Special Processes; Test Control; Control of Measuring and Test Equipment; Corrective Action; and QA Records.

The details of the audit, along with the objective evidence reviewed are contained within the audit checklist, which is available from the BSC Records Processing Center.

## **3.0 AUDIT TEAM MEMBERS AND OBSERVERS**

### **Audit Team:**

Robert F. Hartstern, Audit Team Leader, BSC QA  
Daniel A. Klimas, Audit Team Member, BSC QA

### **Observers:**

Kamalakar Naidu, U.S. Nuclear Regulatory Committee (NRC)  
Bruce Mabrito, Southwest Research Institute / NRC  
Jerry A. Cogar, BSC Manufacturing & Fabrication Technology  
Roxanna VanDillen, BSC Science and Engineering Testing

**4.0 PERSONNEL CONTACTED DURING THE AUDIT**

Steve Andrews, SFIPD / Project Coordinator  
Terry O'Connell, SFIPD / Director of QA  
Greg Perkins, SFIPD / Vice President & General Manager  
Larry Verner, SFIPD / Senior Engineer  
Curtis P. Wendler, One Beacon Insurance Co. / Authorized Nuclear Inspector  
Gene Woelfel, SFIPD / QC Manager & Welding Engineer  
Steve Woolery, SFIPD / QC Chief Inspector – NDE Level III

**5.0 CONDITIONS ADVERSE TO QUALITY**

The condition adverse to quality has been documented in DR BSC(V)-02-D-077 and submitted to the BSC responsible management for SFIPD's resolution. The DR is detailed below.

**DEFICIENCY REPORT BSC(V)-02-D-077**

The Senior Flexonics, Inc. Nuclear QA Manual, Revision 2, Section 8, paragraph 8.4, requires the Material Review Board (MRB) to meet and review Nonconformances (NCR) when a Use-As-Is or Repair disposition is requested. Additionally, the MRB is required to provide technical justification for repair dispositions.

Contrary to the above requirements,

The MRB did not convene for review and disposition of SFIPD's NCR's N-01-023 and N-01-028. As a result, there was no technical justification provided for NCR N-01-028 with a repair disposition.

This is a repetitive condition. The same condition was identified during BSC Survey BSC-SFE-01-008. Corrective action taken to preclude recurrence was ineffective.