



QA: QA

Arnold Horoff, QA Manager
Laboratory Testing, Inc.
2331 Topaz Drive
Hatfield, PA 19440

**BECHTEL SAIC COMPANY, LLC (BSC) QUALITY ASSURANCE (QA) SURVEILLANCE
REPORT BSCQA-02-S-19 OF RECEIPT AND FABRICATION OF METAL SPECIMENS OF
LABORATORY TESTING, INC. (LTI)**

Enclosed is the Surveillance Report BSCQA-02-S-19, conducted by BSC QA on
April 23-24, 2002 at the Laboratory Testing, Inc. facilities in Hatfield, Pennsylvania.

The purpose of the surveillance was to evaluate the implementation of the BSC Purchase Order
24540-160-PO-01195 and LTI Quality Program requirements for Receipt Inspection and
Fabrication of Metal Specimens.

This surveillance found effective implementation of the BSC Purchase Order and LTI QA
Program. This surveillance is considered complete and closed as of the date of this letter. A
response to this surveillance report is not required.

If you have any questions, please contact either Richard L. Maudlin at (702) 295-2961 or
Daniel A. Klimas at (702) 295-2665.

A handwritten signature in cursive script, appearing to read 'D. T. Krishna'.

Donald T. Krishna, Manager
Quality Assurance

5/22/02

Date Signed

RLM:bw-0521022741

Enclosure:
Surveillance Report BSCQA-02-S-19

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May 22, 2002

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cc w/encl:

L. H. Barrett, DOE/HQ (RW-2) FORS
G. K. Beall, BSC, Las Vegas, NV
James Blaylock, BSC, Las Vegas, NV
L. W. Bradshaw, Nye County, Pahrump, NV
Margaret Chu, DOE/HQ (RW-1) FORS
J. R. Dyer, DOE/YMSCO, Las Vegas, NV
Leonard Fiorenzi, Eureka County, Eureka, NV
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Geneva Hollis, Nye County, Tonopah, NV
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B. L. Wilson, BSC, Las Vegas, NV
Mickey Yarbrow, Lander County, Battle Mountain, NV

cc w/encl:

T. W. Doering, BSC, Las Vegas, NV
J. C. Estill, BSC/LLNL, Livermore, CA
S. T. Mahler, BSC/LLNL, Livermore, CA
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C. C. Warren, BSC, Livermore, CA

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OFFICE OF CIVILIAN RADIOACTIVE WASTE MANAGEMENT
QUALITY ASSURANCE SURVEILLANCE REPORT

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QA Surveillance Number:
BSCQA-02-S-19

Complete only applicable items.

1. Organization/Location Laboratory Testing, Inc. (LTI) / Hatfield, PA	2. Subject Receipt and Fabrication of Metal Specimens	3. Date(s) Performed 04/23-24/2002
4. Surveillance Scope Evaluate the implementation of the BSC PO 24540-160-PO-01195 and LTI Quality Program requirements for Receipt Inspection and Fabrication of Metal Specimens.		
5. Requirement(s) (Procedure, Specification, Drawing, etc.) BSC Purchase Order (PO) 24540-160-PO-01195, List of Items for LTI Fabrication of Specimens from Alloy 22 Customer Supplied Material, dated 02/14/2002. LTI Procedure PN RI-1, Revision 5, LTI Procedure for Receiving and Order Entry. LTI Procedure PN QC-III-MC, Revision 4, LTI Procedure for Material Control and Maintain Traceability for Upgrading Material to Customer's Requirements.		6. Originator Richard L. Maudlin Team Members Roxanna VanDillen (Subject Matter Expert)

SURVEILLANCE RESULTS

7. Description/Details
This surveillance was performed by observing the fabrication of metal specimens and the review of documentation to support the receipt acceptance and documentation submittals required by the BSC PO List of Items, Hold Points #1 through #5.

The requirements of BSC PO 24540-160-PO-01195, List of Items, LTI Procedure PN RI-1, and LTI Procedure PN QC-111-MC were evaluated as follows:


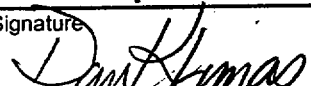
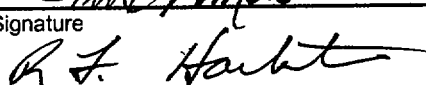
- Documents supporting approval to proceed with work beyond Hold Points.
- Review of customer Purchase Orders by Order Entry personnel.
- Documentation submittals supporting Hold Points.
- Documentation supporting receipt inspection of Customer Supplied Material.
- Plate traceability after cutting plate for specimen fabrication.
- Specimen traceability during fabrication.
- Documentation supporting the calibration of Measuring and Test Equipment (M&TE) to be used in fabrication and final inspection process.
- Documentation supporting the qualification of LTI suppliers who calibrated LTI Standards.
- Adequacy of Fabrication Process Travelers.

(See Continuation Page)

8. Persons (and their organizations) Contacted Arnold Horoff, QA Manager, LTI Doug Holloway, Supervisor, LTI Rob Schmidt, Machine Technician, LTI Andrew Glordano, Machine Operator, LTI	9. CAQ/NCR/TE Issued <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Recommendation Issued <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	CAQ/NCR/TE Number(s): N/A CIRS Number(s): N/A
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10. Surveillance Conclusions ☒ SAT ☐ UNSAT

Overall, this surveillance found effective implementation of the BSC PO 24540-160-PO-01195, LTI Procedure PN RI-1, and LTI Procedure PN QC-111-MC. Since the cutting of specimens had just started, it is recommended that another surveillance be performed prior to shipment of the specimens to LLNL.

11. Completed By (Originator) (Print Name) Richard L. Maudlin	Signature 	Date 05/21/02
12. Reviewed By (Appropriate QA Manager) (Print Name) Daniel A. Klimas	Signature 	Date 5/21/02
13. Approved By (QVM) (Print Name) Robert F. Hartstern	Signature 	Date 5/21/02

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OFFICE OF CIVILIAN RADIOACTIVE WASTE MANAGEMENT
QUALITY ASSURANCE SURVEILLANCE REPORT

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QA Surveillance Number:
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Complete only applicable items.

1. Organization/Location
Laboratory Testing, Inc. (LTI) /
Hatfield, PA

2. Subject
Receipt and Fabrication of Metal Specimens

3. Date(s) Performed
04/23-24/2002

BLOCK 7 Continued:

- Milling process of plates.
- Training and qualification of Inspection Personnel.

As of the date of this surveillance, LTI had completed receipt inspection of the customer supplied material, had cut each of the two plates, D1 and D4, in half and was just starting to cut the individual specimens from Plate marked D4B.2. The four plates, from which specimens will be cut, are identified as Plates D1A.1, D1A.2, D4B.1 and D4B.2. During the surveillance, approximately six specimens had been cut from Plate D4B.2. Traceability of the cut specimens was controlled by placing each cut specimen in a cardboard box marked with the Plate number D4B.2 and the LTI Work Order Number 06137. The evaluation of receipt inspection by LTI, specimen traceability, and the fabrication process was accomplished by observation of the cutting process and review of the following supporting documentation.

- Documentation for release to continue past Hold Point No. 1, dated 03/16/2002.
- Documentation for release to continue past Hold Point Nos. 2-5, dated 04/18/2002.
- List of Measuring and Test Equipment to be used for the inspection of metal specimens.
- Receiving Inspection Checklist and Plate Characteristics form dated 03/11/2002.
- LTI In-Process Fabrication Plan Review - In Process Specimen Traceability Documentation - Remnants Sub-Part Traceability Control Plan Review.
- LTI Machine Shop Technique and Inspection Record for Work Order BSC005-02-03-06137.
- Calibration documentation for the calibration of Mitutoyo Micrometer, Serial No. MI-25; Genx Comparator with Quarda-ChekII Digital, Serial No. 816240, and Surtronic 3P Stylist Type Profilometer, Serial No. 1400893; Profilometer Standard, Serial No. B1126.
- Supplier qualification documentation for GNH Services and AA Janson, Inc.
- LTI Approved Vendors List dated 03/22/2002.
- LTI documentation supporting the qualification of inspection personnel.
- In process verification of plate ID of first plate being cut (Plate ID D4B.2).
- Verification of plate ID for plates awaiting to be fabricated (Plate IDs D1A.1, D1A.2, and D4B.1).
- Verification of the markings on the container used to maintain traceability of cut specimens.