

U.S. DEPARTMENT OF ENERGY  
OFFICE OF CIVILIAN RADIOACTIVE WASTE MANAGEMENT  
OFFICE OF QUALITY ASSURANCE

SUPPLIER AUDIT REPORT

OF

FRAMATOME COGEMA FUELS

LYNCHBURG, VIRGINIA

REPORT NUMBER OQA-SA-96-020  
JULY 25-26, 1996

Prepared by:  Date: 08/07/96

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Approved by:  Date: 8/18/96

Donald G. Horton  
Director  
Office of Quality Assurance

## **1.0 EXECUTIVE SUMMARY**

The results of the supplier audit of Framatome Cogema Fuels revealed unsatisfactory conditions resulting in the issuance of one Deficiency Report to the Civilian Radioactive Waste Management System Management and Operating Contractor (CRWMS M&O) for action which relates to the Quality Assurance (QA) program for the Office of Civilian Radioactive Waste Management (OCRWM) activities. The deficiency report relates to supplier selection, purchase orders issued to unqualified suppliers, calibration certification documentation, and calibration documentation not being stored in duplicate storage.

The unsatisfactory conditions identified during the audit were discussed with the QA Audits and Programs Manager of Framatome Cogema Fuels who agreed to work with the CRWMS M&O in resolving the unsatisfactory conditions.

The results of the audit do not warrant any recommendation for limitations or other conditions that should be invoked relative to the items or services being provided; however, responsibility for final determination of acceptability rests with the CRWMS M&O.

## **2.0 SCOPE**

The supplier audit was conducted to evaluate the adequacy, implementation, and effectiveness of Framatome Cogema Fuels' quality program. This was accomplished by determining if the Framatome Cogema Fuels' program satisfies the QA requirements specified in the CRWMS M&O contract document DE-AC01-91RW00134, implementation of the Framatome Cogema Fuels' QA Manual, Revision 3, as accepted by the CRWMS M&O, and the OCRWM Quality Assurance and Requirements Description (QARD) for the scope of work. The QA program elements determined to be applicable are: Organization; QA Program; Design Control; Procurement Document Control; Implementing Documents; Document Control; Control of Purchased Items and Services; Test Control; Measuring and Test Equipment; Nonconformance Control; Corrective Action; QA Records; and Audits.

## **3.0 AUDIT TEAM AND OBSERVERS**

Richard L. Maudlin, Audit Team Leader, Office of Quality Assurance (OQA), Yucca Mountain Quality Assurance Division (YMQAD)  
Patrick V. Auer, Audit Team Member, OQA, YMQAD

#### 4.0 PERSONNEL CONTACTED DURING FACILITY AUDIT

C. Armontrout, Audits, Programs Manager, Framatome Cogema Fuels  
J. Cogar, Engineering Development Manager, Framatome Cogema Fuels  
C. Conrad, Supervisor, Manufacturing Engineering, Framatome Cogema Fuels  
J. Dorman, Principle Engineer, Framatome Cogema Fuels  
M. Elliot, Foreman, Product Quality, Framatome Cogema Fuels  
J. Ford, Gage Control Technician, Framatome Cogema Fuels  
R. Foster, QA Lead Auditor, Framatome Cogema Fuels  
C. Gooden, QA Secretary, Framatome Cogema Fuels  
B. Mann, , Foreman, Product Quality, Framatome Cogema Fuels  
S. Romine, Internal Auditor, Framatome Cogema Fuels  
G. Vames, High Level Waste Programs Manager, Framatome Cogema Fuels

#### 5.0 SUMMARY OF AUDIT RESULTS

Framatome Cogema Fuels' QA Manual, Revision 3, addresses the requirements of the CRWMS M&O contract document DE-AC01-91RW00134 and the applicable elements of the OCRWM QARD for the intended scope of work. Implementation of the Framatome Cogema Fuels' QA Manual was considered effective with the exception of those unsatisfactory conditions described in Section 6.0 of this report, "Deficiencies/Recommendations."

The details of the audit, along with the objective evidence reviewed, are contained within the audit checklist which is available from the OQA's supplier evaluation files.

#### 6.0 DEFICIENCIES/RECOMMENDATIONS

The unsatisfactory conditions have been documented on the respective corrective action document and submitted to the CRWMS M&O for resolution.

##### DEFICIENCIES (DR)

DR No. YMQAD-96-D-079 - QARD, Section 7.0, Subsection 7.2.2 (A), states: "Supplier selection shall be based on an evaluation, performed before the contract is awarded, of the supplier's capability to provide items or services in accordance with procurement document requirements." Subsection 7.2.3 (D) states: "Supplier QA programs shall be evaluated either before or after contract placement ...." Framatome Cogema Fuels procedure QCR-64, Revision 3, requires that calibration documentation include such information as: (1) A statement of accuracy; (2) The last and the next

calibration due date; and (3) Reference to the specific standard used to perform the calibrations. OCRWM QARD, Section 17.0, Subsection 17.2.11 (A), states: "QA records shall be temporarily stored in a container or facility with a fire rating of 1 hour, or dual storage shall be provided."

Contrary to the above:

Purchase Order 36550 was issued to the Commonwealth of Virginia for the calibration of Framatome Cogema Fuels' standards which, in turn, were used to calibrate instruments that were used to perform quality-affecting activities for the CRWMS M&O; however, there was no objective evidence that the Commonwealth of Virginia had been evaluated in accordance with Section 7.0 of the QARD and the Framatome Cogema Fuels' QA Manual for approving suppliers.

Calibration certification documentation did not include the required information as follows:

Calibration certification from Gage Laboratory Corporation, No. R301451, did not include a statement of accuracy of the standards used to perform the calibrations.

Calibration certification from Satec for calibration of FCF 044-1135 (QC-519), performed on June 20, 1996, did not include the next calibration due date of the supplier's standard and a statement of accuracy of the standards used in performing the calibration.

Calibration certification from the Commonwealth of Virginia, dated February 6, 1996, Test No. VA-96-6270, did not include a reference to the specific standard used, the last and next calibration due date of the supplier's standard used, and a statement of accuracy of the standards used in performing the calibration.

Calibration records of instruments used to perform work for the CRWMS M&O were not being maintained in a one hour fire rated facility or dual storage.