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# CENTER FOR NUCLEAR WASTE REGULATORY ANALYSES QUALITY ASSURANCE SURVEILLANCE REPORT

PROJECT NO.: 20.01402 ~~20.171~~ <sup>9/18/03</sup>

REPORT NO.: 2002-22

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**SURVEILLANCE SCOPE:** Surveillance activities performed during the welding of C-22 material for the Procedure Qualification Record (C22-GTAW-1) utilizing Welding Procedure Specification (WPS)-C22-GTAW

**REFERENCE DOCUMENTS:** Welding Procedure Specification WPS-C22-GTAW ; QAP-004, Surveillance Control

**STARTING DATE:** August 27, 2002

**ENDING DATE:** August 27, 2002

**QA REPRESENTATIVE:** Mark R. Ehnstrom and Bruce Mabrito

**PERSONS CONDUCTING TEST/EXAM/ACTIVITY:** Francis Caroline and Francisco Garcia

**SATISFACTORY FINDINGS:**

Surveillance activities were performed during the welding of the C-22 material for the Procedure Qualification Record in accordance with the Welding Procedure Specification. The WPS had been written by Francis Caroline, a Southwest Research Institute (SwRI) welding consultant. Surveillance found that the welding was being performed in accordance with the WPS. Quality affecting requirements such as shielding gas, current, voltage, and travel speed were being followed. To record temperature during the welding process a Reliant Program Temperature Controller & Chart Recorder (Serial Number 37/C0018/113) was used. This instrumentation was calibrated by the SwRI Calibration Laboratory on May 30, 2002 and has a one year calibration cycle. Pre-heat of the material was performed by an open flame torch and the temperature was measured and recorded by the Reliant Program and Chart Recorder. This instrument also recorded the temperature prior to each individual welding pass to document that base material temperatures had dropped to an acceptable temperature prior to the beginning of the next welding pass. Measures were implemented prior to the beginning of welding to limit the amount of deformation resulting from the heat generated during the welding process. Francisco Garcia was the welder of record. Both F. Caroline and F. Garcia had been through the Conflict Of Interest evaluation and had received Indoctrination and Training to the CNWRA Quality Program.

**UNSATISFACTORY FINDINGS:** None

**NONCONFORMANCE REPORT NO.:** N/A

**Corrective Action Request No.:** N/A

**ATTACHMENTS:** None

**RECOMMENDATIONS/ACTIONS:** Surveillance activities will again be performed during the welding of the C-22 samples which will be used during research activities at the CNWRA.

**APPROVED:** *Bruce Mabrito*  
CENTER DIRECTOR OF QUALITY ASSURANCE

**DATE:** 9/18/2002

**DISTRIBUTION:**  
ORIGINAL - CENTER QA DIRECTORS, QA Records  
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PRINCIPAL ENGINEER: D. Dunn  
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F. Caroline / Div. 18