

UNITED STATES
NUCLEAR REGULATORY COMMISSIO
REGION II
230 PEACHTREE STREET, N. W. SUITE 818
ATLANTA, GEORGIA 30303

REACTOR FACILITIES BRANCH

FILE COPY

In Reply Refer To:

IE:II:VLB
50-390/75-8
50-391/75-8

OCT 17 1975

Tennessee Valley Authority
ATTN: Mr. J. E. Watson
Manager of Power
818 Power Building
Chattanooga, Tennessee 37401

Gentlemen:

This refers to the inspection conducted by Mr. V. L. Brownlee of this office on September 10-12 and 16-18, 1975, of activities authorized by NRC Construction Permit Nos. CPPR-91 and CPPR-92 for the Watts Bar Nuclear Plant, Units 1 and 2 facilities, and to the discussion of our findings held with Messrs. J. R. Rountree and J. C. Killian at the conclusion of the inspection.

Areas examined during the inspection and our findings are discussed in the enclosed inspection report. Within these areas, the inspection consisted of selective examination of procedures and representative records, interviews with personnel, and observations by the inspector.

We have examined actions you have taken with regard to previously reported unresolved items. These are identified in Section IV of the summary of the enclosed report.

Three new unresolved items resulted from this inspection and are identified in Section III of the summary of the enclosed report. These items will be examined during subsequent inspections.

During the inspection, it was found that certain activities under your license appear to be in noncompliance with NRC requirements. These items and references to pertinent requirements are listed in Section I of the summary of the enclosed report.

This notice is sent to you pursuant to the provisions of Section 2.201 of the NRC's "Rules of Practice," Part 2, Title 10, Code of Federal Regulations. Section 2.201 requires you to submit to this office, within 20 days of your receipt of this notice, a written statement



A handwritten signature in cursive script, appearing to be "J. E. Watson".

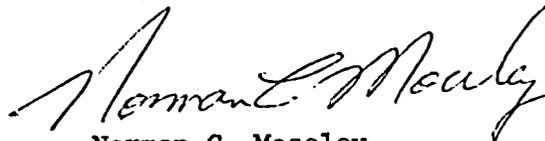
OCT 17 1975

or explanation in reply including: (1) corrective steps which have been taken by you, and the results achieved; (2) corrective steps which will be taken to avoid further noncompliance; and (3) the date when full compliance will be achieved.

In accordance with Section 2.790 of the NRC's "Rules of Practice," Part 2, Title 10, Code of Federal Regulations, a copy of this letter and the enclosed inspection report will be placed in the NRC's Public Document Room. If this report contains any information that you believe to be proprietary, it is necessary that you submit a written application to this office requesting that such information be withheld from public disclosure. If no proprietary information is identified, a written statement to that effect should be submitted. If an application is submitted, it must fully identify the bases for which information is claimed to be proprietary. The application should be prepared so that information sought to be withheld is incorporated in a separate paper and referenced in the application since the application will be placed in the Public Document Room. Your application, or written statement, should be submitted to us within 20 days. If we are not contacted as specified, the enclosed report and this letter may then be placed in the Public Document Room.

Should you have any questions concerning this letter, we will be glad to discuss them with you.

Very truly yours,



Norman C. Moseley
Director

Enclosure:

IE Inspection Report Nos.
50-390/75-8 and 50-391/75-8

cc w/encl: Mr. J. E. Gilleland
Assistant Manager of
Power

UNITED STATES
NUCLEAR REGULATORY COMMISSION
REGION II
230 PEACHTREE STREET, N. W. SUITE 818
ATLANTA, GEORGIA 30303

IE Inspection Report Nos. 50-390/75-8 and 50-391/75-8

Licensee: Tennessee Valley Authority
818 Power Building
Chattanooga, Tennessee 27401

Facility Name: Watts Bar Nuclear Plant, Units 1 and 2
Docket Nos.: 50-390 and 50-391
License Nos.: CPPR-91 and CPPR-92
Category: A2/A2

Location: Spring City, Tennessee

Type of License: W PWR, 1160 Mwe

Type of Inspection: Announced, Construction

Dates of Inspection: September 10-12 and 16-18, 1975

Dates of Previous Inspection: July 29-31, 1975

Principal Inspector: V. L. Brownlee, Reactor Inspector
Facilities Section
Facilities Construction Branch

Accompanying Inspectors: E. J. Vallish, Reactor Inspector
Facilities Section
Facilities Construction Branch
(September 10-12, 1975)

J. J. Blake, Metallurgical Engineer
Engineering Section
Facilities Construction Branch
(September 10-12 and 16-18, 1975)

A. R. Herdt, Metallurgical Engineer
Engineering Section
Facilities Construction Branch
(September 10-12 and 16-18, 1975)

Other Accompanying Personnel: J. C. Bryant, Senior Inspector
Facilities Section
Facilities Construction Branch
(September 17-18, 1975)



Principal Inspector: V. L. Brownlee
V. L. Brownlee, Reactor Inspector
Facilities Section
Facilities Construction Branch

10/16/75
Date

Reviewed by: J. C. Bryant
J. C. Bryant, Senior Inspector
Facilities Section
Facilities Construction Branch

10/16/75
Date

SUMMARY OF FINDINGS

I. Enforcement Items

Certain items appear to be in noncompliance with 10 CFR 50, Appendix B, "Quality Assurance Requirements for Nuclear Power Plants and Fuel Processing Plants," as indicated below:

A. Infraction

75-8-A1 (II) Vendor QA Audits (Units 1 and 2)

Criterion V of Appendix B to 10 CFR 50 and PSAR, Appendix A, Section A.2.5 specify that activities affecting quality are accomplished in accordance with instructions contained in applicable procedures. Procedure DED-QAP 3.2, "Vendor QA Audit Program," requires that vendor audits are to be performed during regularly scheduled intervals in accordance with the criteria stated in paragraph 4.1.

Contrary to the above, TVA had not performed any vendor audits of Bristol Steel and Iron Works, Incorporated at the regularly scheduled intervals after the award of contract. (Details II, paragraph 4.b)

This infraction had the potential for causing or contributing to an occurrence related to safety.

B. Deficiencies

75-8-A2 (III) Welding Material Control Procedure (Units 1 and 2)

Criterion V of Appendix B to 10 CFR 50 and PSAR, Appendix A, Section A.2.5 specify that activities affecting quality are prescribed by documented instructions in the form of drawings, specifications and procedures.

Contrary to the above, the site Procedure WBNP-QCP-4.1, "Procurement, Storage, Issue and Control of Welding Materials," does not contain all of the necessary instructions for the storage and reconditioning of welding materials. (Details II, paragraph 6)

II. Licensee Action on Previously Identified Enforcement Matters

None

III. New Unresolved Items

75-8/1 Charpy Impact Test Specimens (Units 1 and 2)

The licensee agreed to review the method of measuring Charpy Impact Test Specimens presently being used to assure traceable calibration. (Details II, paragraph 3)

74-8/2 Retention of Site Generated Records (Units 1 and 2)

The licensee agreed to review the contracts and/or agreements with contractors to assure that all records generated at the site would be retained at the site rather than at the contractors offices until completion of the contract. (Details II, paragraph 7)

75-8/3 Concrete - Residual Heat Removal Support Plate Embeds (Unit 1)

Concrete surrounding the RHR support plate embeds, MK 41, had considerable honeycombing. This matter is being documented, and the repair and inspection procedures developed. (Details I, paragraph 7)

IV. Status of Previously Reported Unresolved Items

75-3/1 Regulatory Operations Bulletin and Licensee Response (Units 1 and 2)

ROB 74-9 - "Deficiency in General Electric Model 4KV Magne-Blast Circuit Breakers." This item remains open.

75-5/1 Valve Wall Thickness Verification Program (Units 1 and 2)

TVA (DED) will submit a valve wall thickness program that meets Region II letters of June 30, 1972, and February 16, 1973. This item remains open.

75-6/1 IE Bulletin No. 75-06, "Westinghouse Type OT-2 Control Switches" (Units 1 and 2)

TVA is implementing corrective actions and plans within the normal field construction program to assure repair, inspection and testing of all subject type switches. This matter is closed. (Details I, paragraph 6)

75-7/1 Electrical Separations Criteria (Units 1 and 2)

The licensee has omitted the electrical separations criteria applicable to the auxiliary instrument room in Procedure WBNP-QCP-3.4. This item remains open.

75-7/2 Concrete - Crane Wall (Unit 1)

Crane wall pour Nos. C4b and C3a exhibited evidence of voiding and possible honeycombing. This item remains open.

V. Design Changes

None

VI. Unusual Occurrences

None

VII. Other Significant Findings

None

VIII. Management Interview

The inspectors met with TVA representatives at Knoxville on September 12, and at Watts Bar site on September 18, 1975, to report the inspection findings. The items of noncompliance and Unresolved Items (Section I and III above) were discussed in detail.

DETAILS I

Prepared by: V. L. Brownlee 10/1/75
V. L. Brownlee, Reactor Inspector Date
Facilities Section
Facilities Construction Branch
E. J. Vallish 10-6-75
E. J. Vallish, Reactor Inspector Date
Facilities Section
Facilities Construction Branch

Dates of Inspection: September 10-12 and 16-18, 1975

Reviewed by: J. C. Bryant 10/6/75
J. C. Bryant, Senior Inspector Date
Facilities Section
Facilities Construction Branch

All information in Details I applies equally to Units 1 and 2 except where identified with a specific reactor.

1. Individuals Contacted

a. Tennessee Valley Authority (TVA)

(1) Knoxville (September 10-12, 1975)

J. R. Rountree - Assistant to Manager, OEDC
J. P. Knight - QA Manager, OEDC
D. R. Patterson - Chief, Mechanical Engineering Branch
W. D. DeFord - Supervisor, QA Engineering Section
J. B. Gore - Assistant to Chief QA Staff, DEC
S. Duhan - Supervisor, Quality Audits, QA Staff, OEDC
L. G. Hebert - Quality Audits, QA Staff OEDC
D. B. Weaver - Assistant Director, DED
J. A. Crittendon - Staff Engineer, QA and Procedures
Control, DED
R. G. Domer - Chief, Civil Engineering Branch, DED
R. W. Dibeler - Chief, QA Staff, DEC
R. E. Whitt - Supervisor, Quality Improvement,
QA Staff, OEDC

R. O. Lane - Head, Materials Engineering Section,
Singleton Laboratory
P. Guthrie - Metallurgist, Singleton Materials Laboratory
L. K. Smith - Supervisor QA Audit Section, QA Staff, DED
T. V. Abbatiello - QA Engineering Section, QA Staff, DED
L. W. Blevins - QA Engineering Section, QA Staff, DED
D. B. Bowen - Assistant Design Project Manager
(Sequoyah and Watts Bar), DED
R. M. Jessee - Engineer, Mechanical Engineering Branch, DED
J. S. Cooley - QA Engineering Section, QA Staff, DED
L. H. Clark - QA Audit Section
J. W. Mabee - QA Audit Section
K. B. Akers - Mechanical Engineer, Projects
J. C. Key - Supervisor Mechanical Engineering, Projects

(2) Site (September 16-18, 1975)

J. C. Killian - Project Manager
T. B. Northern, Jr. - Construction Engineer
L. C. Northard - Supervisor, Site QA Unit, DEC Staff
J. M. Lamb - Supervisor, Mechanical Engineering Unit
H. S. Shepperd - Supervisor, Civil Engineering Unit
R. L. Heatherly - Supervisor, QC and Records Unit
J. C. Cofield - Supervisor, Materials Engineering Unit
J. H. Perdue - Supervisor, Electrical Engineering Unit
J. A. Williams - Electrical Engineer
L. T. McCord - Electrical Engineer

2. Scope

The purpose of this inspection was to examine TVA's nuclear plant QA program as it relates to control of special processes and inspection during design, procurement, fabrication and erection of structures, supports and piping systems. The inspection was performed in two parts: (1) TVA QA, Engineering Design, and Inspection Offices, Knoxville Tennessee, September 10-12, 1975; (2) Watts Bar Nuclear Plant Site, Watts Bar, Tennessee, September 16-18, 1975.

3. Knoxville Offices

a. Implementation of QA Program

Inspection was conducted of the QA program, concerning control of special processes and inspection of the containment, penetrations, other safety related structures and supports and piping systems as it is executed through design, procurement

and fabrication. DED Engineering Procedures and TVA Specifications G-29C and G-29M were reviewed; then a walk-through of the typical design activities and QA interfacing was conducted. Development of the design of a welded component was followed through, including vendor selection, audit, contract performance inspection and reporting. The functions of the Procurement Department and interfacing with DED engineers, Inspection and Test Branch (I&T), QA activities and DEC functions was examined.

The transition was followed of a functional QA requirement being made into a QA procedure, followed by a QC procedure, followed by execution in the field.

The internal and external audit functions were examined. Audit schedules and audit procedures were reviewed.

Review was made of purchase order file, "N4S-4, Requisition 86283-Structural Steel Reactor Coolant System Supports, Restraints, Anchor Bolts and Embedments - Folder No. 1 - Bellefonte Nuclear Plant - August 1974 to Present." Additionally, the DED QA Section Audit Files for the DRAGO, CB&I and Bristol Contracts for Watts Bar facility and the NAVCO Contract for the Bellefonte facility were reviewed.

Results of the inspection indicated that the QA program as it relates to control of special processes and inspection, during design, procurement and fabrication as it is being implemented; conforms to the application with regard to organizational-functional relationship, organizational duties and responsibilities, adequacy of requirements for procedural controls, records and audit activities.

b. DED Quality Assurance Audit Section

The scope of the Audit Section's functional duties and responsibilities will increase to include the following QA functions starting December 1, 1975:

- (1) Review and approval of all "Q" purchase requisitions.
- (2) Review and approval of all purchase orders prior to award of contract.
- (3) Review and approval of all contractors' QA programs.
- (4) Review and approval of TVA's Inspection and Test Branch inspection procedures and plans.

This restructuring of QA functional responsibilities would appear to be a strengthening factor for the overall TVA QA program during the design and procurement phase.

4. Singleton Materials Laboratory (SML)

A visit to the Singleton Materials Laboratory was made for orientation and familiarization. All laboratory functions were moved into the new laboratory building about a month ago. Concrete program related activities are underway. A corrosion control program has started and the metals program for research and development will start shortly.

Training and certification of TVA concrete inspectors is accomplished at the SML.

5. Watts Bar Site

a. Implementation of Site QA Program

Discussions with site engineers, review of organizational/functional charts, and review of QA manuals and related procedures confirm that TVA conforms to the application with regard to organizational/functional relationship, organizational duties and responsibilities, adequacy of requirements for procedural controls, records and audit activities. This area has been previously reported in IE Reports 50-390, 391/75-7, Details I, paragraph 3.

6. Previously Reported Unresolved Item - 75-3/1 IE Bulletin No. 75-06, "Westinghouse Type OT-2 Control Switches"

Discussions with site electrical engineers and review of site procedures confirm the following:

Arrangements have been made with Westinghouse to rework all OT-2 control switches. The TVA instrument tabulation list is being modified to call out a hold test point for all OT-2 switches. TVA field engineers are presently developing a test procedure and test apparatus.

IE:II has no further questions.

7. New Unresolved Item - Residual Heat Removal Support Plates (Unit 1)

The concrete surrounding two residual heat removal support embed plates identified as MK41 located in the polar crane wall at 357°14"

and - 5°32" at elevation 717' 11½" had considerable honeycombing. The honeycomb area has been chipped out to sound concrete. The method of repair had not been determined at time of this inspection. The matter was being documented in accordance with site procedures. IE:II will examine the repair procedure, repaired area, and the inspection and test results during a subsequent inspection.

Details II

Prepared by: A. R. Herdt 10/16/75
A. R. Herdt, Metallurgical Engineer Date
Engineering Section
Facilities Construction Branch

for J. J. Blake 10/16/75
J. J. Blake, Metallurgical Engineer Date
Engineering Section
Facilities Construction Branch

Dates of Inspection: September 10-12 and 16-18, 1975

Reviewed by: S. D. Beratan 10/16/75
for L. L. Beratan, Senior Inspector Date
Engineering Section
Facilities Construction Branch

All information in Details II applies equally to Units 1 and 2 except where information is identified with a specific reactor.

1. Persons Contacted

Tennessee Valley Authority

(1) Knoxville

- J. R. Rountree - Assistant to Manager, OEDC
- J. P. Knight - QA Manager, OEDC
- D. R. Patterson - Chief, Mechanical Engineering Branch
- W. D. DeFord - Supervisor, QA Engineering Section
- S. Duhan - Supervisor, Quality Audits, QA Staff, OEDC
- L. G. Hebert - Quality Audits, QA Staff OEDC
- D. B. Weaver - Assistant Director, DED
- J. A. Crittendon - Staff Engineer, QA and Procedures Control, DED
- R. G. Domer - Chief, Civil Engineering Branch, DED
- R. W. Dibeler - Chief, QA Staff, DEC
- R. E. Whitt - Supervisor, Quality Improvement, QA Staff, OEDC
- R. O. Lane - Head, Materials Engineering Section, Singleton Laboratory
- P. Guthrie - Metallurgist, Singleton Materials Laboratory
- C. Mycoff - Senior Mechanical Engineer, Mechanical Engineering Branch, DED

T. V. Abbatiello - QA Engineering Section, QA Staff, DED
T. Roberts - Senior Civil Engineer, Civil Engineering Branch, DED
R. M. Jessee - Engineer, Mechanical Engineering Branch, DED
J. S. Colley - QA Engineering Section, QA Staff, DED

(2) Watts Bar

J. C. Killian - Project Manager
T. B. Northern, Jr. - Construction Engineer
L. C. Northard - Site QA Supervisor
J. Morgan - Welding and NDE Supervisor

2. Scope

The scope of this inspection was to examine TVA's nuclear plant quality assurance as it relates to control of special processes, specifically welding and nondestructive examination, during design, procurement, fabrication and erection of structures, supports and piping systems. The purpose was to determine whether adequate QA/QC measures are established and adequately translated to assure that the control of activities and product conform to the applicable codes, standards and SAR commitments. TVA Engineering Design, Inspection and Testing, Materials Laboratory as well as field procedures, contractual details and interface activities relative to structures, supports and safety related piping systems were examined.

This inspection consisted of two parts: September 10-12, 1975, at TVA's offices in Knoxville; and the second part at the Watts Bar site on September 16-18, 1975.

3. Singleton Materials Laboratory

A visit to the Singleton Materials Laboratory was made for familiarization and for examination of the facilities used for welding procedure qualification testing. The laboratory had moved into its new building a month ago.

The inspectors reviewed the Metal Testing Manual dated June 1973, which describes the welding/material activities. The inspectors examined the material facilities specifically the metallographic, tensile testing and Charpy impact testing equipment.

The inspectors noted that the Charpy impact testing equipment was not in use since it still needed to be calibrated. The inspectors examined the Charpy impact test specimens and inquired as to the measuring techniques being used since the dimensions of these specimens are most critical. The licensee was presently determining the dimensions from the cutting wheel and an optical measuring device. The inspectors

questioned the accuracy of this device. The licensee agreed with the inspectors that the method should be re-evaluated to assure accurate and traceable calibrations. The inspectors informed the licensee that this item will be considered unresolved and examined during subsequent inspections.

4. Implementation of the QA Program

Inspection was conducted of the QA Program concerning welding of the containment, structures, supports and safety related piping as it is followed through design, procurement and fabrication.

a. Procedures and Specifications

TVA General Construction Specifications G-29M is used for ASME Code Fabrication, and G-29C is used for AWS Code fabrication were reviewed. These specifications include the welding procedures, welding procedure qualification records as well as the welder and welding operator performance qualifications. Also included in these specifications are: general welding instructions including welding materials, joint design, base metal preparation; nondestructive examination procedures; and weld rod control procedure. Discussions with TVA personnel indicated that all the welding procedures required in these areas have not yet been qualified, specifically in the heavy wall carbon steel pipe area which require Charpy impact testing.

The inspector reviewed the following associated procedures:

DEC-QAP-1.0	Auditing Construction Activities
DEC-QAP-2.01	Classification of NDE Personnel
DEC-QAP-2.02	Qualification, Training and Certification Requirements for Liquid Penetrant NDE Personnel
DEC-QAP-2.03	Qualification, Training and Certification Requirements for MT NDE Personnel
DEC-QAP-2.04	Qualification, Training and Certification Requirements for RT NDE Personnel
DEC-QAP-2.05	Qualification, Training and Certification Requirements for UT NDE Personnel

DEC-QAP-2.07	Qualification of Inspection Examination and Testing Personnel
DED-EP-3.13	Preparation, Review and Approval of Process Specifications and Assignment of Welding and NDE Procedures
DED-EP-5.01	DED Purchase Requisitions, Preparation, Reviews, Signatures and Memos to Purchasing
DED-QAP-3.2	Vendor QA Audit Program

Within the areas examined, no items of noncompliance were identified.

b. Procurement of Primary Structures and Piping

The inspectors reviewed the procurement documents including the contract, the specification requirements, QA manual and associated correspondence. The vendors with the item being supplied are listed below:

(1) Watts Bar

<u>Item</u>	<u>Vendor</u>
Containment, Penetrations (Pipe)	Chicago Bridge & Iron Co.
Component Supports	Bristol Steel & Iron Works, Inc.
Piping	DRAVO

(2) Bellefonte

Containment	Bristol Steel & Iron Works, Inc.
Component Supports	Lakeside Steel

In reviewing these contracts, the inspectors noted that for the Bristol Steel & Iron Works, Inc (BSW) contract for structural steel reactor coolant system supports, anchor Bolts and Embedments for Units 1 and 2 Watts Bar, a pre-award survey was performed in May 1974. This survey was also used as the basis for award of the contract for the structural steel liners and major equipment anchorages for the Units 1 and 2 Bellefonte Nuclear Plant. The contract for the Watts Bar work was awarded in June 1974. The fabrication was to be in accordance with ASME and AWS Codes where applicable and TVA was to approve all

welding procedures and nondestructive examination procedures and drawings, etc., to be used both by BSW and any of its subcontractors.

The Quality Assurance Manual was approved by TVA in January 1975. A review of the documentation packages revealed that problems had occurred in the QA area specifically with regard to documentation nonconformance reports, QA records, welding procedures and welding procedure qualification records.

The inspector requested a copy of the vendor audits performed on BSW in accordance with the requirements of DED-QAP-3.2, "Vendor QA Audit Program," specifically paragraph 4.1. This paragraph states in part that, "audits of a vendor shall be scheduled in accordance with the following criteria: (b) Early enough after award to assess the implementation of the vendor's QA program during his design and procurement phase where applicable; (c) at an appropriate time to assess the implementation of the vendor's QA program during his fabrication phase."

The inspector observed that TVA has performed no vendor QA audits in accordance with DED-QAP-3.2 except for the pre-award survey. Another example of this noncompliance concerns the BSW contract for the structural steel liner and major equipment anchorages in the prestressed containment vessels for the reactor buildings of Units 1 and 2 of the Bellefonte Nuclear Plant. The licensee has scheduled an audit at the request of its Inspection and Test Branch (I&T) because of recurring problems in the implementation of the QA Program, as witnessed by the I&T inspectors assigned to monitor the work at BSW. This audit is scheduled for the week of September 15, 1975. IE:II will review the results of this audit.

The inspector informed the licensee that failure to follow this procedure was contrary to Criterion V of Appendix B, 10 CFR 50 and the commitment in the PSAR, Appendix A, Section A.2.5.

5. Site QA/QC Program

During this phase of the inspection, the inspectors reviewed the licensee's activities in the area of implementation of required special process controls through the preparation and use of Site Quality Assurance and Quality Control Manuals and Procedures.

a. QA Program

The licensee is presently using the OEDC QA Manual in ASME Section III, Nuclear Power Plant Components (NCM), which defines the requirements necessary to assure compliance with the Code in control of the manufacturing and installation processes. Included in this manual are the general requirements for implementing an integrated Manufacturing and Installation Quality Plan (MIQP) to provide for optimum manufacture, installation and quality control of all systems within the jurisdiction of the ASME Code Section III. The license had issued Construction Specification No. N3M-868, "Field Fabrication, Assembly, Examination and Tests In Piping Systems for Watts Bar Nuclear Plant," which sets forth the methods and requirements to be followed by TVA in field fabrication, assembly, installation, examination, and testing of piping systems. Installation of Class 1, 2 and 3 piping systems shall be in accordance with the ASME Code Section III, 1971 through Summer 1973 Addenda. Installation of those non-nuclear systems shall be in accordance with the 1973 edition through Summer 1973 addenda of ANSI B31.1, Power Piping.

The inspector reviewed appropriate sections of OEDC QA Manual and the Construction Specification. Within these areas inspected, no items of noncompliance were identified.

b. QC Program

The licensee is currently involved in the preparation of a complete QC Manual for application at this site. This includes re-issue of TVA's Division of Engineering Construction (DEC) Quality Control Procedures (QCP's) as Watts Bar Nuclear Plant (WBNP) QCP's where applicable, and generation of new procedures for operations unique to Watts Bar at this time. Procedures selected for review included the following:

WBNP-QCP 4.1	Procurement, Storage, Issue and Control of Welding Materials.
WBNP-QCP 4.2	Welder and Welding Operator Performance Qualification.
WBNP-QCP 4.6	Surveillance of Field Erection of Containment Vessels and Contractor's Quality Assurance Program.
WBNP-QCP 4.8	Inspection and Documentation of Seismically Qualified Supports.

WBNP-QCP 4.3	Welding Surveillance and Weld Procedure Assignment
WBNP-QCP 1.2	Control and Calibration of Construction Tools, Gages, Instruments and Measuring Devices
WBNP-QCP 1.6	Receipt, Inspection, Storage, Withdrawal and Transfer of Permanent Material

At the time of this inspection, the site personnel had not completed the QCP's required for piping installations in that this is still a long lead item.

There was one item of noncompliance and one unresolved item identified during this inspection. The noncompliance concerned WBNP-QCP 4.1 and is discussed in paragraph 6 of these details.

The unresolved item concerned WBNP-QCP 4.6 and is discussed in paragraph 7 of these details.

6. Welding Material Control

The inspector reviewed the adequacy and implementation of the site Procedure WBNP-QCP 4.1 "Procurement, Storage, Issue and Control of Welding Materials." The review for adequacy turned up two areas where the procedure was incomplete or confusing.

Paragraph 6.2.2.1 states in part that "once a package has been opened, its contents shall be stored according to requirements for that particular type of material as specified below." There are no requirements specified below.

Paragraph 6.2.3.4 states in part that "All returned electrodes--- shall be reconditioned in accordance with the more strenuous requirements of G-29M or G-29C for the particular electrode classification." There were no guidelines as to which requirements were more strenuous.

It was noted during the review of the implementation of this procedure that the rod room attendants had gone back to the G-29 parent document and had extracted the electrode storage requirements that had been omitted from paragraph 6.2.2.1. They were also reconditioning electrodes under what they considered to be the more strenuous requirements referenced by paragraph 6.2.3.4.

The adequacy of this procedure was identified as an item of noncompliance with a severity level of a deficiency. The licensee agreed to revise the procedure to provide the required specific instructions.

7. Retention of Site Generated Records

During the review of WBNP-QCP 4.6, "Surveillance of Field Erection of Containment Vessels and Contractor's Quality Assurance Program," the inspector noted that the procedure made reference to the fact that the contractor's fabrication records were the responsibility of the contractor until the completion of the contract. When the inspector asked what provisions had been made for retention of the records at the site if the contractor were to leave the site for some reason prior to the completion of the contract, the licensee was unsure of whether the records would remain or be transferred to the contractor's home office. During the exit meeting the licensee stated that agreements with the contractor would be reviewed and if no provisions exist for continuous retention of these records at the site additional agreements would be made. This item was identified as an unresolved item.