

<b>WEP</b> Closure Statement ----- Evaluation Report	<u>EMPLOYEE CONCERN GROUP CLOSURE</u>  CRACKED WELDS IN UNIT-1 PIPE WHIP RESTRAINTS IN THE NORTH VALVE ROOM	Page <u>1</u> of <u>3</u>  Date <u>11/21/86</u>  Revision <u>0</u>  WEP Group No <u>001</u>
	WEP GROUP IDENTIFIER <u>EC-SP-1</u>	

Approved \_\_\_\_\_ Date \_\_\_\_\_

Reviewed A.E. Bradford 11/21/86 Prepared [Signature]

Address the following items in the space remaining on this page and on additional pages as needed (see Standard Practice WEP 3.1.10 for specific instructions).

1. Employee Concern(s)/Quality Indicator(s)	5. Findings
2. Characterization of Issue	6. Conclusions
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1. Employee Concern(s)/Quality Indicator(s) (Reference 7.1)  
 Employee Concern IN-86-297-001.

2. Characterization of Issue  
 The concerned individual (CI) initiated an employee concern which states: "In the North Valve Room of Unit 1, on the large pipe whip restraints, approximately 1983, there were several welds that were cracked. CI was laid off before the welds were repaired."  
 Cracked welds are not allowed by any Tennessee Valley Authority (TVA) standard or specification or applicable national standards (Reference 7.2 and 7.3).

3. Summary  
 The CI identified the welds on the appropriate drawings.  
 The documentation package, which reflects all work and inspections performed on the subject welds, was reviewed to ascertain the current status of the welds. Documentation indicates that the welds were repaired and reinspected in November and December, 1983, which was after the CI was laid off. The welds and inspection documentation are now in a fully acceptable condition.

4. Evaluation Methodology  
 The Department of Energy Weld Evaluation Project (DOE/WEP) Assessment Plan 001 (Reference 7.4) requires a review of weld documentation for

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the nine (9) piping restraint welds in question. If the documentation review concluded that the welds were properly reworked, reinspected and found acceptable, this group could be closed.

**5. Findings**

The DOE/WEP requested that Quality Technology Company (QTC) locate the problem welds (Reference 7.5). In response to the request of DOE/WEP, the CI, through QTC, furnished drawings with the welds of concern highlighted. Drawing numbers are 48W1708-13 (Revision 14) and 48W1708-04 (Revision 13). (Reference 7.6)

Upon request from DOE/WEP, the TVA Weld Task Group supplied a documentation package which contained the inspection records for the whip restraints identified by the CI (Reference 7.7). The repair and reinspection was accomplished in November and December 1983.

DOE/WEP requested that QTC determine the termination date of the concerned individual. This date was reported as being March 23, 1983 (Reference 7.8).

The inspection records for the welds identified by the CI were reviewed. The records indicated that the welds were repaired, reinspected and accepted in accordance with procedural and specification requirements (Reference 7.7). The welding was performed to TVA's General Construction Specification G-29C (Reference 7.2).

The concern is site-specific and not generic to any other TVA site.

**6. Conclusions**

Documentation review confirms that the welds in question were reworked, reinspected and accepted subsequent to the CI terminating employment of TVA. The concern was correct in that the welds identified required rework as stated.

Corrective action in repair and acceptance of the welds has been completed and documented following the employee termination at TVA. The CI would not have known that normal work control practices had resulted in correction of the defects.

**7. References**

7.1 Employee Concern as listed in Section 1.

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- 7.2 Tennessee Valley Authority General Construction Specification G-29C, Process Specification 3.M.5.1(e), Paragraph B.1.1.
- 7.3 American National Standards Institute/American Welding Society (ANSI/AWS) Structural Welding Code D1.1, Revision 2, Section 10.17.1.1.
- 7.4 DOE/WEP Assessment Plan 001, Revision 0, March 28, 1986.
- 7.5 Letter K. G. Therp to Scott Schum, Workmanship/Specific Weld Problems, KGT-30-86, dated January 29, 1986.
- 7.6 Drawing 48W1708-13, Revision 14 and 48W1708-4, Revision 13.
- 7.7 TVA weld documentation package contained in DOE/WEP Group 001 package.
- 7.8 QTC Response Sheet, File Number 1059, dated March 12, 1986.