

<b>WEP</b> Closure Statement ----- Evaluation Report	<u>QUALITY INDICATOR GROUP CLOSURE</u> "WINDOW" GROUND INTO FIELD WELD WAS NOT RADIOGRAPHED AFTER REPAIR	Page <u>1</u> of <u>3</u> Date <u>11/24/86</u> Revision <u>0</u> WEP Group No <u>018</u>
	WEP GROUP IDENTIFIER <u>QI-SP-5</u>	

Approved _____ Reviewed <u>A. E. Bradford 11/24/86</u>	Date _____ Prepared <u>H. Richardson</u>
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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).

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1. Employee Concern(s)/Quality Indicator(s) (Reference 7.1)

Tennessee Valley Authority (TVA) Nonconforming Condition Report (NCR) 6575.

2. Characterization of Issue

NCR 6575 identified a weld repair in which a "window" was ground into a weld approximately opposite the repair area. This "window," when subsequently welded, was not inspected to the requirements of the original weld. This is contrary to ASME Section III, NB-0445.4, which requires examination of weld repairs to be repeated as required by the original weld (Reference 7.2). ASME Section III, NC 5222, requires that circumferential butt welded joints be radiographed (Reference 7.3).

NOTE: The practice of using a "window" area appears to occur when the required repair is in a difficult or restricted area.

3. Summary

All Weld Repair Operation Sheets have been reviewed by the Department of Energy/Weld Evaluation Project (DOE/WEP) to determine if a similar condition has occurred, i.e., weld repair with the use of a "window" without subsequent examination to the requirements of the original weld. The review identified only one weld that had a "window" used in the repair process that was not volumetrically examined. This was field weld 1-63B-D087-14-R1 as identified in NCR 6575. This weld has subsequently been radiographed and found acceptable.

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4. Evaluation Methodology

In accordance with Assessment Plan 018 (Reference 7.4), the DOE/WEP identified all large-bore welds with rejected radiography (RT) hold points in which excavation of the root was required to effect the repair. The RTs for these welds were reviewed to assure that all required repair sectors and potential "window" areas had been radiographed. An Examination Package was prepared by DOE/WEP to perform the RTs on any "window" requiring this inspection.

5. Findings

A review was performed by DOE/WEP to determine which welds had rejected RT hold points. The applicable Weld Repair Data Sheets were then reviewed to determine which welds required excavation down to the root. Approximately 3,870 data sheets were reviewed and 634 welds were identified as requiring repair down to the root. Of these, it was further determined that four welds had used "window" areas to view the repair. Review of radiographs for the four welds indicated that one weld, 1-063B-D087-14, had not had the "window" area radiographed (Reference 7.5). All other welds had been cut out, rewelded, and radiographed (Reference 7.6). As a result, an Examination Package was prepared (Reference 7.7) to perform and document the required RT. Tennessee Valley Authority (TVA) performed the RT on May 17, 1986 (Reference 7.7).

6. Conclusions

The TVA closure of NCR 6575, based on the results of RT examination, was determined by DOE/WEP to be acceptable. These results were reviewed and concurred with by DOE/WEP on August 28, 1986. DOE/WEP finds the completion of all actions required by specific Group 018 to be acceptable, and considers this group closed.

7. References

- 7.1 Employee Concern as listed in Section 1.
- 7.2 ASME Boiler and Pressure Vessel Code, Section III, NB-0445, 1971.
- 7.3 ASME Boiler and Pressure Vessel Code, Section III, NC-5222, 1971.
- 7.4 DOE/WEP Assessment Plan 018, Revision 0, March 24, 1986.

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- 7.5 EG&G Idaho Interoffice Correspondence from K. G. Therp to A. E. Bradford, October 6, 1986.
- 7.6 EG&G Idaho memo from M. B. McLean to T. Parcell, April 18, 1986.
- 7.7 DOE/WEP Examination Package 018-0001.