

<b>WEP</b> Closure Statement ----- Evaluation Report	<u>QUALITY INDICATOR GROUP CLOSURE</u>  RECONSTRUCTION OF MISSING WELD MATERIAL REQUISITION CHITS	Page <u>1</u> of <u>3</u>  Date <u>01/21/87</u>  Revision <u>0</u>
	WEP GROUP IDENTIFIER <u>QI-SP-6</u>	WEP Group No <u>019</u>

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

Reviewed A.E. Bradford 1-23-87 Prepared EC King

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) 4390, Revision 0, 1 and 2.

2. Characterization of Issue

NCR 4390 identified a problem in which 16 welds attaching lugs to subassemblies were performed using weld rod issued incorrectly on a "white" weld material requisition rather than the required "green" weld material requisition. This weld rod was for use on ASME Section III piping systems. The NCR stated that the weld material requisitions had been reconstructed but the reconstruction was not done in accordance with TVA procedure WBNP-QCI-1.08 (Reference 7.2). Revision 1 of NCR 4390 was dispositioned to remove the 16 lugs and reinstall using correctly documented materials. Subsequently, Revision 2 of NCR 4390 revised the disposition to require only reconstructing the documentation.

Department of Energy Weld Evaluation Project (DOE/WEP) personnel concluded based on review of all revisions that it was indeterminate whether or not the welds were removed or only the documentation reconstructed. Additionally, it is unclear if the documentation complies with TVA requirements for reconstruction.

The TVA WBNP-QCI-1.08, Revision 4, Quality Assurance Records, Paragraph 6.2.1.1 states "Reconstructs and reissues missing inspection records using supporting information of acceptance (i.e., inspector's log books, signed chit sheets, Xerox copies of data cards, signed off drawings, etc.)."

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The TVA WBNP-QCI-4.01 (Reference 7.3), Rev. 1, Storage, Issue, and Control of Welding Materials, Paragraph 6.3.1.1.1 states, "Uses a prenumbered green welding material requisition to obtain welding materials for ASME Section III piping systems."

### 3. Summary

Results of the review of welding documentation for each of the 16 lugs indicates that both weld quality and documentation are in compliance with TVA requirements.

### 4. Evaluation Methodology

The Department of Energy Weld Evaluation Project (DOE/WEP) reviewed Nonconforming Condition Reports (NCR) 4390, Revision 0, 1 and 2. The results of the corrective action used were indeterminate. Assessment Plan 019 (Reference 7.4) was written to perform a document review of the welding documentation for the lugs identified by NCR 4390. The document review was done to determine if the lugs were removed and reinstalled using the required documentation per the disposition of NCR 4390, Revision 1 or if the lugs were left in place and the required documentation reconstructed per the disposition of NCR 4390, Revision 2. Documentation was obtained for review as required per Assessment Plan 019, Assessment Method Section, with the exception of Item 3. In addition, Inspector's Daily Log Sheets (dated October 5, 1982, October 7, 1982, October 8, 1982 and October 12, 1982) (Reference 7.5) were obtained for the inspector (J. A. Manning) who performed inspections on the lugs prior to the initiation of NCR 4390, Revision 0.

### 5. Findings

DOE/WEP Assessment Plan 019, Assessment Method Section, Item 3 states, "Obtain the weld filler metal requisition identified on the operation sheets." The weld material requisition chits were discarded after processing and are no longer available for review, but the required information can be obtained from the inspectors log sheets which show the weld procedure and the weld filler material used for each weld.

Weld Operation Sheet Number 1-01-F-3-63 for welds 1-001A-D003-03A through 03D was missing the welder ID, filler metal used and the weld completion date. The date of completion for welds 1-001A-D003-03A through 03D was determined to be October 12, 1982 and the welding completed by Edwards (6SAA) using E7018 weld rod. This information was obtained from J. A. Manning's, Inspector Daily Log Sheets dated

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October 12, 1982. The remaining 12 welds had all the required information on the appropriate field weld operation sheets (1-01-F-1-69, 1-01-F-6-37 and 1-01-F-9-5).

Field Weld Operation Sheets were reconstructed from the inspectors log sheets which conforms to the requirements of WBNP-QCI-1.08, Paragraph 6.2.1.1 for documentation reconstruction. All welds have received fit-up and final visual examinations as required by TVA Drawing 47B333-OA-3 (Reference 7.7). The lugs were not removed and the documentation was reconstructed as required by the disposition of NCR 4390, Revision 2.

**6. Conclusions**

Results of the document review indicates that both weld quality and reconstructed documentation are in compliance with TVA requirements.

DOE/WEP considers this group closed.

**7. References**

- 7.1 Original Quality Indicators as listed in Section 1.
- 7.2 TVA WBNP-QCI-1.08, Revision 4, Quality Assurance Records.
- 7.3 TVA WBNP-QCI-4.01, Revision 1, Storage, Issue, and Control of Welding Materials.
- 7.4 DOE/WEP Assessment Plan 019, Revision 0, March 28, 1986.
- 7.5 TVA Inspector Log Sheets for Quality Control Inspector J. A. Manning, dated October 5, 1982, October 7, 1982, October 8, 1982, and October 12, 1982.
- 7.6 TVA Field Weld Operation Sheets, 1-01-F-1-69, 1-01-F-3-63, 1-01-F-6-37 and 1-01-F-9-5.
- 7.7 TVA Drawing 47B33-OA-3.