



**UNITED STATES
NUCLEAR REGULATORY COMMISSION**
REGION II
SAM NUNN ATLANTA FEDERAL CENTER
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July 29, 2008

Mr. Ashok S. Bhatnagar
Senior Vice President
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**SUBJECT: WATTS BAR NUCLEAR PLANT UNIT 2 CONSTRUCTION - NRC INTEGRATED
INSPECTION REPORT 05000391/2008007**

Dear Mr. Bhatnagar:

On June 30, 2008, the U.S. Nuclear Regulatory Commission (NRC) completed an inspection of construction activities at your Watts Bar Unit 2 reactor facility. The enclosed integrated inspection report documents the inspection results, which were discussed on July 10, 2008, with Mr. Masoud Bajestani and other members of your staff.

This inspection examined activities conducted under your Unit 2 construction permit as they relate to safety and compliance with the Commission's rules and regulations, with the conditions of your construction permit, and with fulfillment of Unit 2 regulatory framework commitments. The inspectors reviewed selected procedures and records, observed activities, and interviewed personnel.

Overall, we found that your oversight of construction activities was generally effective with only minor discrepancies identified. Based on the results of this inspection, no findings or violations of significance were identified.

In accordance with 10 CFR 2.390 of the NRC's "Rules of Practice," a copy of this letter and its enclosure will be available electronically for public inspection in the NRC Public Document Room or from the Publicly Available Records (PARS) component of NRC's document system (ADAMS). ADAMS is accessible from the NRC Web site at <http://www.nrc.gov/reading-rm/adams.html> (the Public Electronic Reading Room).

Sincerely,

/RA/

Robert C. Haag, Chief
Construction Projects Branch 3
Division of Construction Projects

Docket No. 50-391
Construction Permit No. CPPR-92

Enclosure: Inspection Report 05000391/2008007 w/attachment

cc w/encl: (See next page)

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cc w/encl:

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Letter to Ashok S. Bhatnagar from Robert C. Haag dated July 29, 2008

SUBJECT: WATTS BAR NUCLEAR PLANT UNIT 2 CONSTRUCTION – NRC
INTEGRATED INSPECTION REPORT 05000391/2008007

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PUBLIC

U.S. NUCLEAR REGULATORY COMMISSION

REGION II

Docket No.: 50-391

Construction Permit No.: CPPR-92

Report No.: 05000391/2008007

Applicant: Tennessee Valley Authority (TVA)

Facility: Watts Bar Nuclear Plant, Unit 2

Location: 1260 Nuclear Plant Rd
Spring City, TN 37381

Dates: April 1 - June 30, 2008

Inspectors: W. Bearden, Senior Resident Inspector, Construction Projects
Branch 3 (CPB3), Division of Construction Projects (DCP)
Region II (RII)
T. Nazario, Resident Inspector, CPB3, DCP, RII
H. Abuseini, Resident Inspector, CPB3, DCP, RII

Approved by: Robert C. Haag, Chief
Construction Projects Branch 3
Division of Construction Projects

Enclosure

EXECUTIVE SUMMARY

Watts Bar Nuclear Plant, Unit 2
NRC Inspection Report 05000391/2008007

This integrated inspection included aspects of engineering and construction activities performed by the applicant associated with the Unit 2 construction project. This report covered a three-month period of resident inspector inspections in the areas of quality assurance; identification and resolution of problems; construction activities; engineering activities; and training and qualification of plant personnel. The inspection program for the Unit 2 Construction Program is described in NRC Inspection Manual Chapter (IMC) 2517. Information regarding the Watts Bar Unit 2 Construction Project and NRC inspections can be found at <http://www.nrc.gov/reactors/plant-specific-items/watts-bar.html>.

The inspectors concluded that the applicant continued to implement adequate controls to conduct ongoing procurement, design, and construction activities. The inspection did not result in any findings of significance.

Inspection Results

- Adequate management and Quality Assurance (QA) oversight was in place commensurate with activities in progress. The inspectors noted a significant portion of the oversight continued to be performed by TVA personnel, but that the level of oversight by Bechtel at the site and at the Knoxville engineering office had increased from the previous inspection period. (Section Q.1.1)
- The applicant's and contractor's processes for identification and resolution of problems continued to be adequate. The inspectors observed the newly created process for handling of potential trends and determined that the guidance was adequate. (Section Q.1.2)
- The applicant's program for performing physical walkdowns of systems, structures, and components continued to provide adequate detail and guidance to allow walkdown personnel to determine the accurate status of construction completion for Watts Bar Unit 2. QA oversight in this area was adequate. (Section C.1.1)
- Ongoing construction activities associated with the applicant's planned modifications to the Auxiliary Building Secondary Containment Enclosure were adequate. Some of the engineering packages required for the modifications have not yet been issued. (Section E.1.1)

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REPORT DETAILS

Summary of Plant Status

During the current inspection period, the applicant continued to develop construction procedures and work instructions. The number of engineering design activities and physical plant walkdowns to determine existing status of structures, systems and components (SSCs) increased from the previous inspection period. Additionally, manning of key management positions and training of personnel continued. An additional NRC construction resident inspector was assigned to the site during this period.

I. Quality Assurance Program

Q.1 Quality Assurance Oversight Activities

Q.1.1 Quality Assurance Oversight (IP 35061)

a. Inspection Scope

The inspectors monitored the applicant's and contractor's management and QA oversight activities to assure adequate oversight of construction activities was in place. This included review of oversight and audit plans and schedules; surveillance, assessment, and oversight results; and reports to management. Specific documents reviewed are listed in the attachment.

b. Observations and Findings

No findings of significance were identified.

The inspectors observed applicant and contractor management and QA oversight of ongoing physical walkdown and construction activities. A significant portion of the oversight continued to be performed by TVA personnel. However, the presence of contractor QA personnel noticeably increased at the site and at the Knoxville engineering offices during the inspection period. Although the applicant's QA organization performed oversight of a broad range of engineering and construction activities, the primary focus was on performance of walkdowns. That emphasis was appropriate as it was the major ongoing field activity during the reporting period. Additionally, the inspectors reviewed selected assessment reports issued by the applicant's and contractor's QA organization to document observation of ongoing work activities. Minor work package documentation and other errors identified by the applicant during the QA oversight activities were documented in the corrective action program.

c. Conclusions

Adequate management and QA oversight was in place commensurate with activities in progress. The inspectors noted an increase in the level of oversight by Bechtel at the site and at the Knoxville engineering offices. However, a significant portion of the oversight continued to be performed by TVA personnel.

Q.1.2 Identification and Resolution of Construction Problems (IP 40504)

a. Inspection Scope

The inspectors monitored the applicant's and contractor's programs for identification and resolution of problems (PI&R). The inspectors observed Management Review Committee (MRC) meetings and reviewed the classification and disposition of selected Problem Evaluation Reports (PERs). Specific documents reviewed are listed in the attachment.

b. Observations and Findings

No findings of significance were identified.

Management Review Committees have been established by the applicant and the contractor. The Project Management Review Committee (PMRC) was implemented by Bechtel and the Construction Completion Management Review Committee (CCMRC) was implemented by the applicant to oversee the respective PI&R processes. In addition, the CCMRC was the primary tool for applicant management oversight of QA activities and Bechtel design and construction work. The inspectors noted that MRC personnel in both organizations exhibited a good questioning attitude, defined proper PER classifications, and appropriately identified deficiencies in PER documentation.

During the previous inspection period, inspectors had noted that Bechtel management had highlighted the fact that multiple PERs had been initiated in the areas of training and documentation errors. Since that time detailed trending guidance has been established by the applicant. The inspectors attended special MRC meetings to address potential trends. The inspectors determined that the recently implemented program provided adequate guidance on handling of potential trends.

c. Conclusions

The applicant's and contractor's processes for identification and resolution of problems continued to be adequate. The inspectors observed the newly created process for handling of potential trends and determined that the guidance was adequate.

II. Management Oversight and Controls

C.1 Construction Activities

C.1.1 System Walkdowns (IPs 35061, 46053, 49063, 51053 and 51063)

a. Inspection Scope

The inspectors monitored the applicant's program for conducting physical walkdowns of SSCs to determine the current status of construction completion at Watts Bar Unit 2. Areas inspected included walkdown procedures, qualification and experience of walkdown personnel, management and QA oversight of ongoing walkdown activities, review of walkdown documentation, and direct observation of selected walkdowns in the following areas:

- electrical panels
- control room design review
- cable vertical drop
- ice condensers
- small bore isometric for Auxiliary Feedwater System
- small bore isometric for Chemical and Volume Control System

The inspectors also observed selected portions of general walkdowns performed to support DCN 52283, ABSCE Boundary Modification. This modification is discussed in more detail in Section E.1.1.

Specific documents reviewed are listed in the attachment.

b. Observations and Findings

No findings of significance were identified.

The applicant initiated a series of physical walkdowns of SSCs to determine the current status of construction completion. The walkdown results will be used as design input for planned analysis and design activities. The walkdown teams utilized walkdown packages developed from information and criteria provided by the engineering organization. The teams collected and recorded field information on the as-constructed condition of components in accordance with the applicable walkdown packages and procedures. Results of completed walkdowns were recorded on applicable data forms and/or drawings which were reviewed by the walkdown review team for completeness, accuracy, and compliance to engineering acceptance criteria prior to submittal to design engineering. The walkdown program required walkdown personnel to document non-conforming conditions and discrepancies in the Corrective Action Program (CAP). Additionally, components which required maintenance (e.g. missing bolts, clamps, etc.) were identified in the walkdown packages.

During this reporting period the applicant performed walkdowns in the areas of mechanical system flow diagrams, large bore isometric, small bore isometric, conduit supports, heating ventilation and air conditioning (HVAC) ducting and supports,

embedded components, control room design review (CRDR), cable attributes, cable pullby, miscellaneous Class 1E cables, electrical panels, ice condensers, and cable vertical drop (cable installation and supports). The inspectors determined that the experience level for personnel performing the walkdowns met the applicant's procedural requirements. QA oversight was adequate.

c. Conclusions

The applicant's program for performing physical walkdowns of SSCs provided adequate detail and guidance to allow walkdown personnel to determine the accurate status of construction completion of Watts Bar Unit 2. QA oversight in this area was adequate.

E.1 Engineering Activities

E.1.1 Engineering Organization and Design Control (IP 53053)

a. Inspection Scope

The inspectors reviewed ongoing design and construction activities associated with the applicant's plans to modify the Auxiliary Building Secondary Containment Enclosure (ABSCE) boundary. The inspectors reviewed documents, interviewed cognizant personnel and walked down applicable areas associated with engineering design change request (EDCR) 52621, "ABSCE Rollup Door." The inspectors also observed ongoing mechanical seal installation activities of the containment penetrations in support of the ABSCE modification, EDCR 2591, "Mechanical Penetration Seals (EI 782)". Specific documents reviewed are listed in the attachment.

b. Observations and Findings

No findings of significance were identified.

This modification would relocate the ABSCE boundary and create construction openings to allow materials, equipment and personnel /access to Unit 2 containment during the Watts Bar Unit 2 completion project. The modification consists of one design change notice (DCN) 52283, "Relocate ABSCE Boundary to Support Unit 2 Completion" and several EDCRs. The DCN has not been issued; however, the EDCRs are being implemented and some have been completed.

c. Conclusions

Ongoing construction activities associated with the applicant's planned modifications to the ABSCE were adequate. Some of the engineering packages required for the modifications have not yet been issued.

T.1.1 Training and Qualification of Plant Personnel

T.1.1 Craft Training (IP 35061)

a. Inspection Scope

The inspectors observed activities associated with new employee indoctrination and training. The inspectors monitored craft classroom and Dynamic Learning Center training sessions. Specific documents reviewed are listed in the attachment.

b. Observations and Findings

No findings of significance were identified.

New employee indoctrination and training for management expectations on procedural compliance, Safety Conscience Work Environment (SCWE), and work rules were required before newly hired employees were released for work. The inspectors noted that the applicant had not yet developed training plans for specific task-related requirements to support future construction activities. The inspectors determined that the applicant's program for training of newly hired personnel was adequate commensurate with the current level of activity.

c. Conclusions

The applicant's program for training of newly hired personnel was adequate for the current level of construction activities being performed.

T.1.2 Training of Engineering and Supervisory Personnel (IP 35061)

a. Inspection Scope

The inspectors observed selected training activities associated with engineering and supervisory personnel. Training sessions were monitored at the site and in the applicant's Knoxville engineering offices. Training monitored included sessions on handling of operating experience information, use of the applicant's Electronic Corrective Action Program (ECAP), and seismic design requirements. Specific documents reviewed are listed in the attachment.

The inspectors also attended a special training session conducted by Hartford Steam Boiler which addressed American Society of Mechanical Engineers (ASME) Section III Code requirements. This training was required of all TVA Unit 2 personnel and any Bechtel engineering and supervisory personnel responsible for ASME Code activities.

b. Observations and Findings

No findings of significance were identified.

b. Conclusions

The applicant's program for training of supervisory and engineering personnel was adequate.

V. Management Meetings

X.1 Exit Meeting Summary

On July 10, 2008, the resident inspectors presented the inspection results to Mr. Masoud Bajestani and other members of his staff. Although some proprietary information may have been reviewed during the inspection, no proprietary information was included in this inspection report.

SUPPLEMENTAL INFORMATION

KEY POINTS OF CONTACT

Applicant personnel

G. Arent, Licensing Manager, Unit 2
J. Atwell, Project Director, Bechtel
M. Bajestani, Vice President, Unit 2
M. Bali, Electrical Design Manager, Bechtel
R. Baron, Nuclear Assurance Project Manager, TVA, Unit 2
B. Briody, Maintenance and Modifications Manager, TVA, Unit 2
P. Byron, Licensing Engineer
G. Caul, Project Quality Assurance Supervisor, Bechtel
B. Crouch, Lead Mechanical Engineer, TVA, Unit 2
R. Esnes, Engineering Manager, Washington Group, Inc
T. Franchuk, Quality Assurance Manager, Bechtel
E. Freeman, Acting Engineering Manager, TVA, Unit 2
W. Goodman, Procurement Manager, Bechtel
J. Hannah, Corrective Action Coordinator, Bechtel
S. Hilmes, Lead Electrical Engineer, TVA, Unit 2
M. Lackey, ECP Rep, TVA, Unit 2
S. Loofbourrow, Quality Manager, Bechtel
D. Malone, Quality Assurance, TVA, Unit 2
J. McCarthy, Licensing Supervisor, Unit 2
R. Moll, Preop Startup Manager, Unit 2
D. Myers, Quality Assurance Manager, TVA, Unit 2
D. Olcsvary, Contracts/Procurement Manager, TVA, Unit 2
D. Osborne, Lead Civil Engineer, TVA, Unit 2
J. Robertson, Acting Engineering Manager, Bechtel
S. Sawa, Training Manager, Bechtel
J. Schlessel, Construction Manager, TVA, Unit 2
D. Soberski, Quality Control Supervisor, Bechtel
P. Theobald, Radcon Supervisor, TVA, Unit 2
D. Webster, Acting Construction Manager, Bechtel, Unit 2
D. Tinley, Quality Assurance, TVA, Unit 2
D. Webb, Operations Manager, TVA, Unit 2

INSPECTION PROCEDURES USED

IP 35061	In-depth QA Inspection of Performance
IP 40504	Part 52, Identification and Resolution of Construction Problems
IP 46053	Structural Concrete Work Observation
IP 49063	Safety Related Piping Work Observation
IP 51053	Electrical Components and Systems Work Observation
IP 51063	Electrical Cable Work Observation
IP 53053	Containment Penetrations

LIST OF ITEMS OPENED, CLOSED, AND DISCUSSED

None

LIST OF DOCUMENTS REVIEWED

I. Quality Assurance Program

Q.1.1 Quality Assurance Oversight

Bechtel Oversight/Self-Assessment Documents

25402-WBN-AR-08-0001, Watts Bar Unit 2 Quality Assurance Audit
 25402-WBN-SR-08-0045, In process civil walkdown of cable tray supports
 25402-WBN-SR-08-0038, Electrical walkdown package WBN2-E-212-015-00 documentation review
 25402-WBN-SR-08-0039, Civil walkdown package WBN2-C-276-274-00 documentation review
 25402-WBN-SR-08-0040, Civil walkdown package WBN2-C-276-498-00 documentation review
 25402-WBN-SR-08-0041, Anchor bolt data for 2-PNL-013 contained in civil walkdown package WBN2-C-276-437-00
 25402-WBN-SR-08-0043, Electrical, civil, and isometric walkdown review teams
 25402-WBN-SR-08-0088, Signature documentation for engineering documents
 25402-WBN-SR-08-0089, In-process observation of isometric walkdown teams
 25402-WBN-SR-08-0090, QC inspection training
 25402-WBN-SR-08-0091, Civil walkdown package documentation review
 25402-WBN-SR-08-0092, In-process civil walkdown review

TVA Oversight/Self-Assessment Documents

NA-WB-08-006, Nuclear Assurance Oversight Report, March 2008
 NA-WB-08-005, Nuclear Assurance assessment of Bechtel QC certification program
 Observation report 43395, Review of walkdown packages
 Observation report 43380, Observation of isometric walkdown
 Observation report 43379, Review of completed isometric walkdown package WBN2-PD-062-313-000

Problem Evaluation Reports (PERs) identified by QA

140832, Missing information in walkdown packages
 140726, Portions of CVCS piping missing identification markings
 139465, Use of obsolete seismic results in calculation
 141240, QC inspector experience not adequately documented incertification package
 142230, QA Audit finding, procedure deficiency

142233, QA Audit finding, ECAP not properly used to route PERs
 142235, QA Audit finding, PER timeliness
 142238, QA Audit finding, lack of PER coordinators
 142239, QA Audit finding, Hardware PERs not processed as nonconformances
 142241, QA Audit finding, proposed enhancements to CAP process
 142294, QA Audit finding, EDCR admin issues

Q.1.2 Identification and Resolution of Problems

Procedures and Standards

25402-MGT-0003, Corrective Action Program, Rev. 0
 NGDC PP-3, Watts Bar Unit 2 Corrective Action Program, Rev. 0

II. Management Oversight and Controls

C1.1 System Walkdowns

Procedures and Standards

WDP-GEN-1, General Walkdown Requirements, Rev. 7
 WDP-E-4, Walkdown Procedure for Electrical, Rev. 1
 WDP-M-5, Walkdown Procedure for Mechanical, Rev. 0
 WDP-PD-2, Walkdown Procedure for Piping and Pipe Supports, Rev. 2

PERs

143249, Ice condenser baskets
 146709, Storage level for ABSCE seal material

Miscellaneous Documents

Walkdown Package WBN-PD-003-005-00, AFW Drain Line 1.5" Loop 1
 Walkdown Package WBN-PD-062-303-00, CVCS Seal water Injection Filter vent and drain lines
 Walkdown Package WBN-PD-062-137-00, System 062 Number 1 Seal Bypass Line for RCP4
 Walkdown Package WBN2-E-276-607-00, Panels 2-L-360 and 2-L-361
 Walkdown Package WBN2-E-275-672-01, Panel 2-R-43
 Walkdown Package WBN2-E-278-543-00, Panel 2-PNL-55-M22.
 Walkdown Package WBN2-E-293-145-08, various conduits vertical drop

E.1 Engineering Activities

E.1.1 Engineering Organization and Design Control

Modifications

EDCR 52621, ABSCE Rollup door
 EDCR, 52591, Mechanical Penetration Seals (EI 782)

PERs

145651, Potential scaffold clearance issues as a result of ABSCE modification

T.1 Training and Qualification of Plant Personnel

T.1.1 Craft Training

Miscellaneous Documents

Lesson Plan DLC308.000, Safety and Human Reinforcement, Rev. 0

T.1.2 Training of Supervisory and Engineering Personnel

Miscellaneous Documents

Hartford Steam Boiler lesson plan, The ASME system

LIST OF ACRONYMS

ABSCE	auxiliary building secondary containment enclosure
ANSI	American National Standards Institute
ASL	approved supplier list
ASME	American Society of Mechanical Engineers
CAP	Corrective Action Program
CCMRC	Construction Completion Management Review Committee
CFR	Code of Federal Regulations
DCN	design change notice
ECAP	Electronic Corrective Action Program
ECP	Employee Concerns Program
EOC	extent of condition
FME	foreign material exclusion
IMC	Inspection Manual Chapter (NRC)
IP	Inspection Procedure (NRC)
MRC	Management Review Committee
NGDC	New Generation Development and Construction
NRC	Nuclear Regulatory Commission
PER	Problem Evaluation Report
PI&R	problem identification and resolution
PM	preventative maintenance
PMRC	Project Management Review Committee
QA	quality assurance
QA/QC	quality assurance/quality control
SCWE	safety conscious work environment
SP	special program
SSC	structures, systems, and components
TVA	Tennessee Valley Authority
WB2CCP	Watts Bar Nuclear Plant Unit 2 Construction Completion Project
WBN	Watts Bar Nuclear Plant