

TENNESSEE VALLEY AUTHORITY

CHATTANOOGA, TENNESSEE 37401

1630 Chestnut Street Tower II

85 JUL 29 P 1: 19
July 25, 1985

BLRD-50-438/83-60
BLRD-50-439/83-53
WBRD-50-391/83-63

U.S. Nuclear Regulatory Commission
Region II
Attn: Dr. J. Nelson Grace, Regional Administrator
101 Marietta Street, NW, Suite 2900
Atlanta, Georgia 30323

Dear Dr. Grace:

WATTS BAR NUCLEAR PLANT UNIT 2 AND BELLEFONTE NUCLEAR PLANT UNITS 1 AND 2 -
LIMITORQUE QA PROGRAM - WBRD-50 391/83-63, BLRD-50-438/83-60,
BLRD-50-439/83-53 - FINAL REPORT

The subject deficiency was initially reported to NRC-OIE Inspector Linda Watson on November 15, 1983 in accordance with 10 CFR 50.55(e), as NCR QDBVA84 S-D-01. This was followed by our interim reports dated December 15, 1983 and April 30 and August 7, 1984. Our August 7, 1984 submittal also contained a final report for Watts Bar unit 1. Our fourth and fifth interim reports for Watts Bar unit 2 and Bellefonte units 1 and 2 were submitted on November 1, 1984 and March 23, 1985, respectively. Enclosed is our final report for Watts Bar unit 2 and Bellefonte units 1 and 2. We consider 10 CFR Part 21 applicable to this deficiency.

If you have any questions, please get in touch with R. H. Shell at FTS 858-2688.

Very truly yours,

TENNESSEE VALLEY AUTHORITY

J. A. Damer
for J. W. Hufham, Manager
Licensing and Risk Protection

Enclosure

cc: Mr. James Taylor, Director (Enclosure)
Office of Inspection and Enforcement
U.S. Nuclear Regulatory Commission
Washington, D.C. 20555

Records Center (Enclosure)
Institute of Nuclear Power Operations
1100 Circle 75 Parkway, Suite 1500
Atlanta, Georgia 30339

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ENCLOSURE

WATTS BAR NUCLEAR PLANT UNIT 2
AND BELLEFONTE NUCLEAR PLANT UNITS 1 AND 2
LIMITORQUE QUALITY ASSURANCE PROGRAM
WBRD-50-391/83-63, BLRD-50-'38/83-60, BIRD-50-439/83-53
NCR QDBVA84-5-D-01
10 CFR 50.55(e)
FINAL REPORT FOR WATTS BAR UNIT 2 AND
BELLEFONTE UNITS 1 AND 2

Description of Deficiency

Vendor audit QDBVA84-5 was conducted at Limitorque Corporation, Lynchburg, Virginia, during the period of November 1-4, 1983. As a result of this audit, deviation QDBVA84-5-01 was initiated, which identified the lack of an adequately implemented quality assurance program. TVA contract No. 81Z26-829681, errata to TVA Specification SS-MEB-SS10.10, "Technical Specification for Electric Motor Operators (All Valves)," change No. 8, requires quality assurance to meet the requirements of ANSI N45.2. Discrepancies noted during program evaluation determined program implementation did not meet contract supplier program commitments.

Some of the deficiencies noted included: inadequate documentation of quality control inspector training, inadequate control and implementation of quality control procedures, inadequate inspection documents, vendor qualification not addressed in quality assurance program, and audit follow-up and verification being performed by quality control manager.

Safety Implications

Limitorque motor operators are used on various safety-related valves at all TVA nuclear plants and are essential to the operation of the valves on which they are used. If the operators are inoperable or severely damaged, there could be an adverse impact on ability of the affected safety-related valve to perform its intended function. This could adversely affect the safe operation of the plant.

Corrective Action - Watts Bar Unit 2 and Bellefonte Units 1 and 2

The supplier submitted his proposed corrective action for the noted deviation on January 13, 1984, with an additional response made on February 7, 1984. These responses were reviewed and determined acceptable pending verification of implementation. Verification activities were conducted at the supplier's facility during the period of February 22-23, 1984. Our evaluators determined adequate corrective actions were in process or had been implemented. This resulted in recommendation to TVA's Division of Purchasing that the hold on request for deliveries for class 1E operators and replacement parts be removed. Verification of remaining open items was pending their completion per commitment dates.

A reaudit of Limitorque Corporation's quality assurance program was conducted on October 9-13, 1984, and included verification of corrective actions for

open items on QDBVA-84-5-D-01. Items B and G were closed as a result of this audit and items H and J remained open. Acceptable implementation of corrective action for items H and J was verified on July 17, 1985, and the deviation is considered closed.

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