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U. S. ATOMIC ENERGY COMMISSION  
DIVISION OF COMPLIANCE  
REGION I

CO Inspection Report No. 50-286/72-01

Subject: Consolidated Edison Company of New York

Indian Point 3

License No. CPPR-62

Location: Buchanan, New York

Priority                     

Category     A    

Type of Licensee: PWR, 1050 MWe(West)

Type of Inspection: Routine, unannounced

Dates of Inspection: January 27 - 28, 1972

Dates of Previous Inspection: October 26 - 28, 1971

Principal Inspector: *R. F. Heishman*  
R. F. Heishman, Reactor Inspector

3/1/72  
Date

Accompanying Inspectors: none

                      
Date

                      
Date

Other Accompanying Personnel: none

                      
Date

Reviewed By: *E. M. Howard*  
E. M. Howard, Senior Reactor Inspector

3/2/72  
Date

Proprietary Information: none

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SECTION I

Enforcement Action

Traceability of welding electrodes is not maintained for reactor coolant piping field welding. (Section II, Paragraph 3)

Licensee Action On Previously Identified Enforcement Matters

None

Unresolved Items

Record of welding purge gas flow rates are inconsistent. (Section II, Paragraph 7)

Status of Previously Identified Unresolved Items

- A. The previously identified unresolved item pertaining to the lack of a Quality record retention procedure has been resolved. (Section II, Paragraph 4)
- B. The Code data sheet (Form N1A) for the reactor vessel has been reviewed on site. This item is considered resolved. (Section II, Paragraph 5)
- C. Procedures pertaining to the repair of the steam generators cladding were inspected. This item remains outstanding pending inspection of repair records. (Section II, Paragraph 6)
- D. The items contained in the CO Regional office notification letters pertaining to scram breakers and main steam relief valve headers are under review by the engineering department. These items remain unresolved.

Design Changes

None

Unusual Occurrences

None

Persons Contacted

Con Ed

- Mr. A. D. Kohler, Resident Construction Manager
- Mr. F. M. Matra, IP-3 Project Superintendent
- Mr. R. M. Schuster, QC Engineer (NDT)
- Mr. A. Dunnigan, QC Records Specialist

WEDCO

- Mr. M. Snow, Reliability Manager
- Mr. S. M. Roberts, QA Manager
- Mr. R. W. Diebler, Site QC Manager
- Mr. E. C. Paulcheck, QC Engineer (Mechanical)
- Mr. C. Hughes, QC Welding Engineer
- Mr. J. Morehead, Installation Engineer

Management Interview

The following subjects were discussed with Messrs. Kohler, Matra, Dadson, Snow and others on January 27, 1972.

- A. The inspector stated that the following items were considered resolved:
  - 1. QA records procedure #8. (Section II, Paragraph 4)
  - 2. Code data sheet (Form N1A) for reactor vessel. (Section II, Paragraph 5)

The licensee acknowledged the comment.

- B. The inspector stated that the results of the engineering evaluation of the scram breaker and main steam line header problems identified at other facilities would be reviewed during subsequent inspections.

Mr. Kohler stated the results would be made available to the inspector when the evaluation was completed.

- C. The inspector stated that records to indicate traceability of welding electrodes used in field welding of the reactor coolant piping were not available.

Mr. Snow stated there was no requirement for recording heat numbers of electrodes for each weld.

The inspector stated that Criterion VIII, Appendix B, 10 CFR 50 established the requirement. In addition, the inspector stated that the procedures governing the maintenance of weld data sheets which was previously inspected included the requirement for recording this data and a space was provided for the weld data sheet for this purpose.

The licensee stated that this item would be corrected. (Section II, Paragraph 3)

- D. The inspector stated that the welding gas purge flow recorded on the weld data sheet appeared inconsistent in that some sheets indicated before welding, some indicated during welding and some no indication.

The licensee stated that this item would be corrected. (Section II, Paragraph 7)

SECTION II

Prepared by: R. F. Heishman, Reactor Inspector

Additional Subjects Inspected, Not Identified in Section I, Where No Deficiencies or Unresolved Items Were Found

1. General

The licensee reported that the status of construction was 62% complete as of January 6, 1972. The following is a breakdown of significant areas:

Structural

VC Building 60%; Liner 99%  
PAB 80%  
Intake structure 95%  
Electrical Tunnel 100%  
Pipe Tunnel 55%

Electrical

Cabletrays & Conduit installation 45%  
Cable 480V 5%  
Cable 69KV 15%

Piping

Reactor Coolant 30%  
Safety Injection 12%  
Main Steam 15%

The licensee reported that Mr. G. I. Coulbourn has been appointed Con Ed Nuclear Startup Manager for IP-2 and IP-3. The Wedco Reliability Manager reported that the Wedco QA Manager had been re-assigned to the W International Division and no replacement was yet available.

2. Reactor Coolant Piping

- a. Records in the following areas were inspected to verify whether the licensee-contractor is meeting the construction requirements and to test and verify the quality control system:
  - (1) Visual inspection including, joint preparation; cleanliness; environmental control; root gap; axial and angular alignment; completed root pass; and completed weld.
  - (2) Nondestructive testing records including radiograph quality; evaluation of weld quality; dye penetrant examination; correlation of record to a specific weld.
  - (3) Defect repair records including defect removal technique; defect removal verification; identification of welder; qualification of welder; and acceptance of repairs.
  - (4) Records of welding material control including issue control and identification; post issue control of temperature and moisture; and disposition of issued but unused material; and pre-issue storage conditions.
  - (5) Weld records of qualification including weld procedures; welder; nondestructive test techniques; and NDT technicians.
  - (6) Weld records of identification including weld location; welder; weld procedure; NDT technician; NDT procedure and NDT results.
  
- b. The inspector observed the work performance of the licensee-contractor to verify that the construction requirements were being met and to verify the quality control system in the following areas:
  - (1) Availability and use of prescribed procedures for weld performance, including identification of weld type and material.
  - (2) Joint preparation and alignment including verification by the appropriate QC inspector.
  - (3) Identification of weld, location, welder, and inspector.

- (4) Physical appearance of partially completed and completed weld including burn through; cracks; porosity; undercut; weld profile (contour and reinforcement) and presence of arc strikes and weld spatter on adjacent surfaces.
- (5) Identification, handling and control of weld materials.

Details of Subjects Discussed in Section I

3. Traceability of Welding Electrodes

The Wedco electrode control procedure which was previously reviewed established the requirement that the QC inspector recorded the heat number of the electrode on the weld joint history record. The field weld records do not contain any reference to the heat number and the inspector was informed that the requirement had been changed to delete the recording of the electrode heat number on the weld joint history record, Criterion VIII, Appendix B, 10 CFR 50 requires that materials be traceable during fabrication, erection, installation and use. Records of electrode traceability are maintained from site receipt through issue to area foreman; however, beyond this point traceability is lost. This item is being included as a nonconformance item in the documentation letter.

4. QA Records Procedure

The inspector reviewed Con Ed Quality Assurance Procedure No. 8 entitled, "Procedure for Quality Assurance and Quality Control Record Retention" dated December 28, 1971. This procedure was previously identified as an unresolved item in that the final procedure had not been approved. This item is considered resolved.

5. Reactor Vessel Code Data Sheet (Form N1A)

The ASME Code Data (Form N1A) was inspected for the reactor vessel and vessel head and found to be in accordance with Section III 1965 and addenda through winter 1965. This item was previously identified as not on site. This item is considered resolved.

6. Steam Generator Cladding Repair

The inspector reviewed the repair procedure entitled, "Nonradioactive Field Modification Procedure for Explosive Cladding on "44" Type Steam Generator Tube Plate", revision 4 dated December 7, 1971. This procedure was written and qualified by Westinghouse Tampa Division. Con Ed reviewed and provided comments on the procedure prior to implementation. The procedure includes the requirements for welding and testing in accordance with Sections III and IX of the ASME B&PV Code. The repairs are in progress and are scheduled to be completed by August 1972. This item remains unresolved pending completion of repair and testing.

7. Welding Gas Purge Flow Records

The weld records inspected appeared inconsistent relative to purge flow. Several field weld records indicated purge flow prior to welding, several indicated purge flow during welding and several did not indicate when the measurement was taken. The QC procedures do not specify the specific record requirement. The observation of the inspector of field welding in progress indicated that the correct flow was being maintained prior to and during the root pass welding operations. This item will be reviewed during subsequent inspections.