NRC FORM 591FF PART 1
(12-2007)
10 CFR 2.201

U.S. NUCLEAR REGULATORY COMMISSION

INSPECTION REPORT

1. LICENSEE OR CERTIFICATE HOLDER/LOCATION INSPECTED:	2. NRC/REGIONAL OFFICE:
United States Enrichment Corporation 6903 Rockledge Road Bethesda, MD 20817 REPORT NO: 2010-002	U.S. Nuclear Regulatory Commission Region II 245 Peachtree Center Ave, NE, Suite 1200 Atlanta, GA 30303-1257

3. DOCKET NUMBER:	4. LICENSE OR CERTIFICATE NUMBER:	5. DATE(S) OF INSPECTION:
70-7001	GDP-1	April 1 – June 30, 2010

LICENSEE OR CERTIFICATE HOLDER:

The inspection was an examination of the activities conducted under your license or certificate as they relate to safety and/or safeguards and to compliance with the Nuclear Regulatory Commission (NRC) rules and regulations and the conditions of your license or certificate. The inspection consisted of selective examinations of procedures and representative records, interviews with personnel, and observations by the inspector. The

☑ 1. Based on the inspection findings, no violations were identified.

☐ 2. Previous violation(s) closed.

☐ 3. Reported events reviewed

☐ 4. The violation(s), specifically described to you by the inspector as non-cited violations, are not being cited because they were self-identified, non-repetitive, and corrective action was or is being taken, and the remaining criteria in the NRC Enforcement Policy, to exercise discretion, were satisfied.
Non-Cited Violation(s) was/were discussed involving the following requirement(s) and Corrective Action(s):

☐ 5. During this inspection, certain of your activities, as described below and/or attached, were in violation of NRC requirements and are being cited. This form is a NOTICE OF VIOLATION, which may be subject to posting in accordance with 10 CFR 19.11.
(Violations and Corrective Actions)

LICENSEE OR CERTIFICATE HOLDER STATEMENT OF CORRECTIVE ACTIONS FOR ITEM 5, ABOVE

I hereby state that, within 30 days, the actions described by me to the inspector will be taken to correct the violation(s) identified. This statement of corrective actions is made in accordance with the requirements of 10 CFR 2.201 (corrective steps already taken, corrective steps which will be taken, date when full compliance will be achieved). I understand that no further written response to the NRC will be required, unless specifically requested.

Title	Printed Name	Signature	Date
LICENSEE/CERTIFICATE HOLDER REPRESENTATIVE			
NRC INSPECTOR	Michael O. Miller	/RA by JHenson for MMiller/	7/28/2010

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6. INSPECTOR(S): Michael O. Miller, John Pelchat, Paul Startz

7. INSPECTION PROCEDURES USED: 88100, 88102, 88103

EXECUTIVE SUMMARY

This report covers a three-month period of inspection by resident inspectors and regional inspectors acting on behalf of the resident inspectors. Inspectors performed a selective examination which was accomplished by direct observation of safety significant activities and equipment, tours of the facility, interviews and discussions with certificate-holder personnel, independent verification of safety system status and limiting conditions for operation, corrective actions, and a review of facility records. The NRC's program for overseeing the safe operation of uranium enrichment facilities is described in Manual Chapter 2600, “Fuel Cycle Facility Operational Safety and Safeguards Inspection Program,” dated March 21, 2008.

The inspectors identified no violations of NRC requirements during this inspection period that had a significance which was more than minor.

Summary of Plant Status

The certificate holder performed routine operations throughout the inspection period. Plant load was reduced to summertime low power levels, and product assay was according to the production schedule.

Plant Operations (88100)

a. Inspection Scope and Observations

- The inspectors observed routine operations on a daily basis in the cascade buildings and area control rooms, the feed vaporization facilities and operations monitoring rooms, product and tails withdrawal facilities, and the central control facility, such that the entire plant was toured each month. The operations staff was alert and generally knowledgeable of the current status of equipment associated with their assigned facilities. While conducting plant tours, the inspectors noted continued improvement in housekeeping, storage of transient combustible material, and the readability of posted radiological signs.

b. Conclusions

No violations of significance were identified.

Surveillance Observations (88102)

a. Inspection Scope and Observations

- Inspectors reviewed the adequacy of the facility's surveillance testing, calibration, and inspection required by the technical safety requirements (TSRs), nuclear criticality safety evaluations/approvals (NCSE/As), and the material control and accountability program. Inspectors also reviewed the calibration of quality and nuclear criticality safety-augmented quality (Q and NCS-AQ) safety-related instrumentation not specifically controlled by TSRs. The inspectors evaluated the effectiveness of the facility's controls in identifying, resolving, and preventing problems by reviewing corrective action systems, root cause analysis, safety committees, and self-assessment in the area of surveillance.

- The inspectors performed safety systems reviews and observed routine operations in the C-310 Purge and Product building. Inspectors evaluated the Normetex pumps and related UF_6 release detectors, isolation block valves, and associated instrumentation. The inspectors compared samples of the Normetex pump system to as-built piping and instrumentation diagram drawings 15E15715-C (Rev. 25) and 15E-15944-C (Rev. B1); and they compared the safety system configuration to the nuclear criticality safety evaluation NCSE 041 (Rev. 11) and the nuclear criticality safety approval NCSA 310-003 (Rev. 7). The inspectors reviewed samples of the associated surveillance inspections and surveillance schedule of the safety related equipment. The inspectors evaluated surveillance maintenance test package #P-0919971-01 and the associated calibration procedure CP4-GP-IM6310. The surveillance activity and documentation properly identified the discovery of an out-of-tolerance condition, the replacement of the pressure transducer, and the successful follow-up calibration.

- The inspectors performed reviews of the following surveillance activities that detected anomalies:
  - Datasheet C10I00651 (ATRC-10-0564) C-337 freezer sublimer pressure sensor found out of tolerance while performing WO 0919972 per procedure CP4-GP-IM6181.
  - Datasheet C10I00323 (ATRC-10-0267) C-335 datum pressure sensor found out of tolerance while performing WO 0919955 per procedure CP4-GP-IM6147.
  - Datasheet C10I00615 (ATRC-10-0529) C-335 pressure switch discovered out of tolerance while performing WO 0920267 per procedure CP4-GP-IM6360.
  - Datasheet C09I02264 (ATRC-09-2077) PBS-B-5 pressure switch found out of tolerance while performing WO 0908501 per procedure CP4-GP-IM6120.

b. Conclusions

No violations of significance were identified.

Maintenance Observations (88103)

a. Inspection Scope and Observations

- During the inspection of maintenance activities, the inspectors witnessed maintenance and post-maintenance testing as they were performed, reviewed the test data to verify that the systems, structures, and components involved in these tests satisfied the requirements described in the TSRs, the Safety Analysis Report (SAR), and applicable certificate holder procedures, and that the tests demonstrated that the Safety Systems and Components (SSCs) were capable of performing their intended safety functions. The inspectors also attended pre-job briefings and safety meetings related to maintenance in order to evaluate the effectiveness of the certificate holder's ability in identifying, resolving, and preventing problems

b. Conclusions

No violations of significance were identified

Exit Meeting Summary

The inspection scope and results for the Integrated Inspection Report, 2nd Quarter 2010, were summarized on July 1, 2010, with Steve Penrod and members of his staff in an exit meeting. The inspectors asked the certificate holder or certificate holder staff whether any materials examined during the inspection should be considered proprietary. No proprietary information was identified.

ATTACHMENT

Key Points of Contact

Name	Title
Keith Ahern	Production Support
Joseph Barletto	Plant Shift Superintendant
Paul Bean	Quality Assurance Manager
Kevin Beasley	Plant Shift Superintendant
Mike Boren	Regulatory Compliance and Nuclear Operations
Rodney Cook	Plant Shift Superintendant
Ronald Dockery	Plant Shift Superintendant
Eddie Gray	Chief of Security
Sherrill Gunn	Operations Manager
Robert Helme	Engineering Manager
Jim Lewis	Plant Manager
Louis Moffatt, II	Cascade Group Manager
Steve Penrod	Vice President and General Manager
Vernon Shanks	Regulatory Affairs Manager
Steve Smith	Security Manager
Diane Snow	Manager, Environmental, Safety, and Health
Dave Stadler	Lead, Regulatory Engineer
April Tilford	Emergency Management
Billy Wallace	Plant Shift Superintendant
Derek Warford	Plant Shift Superintendant
Craig Willett	Maintenance Functional Manager

List of Items Opened, Closed, and Discussed

Opened

07007001/2010-002-00	LER	EN 45890: TAR FOUND ON OVERPRESSURE RUPTURE DISCS POTENTIALLY CHANGING THE RELIEF SET POINT USEC requested that a Notice of Enforcement Discretion (NOED) be granted pursuant to the NRC's policy regarding the exercise of discretion for an operating facility, described in Section VII.C of the NRC's Enforcement Policy. This NOED was effective for ten days to extend the action time for Action A.2 of LCO 2.4.3.4 to May 10, 2010, at 4:42 p.m. TAC NO. L32752, GDP NOED NO.10-02-002 USEC CAP items: ATRC-10-1131, ATRC-10-1134, ATRC-10-1139, ATRC-10-1165, ATRC-10-1166, and PAD-2010-006
07007001/2010-002-00	URI	WIDE SPREAD CONTAMINATION EVENT ON MARCH 16, 2010 While performing routine cylinder change on Autoclave 1 East, the Health Physics technician found contamination around the working area and on both operators. The cylinder that was being replaced was also contaminated. The Health Physics technician also found contaminated items in the control room. USEC CAP item: ATRC-10-0704 and ATRC-10-1023