

Attachment 1

to

Letter from C. A. Schrock (WPSC) to NRC Document Control Desk

dated

June 10, 1993

Description of Revisions to the Kewaunee Nuclear Power Plant

Operational Quality Assurance Program Description

Revision 14

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Based on organizational changes within the Nuclear organization at Wisconsin Public Service Corporation (WPSC), the following changes are being proposed to maintain the accuracy of the Operational Quality Assurance Program Description (OQAPD).

The position of Superintendent - Nuclear Information Systems has been deleted. This change was initiated to provide more effective use of company personnel. The responsibilities which were associated with this position have been reassigned as follows:

- Administrative issues have been assigned to the Nuclear Personnel Supervisor. The title of Nuclear Personnel Supervisor was changed from Plant Personnel Supervisor. This position continues to report to the Manager - Nuclear Plant Support Services and is also responsible for plant budgeting and plant and corporate personnel issues.
- Coordinating the development of the configuration management program, records management, and plant and corporate document control are now responsibilities of the new position of Superintendent - Nuclear Engineering Control. This position reports to the Manager - Nuclear Engineering.
- Plant information system activities have been assigned to the new position of Superintendent - Nuclear Computer Systems. This new position reports to the Manager - Nuclear Plant Support Services and is responsible for the coordination of the nuclear organization's computer systems, including the corporate and plant local area networks.
- Emergency Preparedness activities have been transferred to the Governmental Affairs Group of the Public Affairs Department. The Emergency Preparedness Group's primary function will continue to be the maintenance of an effective emergency preparedness program for the Kewaunee Nuclear Power Plant (KNPP). However, the group's experience in interfacing with state and local government officials and its emergency planning experience can now be effectively applied to other areas of the company. This organizational change will also unite the emergency public information aspects of emergency response and the plant emergency preparedness program within the same department.

Wisconsin Public Service Corporation is committed to maintaining an effective emergency preparedness program for KNPP. The Emergency Preparedness Group will have a direct line of communication with the Senior Vice President - Nuclear Power through the Director - Governmental Affairs and Emergency Preparedness. The Emergency Preparedness Group's working relationship with the plant and the group's work locations at the plant and corporate offices remain unchanged. Implementation of commitments made in response to NRC Inspection Report 50-305/92021 are continuing; these changes will be reflected in the next revision to the OQAPD.

Specifically, the changes that affect the OQAPD are as follows:

Page 3 Description of Change

The Director - Governmental Affairs and Emergency Preparedness has been added to the OQAPD.

Reason for Change

The responsibility for the Emergency Preparedness program has been transferred to this position as a result of organizational changes at WPSC.

Safety Evaluation

Emergency Preparedness activities have been transferred to the Governmental Affairs Group of the Public Affairs Department. The Emergency Preparedness Group's primary function will continue to be the maintenance of an effective emergency preparedness program for the Kewaunee Nuclear Power Plant (KNPP). However, the group's experience in interfacing with state and local government officials and its emergency planning can now be effectively applied to other areas of the company. This organizational change will also unite the emergency public information aspects of emergency response and the plant emergency preparedness program within the same department. This change is administrative in nature and does not reduce previous commitments in the OQAP Description.

Page 4 Description of Change

Design document control has been added to the list of responsibilities of the Manager - Nuclear Engineering.

Reason for Change

This change reflects the current practice of WPSC.

Safety Evaluation

The responsibility of design document control is now under the Manager - Nuclear Engineering versus the Manager - Nuclear Plant Support Services. The Manager - Nuclear Engineering has delegated this responsibility to the Superintendent - Nuclear Engineering Control. This change is administrative in nature and does not reduce previous commitments in the OQAP Description.

Page 4

Description of Change

The title of Superintendent - Engineering Support has been changed to Superintendent - Nuclear Engineering Support and drawing control has been deleted from his responsibilities.

Reason for Change

The proper title of this position is Superintendent - Nuclear Engineering Support. The responsibility for drawing control has been transferred to another position.

Safety Evaluation

Superintendent - Nuclear Engineering Support is the correct title for this position. Drawing control has been transferred to the position of Superintendent - Nuclear Engineering Control, as a result of WPSC's reorganization. These changes are administrative in nature and do not reduce previous commitments in the OQAP Description.

Page 4

Description of Change

The Superintendent - Nuclear Engineering Control has been added to the list of positions reporting to the Manager - Nuclear Engineering.

Reason for Change

This change reflects the current organizational structure of WPSC.

Safety Evaluation

Due to WPSC's reorganization, a new position of Superintendent - Nuclear Engineering Control was created. This position reports to the Manager - Nuclear Engineering and is responsible for records management, drawing control, coordination of the development and implementation of the nuclear configuration management program, and plant and corporate design document control. This change is administrative in nature and does not reduce previous commitments in the OQAP Description.

Page 5

Description of Change

The plant operations engineering group has been deleted from the list of groups reporting to the Assistant Manager - Plant Operations.

Reason for Change

This change reflects the current organizational structure of WPSC.

Safety Evaluation

The plant operations engineering group, which consisted of one plant operations engineer, has been eliminated. The responsibilities of this position have been redistributed to the existing staff within the Operations organization. This change does not reduce previous commitments in the OQAP Description, as this change is a shift in responsibilities, not an elimination of responsibilities.

Page 5

Description of Change

Nuclear department computer coordination has been removed from the responsibilities of the Superintendent - Plant Instrument and Control.

Reason for Change

This reflects the current organizational structure of WPSC.

Safety Evaluation

The responsibility for nuclear department computer coordination has been transferred to the new position of Superintendent - Nuclear Computer Systems due to WPSC's reorganization. These changes were initiated to provide more effective use of company personnel and do not reduce previous commitments in the OQAP Description.

Page 6

Description of Change

Emergency preparedness has been removed from the list of responsibilities of the Manager - Nuclear Plant Support Services.

Reason for Change

This change reflects the current organizational structure of WPSC.

Safety Evaluation

Emergency preparedness activities have been transferred to the Governmental Affairs Group of the Public Affairs Department. This group will have a direct line of communication with the Senior Vice President - Nuclear Power through the Director - Governmental Affairs and Emergency Preparedness. The

Emergency Preparedness Group's working relationship with the plant and the group's work locations at the plant and corporate offices remain unchanged. This change is administrative in nature and does not reduce previous commitments in the OQAP Description.

Page 6

Description of Change

Nuclear information systems has been deleted and nuclear computer systems has been added to the departments which report to the Manager - Nuclear Plant Support Services.

Reason for Change

This change reflects the current organizational structure of WPSC.

Safety Evaluation

Due to WPSC's reorganization, the position of Superintendent - Nuclear Information Systems has been deleted and a new position of Superintendent - Nuclear Computer Systems has been created. This change is discussed below. This is an administrative change and does not reduce previous commitments in the OQAP Description.

Page 6

Description of Change

The Superintendent - Nuclear Information Systems has been deleted and the Superintendent - Nuclear Computer Services has been added to the personnel reporting to the Manager - Nuclear Plant Support Services.

Reason for Change

These changes reflect the current organizational structure of WPSC.

Safety Evaluation

These changes were initiated to provide more effective use of company personnel. The responsibilities of the former position of Superintendent - Nuclear Information Systems have been reassigned to the Superintendent - Nuclear Computer Services, the Superintendent - Nuclear Engineering Control, the Nuclear Personnel Supervisor, and the Public Affairs Department. These changes are administrative in nature and do not reduce previous commitments in the OQAP Description.

Page 7

Description of Change

A sentence describing a portion of responsibilities of the Superintendent - Plant Quality Programs has been reworded.

Reason for Change

This change was made for better sentence organization.

Safety Evaluation

This change is administrative in nature and was made to provide better sentence structure. This change does not reduce previous commitments in the OQAP Description.

Page 7

Description of Change

The title of Plant Personnel Supervisor was changed to Nuclear Personnel Supervisor and responsibilities delegated to this position have been expanded.

Reason for Change

This change reflects the current organizational structure of WPSC.

Safety Evaluation

The Nuclear Personnel Supervisor continues to report to the Manager - Nuclear Plant Support Services and is responsible for plant budgeting and administrative activities. In addition to the responsibility of plant personnel issues, corporate personnel issues have been assigned to this position. This change is administrative in nature and does not reduce previous commitments in the OQAP Description.

Page 9

Description of Change

The System Operating Group has been removed from the list of Other Key Groups.

Reason for Change

This reflects the current organizational structure of WPSC.

Safety Evaluation

A Quality Assurance audit conducted by Wisconsin Public Service Corporation determined that the System Operating Group has minimal effect on OQAP items and, therefore, recommended the group be removed from the support groups listed in the OQAPD.

System Operating is responsible for the safe, reliable, and economic operation of the WPS bulk electric and gas systems. The Kewaunee plant supports System Operating in providing electrical generation for the system.

System Operating personnel are not badged or trained in accordance with the OQAP, therefore, this group is being removed from the OQAP Description. This change is administrative in nature and does not reduce previous commitments in the OQAP Description.

Page 9

Description of Change

The Emergency Preparedness Group has been added to the list of Other Key Groups.

Reason for Change

This change reflects the current organizational structure of WPSC.

Safety Evaluation

Emergency preparedness activities have been transferred to the Governmental Affairs Group of the Public Affairs Department. This group will have a direct line of communication with the Senior Vice President - Nuclear Power through the Director - Governmental Affairs and Emergency Preparedness. The Emergency Preparedness Group's working relationship with the plant and the group's work locations at the plant and corporate offices remain unchanged. This change is administrative in nature and does not reduce previous commitments in the OQAP Description.

Page 10

Description of Change

A paragraph has been added to clarify that QA Type 2 and QA Type 3 items may require special control.

Reason for Change

The OQAP is applicable in non-QA 1 areas though not necessarily in its entirety.

Safety Evaluation

All sections of the OQAP are mandatory for QA type 1, however only certain sections are applicable for QA2 and 3 items as required by directives and procedures. Where special QA requirements for QA type 2 and 3 items are required, an "X" designator is added to the QA type. This revision is made for clarification only and does not reduce previous commitments in the OQAP Description.

Page 26

Description of Change

The position of Superintendent - Nuclear Engineering Control and the Emergency Preparedness Group have been added to Figure 1 - Offsite Functional Quality Assurance Organization, and the System Operating group has been deleted.

Reason for Change

This change reflects the current organizational structure of WPSC.

Safety Evaluation

These changes have been previously discussed. Refer to the Safety Evaluations for page 3, 4, and 9 changes.

Page 27

Description of Change

The Superintendent - Nuclear Information Systems has been deleted and the Superintendent - Nuclear Computer Systems has been added to Figure 2 - Onsite Functional Quality Assurance Organization. Also, the title of Plant Personnel Supervisor has been changed to Nuclear Personnel Supervisor.

Reason for Change

This change reflects the current organizational structure of WPSC.

Safety Evaluation

These changes have been previously discussed. Refer to the Safety Evaluation for page 6 and 7 changes.

Attachment 2

to

Letter from C. A. Schrock (WPSC) to NRC Document Control Desk

dated

June 10, 1993

Kewaunee Nuclear Power Plant

Operational Quality Assurance Program Description

Revision 14

INTRODUCTION

The policy of Wisconsin Public Service Corporation is to comply with the requirements of the Operational Quality Assurance Program (OQAP) which is authorized under the direction of the Senior Vice President-Nuclear Power. The OQAP fulfills the requirements of 10CFR50 Appendix B, "Quality Assurance Criteria for Nuclear Power Plants and Fuel Reprocessing Plants." Compliance with the OQAP is mandatory for Wisconsin Public Service Corporation employees and equivalent measures appropriate to the circumstance shall be enforced upon suppliers of materials, equipment or services.

The Operational Quality Assurance Program is established to define, implement and audit operation, maintenance, and modification activities related to nuclear plant safety. The OQAP complies with the provisions of ANSI N18.7-1976, "Administrative Controls and Quality Assurance for the Operational Phase of Nuclear Power Plants," with exceptions, interpretations, and qualifications noted in Appendix A of this description.

1.0 ORGANIZATION

1.1 General Requirements

All members of the organization involved in operation of the Kewaunee Nuclear Power Plant shall be made aware of and recognize the necessity for well formulated and detailed administrative controls to assure safe and efficient operation. Lines of authority, responsibility and communication are established under the direction of the Senior Vice President-Nuclear Power and identify all levels of management involved in the OQAP, (See Figures 1 & 2). The quality assurance functions performed by each organizational element are cited in the descriptions below.

1.2 Duties and Responsibilities

SENIOR VICE PRESIDENT-NUCLEAR POWER

Under his authority the Operational Quality Assurance Program is established. He has corporate responsibility for all matters relating to the administration, engineering, design, manufacture, construction, installation, maintenance, modification, test, start-up, licensing, training programs, commercial operation and quality assurance of the Kewaunee Nuclear Power Plant. He is responsible for final review and approval of changes to the Operational Quality Assurance Program. He is also responsible for the Independent Technical Review Program; however, NSRAC reports directly to a Senior Company Officer.

SENIOR VICE PRESIDENT-POWER SUPPLY AND ENGINEERING

He has delegated his Quality Assurance responsibilities to the Superintendent-Power Plant Design and Construction and the Vice President-Energy Supply.

SUPERINTENDENT-POWER PLANT DESIGN AND CONSTRUCTION

He is responsible to the Senior Vice President-Power Supply and Engineering. He has delegated his authority and responsibility for providing engineering support of plant modifications and the implementation of the quality assurance requirements associated with these functions to the Assistant Superintendent-Plant Project Engineering.

VICE PRESIDENT-ENERGY SUPPLY

He is responsible to the Senior Vice President-Power Supply and Engineering for procurement, management, and disposition of nuclear fuel and fuel materials, and the implementation of the quality assurance requirements associated with these functions. He has responsibility for reviewing and approving the directives which control the activities affecting quality performed by the Nuclear Fuel Cycle Group and the Nuclear Fuel Analysis Group, ensuring that the directives implement the requirements of the OQAP, and ensuring support is available for special projects involving the nuclear power plant.

ASSISTANT SUPERINTENDENT-PLANT PROJECT ENGINEERING

He is responsible to the Superintendent Power-Plant Design and Construction for providing engineering and design support to the Manager-Nuclear Engineering. He is responsible for ensuring that the design activities carried out under his cognizance are performed under the requirements of the OQAP. He reviews and provides inputs to those directives which control engineering activities.

DIRECTOR - GOVERNMENTAL AFFAIRS AND EMERGENCY PREPAREDNESS

His primary responsibility in support of the KNPP is the maintenance of an effective emergency preparedness program. He has a direct line of communication with the Senior Vice President - Nuclear Power.

MANAGER - NUCLEAR ENGINEERING

He is responsible to the Senior Vice President - Nuclear Power for licensing and systems, technical reviews (including special technical reviews as part of the

Independent Technical Review Program), nuclear projects, safety systems engineering, safety evaluations, modifications, engineering support, corporate health physics, design document control, and the QA Typing Committee. He is also responsible for activities performed by the engineering organization under his supervision, and for the review, approval, and verification of implementation of nuclear administrative directives affecting quality, for his area of responsibility. Responsibilities have been delegated to the personnel listed below.

Assistant Manager - Nuclear Projects - has been delegated the responsibility for the independent technical review program, vendor services, and budget control.

Superintendent - Nuclear Engineering Support - has been delegated the responsibility for plant engineering and field support.

Superintendent - Nuclear Engineering Control - has been delegated the responsibility for records management, drawing control, coordination of the development and implementation of the nuclear configuration management program, and KNPP and corporate design document control.

Superintendent - Nuclear Licensing and Systems - has been delegated the responsibility for functions and activities relating to nuclear licensing, support to the plant relating to nuclear steam supply systems, and performance of licensing related technical reviews (i.e., Technical Specifications).

Superintendent - Nuclear Project Management - has been delegated the responsibility for modification project administration.

Superintendent - Safety System Engineering - has been delegated the responsibility for performance of safety system functional inspections and the Operational Experience Assessment Program.

Nuclear Health Physicist - has been delegated the responsibility for health physics reviews and training support.

MANAGER - KEWAUNEE PLANT

He is responsible to the Senior Vice President - Nuclear Power for the safe and reliable operation and maintenance of the plant in accordance with the requirements of the OQAP. He has the responsibility for the review, approval, and verification of implementation of nuclear administrative directives affecting quality for his areas of responsibility. Those departments which report to the Manager - Kewaunee Plant include maintenance, operations, instrument and control, radiation protection, radiochemistry, and plant projects. Responsibilities have been delegated to the personnel listed below.

Assistant Manager - Plant Maintenance - has been delegated the responsibility for maintenance of plant equipment and maintenance engineering activities.

Assistant Manager - Plant Operations - has been delegated the responsibility for plant operations including general supervision of all shift operating personnel, and the reactor engineering group.

Superintendent - Plant Instrument and Control - has been delegated the responsibility for maintenance of plant instrumentation and controls, and I&C engineering activities.

Assistant to the Plant Manager - has been delegated the responsibility for warehouse activities and plant outage coordination activities.

Superintendent - Plant Radiation Protection - has been delegated the responsibility for radiation protection, plant health physics activities, and the health physics portion of the Radiological Environmental Monitoring Program.

Superintendent - Plant Radiochemistry - has been delegated the responsibility for plant chemistry and the chemistry portion of the Radiological Environmental Monitoring Program.

MANAGER - NUCLEAR PLANT SUPPORT SERVICES

He is responsible to the Senior Vice President - Nuclear Power for plant activities associated with training, security, quality programs, and administrative activities. He has the responsibility for review, approval, and verification of implementation of nuclear administrative directives affecting quality for his area of responsibility. Those departments which report to the Manager - Nuclear Plant Support Services include nuclear computer systems, nuclear training, security, personnel, and plant quality programs. Responsibilities have been delegated to the personnel listed below.

Superintendent - Nuclear Computer Systems - has been delegated the responsibility for coordination of the Nuclear organization's computer systems, including the corporate and plant local area networks.

Superintendent - Nuclear Training - has been delegated the responsibility for nuclear training, which includes accreditation, science and academics, engineering, maintenance, operations and simulator.

Superintendent - Plant Quality Programs - has been delegated the responsibility for verifying the effectiveness of plant quality activities and has the onsite Quality Control Group reporting to him. He is responsible for review of nuclear administrative directives for consistency with the OQAP. He has the authority and organizational freedom to identify quality problems, initiate, recommend or provide solutions, and verify implementation of corrective actions. He is responsible for the administration and implementation of Inservice Inspection, steam generator inspection services and Quality Engineering activities. He has a direct communications link to the corporate QA staff in matters affecting quality.

Security Director - has been delegated the responsibility for plant security, industrial safety, and the fire protection and fitness for duty programs.

Nuclear Personnel Supervisor - has been delegated the responsibility for plant budgeting and administrative activities, and plant and corporate personnel issues.

SUPERINTENDENT-QUALITY ASSURANCE

He is responsible to the Senior Vice President-Nuclear Power for ensuring that an Operational Quality Assurance Program is developed, implemented, and maintained to meet the licensing requirements and management objectives. He is responsible for final review of changes to the OQAP and for final approval of changes to the Quality Assurance Directives. He is responsible for review of directives which

control activities affecting quality. He is independent of cost and scheduling considerations and has the authority and organizational freedom to identify quality problems, stop work on non-conforming activities associated with modifications (new construction) until deficiencies have been corrected; initiate, recommend or provide solutions, and verify implementation of corrective actions. The Superintendent- Quality Assurance maintains stop work authority for nonconforming activities associated with plant operations by reporting them to the Senior Vice President-Nuclear Power. He has responsibility for ensuring that functions and activities of the Quality Assurance Staff are controlled and performed in accordance with approved directives which implement the requirements of the OQAP.

The Superintendent-Quality Assurance shall as a minimum meet the requirements of ANSI N18.1-1971 and should have a minimum of a B. S. degree in Science or Engineering from an accredited college or university, a minimum of five years experience in power plant construction, engineering and/or plant operation, and a familiarity with codes and regulations.

NUCLEAR SAFETY REVIEW AND AUDIT COMMITTEE (NSRAC)

NSRAC is responsible to a Senior Company Officer for review and audit of plant related matters concerning safety. The requirements for personnel, committee composition, meeting frequency, quorum and meeting records shall be in accordance with the requirements of the plant Technical Specifications and the NSRAC Charter. The Committee periodically reviews the results of the Quality Assurance Staff audits and is responsible for conducting reviews as part of the Independent Technical Review Program.

PLANT OPERATIONS REVIEW COMMITTEE (PORC)

PORC is responsible to the Manager - Kewaunee Plant for providing advice on matters relating to nuclear safety at the plant. The requirements for personnel, committee composition, meeting frequency, quorum and meeting records shall be in accordance with the Technical Specifications and the PORC Charter. PORC is also responsible for conducting reviews as part of the Independent Technical Review Program.

QUALITY ASSURANCE TYPING COMMITTEE

This Committee is responsible to the Manager-Nuclear Engineering for classification of systems, structures and components within the nuclear power plant according to the importance of the function they serve with respect to plant safety and operability. The description of the committee's duties and authority shall be established in various directives and the QA Typing Committee Charter.

OTHER KEY GROUPS

The Substation and Transmission, and Power Systems Engineering Groups report to the Senior Vice President-Power Supply and Engineering. These groups are responsible to implement the OQAP as applicable whenever their work involves the nuclear power plant and are available for special projects in support of the nuclear power plant. The Emergency Preparedness Group reports to the Director - Governmental Affairs and Emergency Preparedness and is responsible for the maintenance of an effective emergency preparedness program for the Kewaunee Nuclear Power Plant.

2.0 QUALITY ASSURANCE PROGRAM

2.1 General

The Operational Quality Assurance Program complies with the requirements of 10CFR50, Appendix B, the provisions of ANSI N18.7-1976 and the Regulatory Guides which endorse the daughter standards required by ANSI N18.7-1976 with the exceptions, interpretations, and qualifications noted in Appendix A of this description. The requirements of the OQAP apply to those activities which affect the quality of structures, systems or components that prevent or mitigate the consequences of postulated accidents that could cause undue risk to the health and safety of the public. All structures, systems, and components are classified as QA Type 1, 2, 3 or NA according to their function and importance in relation to the safe operation of the reactor, with emphasis on the degree of integrity required to protect the public. The OQAP requirements are mandatory for all QA Type 1 items. QA Type 2 and 3 items, as determined by management, may require special control and an "X" modifier may be added to the QA2 or QA3 type designation. All components and/or systems which are identified as Safety Class I in the Safety Analysis Report shall be categorized as QA Type 1. All nuclear fuel and core components shall be categorized as QA Type 1. The definitions and a list of the Safety Class I, II and III structures, systems and components are found in the Kewaunee USAR Appendix B, Table B.2-1.

During construction, QA types were established for plant equipment by a QA typing committee. The QA types for equipment subsequently added to the plant are established by the Responsible Engineer who installs the equipment under the Design Change program. The Design Change program exists under the requirements of the OQAP. Therefore, the QA types of equipment added since construction are controlled under the OQAP and its definitions. A change to an established QA type must be approved by the QA Typing Committee.

2.2 Requirements

It is mandatory for all Wisconsin Public Service Corporation employees to comply with the OQAP. It is the responsibility of the management charged with the implementation of the program to inform personnel working for them that the quality policies, OQAP manual, and procedures have mandatory requirements which must be implemented and enforced. The Superintendent - Nuclear Training is responsible for conducting training sessions as necessary to keep individuals informed of policies and changes to the OQAP. The lesson plans for these training sessions will be prepared under the cognizance of the Quality Assurance Staff.

The OQAP shall be applied to all activities affecting safety-related functions and include: design changes, purchasing, fabricating, handling, shipping, storing, cleaning, erecting, installing, inspecting, testing, operating, maintaining, repairing, refueling, modifying, engineering, and training. The control over these activities shall be applied to an extent consistent with their importance to safety and shall take into account the need for special controls, processes, tests, equipment, tools, and skills to attain the required quality, and the need for verification of quality by inspection, evaluation, or test.

2.3 Structure

The OQAP manual is the top level quality program document for operational phase activities. The OQAP is a manual which incorporates the requirements of 10 CFR 50 Appendix B, the provisions of ANSI N18.7-1976 and ANSI N45.2.23-1978 and Regulatory Guides 1.8-Rev. 1, 1.30, 1.37, 1.38-Rev. 2, 1.39-Rev. 1, 1.54, 1.58-August, 1973, 1.64-Rev.2, 1.74, 1.88-Rev. 2 and 1.94. The requirements and responsibilities identified by the manual are implemented through directives, procedures, and instructions which prescribe activities affecting quality. Technical

reviews of directives are provided by department heads. Review of nuclear administrative directives for consistency with the OQAP is provided for by the Superintendent - Plant Quality Programs, or the Superintendent - Quality Assurance. Review of Quality Assurance Directives and Fuel Management Directives for consistency with the OQAP is provided by the Superintendent-Quality Assurance.

Quality Assurance Directives are reviewed and approved by the Superintendent-Quality Assurance and are prepared to govern Quality Assurance activities such as auditing, QA training, and other related activities.

Nuclear administrative directives are reviewed and approved by the appropriate responsible individual (i.e., the Senior Vice President-Nuclear Power, the Manager - Nuclear Engineering, the Manager - Kewaunee Plant, or the Manager - Nuclear Plant Support Services). These directives are prepared to govern activities affecting quality, such as design changes, procurement, licensing, training, document control, operation, procedure control, material control, maintenance, and other related activities.

Fuel Management Directives are reviewed and approved by the Vice President-Energy Supply and are prepared to govern fuel management activities affecting quality, such as fuel procurement, reactor core performance and analysis, core design, and other related activities.

2.4 Management Review

Management above or outside the Quality Assurance organization shall routinely be informed of the status and adequacy of the OQAP. Audits of implementing directives shall be conducted to verify conformance to the program. Nonconformances

or differences of opinion which cannot be settled between QA/QC and the department involved shall be brought to the attention of upper management for resolution.

2.5 Indoctrination and Training

A training program shall be established in order to provide for developing and maintaining a staff qualified to operate, maintain and provide the necessary technical support. The indoctrination and training program shall provide for:

- a. Training personnel responsible for performing quality-affecting activities as to the purpose, scope and implementation of the quality-related manuals, instructions, and procedures.
- b. Establishing the scope and depth of indoctrination and training to be provided commensurate with the level of quality-affecting activities being performed by an individual.
- c. Training personnel who perform quality-affecting activities in the principles and techniques of the activity being performed.
- d. Training and retraining on an as-needed basis to maintain a level of quality commensurate with the quality-affecting activity being performed.
- e. Maintaining records of training sessions, attendance and content of the training session.

3.0 DESIGN CONTROL

Modifications to systems that are nuclear safety related, or as described in the USAR, and considered significant for nuclear safety shall be controlled by a Design Change Program established by directives to ensure compliance with the existing design and the requirements of 10CFR50.59. Directives shall be prepared to augment the following aspects of the Design Control Program:

- a. Establish the structure, authority and responsibilities of the groups or positions involved in design change activities.
- b. Correctly translate design inputs into specifications, drawings, procedures, or instructions.
- c. Identify and select the appropriate quality standards in design documents.
- d. Select and review the suitability of materials, parts, equipment and processes essential to the safety-related functions of the structure, system, or component.
- e. Assure that computer software, which is an integral part of the operation of equipment, is designed, documented and tested adequately.
- f. Assure the change is subject to at least the same measures applied to the original design, and provide for a second level review.
- g. Assign the responsibilities of all organizations involved in the design process, both internal (WPS) and external (contractor, vendor) and ensure a method of exchanging technical information across internal and external interfaces.

PORC shall be responsible for reviewing proposed changes or modifications that affect nuclear safety. NSRAC shall review the safety evaluation of changes completed under the provision of 10CFR50.59 to verify that such actions do not constitute an unreviewed safety question.

4.0 PROCUREMENT DOCUMENT CONTROL

Measures shall be established in directives to provide for the preparation of procurement documents to ensure that applicable regulations, design bases, and other QA program requirements are included or referenced. Procurement documents shall include, as appropriate: the scope of work; technical requirements; documentation

requirements; requirements for hold and witness points; the allowance for access to supplier's facilities for review or audit of documentation or manufacturing procedures; and requirements that the supplier has a documented QA program in accordance with 10CFR50, Appendix B which includes a means for disposition of nonconformances.

The directives shall include measures to ensure that procurement documents are reviewed and approved by qualified and authorized personnel prior to release. The directives shall also provide assurance that the procurement document review includes a verification that quality requirements are stated in such a manner, that through either source surveillance and inspecting, supplier audits, or receipt inspection, the quality of the procured items may be verified.

5.0 INSTRUCTIONS, PROCEDURES, AND DRAWINGS

Measures shall be established in appropriate directives to control the preparation, format, content, and use of operating, test and maintenance procedures, and approvals for same. When required, they shall be prepared in sufficient detail to provide adequate guidance in performing activities affecting quality. These procedures shall include, as appropriate, initial conditions, step-by-step instructions, sign-off steps, acceptance criteria, etc., to ensure that activities affecting quality have been satisfactorily completed.

A Design Change Program shall be established by directives to assure that instructions, procedures, and drawings are used, where appropriate, to control activities associated with the modification of safety systems described in the USAR. These directives shall establish a method to update drawings, procedures, and other technical documents associated with the plant modification.

6.0 DOCUMENT CONTROL

The generation, distribution, and revisions of documents that establish specifications or activities affecting quality shall be controlled by formal directives. These directives shall provide for the following document control measures:

- a. Identification of individuals or organizations responsible for preparing, reviewing, approving, and issuing documents and revisions, thereto.
- b. Identifying and providing the proper documents to be used in performing safety-related activities.
- c. Establishing distribution.
- d. Establishing a method of providing up-to-date documents to the controlled files.

7.0 CONTROL OF PURCHASED MATERIAL, EQUIPMENT AND SERVICES

Suppliers of material, equipment and services, including suppliers of spare or replacement parts, shall be selected based on an evaluation of the supplier's capability to provide the purchased items or services in accordance with the requirements of the procurement documents. Directives shall include methods for source evaluation and selection. One or more of the following considerations shall be included for source evaluation: evaluation of the supplier's history of providing a product which performs satisfactorily in actual use; review of industry directories; review of whether the prospective supplier has a quality assurance program reviewed and inspected by the NRC under the Vendor Inspection Program; review of whether the prospective supplier has been recently audited by NUPIC (Nuclear Utilities Procurement Issues Committee) or similar third party inspection publication; review and evaluation of the supplier's Quality Assurance Program, Manual and Procedures, and the supplier's design and manufacturing capability; and a WPS survey of the prospective supplier's technical and

quality capability by directly evaluating his facilities, personnel and the implementation of his quality assurance program.

A Qualified Suppliers System shall be established and maintained by directives developed under criteria imposed by the Operational Quality Assurance Program. Material, equipment, or services purchased from suppliers not on the Qualified Suppliers System shall undergo a review and evaluation to ensure conformance to the acceptable criteria established by the Quality Assurance Program. Directives shall also establish control measures to ensure that documentary evidence of the conformance of material and equipment to procurement requirements is available prior to installation or use.

8.0 IDENTIFICATION AND CONTROL OF MATERIALS, PARTS, AND COMPONENTS

Controls established for procurement shall ensure that safety-related materials, parts, and components are purchased under the requirements and documentation established by the Operational Quality Assurance Program. Implementing directives shall provide for a documented receipt and inspection of incoming material and equipment, along with providing a system for identifying the status of acceptable items to ensure use and installation of only correct and acceptable materials. Identification and traceability of safety-related materials, parts, or components from issuance to installation within the plant shall be provided by this system.

9.0 CONTROL OF SPECIAL PROCESSES

Special processes including welding and non-destructive examination shall be accomplished under controlled conditions by qualified personnel, in accordance with

applicable codes, standards, specifications, criteria, and other special requirements. The Operational Quality Assurance Program is established to ensure compliance and implementation of these requirements.

10.0 INSPECTION

Concerning material receipt, directives shall establish a receipt inspection under the control of the Superintendent-Plant Quality Programs, which provides for visual examination, receipt of required documentation, verification of identification, and on-site technical inspection.

Concerning modifications, the Design Change Program provides for the following requirements: special processes, test, measuring and test equipment, and cleanliness. The work package shall be reviewed by site quality control personnel to ensure that the required special installation procedures are included in the package or properly referenced.

Verification of conformance to established requirements shall be performed by individuals or groups who do not have direct responsibility for performing the work being verified. Personnel or groups assigned responsibility for verification of inspection or testing shall be delineated in appropriate procedures and directives.

Plant personnel performing inspection, examination, and testing functions which are associated with normal operations of the plant and certain technical reviews normally assigned to the on-site operations organization shall be qualified to ANSI N18.1-1971.

Plant personnel who will be performing inspection, examination, and testing functions which are not associated with normal operations of the plant shall be trained

and qualified in accordance with the requirements of Regulatory Guide 1.58, "Qualification of Nuclear Power Plant Inspection, Examination and Testing Personnel", and 10CFR50.55a, Subsection g, "Inservice Inspection Requirements", which endorse, with specific exceptions, ANSI N45.2.6-1973, "Qualifications of Inspection, Examination and Testing Personnel for the Construction Phase of Nuclear Power Plants", except that QA experience cited for levels I, II, and III shall be interpreted to mean actual experience in carrying out the type of activity being performed. QC personnel will be qualified to these references with the noted exceptions.

WPS non-plant personnel who perform plant inspections, examinations and testing shall be trained and qualified in accordance with the above stated paragraph.

Additionally, this also applies to contract personnel working under the WPSC OQAP. Suitable review and acceptance must be made for qualification to other revisions or other standards the contractor's program may specify.

Training of personnel performing activities affecting quality shall be conducted to ensure that suitable proficiency is achieved and maintained.

11.0 TEST CONTROL

A preoperational test program was conducted to demonstrate that structures, systems, and components would perform up to quality standards. A continuing operational test program is being conducted in accordance with Technical Specification surveillance requirements to ensure the operability of safeguard and safety-related structures, systems, and components. Plant directives and procedures shall provide for the prerequisites, evaluation, and documentation of these test results.

When required, the Work Request and Design Change Program shall provide for the testing and evaluation of test results for replacement, repaired, or modified structures, systems, or components.

12.0 CONTROL OF MEASURING AND TEST EQUIPMENT

Measuring and test equipment and reference standards (calibration standards) used for measurements, tests and calibration respectively, shall be of the proper range and type and shall be controlled, calibrated and adjusted, and maintained at specified intervals or prior to use to assure the necessary accuracy of calibrated devices. The referenced standards used shall have an accuracy range and stability which are adequate to verify that the equipment being calibrated is within required tolerance. The reference standards used shall be adequate for the requirements of the equipment being calibrated, shall be recertified against higher level equipment of closer tolerance, and shall be traceable to nationally recognized standards. The method and interval of calibration for measuring and test equipment and reference standards shall be specified and shall be based on the type of equipment, its characteristics and other conditions affecting calibration.

When measuring and testing equipment or reference standards are found to be out of calibration, an evaluation shall be made of previous inspections and test results and acceptability of the items previously inspected.

13.0 HANDLING, STORAGE, AND SHIPPING

Nuclear administrative directives shall provide a system for material and equipment handled at and shipped from the plant to prevent damage, deterioration or loss. Where necessary, for sensitive or high value items, specific written instructions

or procedures will be utilized. Where necessary, special handling tools and equipment will be utilized.

Directives shall provide for special provisions for the control of items which might cause risk to the general public if damage should occur.

Directives shall also provide a system for controlling material during storage to prevent damage, loss, deterioration, or environmental damage. Housekeeping practices shall be controlled to prevent degradation in item quality.

14.0 INSPECTION, TEST, AND OPERATING STATUS

The measures required in this criteria are applied to two general categories, material control and operational control. Material control and the work request program are under the control of plant directives which are controlled under the cognizance of the QC Organization. All changes in procedures for these categories are reviewed by management. If the need for bypassing of a required inspection, test, or other critical operation occurs, it shall be procedurally controlled and reviewed by management.

14.1 Material Control

A receipt inspection at the plant site shall identify the status of acceptable items and shall provide for the control of uninspected and nonconforming items to ensure use and installation of only correct and acceptable materials. Physical identification shall be used to the maximum extent possible to identify the status of materials inspected. The system shall provide for documentation traceable to the item and segregation and disposition of nonconforming items to preclude misuse.

14.2 Operational Control

The work request program shall include provisions for taking equipment out of service, identification of that equipment, and precautions or prerequisites for returning that equipment to service. The work request and supplemental documents shall be reviewed by quality control personnel to ensure that special processes, inspection (hold and witness points) and testing requirements are adequately specified. They are also reviewed by operations personnel to determine the effect on plant operations, the proper tagging out of service of equipment, and the protection of personnel and equipment.

15.0 NONCONFORMING MATERIALS, PARTS, OR COMPONENTS

When a nonconforming item is identified during a receipt inspection, the condition shall be documented on a Nonconformance Report and the item identified or segregated to preclude misuse, further processing, or installation pending disposition. Nonconformance Reports will be controlled and evaluated by cognizant plant personnel for the determination of the disposition of nonconforming items. Nonconformance reports and dispositions shall be submitted to the responsible organization for implementation of corrective action. Provisions shall be established to ensure that items dispositioned as "repair" or "rework" shall be reinspected and require documentation verifying the acceptability of the item prior to release for use.

16.0 CORRECTIVE ACTION

Conditions adverse to quality, such as failures, malfunctions, deficiencies, deviations, defective materials and equipment, and nonconformances shall be identified by Nonconformance Reports and/or Incident Reports. These reports provide the mechanism for all personnel to notify management of conditions adverse to quality.

Measures shall be provided for the prompt processing of these reports to ensure expeditious investigation, evaluation, and implementation of corrective action. For situations determined to be significantly adverse to quality, investigations shall not only provide for identifying and correcting the condition, but also for determining the cause of the condition to ensure that corrective action is taken to preclude its reoccurrence.

Measures shall be established to ensure that Incident Reports are promptly prepared and reviewed for events which may be potentially reportable to the NRC. The Incident Report shall be evaluated by management for safety implications and Technical Specifications violations. The system shall provide for determination of corrective action to be taken, implementation of the corrective action, and final close out of the Incident Report.

Measures shall be established in Quality Assurance Directives to control audit findings. These measures shall include a description of the nonconformance or open-item, corrective action to be taken, response time, verification of implementation of appropriate corrective action, and close out of the deficiency generated as a result of audits. Corrective action taken for nonconformances and open-items shall be reviewed and verified. Disagreement between Quality Assurance and the audited organization regarding corrective action shall be pursued through responsible management with the final authority resting with the Senior Vice President-Nuclear Power.

Technical deficiencies and recommendations generated during technical reviews shall be documented with the report. Technical deficiencies and recommendations shall be submitted to the responsible manager (i.e., Manager-Nuclear Engineering, Manager-Kewaunee Plant, or the Manager-Nuclear Plant Support Services) for disposition as deemed necessary.

17.0 **QUALITY ASSURANCE RECORDS**

Directives shall be prepared to control records that are generated during the operation of the Kewaunee Nuclear Power Plant. These directives shall identify the types of records that are to be controlled including requirements for storage.

Records shall be primarily maintained in the QA Vault, the main records storage facility. Frequently used records, not stored in the QA Vault, will be filed in locked, fire-resistant cabinets with controlled access, or duplicate records will be maintained at remote locations.

Records shall be kept for the prescribed periods of time in accordance with the requirements of Technical Specifications or Regulations. Directives shall provide for a system that permits the retrieval of information in a reasonable amount of time.

18.0 **AUDITS**

Audits shall be conducted in accordance with Quality Assurance Directives to verify that the requirements of the QA program are being implemented. Audits shall be conducted on but not limited to power plant operating and maintenance activities, engineering staff activities, Fuel Management activities, Purchasing Department activities, and Supplier activities. Audits shall be performed by experienced personnel trained, in accordance with ANSI N45.2.23-1978, and independent of any direct responsibility of the activity being audited.

Preparation of procedures for audits, documentation of audit findings, and issuance of audit reports shall be described by applicable Quality Assurance Directives. Supervisory personnel of the audited activity shall review the audit report and provide

corrective actions. Follow-up action shall be provided for by the OQAP to ensure that corrective action is implemented and adequate.

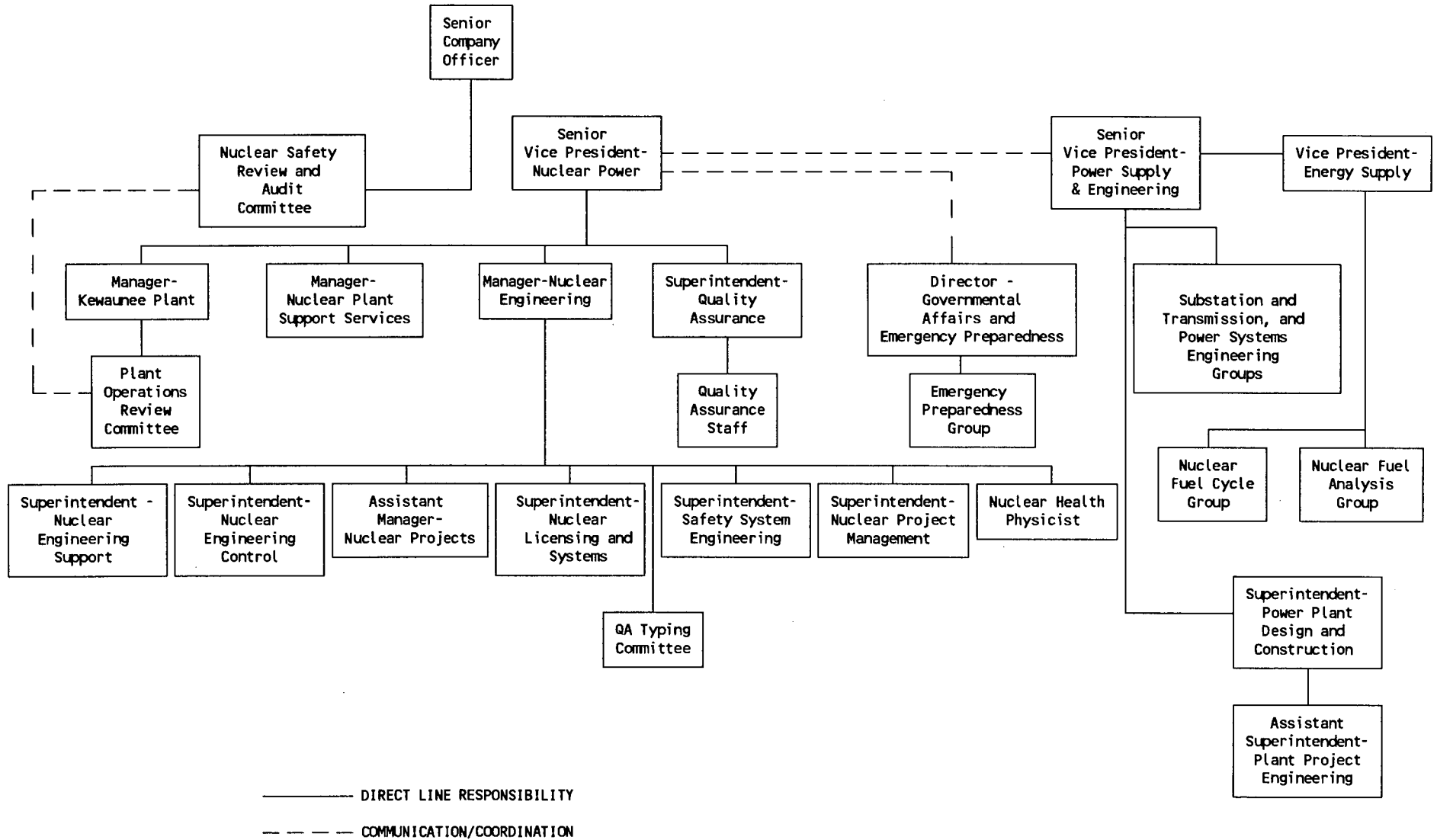
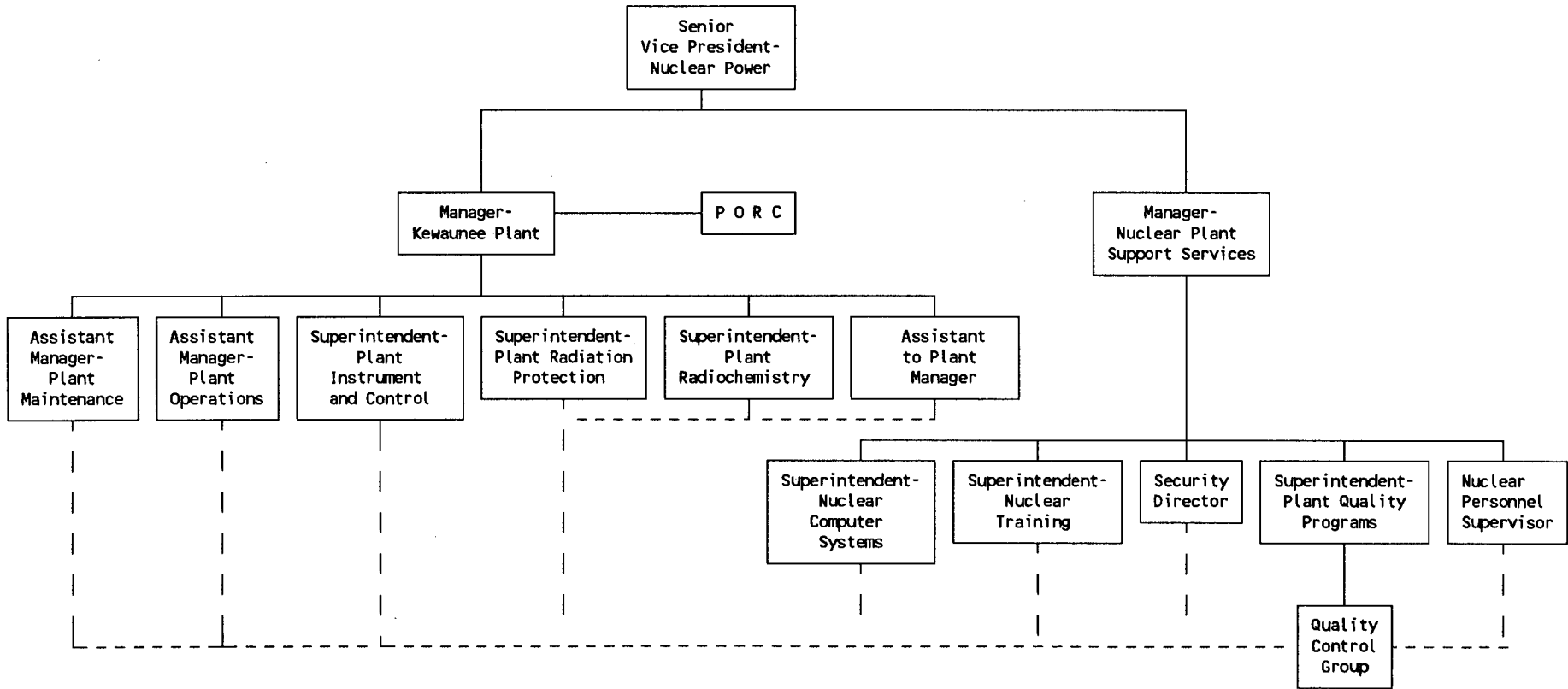


FIGURE 1
OFFSITE FUNCTIONAL QUALITY ASSURANCE ORGANIZATION



———— DIRECT LINE RESPONSIBILITY
- - - - COMMUNICATION/COORDINATION

APPENDIX A ANSI N18.7-1976 EXCEPTIONS, INTERPRETATIONS,
QUALIFICATIONS

GENERAL

ANSI N18.7-1976, "Administrative Controls and Quality Assurance for the Operational Phase of Nuclear Power Plants" is adopted to provide a basis for establishing an operational quality assurance program that meets the requirements of IOCFR50 Appendix B. This standard provides an acceptable means to satisfy the criteria of IOCFR50 Appendix B, but does not limit the use of alternate means to ensure safe operation of the plant. In this regard, those portions of this standard to which exceptions, interpretations and/or qualifications are taken are listed below.

Standards in general present objectives to be met with the method of implementation left general enough to provide for various interpretations for implementation. In the review of the program in accordance with the adoption of these new standards, many changes in implementation have been made. Where questions of interpretation were raised a conscientious interpretation has been formalized with the QA staff. Wherever future questions of interpretation arise they will be decided in a similar manner with continued disagreement being brought before corporate management for resolution.

When a short term or one time contradiction to the program is discovered, a non-conformance action will be taken within the QA organization to ensure a conscientious effort to maintain a quality level equivalent to the safety significance of the activity involved. When a long term or permanent contradiction to the program exists, a program change shall be implemented providing the same level of review as the adoption of this program, and the change will be submitted to the NRC.

Finally, wherever Technical Specifications overlap or contend with the administrative controls provided for in this program, the Technical Specifications will take precedence.

PARTICULAR EXCEPTIONS AND QUALIFICATIONS

ANSI N18.7-1976

Section

- 3.1 Administrative controls shall be established necessary to comply with this standard as adopted, with the exceptions, interpretations, and qualifications addressed in this transmittal.
- 5.2.7.2 This paragraph requires that design activities associated with modification of safety-related structures, systems, and components shall be accomplished in accordance with ANSI N45.2.11-1974. Compliance to apply this standard to those design activities and the provisions of this standard shall be employed as applicable to the degree of importance to safety for the design project under consideration. We shall also adopt the Regulatory Position of Regulatory Guide 1.64, Rev. 2, June 1976, as requested with an exception to position C.2. We will follow our existing practice that design verification should not be performed by the originator's supervisor, except where expertise is not available other than the supervisor immediately responsible for the design.
- 5.2.12 This section specifies that ANSI N45.2.9-1974, "Collection, Storage, and Maintenance of Quality Assurance Records for Nuclear Power Plants", shall be used for management of plant records during the operational phase. Compliance with the provisions of this standard and the Regulatory Position of Regulatory Guide 1.88, Rev. 2, October 1976, shall be deemed applicable to the nature and scope of the work being performed and the importance of the item or service involved with the exceptions noted below.

5.2.15 This section requires that plant procedures which govern safety-related activities shall be reviewed by an individual knowledgeable in the area affected by the procedure no less frequently than every two years to determine if changes are necessary or desirable. However, for procedures performed at a frequency interval greater than every two years (e.g., once every 5 years) the procedure shall instead be reviewed prior to use or within the previous two years.

ANSI N45.2.9-1974

Section

4.3 & 4.4 Concerning Receipt Control.

Nuclear Information Systems Group staff has been designated as the group responsible for receiving and storing records. This staff does not control which records are sent to them, however, there is a record index system identifying which records are under the control of the QA Program. We have assigned responsibility for assuring QA records are retained in the QA Vault to the various department heads. Also there is no log of incoming records. However, the previously-mentioned index is kept up to date and serves as a list of records received and retained. We have a procedure which partially covers the receipt control of records but none specifically for this action. We do not plan at this time to implement any further controls on the receipt of records.

ANSI N45.2.9-1974

Section

5.6 Concerning Permanent and Temporary Storage Facilities.

Criteria specified in this paragraph for those records stored in the QA Vault are met; however, the use of temporary storage facilities, the definition of a

working QA document and the transport of QA records to the vault differ. Several in-house generated QA documents/records are maintained in working files, e.g., NSRAC Meeting Minutes, training records and radiological survey data. These documents/records which we feel are working documents until no longer used on a routine basis are kept in locked, fire-proof file cabinets and are periodically transferred to the QA Vault. Duplication or filing in the vault would be unacceptable due to the quantity and frequent use of these documents. We find our handling of these documents acceptable due to the relative short duration of filing in temporary quarters and relative insensitivity of these documents to the safety of the plant. Finally, we do not have a courier service to immediately transfer a QA record just completed to the vault. Some records are transferred by personnel delivery and others through the routine in-company mail service. At this time we do not plan to implement any further controls on transferring documents to the QA Vault.