



UNITED STATES
ATOMIC ENERGY COMMISSION
DIRECTORATE OF REGULATORY OPERATIONS
REGION III
799 ROOSEVELT ROAD
GLEN ELLYN, ILLINOIS 60137

TELEPHONE
(312) 858-2660

January 8, 1973

Iowa Electric Light and Power Company
ATTN: Mr. Charles W. Sandford
Vice President, Engineering
Security Building
P. O. Box 351
Cedar Rapids, Iowa 52405

Docket No. 50-331

Gentlemen:

Thank you for your letter of December 14, 1972, informing us of the steps you have taken to correct the apparent violation which we brought to your attention in our letter dated November 13, 1972. We will examine this matter during our next inspection.

A copy of inspection report No. 050-331/72-09, referenced in our letter of November 13, 1972, is enclosed. In accordance with Section 2.790 of the AEC's "Rules of Practice," Part 2, Title 10, Code of Federal Regulations, a copy of this letter, our letter of November 13, your letter of December 14, and the enclosed inspection report will be placed in the AEC's Public Document Room. If the inspection report contains information which you or your contractors believe to be proprietary, it is necessary that you submit a written application to this office, within 20 days of the date of this letter, requesting that such information be withheld from public disclosure. If such an application is submitted, it must identify the basis for which information is claimed to be proprietary. The application should be prepared so that proprietary information identified is contained in a separate part of the application, since the application will also be placed in the Public Document Room. If we do not receive an application to withhold information, or are otherwise contacted within the specified time period, the enclosed report and the previously identified letters will be placed in the Public Document Room.

LB

Iowa Electric Light
and Power Company

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January 8, 1973

Unless you wish to make application to withhold information,
no reply to this letter is necessary; however, should you have
questions concerning the enclosed inspection report, we will
be glad to discuss them with you.

Sincerely yours,

Boyce H. Grier
Regional Director

Enclosure:
Inspection Report No.
050-331/72-09

bcc w/ltr dtd 12-14-72:
RO Chief, RCB
RO Chief, RT&OB
RO:HQ (4)
Licensing (4)
DR Central Files
OGC, Beth, P-506A
PDR
Local PDR
NSIC
DTIE

IOWA ELECTRIC LIGHT AND POWER COMPANY

General Office

CEDAR RAPIDS, IOWA

December 14, 1972
IE-72-756

C. W. SANDFORD
VICE PRESIDENT

Mr. Boyce H. Grier
Regional Director
U. S. Atomic Energy Commission
Directorate of Regulatory Operations
Region III
799 Roosevelt Road
Glen Ellyn, Illinois 60137

Re: Duane Arnold Energy Center #1
Subject: Weld Filler Metal Control Program Nonconformance
Files: A-110, Q-42

Dear Mr. Grier:

This letter is in response to your letter of November 13, 1972, specifically its enclosure, Docket No. 50-331. The enclosure described the apparent nonconformance in the weld filler metal control program, which resulted in the use of incorrect weld rod recirculation system pipe welds A-22 and B-10.

The purpose of this letter is to describe the corrective action by Iowa Electric Light and Power Company to resolve the problem and preclude recurrence. Dates are listed, which reflect when the corrective action began or was complete.

When IE QA personnel were notified by Bechtel QC personnel that incorrect weld filler metal had apparently been deposited in recirculation system pipe welds A-22 and B-10, it was determined that further work on welds A-22 and B-10 had been terminated.

Bechtel Non-Conformance Reports 636 and 637 were being written on welds A-22 and B-10 respectively, to control repair instructions. Further work could not proceed until the non-conformance reports containing filler metal removal procedures, repair procedures, and work verification procedures had been reviewed and approved by Bechtel Engineering, the ASME Code Inspector, and GE concurrence was obtained as per Bechtel Field Inspection Procedure G-3.

The status of repair work on welds A-22 and B-10 to date is as follows:

- a. In accordance with the provisions of Non-Conformance Report 636, weld A-22 has been completely ground out, checked for presence of carbon steel, re-welded with the correct filler metal, and non-destructively tested as of December 1, 1972. All tests demonstrate that the repair was successful.

DEC 24 1972

- b. As of December 13, 1972, weld B-10 has been ground to the extent that all carbon steel has been removed as indicated by tests for presence of carbon steel. The ground out areas are being rewelded with the correct filler metal. All work, and non-destructive testing is in accordance with the provisions of Non-Conformance Report 637. It is anticipated that the repair will be complete by December 15, 1972.

All related repair documentation, Inspection Reports, NDT Reports, Ferrite Content/Magnetometer Test Reports, and completed Non-conformance Reports will also be available for review at the DAEC.

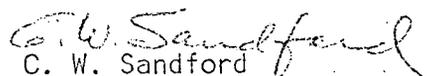
IE management and QA personnel investigated the situation and held two meetings and several discussions with Bechtel management, QA/QC, and welding personnel to determine the cause of the breakdown in the Bechtel weld filler metal control program. As a result of the above, the following corrective action to preclude recurrence was taken:

- a. Written instructions on filler metal control were issued to rod room attendants and welding personnel on November 7, 1972.
- b. An indoctrination program for welding personnel has been developed and put into effect on October 26, 1972. Twelve (12) meetings have been held to date.
- c. The Rod Issuance Cribs have been split with a wire fence barrier to segregate the Stainless Steel (SS) and Carbon Steel (CS) electrode storage and dispensing areas. The segregation was complete by October 25, 1972.
- d. The portable rod storage ovens and permanent ovens were physically segregated as of October 25, 1972.
- e. A program has been developed and put into effect for checking certain welds with a magnetometer on November 29, 1972; and will be completed before the system is hydrotested.
- f. IE QA personnel conducted an audit of Weld Filler Metal Control Program on October 31, 1972 through November 9, 1972.

In addition to the above, we are considering with Bechtel Engineering the possibility of revising Bechtel procedure WFMC-1 such that coated CS electrodes will be distinguishable from coated SS electrodes by color code, in addition to the rod number marked on the side of the rods. After a decision has been reached, the documentation thereof will be available for review at the DAEC.

If you have any further questions, please do not hesitate to contact us.

Yours truly,


C. W. Sandford
Vice President

GAC:CWS:hh

cc: Mr. L. D. Root
Mr. J. R. Newman
Mr. G. A. Cook