



UNITED STATES  
NUCLEAR REGULATORY COMMISSION  
REGION II  
245 PEACHTREE CENTER AVENUE NE, SUITE 1200  
ATLANTA, GEORGIA 30303-1257

December 10, 2013

Mr. B. L. Ivey  
Vice President, Regulatory Affairs  
Southern Nuclear Operating Company  
P.O. Box 1295  
Bin B022  
Birmingham, AL 35201

SUBJECT: SOUTHERN NUCLEAR OPERATING COMPANY, VOGTLE ELECTRIC  
GENERATING PLANT UNITS 3 AND 4 – NRC PERIODIC INSPECTION OF  
QUALITY ASSURANCE PROGRAM, REPORTS 05200025/2013-009 and  
05200026/2013-009

Dear Mr. Ivey:

On November 8, 2013, the U.S. Nuclear Regulatory Commission (NRC) completed an inspection at your Vogtle Electric Generating Plants Units 3 and 4. The enclosed inspection report documents the inspection results, which the inspectors discussed with Mr. Mark Rauckhorst, Vogtle 3 & 4 Construction Vice President, and other members of your staff on November 8, 2013.

The inspection examined the quality assurance (QA) program activities conducted under your license as they relate to safety and compliance with the Commission's rules and regulations and with the conditions of your license. Within this area, the inspection consisted of selected examination of procedures and representative records, observations of activities, and interviews with personnel.

No findings were identified during this inspection.

In accordance with 10 CFR 2.390 of the NRC's "Rules of Practice," a copy of this letter, its enclosure, and your response (if any) will be available electronically for public inspection in the NRC Public Document Room or from the Publicly Available Records (PARS) component of NRC's document system (ADAMS). ADAMS is accessible from the NRC Website at <http://www.nrc.gov/reading-rm/adams.html> (the Public Electronic Reading Room).

Should you have any questions concerning this letter, please contact us.

Sincerely,

**/RA/**

Michael Ernstes, Branch Chief  
Construction Projects Branch 4  
Division of Construction Projects

Docket Nos.: 5200025, 5200026

Licenses Nos: NPF-91, NPF-92

Enclosure: NRC Inspection Report  
05200025/2013-009 and  
05200026/2013-009  
w/Attachment: Supplemental  
Information

Should you have any questions concerning this letter, please contact us.

Sincerely,

**/RA/**

Michael Ernstes, Branch Chief  
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w/Attachment: Supplemental  
Information

PUBLICLY AVAILABLE

NON-PUBLICLY AVAILABLE

SENSITIVE

NON-SENSITIVE

ADAMS:  Yes      ACCESSION NUMBER: \_ML13344B203\_\_\_\_\_

SUNSI REVIEW COMPLETE     FORM 665

ATTACHED

OFFICE	RII: DCP	RII: DCI	RII: DCI				
SIGNATURE	E. Michel	D. Harmon	J. Seat				
NAME	ECM2	DMH3	DJS3				
DATE	12/10/2013	12/10/2013	12/10/2013				
E-MAIL COPY?	YES NO	YES NO	YES NO	YES NO	YES NO	YES NO	YES NO

OFFICIAL RECORD COPY      DOCUMENT NAME: G:\CCI\DCP\CPB4\PROJECT VOGTLE\INSPECTION REPORTS\INTEGRATED INSPECTION REPORTS\2013\2013-009\VOG QA INSPECTION REPORT 2013009.DOCX

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Letter to B. L. Ivey from Michael E. Ernstes dated December XX, 2013

SUBJECT: SOUTHERN NUCLEAR OPERATING COMPANY VOGTLE ELECTRIC  
GENERATING PLANT UNITS 3 AND 4 – NRC PERIODIC INSPECTION OF  
QUALITY ASSURANCE PROGRAM, REPORTS 05200025/2013-009 and  
05200026/2013-009

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PUBLIC



**U.S. NUCLEAR REGULATORY COMMISSION**  
**Region II**

Docket Numbers: 5200025  
5200026

License Numbers: NPF-91  
NPF-92

Report Numbers: 05200025/2013-009  
05200026/2013-009

Licensee: Southern Nuclear Operating Company

Facility: Vogtle Electric Generating Plant, Unit 3  
Vogtle Electric Generating Plant, Unit 4

Location: Waynesboro, GA

Inspection Dates: November 4, 2013 through November 8, 2013

Inspectors: Eric Michel, Senior Construction Inspector, RII DCP  
Darren Piccirillo, Senior Construction Project Inspector, RII DCP  
David Harmon, Construction Inspector, RII DCI  
Jamin Seat, Construction Inspector, RII DCI

Accompanying Personnel: None

Approved by: Michael Ernstes  
Branch Chief  
Construction Projects Branch 4  
Division of Construction Projects

Enclosure

## **SUMMARY OF FINDINGS**

Inspection Report (IR) 05200025/2013-009, 05200026/2013-009; 11/04/2013 through 11/08/2013; Vogtle Unit 3 Combined License, Vogtle Unit 4 Combined License; periodic quality assurance inspection report.

This report covers a one-week period of inspection by regional inspectors. No findings were identified. The purpose of this inspection was to verify implementation of the quality assurance program with a focus on safety-related construction work in progress. Inspectors followed the guidance of NRC inspection procedure 35007 – Quality Assurance Program Implementation During Construction and pre-Construction Activities.

### **A. NRC-Identified and Self Revealed Findings**

No findings were identified.

### **B. Licensee-Identified Violations**

No findings were identified.

## REPORT DETAILS

### CONSTRUCTION REACTOR SAFETY

**Cornerstones: Procurement/Fabrication, Construction/Installation, Inspection/Testing**

#### **2504 Inspection of Construction Programs**

1P01 IP 35007, "Quality Assurance Program Implementation during Construction and Pre-Construction Activities"

.1 Appendix 4, Inspection of Criterion IV – Procurement Document Control

a. Inspection Scope

The inspectors reviewed purchase order 132175-CE01.01, Revs. 0 and 1, for procurement of embedments from Cives Steel Company to verify that the purchase orders:

- required a QA program which met 10 CFR Part 50 Appendix B;
- required 10 CFR Part 21 for reporting;
- met the requirements of Shaw/CB&I procedure PROC-P-030, "Preparing and Issuing Purchase Orders," Rev. 01

The inspectors also reviewed contract documents for subcontractors Mistras (1321752004-1466) and MACTEC (1321751004-1421) to verify that they required a QA program which met 10CFR Part 50 Appendix B and 10 CFR Part 21 for reporting of defects.

b. Findings

No findings were identified.

.2 Appendix 9, Inspection of Criterion IX – Control of Special Processes

a. Inspection Scope

The inspectors toured the modular assembly building (MAB) welding filler metal storage and issuance station to verify that welding filler materials were adequately controlled. Specifically, the inspectors verified that:

- the station was free of food and drinks;
- materials were labeled, organized, and stored off the floor;
- shielded metal arc welding (SMAW) rods were kept in a temperature controlled oven after opening;
- the ovens were regularly monitored by calibrated measuring and test equipment (M&TE).

The inspectors observed SMAW of fillet weld SV3-CA04-S5K-CV2048-20-0007 to verify that it was welded in accordance with applicable codes and procedures. The inspectors verified that the welding procedure was readily available and that the current,

cleanliness, and welding technique met the welding procedure. The inspectors also verified that the welder had the correct filler material classification and size and that they had been issued from the filler metal station. The inspectors also verified that the welder and welding procedure were qualified in accordance with the American Welding Society (AWS) code and that the filler metal was traceable to a Certified Material Test Report (CMTR) that was in accordance with specification SFA-5.1.

The inspectors observed repair weld CV2066-1-RW1 on the CA04 module to verify it was being performed in accordance with the applicable code and procedure requirements. Specifically, the inspectors verified that:

- the welding current and filler material were in accordance with the welding procedure;
- the welder was qualified in accordance with the AWS code;
- the weld was appropriately cleaned before welding;
- the weld data sheet was properly filled out;
- the magnetic particle testing report of the repair cavity was adequately completed and signed off;
- the inspector who performed the magnetic particle test was qualified in accordance with their written practice for nondestructive examination (NDE) examiners.

The inspectors observed magnetic particle examination on weld SV3-CA04-S5K-CV2042-30-0011 to verify that it was performed in accordance with the applicable code and procedure requirements. Specifically, the inspectors:

- observed the calibration check lift test of the yolk;
- verified that the yolk was currently within calibration;
- observed that the examiners verified the temperature of the parts to be examined;
- verified that the parts to be examined were adequately cleaned prior to the examination;
- observed that the examiners verified their procedure with the pie wedge;
- verified that the examination was performed with complete coverage of the area of interest.

The inspectors reviewed duplex stainless steel welding procedure WPS5-10H.10HM70 Rev. 3, and supporting qualification records D-2010-10 and SP107, to verify that it was written and qualified in accordance with the applicable AWS welding code.

b. Findings

No findings were identified.

.3 Appendix 10, Inspection of Criterion X – Inspection

a. Inspection Scope

The inspectors reviewed a representative sample of Southern Nuclear Company (SNC), Chicago Bridge & Iron (CB&I), and Westinghouse Electric Company (WEC) QA documents associated with the inspection of safety-related and non-safety-related risk significant items. Specifically, the inspectors reviewed procedures, specifications,

inspection plans, and inspection reports, to verify compliance with the NRC-approved Quality Assurance Program Description and commitments in the Updated Final Safety Analysis Report.

The inspectors evaluated a sample of inspection implementation documentation associated with safety-related items that required inspection verification. Specifically, the inspectors reviewed Construction Quality Checklists (CQCs) and Inspection Plans for in-process and final inspections for safety-related concrete, reinforcing steel, and embedments within the Unit 3 nuclear island. The documents were evaluated to verify that they provided for, or identified, the following:

- examinations and measurements for each work operation, where necessary;
- frequency or points of inspection;
- holds/witness points;
- qualified inspection personnel who did not directly supervise or perform the work;
- acceptance criteria;
- final inspection of item or work operation to verify conformance with acceptance criteria;
- re-inspection when a deficiency or non-conformance is identified subsequent to final inspection.

The inspectors also evaluated a sample of completed inspection documents associated with safety-related construction. Specifically, the inspectors reviewed inspection reports for completed safety-related concrete, reinforcing steel, and embedments within the Unit 3 nuclear island. The inspectors reviewed completed work documents to verify the following were included:

- observation or type of method used to perform inspection;
- item inspected and date of inspection;
- identification of person conducting inspection;
- M&TE used during inspections;
- identification or reference to acceptance criteria, sampling plan, or reference documents used to determine acceptance;
- results or description of inspection performed;
- resolution of corrective actions for noted nonconformances or deficiencies.

b. Findings

No findings were identified.

.4 Appendix 14, Inspection of Criterion XIV – Inspection, Test, and Operating Status

a. Inspection Scope

The inspectors reviewed a representative sample of WEC QA implementing documents for the inspection, test, and operating status of materials, parts, equipment, and components. Specifically, the inspectors reviewed high level documents associated with the development and implementation of the Initial Test Program for Vogtle Units 3 and 4. The documents were evaluated to verify that they provide for the following:

- the status of inspections and tests performed on individual items was indicated on the item or on documentation traceable to the item;
- inspected/tested items were identified to indicate that they passed the required inspections/tests;
- items were properly designated to prevent inadvertent operation;
- authority for application and removal of tags, markings, labels, and stamps that indicate status.

b. Findings

No findings were identified.

**4. OTHER INSPECTION RESULTS**

4OA5 Other Activities

.1 (Closed) VIO 05200025/2013007-001, 05200026/2013007-001, Failure to Adopt Adequate Procedures to Identify Significant Breakdowns in Quality Assurance Programs

The inspectors reviewed the licensee's response for the previously issued violation VIO-05200025/2013-007-001, 05200026/2013-007-001, Failure to Adopt Adequate Procedures to Identify Significant Breakdowns in Quality Assurance Programs, using NRC IP 92702. Specifically, the inspectors reviewed the licensee's identified causes to ensure their adequacy. The inspectors also reviewed the licensee corrective actions, including their procedures and their contractor Westinghouse's procedures, for evaluating and reporting of defects under 10 CFR 50.55(e) to verify that the procedures were revised in a timely and adequate manner. The inspectors reviewed training attendance records and the training presentation provided for this issue to verify it adequately addressed the identified causes. Finally, the inspectors reviewed the corrective action program reports identified in IR 05200025/2013-007, 05200026/2013-007 which were originally evaluated under the inadequate SNC and WEC procedures (WEC issue report 12-062-M069, and SNC condition report 542665) to verify those reports did not identify a significant breakdown in the quality assurance program.

The inspectors determined that the licensee took adequate corrective actions to address this violation. No additional findings were identified. VIO 05200025/2013007-001, 05200026/2013007-001 is closed.

4OA6 Meetings, Including Exit

.1 Exit Meeting

On November 8, 2013, the inspectors presented the inspection results to Mark Rauckhorst, along with other licensee and consortium staff members. The inspectors stated that no proprietary information would be included in the inspection report. On December 3, 2013 the inspectors conducted a second exit meeting, by telephone, with Mike Yox and other licensee and consortium staff members.

## **KEY POINTS OF CONTACT**

### Licensee and Contractor Personnel

M. Rauckhorst, Vogtle 3 & 4 Construction Vice President  
S. Gray, Westinghouse Consortium Director  
B. Cline, Westinghouse, Safety Review Committee  
F. Willis, SNC, Licensing

## **LIST OF ITEMS OPENED, CLOSED, AND DISCUSSED**

<u>Item Number</u>	<u>Status</u>	<u>Type</u>	<u>Description</u>
05200025/2013007-001, 05200026/2013007-001	VIO	Closed	Failure to Adopt Adequate Procedures to Identify Significant Breakdowns in Quality Assurance Programs (Section 4A05.1)

## **LIST OF DOCUMENTS REVIEWED**

### Construction QA Criterion 4

Cives embedments purchase order 132175-CE01.01, Rev. 0  
Mistras subcontract 1321752004-1466  
MACTEC subcontract 1321751004-1421  
Shaw/CB&I procedure PROC-P-030, "Preparing and Issuing Purchase Orders," Rev. 01

### Construction QA Criterion 9

Welder performance qualification records: 2CS-03, 2CS-05c  
MT report V-13-MT-302-1064  
MT examiner qualification records 132175-1466—00127 and 132175-1466—00128  
Welding procedures: WPS5-10H.10HM70 Rev. 3, WPS2-1.1S01, Rev. 1  
Welding procedure qualification records: D-2010-10, SP107  
Shaw procedure GWS-2, "AWS D1.1 – Structural Steel, General Welding Specification," Rev. 1  
Shaw procedure GWS-5, "AWS D1.6 – Stainless Structural Steel General Welding Specification," Rev. 2.  
Westinghouse specification APP-VW20-Z0-023, "Welding Specification for ASTM A240 UNS S32101 Duplex Stainless Steel Plate," Rev. 3.  
Lincoln Electric certificate of conformance and CMTR for ER7018 welding electrodes heat number 1160A  
Weld data sheet for weld number SV3-CA04-S5K-CV2048-20-0007  
Condition Report CAR 2013-1883  
Westinghouse test report WCAP-17280-P, "Confirmatory Corrosion Testing of S32101/LDX 2101 Duplex Stainless Steel Base and Weld Materials for AP1000 Structural Module Applications," June 2010

### Construction QA Criterion 10

Procedures  
CB&I QAD 02.15, "Qualification and Certification of Inspection and Test Personnel," Rev. 003  
CB&I QAD 10.68, "Inspection Planning," Rev. 002  
CB&I QS 10.67, "Inspection Planning System," Rev. 002  
CB&I QSI 10.1-V, "Inspection Planning and Reporting," Rev. 003

### Drawings

SV3-0000-C9-001, AP1000 Concrete General Notes, Rev. 3  
 SV3-0000-C9-002, AP1000 Concrete General Notes, Rev. 3

### Corrective Action Reports

CAR 2012-0362, "Excessive E&DCRs posted to a drawing," 10/16/2012  
 CAR 2013-1678, "Excessive E&DCRs posted to a drawing," 10/14/2013  
 Service Request 730329, "NRC Minor Violation of Criterion V for excessive E&DCRs posted to a drawing," 11/08/2013

### Inspection Plans

F-C112-002, "Placement: Nuclear Island Concrete," Rev. 10  
 F-C113, "Placement and Grout: Safety Related Placing (Nuclear Island)," Rev. 7  
 F-C155-002, "Structural Steel: Submodule Fabrication," Rev. 0  
 F-S561-004, "Structural Weld Inspection-Modules, AWS D1.1/1.6," Rev. 6  
 CQC-K015, "Fabrication and Assembly of CA04 Upper Flange"  
 CQC-S001G, "CA04 Wall Submodule Assembly (01, 02, 03, 04, 05)"

### Inspection Reports

C112-002-13-0022, "Pre-Placement-Nuclear Island Concrete," 03/04/2013  
 C112-002-13-0053, "Pre-placement-Nuclear Island Concrete," 03/28/2013  
 C112-002-13-0054, "Pre-placement-Nuclear Island Concrete," 03/11/2013  
 C112-002-13-0055, "Pre-placement Nuclear Island Concrete," 03/28/2013  
 C112-02-12-0137, "NI-3 Auxiliary Building Battery Rack Embed Plate Headed Anchors,"  
 01/06/2012  
 C112-002-13-0010, "Pre-placement-Nuclear Island Concrete," 02/05/2013  
 C112-002-13-0020, "Pre-placement-Nuclear Island Concrete," 03/04/2013  
 S510-12-0052, "Cadweld Rebar Splices," 11/14/2013  
 S511-02-12-0001, "Shear Tie Terminator Installation," 06/11/2012  
 S511-001-13-0214, "Mechanical Rebar Splices-Threaded Lenton Coupler Slices/Weldable  
 Couplers," 10/30/2013

### Work Package

SV3-CA04-55W-CV1550, "Fabrication of Submodule CA04-05"  
 SV3-1200-CRW-CV1410, "Unit 3 Auxiliary Building EL. 66'-6" to 82'-6" Rebar for Walls 2,5,&6"  
 SV3-1220-CCW-CV1483, "Auxiliary Building Exterior Walls up to Elevation 82'6"

### Miscellaneous

Shaw Standard Nuclear Quality Assurance Program, Rev. B  
 Southern Nuclear Development Quality Assurance Manual, Version 11.0  
 Westinghouse Procedure APP-GW-GAP-420, "Engineering and Design Coordination Reports,"  
 Rev. 8  
 QC Inspector Weld Visual Testing Qualification Records (2)

### Construction QA Criterion 14

Westinghouse Procedure SV0-GW-GBH-360, "AP1000 Initial Test Program Commissioning  
 Program Plan for Vogtle Unit 3 & 4," Rev. 0,  
 Westinghouse Procedure SV0-GW-VTM-019, "Joint Test Working Group," Rev. 0  
 Westinghouse Procedure SV0-GW-VTM-022, "Initial Test Program Personnel Training," Rev. 0  
 Westinghouse Procedure SV0-GW-VTM-023, "Initial Test Program Document Processing,"  
 Rev.0



Follow Up of Licensee Reports and NOVs

SNC Letter, ND-13-0681, Southern Nuclear Operating Company, Vogtle Electric Generating Plant Units 3 & 4, Reply to Notice of Violation 2013-007-001

ND-LI-001, 10 CFR Part 21 and 10 CFR 50.55(e) Evaluating and Reporting of Defects and Noncompliance for Nuclear Development, Rev 10.0

ES 21.1, WEC 21.0 Level 3 Implementing Procedure, Rev 3

WEC 21.0, Identification and Reporting of Conditions Adverse to Nuclear Safety, Rev 8.0

WEC 21.0, Identification and Reporting of Conditions Adverse to Nuclear Safety, Rev 7.1

WEC Issue Report #12-062-M069, Design Compliance to Licensing Commitments, 03/02/2012

WEC Issue Report #13-275-M007, 10CFR50.55(e) evaluations, 10/02/2013

WEC Issue Report #13-032-M041, NRC Potential Violation on 10CFR50.55(e) Procedures and Implementation, 02/01/2013

Various SNC Training Attendance Sheets, March 2013

SNC TE 598491, NRC Potentially More than Minor Violation re: 10CFR50.55(e) evaluations, 02/28/2013

SNC CR 542665, Shaw Nuclear Source Inspection at SMS is Inadequate, 11/01/2012

**LIST OF ACRONYMS**

ADAMS	Agencywide Documents Access & Management System
AWS	American Welding Society
CB&I	Chicago Bridge & Iron
CFR	Code of Federal Regulations
CMTR	Certified Material Test Report
CQCs	Construction Quality Checklists
DCI	Division of Construction Inspection
DCP	Division of Construction Projects
IP	Inspection Procedure
IR	Inspection Report
M&TE	Measuring and Test Equipment
MAB	Modular Assembly Building
MT	Magnetic Particle Testing
NDE	Nondestructive Examination
NRC	Nuclear Regulatory Commission
QA	Quality Assurance
QC	Quality Control
RII	NRC Region II
SMAW	Shielded Metal Arc Welding
SNC	Southern Nuclear Operating Company, Inc.
WEC	Westinghouse Electric Company