

July 24, 2015

Mr. Dan Grannan, Quality Director
Specialty Maintenance and Construction, Inc.
A Division of Metaltek International
4015 Drane Field Rd.
Lakeland, FL 33811

SUBJECT: NUCLEAR REGULATORY COMMISSION VENDOR INSPECTION REPORT OF
SPECIALTY MAINTENANCE AND CONSTRUCTION, INC.
NO. 99901439/2015-201 AND NOTICE OF NONCONFORMANCE

Dear Mr. Grannan:

On June 8-12, 2015, the U.S. Nuclear Regulatory Commission (NRC) staff conducted an inspection at the Specialty Maintenance and Construction, Inc. (SMCI) facility in Lakeland, FL. The purpose of this limited-scope reactive inspection was to assess SMCI's compliance with selected portions of Appendix B, "Quality Assurance Criteria for Nuclear Power Plants and Fuel Reprocessing Plants," to Title 10 of the *Code of Federal Regulations* (10 CFR) Part 50, "Domestic Licensing of Production and Utilization Facilities." This technically-focused inspection specifically evaluated SMCI's implementation of quality activities associated with the fabrication of the embed plates for the CA-01 (steam generator and refueling canal modules) and CA-02 (independent wall structure connecting CA-1 and CA-03 (in-containment refueling water storage tank module)) modules for the Westinghouse Electric Company's AP1000 reactor design. The enclosed report presents the results of the inspection. This NRC inspection report does not constitute an NRC endorsement of SMCI's overall quality assurance (QA) program.

During this inspection, the NRC inspection team found that the implementation of SMCI's QA program failed to meet certain NRC requirements imposed on you by your customers. Specifically, the NRC inspection team determined that SMCI was not fully implementing its QA program in the areas of design control and control of special processes. The specific findings and references to the pertinent requirements are identified in the enclosure to this letter. In response to the enclosed notice of nonconformance (NON), SMCI should document the results of the extent of condition review for these findings and determine whether there are any effects on other safety-related components.

Please provide a written statement or explanation within 30 days of this letter in accordance with the instructions specified in the enclosed NON. The agency will consider extending the response time if you show good cause for us to do so.

In accordance with 10 CFR 2.390, "Agency Rules of Practice and Procedure," a copy of this letter, its enclosure(s), and your response will be made available electronically for public inspection in the NRC Public Document Room or from the NRC's Agencywide Documents Access and Management System (ADAMS), accessible at <http://www.nrc.gov/reading-rm/adams.html>. To the extent possible, your response (if applicable) should not include any personal privacy, proprietary, or Safeguards Information so that it can be made available to the public without redaction. If personal privacy or proprietary information is necessary to provide an acceptable response, please provide a bracketed copy of your response that identifies the information that should be protected and a redacted copy of your response that deletes such information. If you request that such material be withheld from public disclosure, you must specifically identify the portions of your response that you seek to have withheld and provide in detail the bases for your claim (e.g., explain why the disclosure of information will create an unwarranted invasion of personal privacy or provide the information required by 10 CFR 2.390(b) to support a request for withholding confidential commercial or financial information). If Safeguards Information is necessary to provide an acceptable response, please provide the level of protection described in 10 CFR 73.21, "Protection of Safeguards Information: Performance Requirements."

Sincerely,

/RA/ (MCheck for)

Edward H. Roach, Chief
Mechanical Vendor Inspection Branch
Division of Construction Inspection
and Operational Programs
Office of New Reactors

Docket No.: 99901439

Enclosures:

1. Notice of Nonconformance
2. Inspection Report No. 99901439/2015-201
and Attachment

In accordance with 10 CFR 2.390, "Agency Rules of Practice and Procedure," a copy of this letter, its enclosure(s), and your response will be made available electronically for public inspection in the NRC Public Document Room or from the NRC's Agencywide Documents Access and Management System (ADAMS), accessible at <http://www.nrc.gov/reading-rm/adams.html>. To the extent possible, your response (if applicable) should not include any personal privacy, proprietary, or Safeguards Information so that it can be made available to the public without redaction. If personal privacy or proprietary information is necessary to provide an acceptable response, please provide a bracketed copy of your response that identifies the information that should be protected and a redacted copy of your response that deletes such information. If you request that such material be withheld from public disclosure, you must specifically identify the portions of your response that you seek to have withheld and provide in detail the bases for your claim (e.g., explain why the disclosure of information will create an unwarranted invasion of personal privacy or provide the information required by 10 CFR 2.390(b) to support a request for withholding confidential commercial or financial information). If Safeguards Information is necessary to provide an acceptable response, please provide the level of protection described in 10 CFR 73.21, "Protection of Safeguards Information: Performance Requirements."

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DISTRIBUTION:

See next page.

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NRO-002

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NAME	NMcMurray	TFrye	ERoach (MCheck for)
DATE	07/06/2015	07/06/2015	07/24/2015

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Letter to Dan Grannan from Edward Roach dated July 24, 2015

SUBJECT: NUCLEAR REGULATORY COMMISSION VENDOR INSPECTION REPORT OF
SPECIALTY MAINTENANCE AND CONSTRUCTION, INC.
NO. 99901439/2015-201 AND NOTICE OF NONCONFORMANCE

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NOTICE OF NONCONFORMANCE

Specialty Maintenance and Construction, Inc.
4015 Drane Field Road
Lakeland, FL 33811

Docket No. 99901439
Report No. 2015-201

Based on the results of a U.S. Nuclear Regulatory Commission (NRC) inspection conducted at the Specialty Maintenance and Construction, Inc. (SMCI) facility in Lakeland, FL, on June 8, 2015, through June 12, 2015, certain activities were not conducted in accordance with NRC requirements that were contractually imposed on SMCI by its customers or NRC licensees:

- A. Criterion III, "Design Control," of Appendix B "Quality Assurance Program Criteria for Nuclear Power Plants and Fuel Processing Plants," to Title 10 of the *Code of Federal Regulations* (10 CFR) Part 50, "Domestic Licensing of Production and Utilization Facilities," states, in part, that "Measures shall be established to assure that applicable regulatory requirements and the design basis, as defined in 10 CFR 50.2, and as specified in the license application, for those structures, systems, and components to which this appendix applies are correctly translated into specifications, drawings, procedures, and instructions."

Criterion IX, "Control of Special Processes," of Appendix B to 10 CFR Part 50, states, in part, that "Measures shall be established to assure that special processes, including welding, heat treating, and nondestructive testing, are controlled and accomplished by qualified personnel using qualified procedures in accordance with applicable codes, standards, specifications, criteria, and other special requirements."

Section 3.8.3.6.2, "Nondestructive Examination," of Revision 18 of the AP1000 design certification document, which is incorporated by reference in the Combined License for Vogtle Electric Generating Plant (VEGP), Units 3 and 4 and Virgil C. (VC) Summer Generating Station, Units 2 and 3, states in part, that "Welds are visually examined for 100 percent of their length. Full penetration welds are inspected by ultrasonic or radiographic examination for 10 percent of their length. Partial penetration welds are inspected by magnetic particle or liquid penetrant examination for 10 percent of their length." In addition, Westinghouse Electric Company (WEC) design specification drawings, APP-GW-S9-104, "AP1000 Structural Modules General Notes - V," Revision 4, dated October 6, 2014, and APP-GW-S9-105, "AP1000 Structural Modules General Notes - VI," Revision 4, dated October 14, 2014, incorporate these requirements, and require a visual examination (VT), and magnetic particle (MT) or liquid penetrant (PT) examinations on both the reinforcing fillet weld and the partial joint penetration (PJP).

Contrary to the above, as of June 12, 2015, SMCI failed to transfer all the pertinent design requirements into the applicable instructions and failed to inspect welds in accordance with the applicable travelers and design specification drawings. Specifically;

1. SMCI did not adequately incorporate several general notes on NDE requirements from WEC design specifications drawings into all the applicable travelers. These general notes would require VT, and MT or PT examinations of both the reinforcing fillet weld and the PJP. By not correctly transferring nondestructive examination requirements to the SMCI travelers, partial penetration welds did not receive the required surface examinations required by the WEC design drawings.
2. SMCI only performed VT and MT examination of the reinforcing fillet weld that is applied over the PJP, and did not perform a VT and MT examination of the PJP as required by several general notes from design specification drawing APP-GW-S9-105. Not inspecting the PJP welds leaves the quality of welds to be indeterminate, and therefore affects how these welds would meet their design stress requirements and would perform their intended safety function.

This issue has been identified as Nonconformance 99901439/2015-201-01.

- B. Criterion IX, "Control of Special Processes," of Appendix B to 10 CFR Part 50, states, in part, that "Measures shall be established to assure that special processes, including welding, heat treating, and nondestructive testing, are controlled and accomplished by qualified personnel using qualified procedures in accordance with applicable codes, standards, specifications, criteria, and other special requirements."

SMCI procedure QP-9.0, "Weld Filler Metal and Consumable Control," Revision 2, dated August 16, 2013, provides several quality record requirements to document the use of weld wire, weld filler material, and other weld consumables.

Contrary to the above, as of June 12, 2015, SMCI failed to control welding consumable filler metal in accordance with applicable procedures and criteria. Specifically,

1. SMCI did not record on form WCIL-001 the weld filler metal that was issued for the time period of June 28, 2014, through July 11, 2014, as required by Qp-9.0, section 5.3.8. Because there are no entries on form WCIL-001 for the dates above, there is no objective evidence that the correct weld filler metal was used in production and there was adequate control of the welding filler metal for this time period.
2. During a review of traveler 926-CA01-00774, the NRC inspection team noted that a welder used weld filler metal to weld the beam seat that was not the weld filler metal he was issued and required to use. The use of the correct weld filler metal for welding the beam seat was not adequately controlled as required by QP-9.0, sections 5.3.8, 5.5.2, and 5.5.4.

The NRC inspection team noted that welders were not issued any weld filler metal for (a) welding on embed plates on October 8, 2014, for traveler 926-CA01-01156 for the CA-01 module for VEGP Unit 3, and (b) welding on embed plates on October 8, 2014,

for traveler 926-CA01-01162 for the CA-01 module for VC Summer Generating Station Unit 2. Weld filler metal issued to the welders for this work was not be recorded in form WCIL-001 as required by QP-9.0, sections 5.3.8, 5.5.2, and 5.5.4.

This issue has been identified as Nonconformance 99901439/2015-201-02.

Please provide a written statement or explanation to the U.S. Nuclear Regulatory Commission, ATTN: Document Control Desk, Washington, DC 20555-0001 with a copy to the Chief, Mechanical Vendor Inspection Branch, Division of Construction and Operational Programs, Office of New Reactors, within 30 days of the date of the letter transmitting this notice of nonconformance. This reply should be clearly marked as a "Reply to a Notice of Nonconformance" and should include for each noncompliance: (1) the reason for the noncompliance, or if contested, the basis for disputing the noncompliance; (2) the corrective steps that have been taken and the results achieved; (3) the corrective steps that will be taken to avoid future noncompliances; and (4) the date when your corrective action will be completed. Where good cause is shown, consideration will be given to extending the response time.

Because your response will be made available electronically for public inspection in the NRC Public Document Room or from the NRC's Agencywide Documents Access Management System (ADAMS), accessible through the NRC Web site at <http://www.nrc.gov/reading-rm/adams.html>, to the extent possible, it should not include any personal, privacy, proprietary, or Safeguards Information so that it can be made available to the public without redaction. If personal privacy or proprietary information is necessary to provide an acceptable response, then please provide a bracketed copy of your response that identifies the information that should be protected and a redacted copy of your response that deletes such information. If you request withholding of such material, you must specifically identify the portions of your response that you seek to have withheld and provide in detail the bases for your claim of withholding (e.g., explain why the disclosure of information will create an unwarranted invasion of personal privacy or provide the information required by 10 CFR 2.390(b) to support a request for withholding confidential commercial or financial information). If Safeguards Information is necessary to provide an acceptable response, please provide the level of protection described in 10 CFR 73.21, "Protection of Safeguards Information: Performance Requirements."

Dated this the 24th day of July 2015.

**U.S. NUCLEAR REGULATORY COMMISSION
OFFICE OF NEW REACTORS
DIVISION OF CONSTRUCTION INSPECTION AND OPERATIONAL PROGRAMS
VENDOR INSPECTION REPORT**

Docket No.: 99901439

Report No.: 99901439/2015-201

Vendor: Specialty Maintenance and Construction, Inc.
A Division of Metaltek International
4015 Drane Field Rd.
Lakeland, FL 33811

Vendor Contact: Mr. Dan Grannan
Quality Director
E-mail: Dan.Grannan@MetalTek.com
Phone: 863-644-8432

Nuclear Industry Activity: Specialty Maintenance and Construction, Inc. is under contract to Chicago Bridge & Iron to fabricate the embed plates for the CA-01 (steam generator and refueling canal modules) and CA-02 (independent wall structure connecting CA-1 and CA-03) (in-containment refueling water storage tank module) modules for the Westinghouse Electric Company's AP1000 reactor design.

Inspection Dates: June 8-12, 2015

Inspectors: Yamir Diaz-Castillo NRO/DCIP/MVIB Team Leader
Raju Patel NRO/DCIP/MVIB
John Honcharik NRO/DE/MCB
Nicholas McMurray NRO/DE/MCB
Kamishan Martin NRR/DRA/APHB

Approved by: Edward H. Roach, Chief
Mechanical Vendor Inspection Branch
Division of Construction Inspection
and Operational Programs
Office of New Reactors

EXECUTIVE SUMMARY

Specialty Maintenance and Construction, Inc.
99901439/2015-201

The U.S. Nuclear Regulatory Commission (NRC) staff conducted a reactive vendor inspection at the Specialty Maintenance and Construction, Inc. (SMCI) facility to verify that it had implemented an adequate quality assurance (QA) program that complies with the requirements of Appendix B, "Quality Assurance Criteria for Nuclear Power Plants and Fuel Reprocessing Plants," to Title 10 of the *Code of Federal Regulations* (10 CFR) Part 50, "Domestic Licensing of Production and Utilization Facilities." The NRC inspection team conducted the inspection from June 8-12, 2015. This was the third NRC inspection at the SMCI facility.

This technically-focused inspection specifically evaluated SMCI's implementation of quality activities associated with the fabrication of the embed plates for the CA-01 (steam generator and refueling canal modules) and CA-02 (independent wall structure connecting CA-1 and CA-03) (in-containment refueling water storage tank module) modules for the Westinghouse Electric Company's AP1000 reactor design. These modules are being fabricated for the Vogtle Electric Generating Plant (VEGP), Units 3 and 4 and Virgil C. (VC) Summer Generating Station, Units 2 and 3.

Some of the specific activities observed by the NRC inspection team included:

- Corrective Actions screening meeting
- initiation of a non-conformance report (NCR) using the new uniPoint electronic system
- rework and final quality control inspection performed on a T-section of the CA-03 module associated with NCR No. 150445 for VEGP Unit 3
- visual and magnetic particle examination on an embed plate, traveler No. 926-CA01-02417, weld Nos. 1 and 9, for VEGP Unit 3
- pre-heating and welding of a shear lug to an embed plate, traveler No. 926-CA01-01881 for VC Summer Generating Station Unit 2

The following regulation served as the basis for the NRC inspection:

- Appendix B to 10 CFR Part 50

During the course of this inspection, the NRC inspection team implemented Inspection Procedure 43003, "Reactive Inspections of Nuclear Vendors," dated October 3, 2013.

The information below summarizes the results of this inspection.

Manufacturing Control

The NRC inspection team issued Nonconformance 99901432/2015-201-01 in association with SMCI's failure to implement the regulatory requirements of Criterion III, "Design Control," and Criterion IX, "Control of Special Processes," of Appendix B to 10 CFR Part 50. Nonconformance 99901432/2015-201-01 cites SMCI for failing to transfer all the pertinent design requirements into the applicable instructions and for failing to inspect welds in accordance with the applicable travelers and design specification drawings. Specifically, SMCI did not incorporate a requirement that reinforcing fillet welds shall be subject to a magnetic particle (MT) or liquid penetrant testing in accordance with the design specification drawing and did not perform a visual examination and MT inspection of the partial joint penetration as required by the design specification drawing and Revision 18 of the AP1000 design certification document.

The NRC inspection team also issued Nonconformance 99901432/2015-201-02 in association with SMCI's failure to implement the regulatory requirements of Criterion IX of Appendix B to 10 CFR Part 50. Nonconformance 99901432/2015-201-02 cites SMCI for failing to control welding consumable filler metal in accordance with applicable procedures and criteria. Specifically, the NRC inspection team noted that the Weld Consumable Issuance Log (form WCIL-001) contained a two week period from June 28, 2014, to July 11, 2014, that did not contain any entries. In addition, the NRC inspection team found two examples of welders who were not issued filler metal on form WCIL-001 but recorded using filler metal on two different travelers. Furthermore, a welder was issued filler metal according to form WCIL-001, but recorded a different filler metal in the traveler.

Other Inspection Areas

The NRC inspection team determined that SMCI is implementing its programs for corrective action, nonconforming materials, parts, or components, and training and qualification of personnel in accordance with the applicable regulatory requirements of Appendix B to 10 CFR Part 50. Based on the limited sample of documents reviewed and activities observed, the NRC inspection team also determined that SMCI is implementing its policies and procedures associated with these programs. No findings of significance were identified.

REPORT DETAILS

1. Manufacturing Control

a. Inspection Scope

The U.S Nuclear Regulatory Commission (NRC) inspection team reviewed Specialty Maintenance and Construction, Inc. (SMCI's) policies and implementing procedures that govern the control of special processes program to verify compliance with the requirements of Criterion IX, "Control of Special Processes," of Appendix B, "Quality Assurance Criteria for Nuclear Power Plants and Fuel Reprocessing Plants," to 10 CFR Part 50, "Domestic Licensing of Production and Utilization Facilities," and with the requirements in the American Welding Society (AWS) D1.1, "Structural Welding Code - Steel" 2000 Edition, and AWS D1.6, "Structural Welding Code - Stainless Steel", 1999 Edition.

The NRC inspection team also reviewed a sample of welding and nondestructive examination (NDE) documents. The NRC inspection team observed a visual examination (VT) and magnetic particle examination (MT) on an embed plate, traveler number 926-CA01-02417, weld numbers 1 and 9, for Vogtle Electric Generating Plant (VEGP) Unit 3. The NRC inspection team also observed pre-heating and welding of a shear lug to an embed plate, traveler number 926-CA01-01881, for Virgil C. (VC) Summer Generating Station Unit 2.

The NRC inspection team discussed the special processes program with SMCI's management and technical staff. The attachment to this inspection report lists the documents reviewed by the NRC inspection team.

b. Observations and Findings

During the observation of the VT and MT performed on traveler No. 926-CA01-02417, the NRC inspection team reviewed the traveler note requirements for the NDE of the fillet and partial joint penetration (PJP) welds. The VT and MT were performed on the reinforcing fillet weld that is overlaid onto the PJP. For PJPs, Note 1 of SMCI's welding traveler, No. 926S-CA01-02417, states, in part, that "All welds to be Visually Examined (VT) for 100% of their length (PJP, & Fillets)," and Note 3 states, in part, that "PJP welds to be (MT) for 10 percent of their length or (1) weld per (10) 100 percent of length." The NRC inspection team then proceeded to review the Westinghouse Electric Company's (WEC) design drawings for the NDE requirements. WEC design specification drawings, APP-GW-S9-104, "AP1000 Structural Modules General Notes - V," Revision 4, dated October 6, 2014, and APP-GW-S9-105, "AP1000 Structural Modules General Notes - VI," Revision 4, dated October 14, 2014, state, in part

- General note 6.12.5 states that "All welds shall be visually examined for 100 percent of their length."
- General note 6.12.6 i states that "All fillet welds shall be visually examined (VT) for 100 percent of their length"

- General note 6.12.6 iii states that “Partial penetration welds shall be 10 percent (minimum) inspected by magnetic particle (MT) or liquid penetrant (PT) examination. The examination may be 10 percent of each weld or 100 percent of one weld in ten.”
- General note 6.12.6 iv states that “Reinforcing fillet welds for complete joint penetration and partial penetration welds shall be surface examined in accordance with 6.12.6 ii or 6.12.6 iii after the fillet weld is complete.”

Furthermore, Section 3.8.3.6.2, “Nondestructive Examination,” of Revision 19 of the AP1000 design control document (DCD), which is incorporated by reference in the Combined License for VEGP, Units 3 and 4 and VC Summer Generating Station, Units 2 and 3, states in part, that “Welds are visually examined for 100 percent of their length. Full penetration welds are inspected by ultrasonic or radiographic examination for 10 percent of their length. Partial penetration welds are inspected by magnetic particle or liquid penetrant examination for 10 percent of their length.” The NRC inspection team noted that the requirement in the WEC design drawing is consistent with the requirements in AP1000 DCD, section 3.8.3.6.2, which states that all welds be visually examined for 100 percent of their length and partial penetration welds are inspected by magnetic particle or liquid penetrant examination for 10 percent of their length.

SMCI did not incorporate general note 6.12.6 iv into all the applicable travelers where the combination of General Notes 6.12.5, 6.12.6 i, 6.12.6 iii, and 6.12.6 iv would require VT, and MT or PT examinations of both the reinforcing fillet weld and the PJP. By not correctly transferring nondestructive examination requirements to the SMCI travelers, partial penetration welds did not receive the required surface examinations required by the WEC design drawings. SMCI only performed VT and MT examination of the reinforcing fillet weld that is applied over the PJP, and did not perform a VT and MT examination of the PJP as required by design specification drawing APP-GW-S9-105, which include general notes 6.12.5, 6.12.6 i, and 6.12.6 iii. Not inspecting the PJP welds leaves the quality of welds to be indeterminate, and therefore affects how these welds would meet their design stress requirements and would perform their intended safety function. The NRC inspection team identified this issue as Nonconformance 99901432/2015-201-01 for SMCI’s failure to transfer the applicable design requirements into the applicable instructions and for failure to inspect welds in accordance with the applicable travelers and design specification drawings. SMCI initiated CAR No. 2015-321 to address this issue.

The NRC inspection team reviewed the control of weld filler metal and noted that Section 5.5.4 of SMCI procedure QP-9.0, “Weld Filler Metal And Consumable Control,” Revision 2, dated August 16, 2013, states, in part, that “Quality shall record the date, welder’s name, welder’s stamp, MI #, Heat #, Job #, the time the weld wire is released and the amount issued on the Weld Consumable Issuance Log (Form WCIL-001) when checking out weld wire.”

In addition, Section 5.3.8 of procedure QP-9.0, states, in part, that “Quality will record weld filler metal in the Control Box on the Weld Consumable Issuance Log (Form WCIL-001). This log shall be checked and updated every week by Quality to ensure an accurate count of the amount of weld filler metal available for each job.” Furthermore, Section 5.5.2 of procedure QP-9.0, states, in part, that “When a weld consumable is needed for a Nuclear or ASME Section III and ASME Section VIII job, the welder must have a Traveler for the job they are working on. Quality will review the Traveler with the welder to determine the correct weld consumable that is needed for the job.”

During the review of the Weld Consumable Issuance Log (form WCIL-001), the NRC inspection team noted that SMCI did not record weld filler metal for the time period of June 28, 2014, through July 11, 2014. Because there are no entries on form WCIL-001 for the dates above, there is no objective evidence that the correct welding filler metal was used in production and that there was adequate control of the welding filler metal for this time period. In addition, the NRC inspection team noted that SMCI’s welder No. 72 was issued filler metal MI-15765, Heat/Lot No. 10285 for welding a beam seat for module CA-01 (steam generator and refueling canal module) for VC Summer Generating Station Unit 2, on September 29, 2014, as recorded in Form WCIL-001. However, during a review of traveler 926-CA01-00774, the NRC inspection team noted that welder No. 72 used filler metal MI-15709, Heat/Lot No. 95138 to weld the beam seat, contrary to the filler metal he was issued and required to use. There is no objective evidence that the correct filler metal was used for welding the beam seat and that there was adequate control of the welding filler metal.

The NRC inspection team also found two examples where SMCI’s welders performed welding but there was no documentation available on form WCIL-001 in accordance with QP-9.0. Welder 121 welded on embed plates on October 8, 2014, for traveler 926-CA01-01156 for the CA-01 module for VEGP Unit 3. In addition, welders 121 and 140 welded on embed plates on October 8, 2014, for traveler 926-CA01-01162 for the CA-01 module for VC Summer Generating Station Unit 2. The NRC inspection team noted that welders 121 and 140 were not issued any welding filler metal for the dates above. There is no objective evidence that the correct welding filler metal was used for welding the embed plates and that there was adequate control of the welding filler metal.

For these three examples, use of the incorrect welding filler metal or a contaminated welding filler metal (if not adequately controlled) on safety related components that are not qualified may reduce the strength of the welds affecting the components’ ability to perform its intended safety function. The NRC inspection team identified this issue as Nonconformance 99901432/2015-201-02 for SMCI’s failure to control welding consumable filler metal in accordance with applicable procedures and criteria. SMCI initiated nonconformance report (NCR) Nos. 150528, 150532 and 150533 to address this issue.

During the observation of an MT examination on a plate coupler weld on traveler No. 926-CA01-02417, weld numbers 1 and 16, for VEGP Unit 3, the NRC inspection team found that the MT procedure, NPT-QAP-9C, did not specify the inspection area. The NDE inspector and the NDE Level III inspector stated that the area to be inspected is the weld including ½-inch from the toes of the welds. AWS D1.1 does not specifically specify a quantitative area to be inspected, but the area should be specified in the applicable procedures. SMCI initiated CAR 2015-318 to address this issue.

During the review of NDE inspector qualifications, the NRC inspection team observed that the complete qualification and training records for the NDE inspectors were not available at the SMCI facility. The NDE inspectors are subcontracted out to TEAM Industrial, which provides the NDE inspectors for SMCI. In addition, some of the NDE inspection qualification records that were available at SMCI were not consistent with the NDE inspector qualification records that are kept by TEAM Industrial. SMCI QAM, QP-2.0 and the QP-2.3 procedure for NDE qualifications requires that the records be located at the SMCI shop in order to verify that the NDE inspectors performing work on safety related components are qualified to applicable codes. SMCI initiated CAR 2015-327 to address this issue.

c. Conclusion

The NRC inspection team issued Nonconformance 99901432/2015-201-01 in association with SMCI's failure to implement the regulatory requirements of Criterion III, "Design Control," and Criterion IX of Appendix B to 10 CFR Part 50. Nonconformance 99901432/2015-201-01 cites SMCI for failing to transfer the applicable design requirements into the applicable instructions and for failing to inspect welds in accordance with the applicable travelers and design specification drawings. Specifically, SMCI did not incorporate a requirement that reinforcing fillet welds shall be MT or PT in accordance with the design specification drawing and did not perform a VT and MT inspection of the PJP as required by the design specification drawing.

The NRC inspection team also issued Nonconformance 99901432/2015-201-02 in association with SMCI's failure to implement the regulatory requirements of Criterion IX of Appendix B to 10 CFR Part 50. Nonconformance 99901432/2015-201-02 cites SMCI for failing to control welding consumable filler metal in accordance with applicable procedures and criteria. Specifically, the NRC inspection team noted that form WCIL-001 contained a two week period from June 28, 2014, to July 11, 2014, that did not contain any entries. In addition, the NRC inspection team found two examples of welders who were not issued filler metal on form WCIL-001 but recorded using filler metal on two different travelers. Furthermore, a welder was issued filler metal according to form WCIL-001, but recorded a different filler metal in the traveler.

2. Corrective Action

a. Inspection Scope

The NRC inspection team reviewed SMCI's policies and implementing procedures that govern the corrective action program to verify compliance with the requirements of Criterion XVI, "Corrective Action," of Appendix B to 10 CFR Part 50.

The NRC inspection team reviewed a sample of Corrective Action Reports (CARs) associated with the fabrication of the embed plates for the AP1000 design to verify the adequacy of SMCI's implementation and control of its corrective action program (CAP). The NRC inspection team also observed a Corrective Action Report Screening Committee meeting to determine whether SMCI's staff demonstrated sufficient knowledge of the CAP and whether the meeting provided an adequate review of the CARs, including proposed categorization (significant condition adverse to quality, condition adverse to quality, or other, as applicable), initiating of CARs to determine the appropriate classification of CARs as well as subsequent assignment for resolution of the identified problem or condition. The NRC inspection team also evaluated the adequacy of SMCI's implementation of corrective actions for addressing customer complaints and returns and SMCI's implementation of the corrective actions taken in response to the findings identified in a previous NRC inspection, as detailed in Inspection Report No. 999014398/2014-202. Furthermore, the NRC inspection team verified that SMCI's CAP provides a connection to SMCI's 10 CFR Part 21, "Reporting Defects and Noncompliance," program.

The NRC inspection team discussed the CAP with SMCI's management and technical staff. The attachment to this inspection report lists the documents reviewed by the NRC inspection team.

b. Observations and Findings

b.1 Corrective Action Associated with Nonconformance 99901439/2014-202-01

Following an October 2014 inspection, the NRC issued Nonconformance 999901439/2014-202-01 for SMCI's failure to ensure that significant conditions adverse to quality and conditions adverse to quality are promptly identified and corrected, and for failing to ensure that significant conditions adverse to quality were corrected to preclude repetition. Specifically, SMCI did not take adequate corrective actions in response to the findings from the August 2013 NRC inspection as documented in inspection report No. 99901439/2014-201.

In its response to the NRC dated December 19, 2014, SMCI stated that it had initiated CAR No. 2014-286 to document the causes and corrective actions for this issue. In addition, the response stated that: (1) a checklist for Weld Procedure Specifications (WPS) and Procedure Qualification Reports (PQR) was developed and included in Quality Procedure (QP) 3.2, "Engineering Change Notices," (2) the CAR electronic system was implemented on November 30, 2014, and (3) training was conducted on the new NCR procedure and the process for new work

instructions. SMCI's response also stated that to avoid future noncompliance, SMCI would: (1) revise QP 16.0, "Corrective Action," (2) establish frequencies for the Corrective Action Review Board and Management Review Board meetings, (3) provide additional CAR training to SMCI personnel, (4) restructure the CAR Tracking Database, and (5) complete an analysis for the CRA backlog and develop corrective action plans and due dates.

The NRC inspection team reviewed the documentation that provided the objective evidence for the completion of the corrective actions and confirmed that all the corrective actions were completed and adequately implemented as described in the response. Based on its review, the NRC inspection team closed Nonconformance 99901439/2014-202-01.

b.2 Corrective Action Associated with Nonconformance 99901439/2014-202-02

The NRC also issued Nonconformance 99901439/2014-202-02 for SMCI's failure to adequately identify, document, evaluate, segregate, disposition, and notify affected organizations of a nonconforming product. Specifically, SMCI avoided generating NCRs for all nonconforming conditions by extending the definition of "work in process" to justify rework of nonconforming conditions without proper documentation and did not generate an NCR for spool of wire that was checked into the controlled storage area by a member of SMCI staff in a known wetted condition.

In its response to the NRC dated December 19, 2014, SMCI stated that it had initiated CAR No. 2014-268 to document the causes and corrective actions for this issue. In addition, the response stated that training on the NCR process was conducted on small groups by department to ensure an adequate understanding on how to generate NCRs. SMCI's response also stated that to avoid future noncompliance, SMCI would: (1) review QP 5.3, "Travelers," to address the requirements for NCR generation as well as define "in process" work; (2) train SMCI personnel involved with fabrication and inspection on the definition of "in process" work.

The NRC inspection team reviewed the documentation that provided the objective evidence for the completion of the corrective actions and confirmed that all the corrective actions were completed and adequately implemented as described in the response. Based on its review, the NRC inspection team closed Nonconformance 99901439/2014-202-02.

b.3 Corrective Action Associated with Nonconformance 99901439/2014-202-03

The NRC also issued Nonconformance 99901439/2014-202-03 for SMCI's failure to establish adequate measures for the storage of Level D items. Specifically, the NRC inspection team identified several locations where Level D material was being stored that did not have proper drainage.

In its response to the NRC dated December 19, 2014, SMCI stated that it had initiated CAR No. 2014-281 to document the causes and corrective actions for this issue. In addition, the response stated that material storage areas that were identified by the NRC to have improper drainage have been graded or the material has been moved from the area. SMCI's response also stated that to avoid future noncompliance, SMCI would: (1) provide additional drainage piping along the east side of property to tie in to existing drainage system, (2) re-grade the area surrounding new paint building, (3) Conduct a full site survey for elevations and grading by an outside contractor, (4) develop a work instruction and train personnel for facility elevation monitoring, and (5) develop a surveillance plan and schedule for the monitoring of material storage throughout the facility.

The NRC inspection team reviewed the documentation that provided the objective evidence for the completion of the corrective actions and confirmed that all the corrective actions were completed and adequately implemented as described in the response. Based on its review, the NRC inspection team closed Nonconformance 99901439/2014-202-03.

b.4 Corrective Action Associated with Nonconformance 99901439/2014-202-04

The NRC also issued Nonconformance 99901439/2014-202-02 for SMCI's failure to assure that purchased material conformed to the procurement documents. Specifically, SMCI failed to verify that temperature indicating crayons, used in the fabrication of AP1000 safety-related components, were free of contaminants in accordance with the requirements of Appendix E, "Detrimental and Prohibited Material Control," of WEC document number, APP-GW-ZO- 602 "AP1000 Cleaning and Cleanliness Requirements of Equipment for Use in Nuclear Supply and Associated Systems," Revision 3, dated February 8, 2013.

In its response to the NRC dated December 19, 2014, SMCI stated that it had initiated CAR No. 2014-288 to document the causes and corrective actions for this issue. In addition, the response stated that (1) all consumable items that are used on nuclear projects have been identified and receipt inspected in accordance with SMCI approved procedures, (2) QP-WI-7.0, "Purchasing and Receiving Consumables on Nuclear Projects," was developed and training was conducted, (3) a letter was issued by Purchasing to all personnel on the requirements of purchasing consumable items in accordance with QP 4.0, "Purchasing," and (4) QP 7.1, "Receiving Instructions," was revised to address purchasing requirements of consumables.

The NRC inspection team reviewed the documentation that provided the objective evidence for the completion of the corrective actions and confirmed that all the corrective actions were completed and adequately implemented as described in the response. Based on its review, the NRC inspection team closed Nonconformance 99901439/2014-202-04.

c. Conclusion

The NRC inspection team determined that SMCI is implementing its CAP in accordance with the regulatory requirements of Criterion XVI of Appendix B to 10 CFR Part 50. Based on the limited sample of documents reviewed, the NRC inspection team also determined that SMCI is implementing its policies and procedures associated with the CAP. No findings of significance were identified.

3. Nonconforming Materials, Parts, or Components

a. Inspection Scope

The NRC inspection team reviewed SMCI's policies and implementing procedures that govern the control of nonconformances to verify compliance with the requirements of Criterion XV, "Nonconforming Materials, Parts, or Components," of Appendix B to 10 CFR Part 50.

For the sample of NCRs reviewed, the NRC inspection team verified that SMCI implemented an adequate program to assess and control nonconforming items, including appropriate identification, documentation, segregation, evaluation, and disposition of these items. The NRC inspection team also toured the shop floor to verify that there are designated areas to segregate nonconforming items and to verify the implementation of the corrective actions taken by SMCI to improve the nonconformance program.

The NRC inspection team interviewed several manufacturing and quality control (QC) inspectors and confirmed that QC inspectors have been initiating NCRs for all nonconforming conditions and that no in-process work was being performed without a NCR and a repair or rework traveler.

The NRC inspection team noted that SMCI has adopted a new electronic system for generating and managing NCRs called uniPoint. The NRC inspection team witnessed an SMCI QC inspector generate a NCR using the uniPoint software and documenting the NCR on a red-hold tag. In addition, the NRC inspection team confirmed that for all the red-hold tags attached to nonconforming items, that the red-hold tags contained all the relevant information as well as the associated NCR number documented. For a sample of repair and rework travelers, the NRC inspection team confirmed that the rework or repair was performed as a result of an NCR and that the completed work was signed and dated by the assigned craft personnel and QC inspectors.

The NRC inspection team discussed the nonconformance program with SMCI's management and technical staff. The attachment to this inspection report lists the documents reviewed by the NRC inspection team.

b. Observations and Findings

No findings of significance were identified.

c. Conclusion

The NRC inspection team determined that SMCI is implementing its nonconforming materials, parts, or components program in accordance with the regulatory requirements of Criterion XV of Appendix B to 10 CFR Part 50. Based on the limited sample of documents reviewed, the NRC inspection team also determined that SMCI is implementing its policies and procedures associated with the nonconforming materials, parts, or components program. No findings of significance were identified.

4. Personnel Training and Qualification

a. Inspection Scope

The NRC inspection team reviewed SMCI's policies and implementing procedures that govern the training and qualification program to verify compliance with the requirements of Criterion II, "Quality Assurance Program," in Appendix B to 10 CFR Part 50.

The NRC inspection team reviewed the training and qualification records for QC, and welding personnel to ensure that proficiency is achieved and maintained. The NRC inspection team verified that the QC and welding personnel were qualified in accordance the applicable requirements of SMCI's Quality Assurance Manual, AWS D1.1 and D1.6.

The NRC inspection team verified that all personnel performing activities affecting quality had completed the required training and met all the specified requirements in accordance with SMCI's policies and procedures.

The NRC inspection team discussed the training and qualification program with SMCI's management and technical staff. The attachment to this inspection report lists the documents reviewed by the NRC inspection team.

b. Observations and Findings

No findings of significance were identified.

c. Conclusion

The NRC inspection team determined that SMCI is implementing its training and qualification program in accordance with the regulatory requirements of Criterion II of Appendix B to 10 CFR Part 50. Based on the limited sample of documents reviewed, the NRC inspection team also determined that SMCI is implementing its policies and procedures associated with the training and qualification program. No findings of significance were identified.

5. Entrance and Exit Meetings

On June 8, 2015, the NRC inspection team discussed the scope of the inspection with Mr. Dave Masterson, SMCI's General Manager, and other members of SMCI's management and technical staff. On June 12, 2015, the NRC inspection team presented the inspection results and observations during an exit meeting with Robert Smickley, Chief Executive Officer for MetalTek International, and other members of SMCI's management and technical staff. The attachment to this report lists the attendees of the entrance and exit meetings, as well as those individuals whom the NRC inspection team interviewed.

ATTACHMENT

1. ENTRANCE AND EXIT MEETING ATTENDEES

Name	Title	Affiliation	Entrance	Exit	Interviewed
Robert Smickley	Chief Executive Officer	MetalTek International		X	
Bob Marshall	Executive Vice President, Energy Solutions	Specialty Maintenance & Construction, Inc. (SMCI)		X	
Dave Masterson	General Manager	SMCI	X	X	
Tim Maneval	Operations Manager	SMCI	X	X	
Dan Grannan	Quality Department Director	SMCI	X	X	X
Shawn Beck	Quality Control (QC) Manager	SMCI	X	X	
Gamal Handal	Engineering Manager	SMCI		X	X
Maricelli Rodríguez	Corrective Action Program Manager	SMCI	X	X	X
Lance Penn	Document Control Manager	SMCI	X	X	X
Chuck Veixer	Environmental Health Safety Manager	SMCI	X		
Russell Stone	Project Manager	SMCI	X	X	X
Chris Gates	QC Lead	SMCI	X	X	X
Chris Bopp	Mechanical Engineer	SMCI	X		
George Lynn	Supplier Quality	SMCI	X	X	X
Matthew Parks	Operations Supervisor	SMCI			X
Mark Gresham	Northeast Welding Supervisor	SMCI			X
Leonard Sparks	Project Manager	SMCI			X

Name	Title	Affiliation	Entrance	Exit	Interviewed
Keith Smith	Corrective Action Board Coordinator	SMCI			X
Lance Ginn	Quality Engineer	SMCI			X
Anthony Saputo	Level II QC Lead Inspector	SMCI			X
Susan Pierce	Level II QC Lead Inspector	SMCI			X
Drew Jeffries	QC Non-Destructive Examination (NDE) Inspector	SMCI			X
Josh Stamey	Welder	SMCI			X
Trehy Johnson	Welder	SMCI			X
Luke Hackney	Stud Welder	SMCI			X
John Bard	Project Quality Manager	SMCI			X
Louis Castro	Project Quality Manager	SMCI			X
Christopher Whitlock	Project Manager	TEAM Industrial			X
Mark Miller	QC Inspector	TEAM Industrial			X
Kyle Stevens	QC Inspector	TEAM Industrial			X
Ben Fox	NDE Level III	TEAM Industrial			X
Gary Pratt	Sr. Inspection Specialist	Chicago Bridge & Iron			X
Jason Hurst	Welding Engineer	Westinghouse Electric Company			X
Yamir Diaz-Castillo	Inspection Team Leader	NRC	X	X	
Raju Patel	Inspector	NRC	X	X	
John Honcharik	Inspector	NRC	X	X	

Name	Title	Affiliation	Entrance	Exit	Interviewed
Nicholas McMurray	Inspector	NRC	X	X	
Kamishan Martin	Inspector	NRC	X	X	

2. INSPECTION PROCEDURE USED

IP 43003, "Reactive Inspections of Nuclear Vendors," dated October 3, 2013

3. LIST OF ITEMS OPENED, CLOSED, AND DISCUSSED

Item Number	Status	Type	Description	Applicable ITAAC
99901439/2014-201-01	CLOSED	NON	Criterion IX	N/A
99901439/2014-201-02	CLOSED	NON	Criterion XV	N/A
99901439/2014-202-01	CLOSED	NON	Criterion XVI	N/A
99901439/2014-202-02	CLOSED	NON	Criterion XIII	N/A
99901439/2014-202-03	CLOSED	NON	Criterion XV	N/A
99901439/2014-202-04	CLOSED	NON	Criterion XVI	N/A
99901439/2015-201-01	OPENED	NON	Criterion III and IX	N/A
99901439/2015-201-02	OPENED	NON	Criterion IX	N/A

4. DOCUMENTS REVIEWED

Policies and Procedures

- SMCI's Quality Assurance Manual, Revision 7, dated February 20, 2015
- Quality Procedure (QP) -2.0, "Indoctrination, Training and Qualification of Personnel," dated October 12, 2012
- QP-2.3, "Written Practice for Qualification and Certification of NDT Personnel," Revision 0, dated March 24, 2014
- QP-5.3 "Manufacturing Travelers," Revision 3, dated March 13, 2015
- QP-6.0, "Document Control," Revision 4, dated June 5, 2015
- QP-9.0, "Weld Filler Metal and Consumables Control," Revision 7, dated March 20, 2015
- QP-Work Instruction (WI)-9.1, "Magnetic Particle Examination," Revision 4, dated April 9, 2015
- QP-WI-9.1-ADD-1, "Magnetic Particle Examination Addendum 1 AWS D1.1 2000 Edition," Revision 1, dated April 9, 2015
- QP-WI-9.2, "Visual Examination," Revision 5, dated April 9, 2015
- QP-WI-9.2-ADD-1, "Visual Examination Addendum 1 AWS D1.1 2000 Edition," Revision 1, dated April 9, 2015
- QP-15.0, "Nonconformances," Revision 2, dated May 9, 2014
- QP-15.1, "Originating Nonconformance Reports Using Unipoint," Revision 1, dated March 17, 2015
- QP-15.2, "Documenting Disposition of Nonconformances Using Unipoint," Revision 1, dated March 17, 2015
- QP-16.0, "Corrective Action," Revision 3, dated March 2, 2015
- QP-WI-16.2, "Casual Analysis," Revision 0, dated May 9, 2014
- QP-WI-16.3, "Trending Analysis," Revision 1, dated March 16, 2015
- QP-WI-16.4, "Customer Concerns," Revision 0, dated April 7, 2015
- QC Form Review Checklist, dated April 14, 2015

- NPT-QAP-9C, “Magnetic Particle Testing,” Revision A, dated March 21, 2011

Design Documents

- Westinghouse Electric Company APP-CA20-GEF-1305, “Weld Examination Clarification, Revision 0, dated August 4, 2014
- APP-GW-S9-104, “AP1000 Structural Modules General Notes - V”, Revision 4, dated October 6, 2014
- APP-GW-S9-105, “AP1000 Structural Modules General Notes – VI”, Revision 4, dated October 14, 2014
- SD-CA01-A36, “A36 Beam Seat,” Revision 1, dated August 13, 2014

Calibration, Inspection, Material, and Welding Records

- Certificate of Calibration, “Magnaflux White Light Meter 130402614,” dated April 15, 2015
- Certificate of Calibration, “Precision Metrology South Temperature Humidity Meter Extech 445815,” dated January 6, 2015
- Certificate of Certification, “No. 2 Yellow Powder. Batch: 14J015,” dated September 4, 2014
- Certification of Compliance/Conformance, “Spooled Wire, .045” x 33lb spools, ESAB, E7Ab, E71T-1M/12MJH4 Lot# 100285,” dated January 28, 2014
- Welding Machine Qualification Record, “Lincoln Flextec 450 Unit #146,” dated July 8, 2014
- Traveler No. 926-CA01-00889, dated September 5, 2014
- Traveler No. 926-CA01-01162, dated September 24, 2014
- Traveler No. 926-CA01-00232B, dated September 25, 2014
- Traveler No. 926-CA01-00774A, dated October 2, 2014
- Traveler No. 926-CA01-01156A, dated October 28, 2014
- Traveler No. 926-CA01-00718, dated January 17, 2015
- Traveler No. 926-CA01-01881, dated May 19, 2015
- Traveler No. 926-CA01-02417, dated May 20, 2015

Welding Procedure Specifications (WPS) and Supporting Procedure Qualification Records (PQR)

- WPS No. 1006, Revision 9, dated February 27, 2015
 - PQR No. 1006, Revision 3, dated February 26, 2015
 - PQR No. 1033, Revision 3, dated February 27, 2015
 - PQR No. 1034, Revision 3, dated February 27, 2015
 - PQR No. 1083, Revision 1, dated February 27, 2015
- WPS No. 1048, Revision 4, dated February 27, 2015
 - PQR No. 1006, Revision 3, dated February 26, 2015
 - PQR No. 1083, Revision 1, dated February 26, 2015
 - PQR No. 1048-#7, Revision 4, dated February 27, 2015
 - PQR No. 1048-#11, Revision 3, dated February 27, 2015
- WPS No. 1087, Revision 3, dated April 15, 2015
 - PQR No. 1087, Revision 1, dated February 18, 2015
- WPS No. 1014, Revision 6, dated March 22, 2014
- WPS No. 1030, Revision 1, dated December 20, 2013

Nonconformance Reports

- 140849, 140493, 140962, 150131, 150201, 152369, 152372, 150393, 150398, 150407, 150419, 150422, 150429, 150432, 150434, 150437, 150440, 150457, 150463, 150467, 150468, 150475, 150478, 150488, 150495, 150499, 150500, 150501, 150503, 150506, 150507, 150509, 150528, 150532, and 150533

Corrective Action Reports

- 2014-243, 2014-268, 2014-281, 2014-286, 2014-288, 2014-311, 2015-005, 2015-026, 2015-030, 2015-069, 2015-079, 2015-080, 2015-090, 2015-097, 2015-103, 2015-115, 2015-116, 2015-119, 2015-131, 2015-134, 2015-156, 2015-163, 2015-166, 2015-171, 2015-172, 2015-173, 2015-174, 2015-196, and 2015-311

Corrective-Action Reports Generated during the NRC Inspection

- 2015-318, 2015-321, 2015-323, 2015-325, 2015-326, 2015-327, and 2015-328

Training and Qualification Records

- Training and qualification records for the following nondestructive examination and Quality Control personnel: Anthony Osagie, Anthony Saputo, Ben Fox, Christopher Kaufman, John Davis, Jonathan Wood, Kyle Stevens, Susan Pierce, and Youa Daoheuang
- AWS D1.1 Welder Performance Qualification Report, dated May 27, 2015
- AWS D1.6 Welder Performance Qualification Report, dated May 27, 2015
- Bulk Continuity Report (Form BCR-001), dated June 12, 2015
- Demotto, Dale (Welder ID No. (WID) 140)WPS No.1046, Revision 1, dated June 26, 2014
 - WPS No. 1046 (Bug-O), Revision 1, dated June 19, 2014
- Martinez, Joe (WID No. 121)
 - WPS No. 1015 Revision 2, dated June 2, 2014
 - WPS No. 1046 Revision 1, dated July 23, 2014
 - WPS No. 1046 (Bug-O) Revision 1, dated July 23, 2014
- Mendez, Oscar (WID No. 104)
 - WPS No. 1046 Revision 1, dated June 19, 2014
 - WPS No. 1037 Revision 0, dated March 9, 2015
 - WPS No. 1042 Revision 1, dated March 9, 2015
 - WPS No. 1038 Revision 0, dated March 9, 2015
 - WPS No. 1015 Revision 3, dated March 9, 2015
- Montemurro, Ameil (WID No. 185)
 - WPS No. 1046 Revision 1, dated August 15, 2014
- Trehy, Johnson (WID No. 166)
 - WPS No. 1046 (Bug-O) dated Revision 1, dated March 16, 2015
 - WPS No. 1087 Revision 1, dated April 8, 2015
 - WPS No. 1046 Revision 1, dated April 16, 2015
 - WPS No. 1115 Revision 0, dated May 29, 2015
- Weaver, Steve (WID NO. 005)
 - WPS No. 00008 Revision 0, dated August 21, 2013
 - WPS No. 1042 Revision 1, dated April 14, 2014
 - WPS No. 1046 Revision 1, dated June 19, 2014
 - WPS No. 1015 Revision 1, dated January 21, 2015
 - WPS No. 1115 Revision 0, dated May 18, 2015
- Welding Filler Metal Log, dated January 1, 2014 through June 12, 2015

Miscellaneous

- Trend Analysis Report, “Corrective Action Reports and Nonconformance Reports,” dated January 1, 2014 through September 30, 2014
- Trend Analysis Report, “ Corrective Action Reports and Nonconformance Reports,” dated October 1, 2014 through December 21, 2014
- Trend Analysis Report, “Corrective Action Reports and Nonconformance Reports,” dated January 2015 through March 2015
- SMCI Final Test Report for the Unipoint NCR Software, Version 2014.1.1, dated November 18, 2014
- SMCI Training for QP-5.3, “Manufacturing Travelers,” performed on March 5, 2015
- SMCI Training for QP-WI-16.3, “Trending Analysis; Compensatory Action Plan CAR No. 2014-094,” Revision 0, performed on August 25, 2014
- Training records on the following documents: QP 6.0, QP-WI-15.1, QP-WI-15.2, QP-15.3 QP-WI-16.4, CAR 2014-187, CAR 2014-215, and CAR 2014-216
- Training record for NCR process and Unipoint originator, dated May 20, 2015
- Training record for Revision 1 to NCR work instruction for Project Managers and Project Quality Managers, dated April 24, 2015
- Red hold tag for Job No. CA01-9330 associated with NCR No. 141027, dated December 4, 2014
- Red hold tag for Job No. 923S13 for CA03 Module 06 head assembly associated with NCR No. 150337, dated March 31, 2015
- Red hold tag for Job No. 931S14 associated with NCR No. 150398, dated May 1, 2015
- Red hold tag for Job No. 926S14 associated with NCR No. 150439, dated May 12, 2015
- Red hold tag for Job No. 919S13 associated with NCR No. 150480, dated May 20, 2015
- Red hold tag for Job No. 923S13 for CA03 Module 14 associated with NCR No. 150502, dated June 11, 2015
- Red Hold tag for Job No. 943S15 associated with NCR No. 150506, dated June 2, 2015

- Red Hold tag for Job No. 919S13 associated with NCR No. 150515, dated June 4, 2015
- Red hold tag for Job No. 93112721/E21941 associated with NCR No. 150524, dated June 10, 2015
- Red hold tag for Job No. SV3-CA02-109-2 associated with Notice of Unsatisfactory Condition (NOUC) No. 1672 with NCR No. 150527, dated June 10, 2015
- Red hold tag for Job No. 92601486 associated with NCR No. 150537, dated April 6, 2015
- Straightening Job Traveler No. 926-CA01-00735A for straightening of CA01 Ledger Angle associated with CAR No. 2015-215, dated April 17, 2015
- Rework Job Traveler No. 926-CA01-00735B for CA01 ledger angle associated with NCR No. 15032, dated April 23, 2015
- Rework Job Traveler No. 926-CA02-00099A for CA02 ledger angle associated with NCR No. 150490 dated May 29, 2015
- Rework Job Traveler No. 923-02086 for CA03-T section associated with NCR No. 150445, dated May 18, 2015
- Rework Job Traveler No. 923-02066 for CA03 associated with NCR No. 150445, dated May 18, 2015
- Rework Job Traveler No. 923-02060 for CA03 associated with NCR No. 150445, dated May 13, 2015
- SMCI Internal Memo, "Nonconformance and In-Process Inspections," dated December 15, 2014
- Letter from Gary D. Cook, CB&I Project Manager, to Dave Masterson, SMCI General Manager, "Mechanical Rebar Coupler Welds Quality Concerns," dated December 23, 2014
- Letter from Gary D. Cook, CB&I Project Manager, to Dave Masterson, SMCI General Manager, "CA20 Deformed Wire Anchor Welds Destructive Examination," dated May 12, 2015
- Letter from John Mohr, SMCI Quality Director, to Gary D. Cook, CB&I Project Manager, "SMCI Coupler Welding," dated March 9, 2015
- Inspection tickets associated with traveler Nos. 01699, 1213, and 1202
- Chicago Bridge & Iron (CB&I) SMCI NOUC log No. 132177-D100.CB001

- CB&I SMCI NOUC log No. 132177-D100.CA006
- CB&I SMCI NOUC log No. 132175-D100.CA007
- CB&I SMCI NOUC log No. 132175-D100.CA007
- Storm Water log from February 5, 2015 to June 2, 2015
- Storm Water Pollution Prevention Plan drawing, dated April 10, 2015
- MetalTek/SCI Quality Assurance (QA) Internal Surveillance Report & Checklist, dated February 20, 2015
- MetalTek/SMCI QA Internal Surveillance Report & Checklist, dated March 16, 2015
- MetalTek/SMCI QA Internal Surveillance Report & Checklist, dated May 14, 2015