

PP&L

TWO NORTH NINTH STREET, ALLENTOWN, PA. 18101 PHONE: (215) 821-5151

April 30, 1979

Mr. Robert T. Carlson
Chief FS & ES Branch
U. S. Nuclear Regulatory Commission
621 Park Avenue
King of Prussia, Pennsylvania 19406

SUSQUEHANNA STEAM ELECTRIC STATION
NRC INSPECTION OF FEBRUARY 12-15, 1979
REPORT NOS. 50-387/79-04 & 50-388/79-03 (COMBINED)
ERs 100450/100508 FILE 840-4
PLA-348

Dear Mr. Carlson:

Reference is to your letter of March 2, 1979 forwarding IE Inspection Report Nos. 50-387/79-04 & 50-388/79-03 and Enclosure (1) thereto, "Appendix A, Notice of Violation".

Your letter advised that PP&L was to submit within 30 days of receipt, a written explanation addressing (1) corrective steps which have been taken and the results achieved, (2) corrective steps which will be taken to avoid further items of noncompliance, and (3) the date when full compliance will be achieved.

The Notice of Violation (infraction) states as follows and the corrective measures are detailed below:

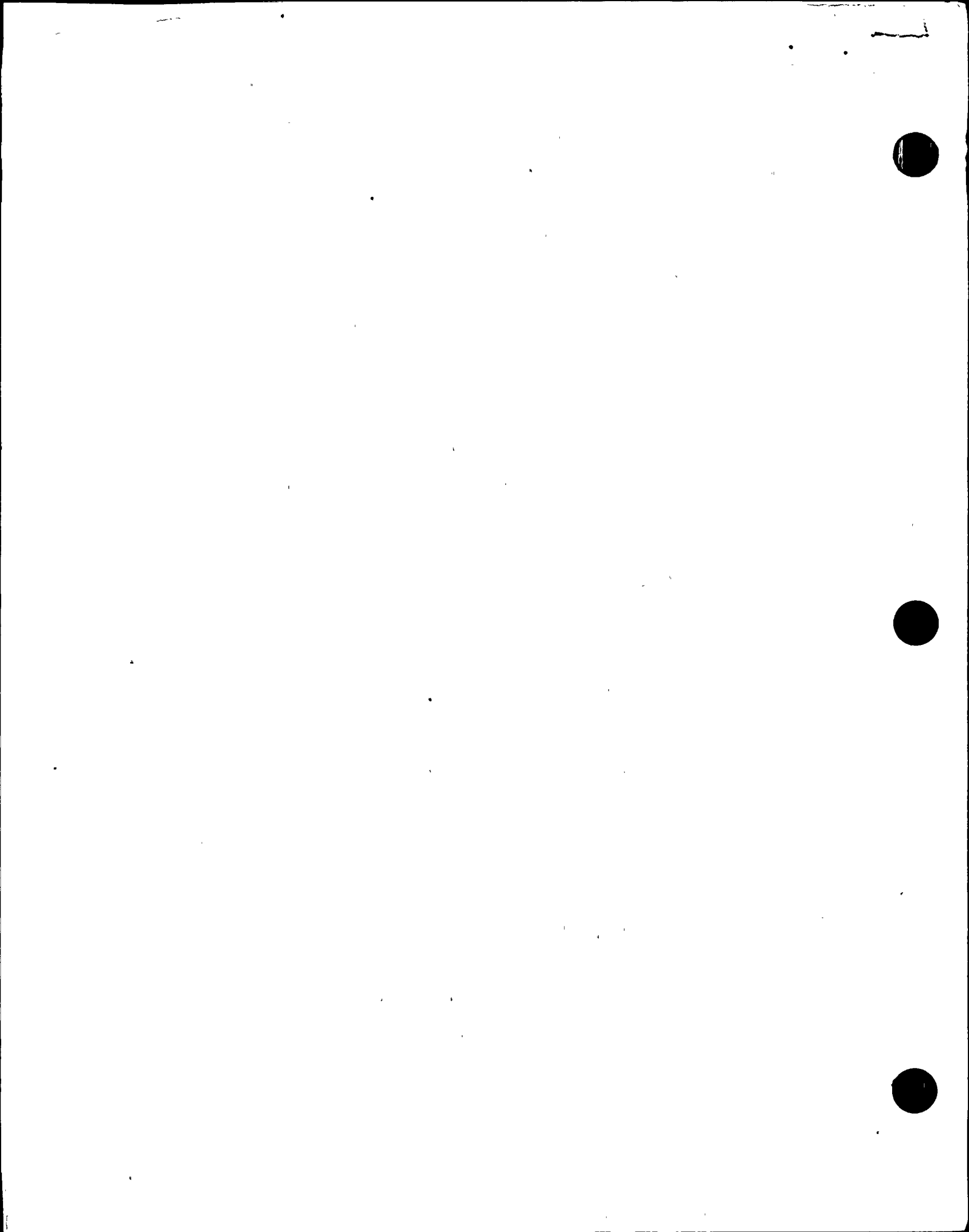
"10CFR50, Appendix B, Criterion IX states in part, "...welding...(is) controlled and accomplished...in accordance with applicable codes..."

The Susquehanna PSAR, Paragraph D.3.3.7 states in part, "Use of qualified procedures and application thereof as required by established codes...will be rigidly enforced on all Bechtel vendors..."

The Bechtel Technical Specification for Shop Fabricated Piping for Nuclear Service, 8856-M-201, Paragraph 5.2, states in part, "All materials, fabrication, testing and examination shall be in accordance with the latest issue of the ASME Boiler and Pressure Vessel Code, Section III...."

7906070184

The ASME Code, Section III, Paragraph NB-4233, states in part, "...alignments that are offset rather than concentric. In these cases, the maximum misalignment at any one point around the joint shall not exceed 3/32 inch...."



Contrary to the above, on 2/12/79 measurements of the internal offset misalignment of the completed and inspected shop weld joint GBB-118-2-3 were found to be 3/16 inch.

(1) Corrective steps which have been taken and the results achieved:

Bechtel initiated NCR-3452 on February 13, 1979 to document the condition observed by the NRC inspector. The NCR was subsequently dispositioned on February 23, 1979 requiring the rework of the nonconforming weld joint. The nonconforming condition identified by the NRC inspector remains under the controls imposed by NCR-3452, pending completion of the rework.

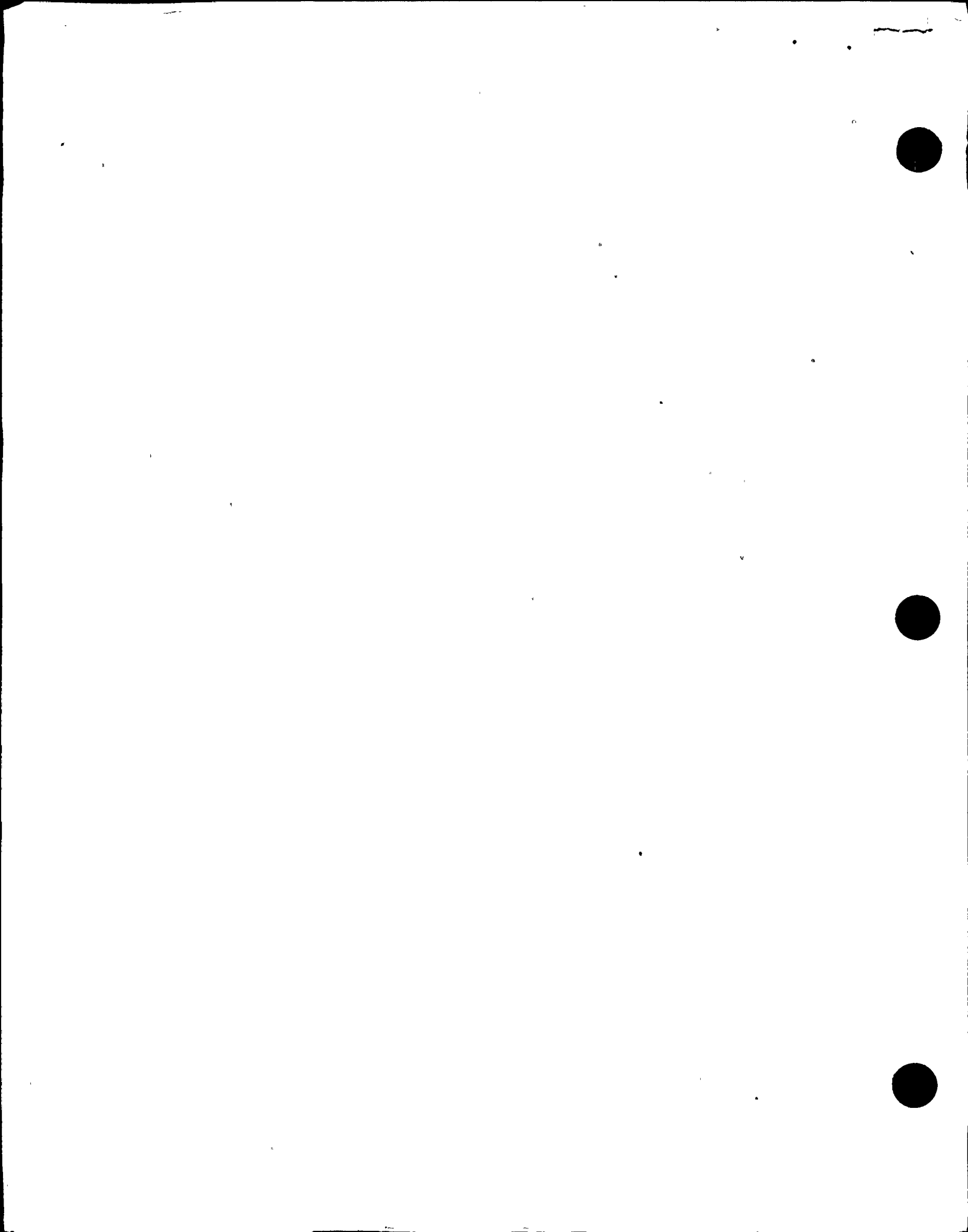
In addition, Bechtel QC and Field Engineering inspected ten Grinnell shop welds to determine if internal misalignment, in excess of the allowable, was evident in other Grinnell welds. The results of the inspection, which revealed no further nonconformances of the type identified by the NRC inspector, are documented on a Field Inspection Report dated March 30, 1979.

(2) Corrective steps which will be taken to avoid further items of noncompliance:

Based on the results of the Bechtel inspection, we believe the nonconforming condition to be an isolated incident which does not require a change to existing procedures except for additional shop surveillance, which has been provided. Bechtel's SFHO supplier quality department has been contacted by Bechtel's field organization and the Bechtel supplier quality representative was directed, on March 23, 1979, to perform increased surveillances at Grinnell's shop. These inspection activities are being documented on the normal shop surveillance inspection reports. The additional shop surveillance inspections will continue for the balance of the order.

(3) Date when full compliance will be achieved:

- (a) Item 1 above. The random inspection of 10 Grinnell welds was completed on March 30, 1979. However, the nonconforming pipe spool identified by the NRC inspector has not yet been reworked and remains under the controls imposed by NCR-3452. We expect the work required by the NCR disposition to be completed by June 30, 1979.
- (b) Item 2 above. Implementation of the supplier surveillance inspection began on April 2, 1979.
- (c) Effective May, 1979, PP&L NQA site staff will begin, on a sampling basis and at a frequency of one shipment per month, examining completed shop welds in order to assess Grinnell's performance and the results of the increased Bechtel surveillance at the supplier's facility. The results of NQA's random verifications will be documented and will continue for a six month period.



Mr. Robert T. Carlson

- 3 -

April 30, 1979

We trust the Commission will conclude that the actions taken to date are adequate.

Very truly yours,



A. R. Sabol
Manager-Nuclear Quality Assurance

ARS:mcb

cc: Mr. Robert M. Gallo
U. S. Nuclear Regulatory Commission
P. O. Box 52
Shickshinny, Pennsylvania 18655

