PP&L

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

October 16, 1979

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

SUSQUEHANNA STEAM ELECTRIC STATION
NRC INSPECTION OF JULY 24-27, 1979
REPORT NOs. 50-387/79-28; 50-388/79-15
ERs 100450/100508 FILE 840-4
PLA-412

Dear Mr. Carlson:

Reference is to your letter of September 18, 1979 which forwarded IE Inspection Reports No. 50-387/79-28 and 50-388/79-15 and Enclosure(1) thereto, "Appendix A, Notice of Violation".

Your letter advised that PP&L was to submit, within thirty (30) days of receipt, a written explanation addressing (1) corrective steps which have been taken and the results achieved, (2) corrective steps which have been 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:

> "10 CFR 50, Appendix B, Criterion VII, states in part: "Measures shall be established to assure that purchased material, equipment, and services...conform to the procurement document. These measures shall include provisions...for source evaluation and selection, objective evidence of quality...inspection...examination of product upon delivery...."
>
> Bechtel specificating C-16 for Susquehanna Steam Electric Station requires the welding to conform to AWS-D.1.1.
>
> AWS structural welding code D.1.1, section 3.2.2 states in part: "In all oxygen cutting, this cutting flame shall be so adjusted and manipulated as to avoid cutting beyond (inside) the prescribed lines...."
>
> Contrary to the above, as of July 24, structural floor beams coped for connection were burned and cut beyond the limit of prescribed lines. Also, these items were inspected and accepted in fabrication shop, upon delivery to the site, and were installed in structures."

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

Bechtel Quality Control performed a detailed inspection of beams supplied by Industrial Engineering Works under Purchase Order C-16-F6a, Release 133. As a result of the inspection, NCR 4288 was initiated on 8-1-79, identifying twenty-three copings on sixteen beams which did not meet specification requirements and also unacceptable weld repairs on cuts. The NCR, dispositioned by Bechtel Project Engineering on 9-6-79, required that the sixteen beams be repaired in accordance with the details of Bechtel Drawing 8856-C-1187, Sheet 2, Revision 0, dated 9-21-79.

(2) Corrective steps which have been taken to avoid further items of noncompliance:

(a) Bechtel Project Engineering is conducting an investigation of drawings to identify any steel beams which required coping and which were supplied by IEW during the period July 11, 1974 through October 5, 1979. With this information Bechtel Quality Control will verify whether the beams identified have been coped in accordance with specification requirements. Should any nonconformances be detected, they will be recorded and controlled via Bechtel Quality Control's nonconformance reports.

Any beams for which repairs may be required will be evaluated and dispositioned by Bechtel Project Engineering as in the case of NCR 4288.

(b) The quality surveillance plan in use by the Bechtel Supplier Quality Representative at IEW is being revised to address coping/re-entry cuts as a hold point for any remaining shipments.

(3) Date when full compliance will be achieved:

(a) The specific discrepancies identified on NCR 4288 will be corrected by 2-1-80.

(b) Project Engineering's evaluation and QC's verification of all IEW supplied coped beams for the period July 11, 1974 through October 5, 1979 will be completed by 2-1-80.

We trust the Commission will find these measures acceptable.

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