

PP&L

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July 21, 1980

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

SUSQUEHANNA STEAM ELECTRIC STATION
NRC INSPECTION OF APRIL 22; MAY 8-9, 1980
REPORT NO. 50-387/80-09
ER 100450 FILE 840-4
PLA-513

Dear Mr. Carlson:

Reference is to your letter of June 9, 1980 which forwarded IE Inspection Report 50-387/80-09 "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 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:

" 10CFR50, Appendix B, Criterion V, states, in part, "Activities affecting quality shall be prescribed by documented instructions, procedures,...and shall be accomplished in accordance with these instructions, procedures, or drawings...."

The Susquehanna PSAR, Section D.2.5 states, in part, "Activities affecting quality shall be prescribed by documented instructions, procedures or drawings appropriate to the circumstances."

Section 7.1 of Nuclear Energy Services, Inc. procedure 80A2771, Revision 2 states, "Straight beam calibration for all base material through which the angle beams will pass shall be performed at a sensitivity level which gives an initial back reflection amplitude from the piping being examined of 80% Full Screen Height (FSH)."

Section 8.1.1 of Nuclear Energy Services, Inc. procedure 80A2771, Revision 2 states, "Straight beam examination to detect laminar reflectors which might affect the interpretation of angle beam results shall be performed at a sensitivity level giving a back reflection from the piping being examined of 80% FSH as noted in Section 7.1."

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Contrary to the above, on May 5 and 6, 1980, straight beam calibration for base material adjacent to piping welds identified on calibration data sheet number 2771-1 and data sheet number 2771-4 was done at a sensitivity level which gave an initial back reflection amplitude from the piping being examined greater than 80% of full screen height, and the straight beam examination to detect laminar reflectors which might affect the interpretation of angle beam results was performed at a sensitivity level giving a back reflection from the piping being examined greater than 80% of full screen height. "

(1) CORRECTIVE STEPS WHICH HAVE BEEN TAKEN AND THE RESULTS ACHIEVED:

The welds in question were re-examined with the base material being scanned at an initial back reflection of 80% full screen height and the weld required volume being scanned at a calibrated sensitivity obtained from machined reflectors in the appropriate calibration standards. All welds re-examined were accepted to ASME Section XI criteria.

(2) CORRECTIVE STEPS WHICH HAVE BEEN TAKEN TO AVOID FURTHER ITEMS OF NONCOMPLIANCE:

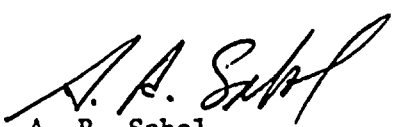
A field change to NES document 80A2771, Rev. 2, was initiated on 5/9/80 by NES Level III Examiner. The subject field change (FC-2) added three paragraphs to the aforementioned procedure in order to provide more detailed instructions to the examiners. The above field change was submitted to and approved by PP&L NQA and reviewed and accepted by Factory Mutual Engineering. A copy of the Field Change was attached to the NES procedure and now forms a part of that procedure.

The changes to NES document 80A2771, Rev. 2, as set forth by NES Field Change No. 2 will be incorporated in the text of the procedure when revision number three (3) is issued.

(3) DATE WHEN FULL COMPLIANCE WAS ACHIEVED:

The issuance of NES Field Change No. 2 was achieved May 9, 1980. Subsequent reinspection of the welds in question was achieved by May 16, 1980. Therefore, full compliance has been achieved.

Very truly yours,


A. R. Sabol
Manager-Nuclear Quality Assurance

ARS:mcb

cc: Mr. Robert M. Gallo
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