

Arizona Public Service Company
P. O. Box 21666
Phoenix, Arizona 85036

Docket No. 50-528
Construction Permit No. CPPR-141

APPENDIX A

Notice of Violation

As a result of the inspection on September 24, 1980, and in accordance with the Interim Enforcement Policy, 45 FR 66754 (October 7, 1980), the following violation was identified:

10 CFR 50, Appendix B, Criterion V, Instructions, Procedures and Drawings, as implemented by PSAR Section 17.1A.5, requires that activities affecting quality be accomplished in accordance with instructions, procedures or drawings appropriate to the circumstances.

Paragraph 8.11 of the constructor-engineer's Work Plan Procedure/Quality Control Instruction No. 28.0, entitled "Maintenance of Materials and Equipment" requires that motor operated valves be maintained according to the manufacturer's instructions.

Contrary to the above, as of September 24, 1980, the motor operators of isolation valves installed at Unit 1 in the main steam and feedwater systems were not undergoing the periodic inspections and maintenance prescribed by the manufacturer.

This is a Severity Level 5 violation. (Supplement II)

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10-10-1940

DETAILS

1. Persons Contacted

a. Arizona Public Service Company (APS)

- *E. E. Van Brunt, Jr. Vice President, Nuclear Projects Management
- *L. K. Mundth, Vice President, Electric Operations
- *G. C. Andognini, Vice President, Power Production
- *J. A. Roedel, Manager, Quality Assurance
- *W. E. Ide, Site QA Supervisor
 - G. Pankonin, QA Engineer
 - R. D. Forrester, QA Engineer
- *D. B. Fasnaght, Nuclear Construction Manager
- *J. M. Allen, Nuclear Engineering Manager
- *A. C. Rogers, Nuclear Engineering Manager
- *R. J. Kimmel, Field Engineering Supervisor
- *K. C. Kieselbach, Cost/Schedule Supervisor

b. Bechtel Power Corporation (Bechtel)

- S. M. Nickell, Construction Superintendent
- *W. J. Stubblefield, Construction Manager
- *W. H. Wilson, Project Manager
- *R. M. Grant, Project QC Engineer
 - J. L. Black, Resident Engineer
- *J. E. Pfunder, Quality Assurance Engineer
- *A. K. Priest, Project Field Engineer
 - V. Matson, Quality Control Engineer-Welding/NDE
 - C. Thomas, Boilermaker Superintendent - Unit 2

Other persons contacted during the inspection period included construction craftsmen, inspectors and supervisory personnel.

* - Denotes management meeting participants

2. Electrical Components and Systems

The inspector examined completed safety-related cable trays in the Unit 1 lower cable spreading room. The features that were checked were joint bolting, grounding, absence of sharp edges and burrs, supports and anchorage, horizontal and vertical separation, cleanliness, identification, and type, size and location per approved drawings and specifications. The applicable requirements were specified on the following drawings:

- | | |
|------------------|--|
| No. 13-E-ZJC-006 | Control Building - Conduit and Tray Plan - Lower Spreading Room Level 2A |
| No. 13-E-ZJC-007 | Same as above for Level 2B |
| No. 13-E-ZAC-050 | Conduit and Tray - Notes, Symbols and Details |



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Also, the protection of installed cable and raceways in the spreading room and in several areas of the Unit 1 auxiliary and containment buildings was observed. Cables appeared to be properly supported and tied down, and coiled cable ends appeared to be appropriately sealed. There was no evidence that trays or conduit were being used as ladders, walkways, or otherwise being abused. Trays and junction boxes were reasonably free of debris, and protection from adjacent construction activities appeared to be adequate.

Six drawings, two cable pull cards and two specifications pertaining to cable installation in conduit, cable trays and duct banks, all in current use by the installation craftsmen, were checked and found to be the latest revision.

During tours of Unit 1 and Unit 2, safety-related electrical equipment items, both installed and in storage areas, were observed to ascertain that protective requirements were being met. Particular attention was given to energization of space heaters, lubrication and rotation of motor shafts, storage position and presence of dunnage, identification, cleanliness, and adequacy of protective covers.

No deviations or items of noncompliance were identified.

3. Containment - Structural Concrete

Final preparations and readiness for the placement of concrete in the top segment of the north reactor pool wall in Unit 2 was examined by the inspector. The requirements were specified in Specification 13-CM-375, Placing of Reinforcing Steel and WPP/WCI 520, Concrete Preplacement. The reinforcing steel was noted to be the proper size and spacing, and was adequately tied and located the specified distance from the forms. The forms were securely supported and appeared to be clean with leak tight joints. Similar observations were made in connection with the reinforcing steel and formwork for the CEDM Decontamination Facility at the 140 ft. level in the Unit 2 containment building.

No deviations or items of noncompliance were identified.

4. Reactor Coolant Pressure Boundary Piping

The inspector examined the activities associated with fitup and preparation for welding the NSSS hot leg spool (line 2-RC-032-42") to steam generator No. 1 in Unit 2. The fitup gap around the full periphery of the weld joint was within the required $1/8 \pm 1/32$ - inch. Thermocouples were in place for preheat and



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interpass temperature measurement and control. The weld process sheet (WR-5 Form) had been prepared and was seen to contain the required information. The governing requirements were contained in Specification 13-PM-204, "Field Fabrication and Installation of Nuclear Piping Systems", and WPP/QCI 380, "Reactor Coolant Piping: Storage, Handling, and Installation". The QC inspection plan (CIP) had been properly prepared and was being executed. The temperature indicator/recorders were seen to have current calibration stickers attached.

The inspector also reviewed the controls being exercised over weld filler materials. Recent purchasing and receiving records for E-7018, E-6010, and E-308L material were examined to verify that the provisions of the governing procedure (WPP/QCI 100.0 - Weld Filler Material Control) were being followed. The records showed that the ASME Code required test had been performed on each lot of the materials. The inspector also inspected two filler material issue stations and verified that the attendants understood the procedural requirements for disbursement, return, and recycle of the welding materials (also included in WPP/QCI 100.0).

No deviations or items of noncompliance were identified.

5. Reactor Vessel Internals

The inspector observed the activities and procedural controls associated with the stored reactor vessel internals. The core barrel, shroud and support structure were properly covered, and access control to the refueling pool storage area appeared adequate. Adherence to the storage and protection requirements was considered satisfactory.

6. Containment Liner Erection

Several completed vertical seam welds on the Unit 2 containment dome from the "spring line" up to the 45-degree point were examined by the inspector. Segment fitup and tack welding in the region just below the top dollar plate was also observed. Good quality workmanship was prevalent. Locations where the plate-to-plate distance along the backing bar exceeded the 3/4-inch maximum allowable distance were legibly marked "do not weld" by the QC inspector. "Buttering" activities by the welders in several of these locations were in progress. The inspector also observed vacuum box leak checking of a completed vertical seam approximately 20-feet above the "spring line" by NDE technicians whose qualifications had previously been checked by the inspector and found satisfactory.

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The inspector also observed the work sequences employed by the craftsmen to remove a bulge in the horizontal seam at the 166-degree azimuth and the tack welding at that location. This condition had been previously identified by the inspector (50-529/80-14/01). After attaching suitable jacking lugs, the plate was forced into position against the backing bar by exerting a minimal force with a 5-ton hydraulic jack. There was no indication of metal distress either during the plate bending or after it had been tack-welded in position. Several days later, the inspector examined the welding on the full length of the horizontal seam at the "spring line". The welding had been completed except for approximately 10-ft. where "buttering" had yet to be done in order to accomplish the 3/4-inch minimum dimension for plate edge fitup. The workmanship appeared satisfactory.

No deviations or items of noncompliance were identified.

7. Structural Steel Installation

Installation of structural steel at the 88-ft. elevation of area AAB in the Unit 3 auxiliary building was observed by the inspector. The component materials and installation tolerances were as specified in the latest issues of the governing documents. They are Specification 13-CM-320, "Erection of Structural and Miscellaneous Steel"; Drawing 13-C-ZAS-511, "Auxiliary Building - Area AAB, Structural Steel Framing Plan For Elevation 88' - 0"; and Drawing 13-C-00A-001, "Civil/Structural-General Notes". Bolted connections were tight, and the bolts and nuts (ASTM A325) had been marked in preparation for torquing. Beam clip to beam web welds were in accordance with the AWS standards and the workmanship appeared good. Inspection was being performed and inspection records were being developed in accordance with WPP/QCI 58.0, "Erection of Structural and Miscellaneous Steel".

No deviations or items of noncompliance were identified.

8. Safety Related Components

Several times during this reporting period the inspector toured the plantsite to observe the care and preservation of components, fire prevention and protection conditions, and general housekeeping conditions. In equipment storage areas, particular attention was given to the presence and adequacy of protective covers, coatings, equipment identification and segregation of nonconforming items, lubrication and rotation of operating shafts, storage position of valves with automatic operators and adequacy of cribbing for air circulation. In work areas, attention was directed to equipment protection from adjacent work activities, adequate capping of pipe openings that were not being worked on, and control of welding electrodes and electrode stubs.

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The main feedwater isolation valves (Nos. V-132, V-137, V-174 and V-177) installed in Unit 1 main steam support structure were examined by the inspector to verify that the installation satisfied the piping and support drawings. The valves appeared to be installed the requirements. It was observed, however, that the protective plastic covers for the valve motor - operators were such that the operators were only partially covered (one was totally uncovered). The operator for V-137 had an accumulation of construction generated dirt (dust, grinding chips, etc.) and hydraulic fluid which apparently had leaked from the mechanism. The operators for the main steam isolation valves were also observed to be uncovered. Bechtel has a control program entitled "Instorage Maintenance System Computer Program" which should have enabled this situation to be detected and corrected. Upon further inquiry by the inspector, it was found that provisions for maintenance of motor-operated valves had not been incorporated in the aforementioned maintenance program. This is not in keeping with the requirements of WPP/QCI 28.0, "Maintenance of Materials and Equipment" which states, in paragraph 8.11, that motor operated valves are to be maintained according to the manufacturer's instructions. These instructions were not being followed. The licensee took immediate action to get the four motor-operators cleaned and covered, and to rectify the omission of motor-operated valves in the instorage maintenance program. The failure to include the valves in this program is an apparent item of noncompliance. (50-528/80-17-01)

9. Management Meetings

On September 12 and 30, 1980, the inspector met with the licensee representatives identified in Paragraph 1 to summarize the scope of the inspection activities and review the inspection findings as described in this report.

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