U. S. NUCLEAR REGULATORY COMMISSION

REGION V

Report No. 50-530/86-19

Docket No. 50-530

Construction Permit No. CPPR-143

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

Facility Name: Palo Verde Nuclear Generating Station Unit 3

Inspection at: Palo Verde Site, Wintersburg, Arizona

Inspection Conducted: July 28 through August 1, 1986

Inspector: D.J. Willett for — 8-19-86
W. Wagner, Reactor Inspector — Date Signed

Approved by: D.J. Willett for — 8-19-86
S. Richards, Chief, Engineering Section — Date Signed

Summary:

Inspection on July 28 through August 1, 1986 (Report No. 50-530/86-19)

Areas Inspected: Routine, unannounced inspection by regional based inspector of licensee's action on inspectors' identified items. NRC Inspection Procedure 92701 was covered during this inspection.

Results: In the area examined, no items of noncompliance or deviations were identified.

DETAILS

1. Persons Contacted

   a. Arizona Nuclear Power Project (ANPP)

   *W. E. Ide, Director Corporate QA/QC
   *J. Matteson, Quality Monitoring Supervisor
   *C. Russo, Manager, Quality Audits and Monitoring
   *T. Shriver, Manager, Compliance
   *J. Sherrin, Supervisor Quality Document Review
   W. Gratza, QA Engineer

   b. Bechtel Power Corporation (Bechtel)

   *P. Huber, Lead QA Engineer
   *G. Gelinas, Project QC Engineer
   R. Ruff, Lead Electrical/Instrumentation QC Engineer
   M. Sibley, Welding QC Engineer
   G. New, Welding QC Engineer
   R. Rosen, Senior QA Engineer
   D. Freeland, Engineering Group Supervisor

   *Denotes those attending the exit meeting on July 31, 1986.

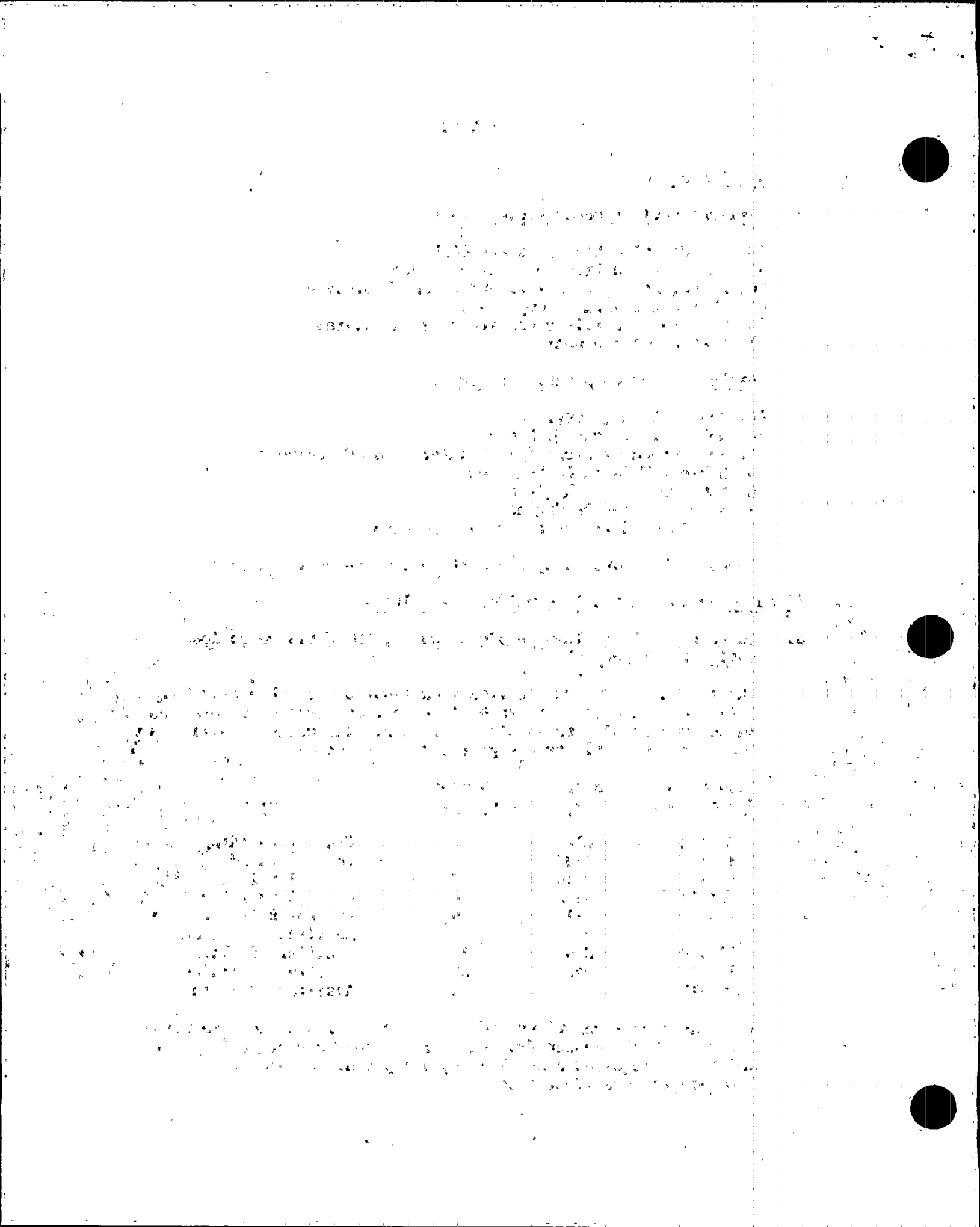
2. Licensee Action on Previously Identified Items

   a. (Closed) Followup Item 50-530/86-03-02, "Weld Discrepancies on Cable Tray Supports"

   The inspector performed a visual examination of cable tray hanger welds to assure that the as-built hanger and weld configurations are in accordance with the design documents. The welds associated with the following cable tray supports were inspected:

Cable Tray Support No.	Hanger No.	Number of Welds	Location
3EZJ1A	H103	6	Control Building
3EZJ1A	H105	9	Control Building
3EZJ1A	H114	7	Control Building
3EZJ1A	H115	8	Control Building
3EZJ1A	H116	9	Control Building
3EZA1C	H20	17	Auxiliary Building
3EZA1C	H75	17	Auxiliary Building
3EZA1B	H48	20	Auxiliary Building
3EZA1B	H49	21	Auxiliary Building

   The hanger configurations and the 114 welds inspected were found to comply with the design drawings. The welds were properly located and of the required size, length, and pitch. No discrepant weld attachments were identified.



This item is closed.

b. (Open) Followup Item 50-530/86-03-04, "Review of Records for QC Verification of Ex-Core Terminations"

The NRC Construction Appraisal Team (CAT) was concerned that ex-core termination installations were not receiving adequate QC coverage. As a result of this concern, Bechtel added Addendum 3 to special CIP 695.0 to assure 100 percent coverage of the termination activity. The licensee informed the inspector that approximately 40 in-process QC inspection documents were missing. This was documented on NCR No. EX 8139 of July 25, 1986, and dispositioned "use-as-is" on July 31, 1986.

The licensee investigation determined that sufficient evidence existed to show that all special CIP 695.0 requirements were met since all EE580 cards (Termination Installation Cards) are signed-off by the QCE referencing the special CIP 695.0 in the remarks section of each card. In addition, other records established that the work was appropriately accomplished.

c. (Closed) Followup Item 50-530/86-03-12, "Undersized Beam Attachment Pins"

The inspector discussed the engineering evaluation with the Bechtel design engineer to assure that the undersized pins, dispositioned use-as-is, are in compliance with the original code design requirements. Original design documents specified a 5/8-inch beam attachment which requires a 3/4-inch load pin; instead a 1/2-inch beam attachment was installed which required a 5/8-inch load pin. The inspector's review of the engineering evaluation calculations and load rating chart showed that the smaller size brackets would withstand the existing loads and are in compliance with original code requirements.

This item is closed.

d. (Closed) Followup Item 50-530/86-03-18, "Undersized Welds Identified in IE Notice 85-33"

The NRC issued Information Notice 85-33 on the subject of undersized weld reinforcement in ASME Code nozzle-to-shell welded joints in tanks and heat exchangers. The licensee has performed an inspection of tanks and heat exchangers prior to the NRC CAT inspection, and similar findings were identified. The licensee committed to review and evaluate these findings.

The licensee issued DER 86-01 to address the concerns identified in Information Notice 85-33. The actual inspection was performed in accordance with special CIP No. 676.0. One vessel per manufacturer was inspected with the selected nozzles being inspected for compliance to applicable vendor drawings and code requirements. NCRs were issued to document any nonconforming nozzle-to-shell welds. ASME Code weld strength calculations were performed on all

reported undersized welds to determine if the weld had adequate strength to meet the allowable code stress. The results of these weld strength calculations was that all welds were found to be sufficient to carry the required loads, and do not pose a safety hazard. In addition, the NCR disposition required all undersized welds be increased in size to be made compliant with the Code. The licensee concluded that the condition is evaluated as not reportable under the requirements of 10 CFR 50.55(e) and 10 CFR 21.

This item is closed.

3. Exit Meeting

The inspector met with the licensee representative denoted in paragraph 1 on July 31, 1986. The scope of the inspection and the inspector's findings as described in this report were discussed.