

Fisher Controls Company
Docket No. 99900105/79-01

NOTICE OF DEVIATION

Based on the results of an NRC inspection conducted on September 24-28, 1979, it appears that certain of your activities were not conducted in accordance with NRC requirements as indicated below:

Criterion V of Appendix B to 10 CFR 50 states: "Activities affecting quality shall be prescribed by documented instructions, procedures, or drawings, of a type appropriate to the circumstances and shall be accomplished in accordance with these instructions, procedures, or drawings. Instructions, procedures, or drawings shall include appropriate quantitative or qualitative acceptance criteria for determining that important activities have been satisfactorily accomplished."

The Fisher Control Company (FCC) procedure number 5E3.10 with Amendment number AM-23, for hardfacing P8 materials with multilayer of Alloy #6 materials specifies that the preheat temperature shall be $1200^{\circ}\text{F} \pm 100^{\circ}\text{F}$.

Contrary to the above, it was observed that the specified preheat temperature was not achieved or maintained during the hardfacing of valve seat ring, S.O. RD281.4, using procedure 5E3.10, Amendment AM-23. Preheat temperatures were observed to fluctuate between 900°F and 1100°F during this operation.

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