

U. S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT

REGION I

Report No. 50-423/79-08

Docket No. 50-423

License No. CPPR-113 Priority -- Category A

Licensee: Northeast Nuclear Energy Company

P.O. Box 270

Hartford, Connecticut 06101

Facility Name: Millstone Nuclear Power Station, Unit No. 3

Inspection At: Millstone Unit 3, Waterford, Connecticut

Inspection Conducted: September 24 to 26, 1979

Inspectors: W. F. Sanders
W. F. Sanders, Reactor Inspector

Oct 25, 1979
date

date

date

Approved by: J. E. Tripp
J. E. Tripp, Chief, Engineering Support
Section No. 1, RC&ES Branch

10/25/79
date

Inspection Summary:

Inspection on September 24-26, 1979 (Report No. 50-423/79-08)

Areas Inspected: Routine, unannounced inspection by one regional based inspector of construction activities in progress on the installation, erection and welding on the primary containment steel structures, supports and penetrations. The inspection involved 18 inspector-hours on site by one regional based inspector.

Results: No items of noncompliance were identified.

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DETAILS

1. Persons Contacted

Northeast Utilities Service Company

- *J. O'Brien, Construction Quality Assurance Specialist
- *J. Peterson, Senior Project Technician
- *J. F. Putnam, Resident Mechanical Engineer
- S. R. Toth, System Superintendent/Generation Construction

Stone and Webster Engineering Corporation

- L. J. Barberie, Senior Field Quality Control Engineer
- *J. Kappas, Superintendent Construction
- *M. M. Lenhalt, Contract Administration
- G. Marsh, Senior Field Quality Control Engineer
- *R. A. Plant, Manager Field Quality Control
- *A. Prusi, Assistant Resident Engineer
- *G. G. Turner, Superintendent Field Quality Control
- *J. L. Whedbee, Assistant Superintendent, Field Quality Control

Graver Energy System Inc.

- V. Gattuso, Construction Superintendent
- W. Walker, Site Quality Assurance Supervisor
- W. Welsh, Quality Control Inspector

*Denotes those present at the exit interview. In addition the inspector interviewed other licensee and contractor personnel during the course of inspection, including construction crafts.

2. Plant Tour

An inspection tour was made on each of the three days to observe work activities in progress, handling of material, completed work and plant status in several areas of the plant. Installed components and working items were examined for any obvious defects, loss of protective coverings and noncompliance with applicable codes, standards and regulatory requirements or license conditions. Particular note was taken of the presence of quality control inspectors and quality control evidence such as inspection records, material identification, and nonconforming material. No items of noncompliance were identified during this inspection.

3. Welding

An inspection was made of the welding in progress on the primary containment liner top dome. Specific observations were made of the welding of seam no. 40 which was an overhead weld on the inside of the dome using the SMAW process and performed by welder symbol no. 092. It was noted that the first 10 feet of the weld had been designated for Radiography. Similar inspections were made on seam no. 29 on the top of the dome. This was a

down hand weld performed by welder symbol no. 075 and sub-assembly no. 24 which was also down hand welding performed by welder symbol no. 56. After observations were made of the weld metal deposition, and visual inspections of the completed welds for compliance to the requirements of weld procedure Graver 205 N Rev. 9, a follow up inspection was made of the three welders performance qualifications, position qualified, and the testing as required by ASME Section IX. No items of noncompliance were identified.

4. Welding Material

An inspection was made of the weld material issue station used by the contractor for the fabrication and erection of the steel primary containment liner and related structural steel. Observations were made to determine conformance with the requirements of applicable specification, Graver NQAP no. 19.0, Rev. 7 in the areas of identification, segregation, cleanliness, temperature control, oven calibration, issue records, and handling of returned material. The inspector noted that two different electrodes were being used. No items of noncompliance were identified.

5. Records

An inspection was made of the following completed work records:

- . Material certifications
- . Inspection records
- . Magnetic particle
- . Radiography
- . Vacuum Box testing

As applicable to the following items:

- . Liner seam no. 40
- . Liner seam no. 29
- . Subassembly no. 24
- . Pipe rupture restraint no. 3-FWS-PRR-14-LA
- . Pipe Rupture restraint no. 3-FWS-PRR-14-LD
- . Penetration assemblies P-46, P-50, P-15 and P-19 (except RT & UT)

No items of noncompliance were identified.

6. Exit Interview

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At the conclusion of the inspection on September 26, 1979, a meeting was held at the site with representatives of the licensee. Attendees at this meeting included personnel whose names are indicated in Paragraph 1. The inspector summarized the results of the inspection as described in this report.