

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

Report No. 99900063/79-02

Program 51300

Company: Pacific Pump Division
7515 Bickett Street
Huntington Park, California 90255

Inspection
Conducted: October 1-5, 1979

Inspector: C. J. Haleff 11-2-79
H. W. Roberts, Contractor Inspector Date
Components Section II
Vendor Inspection Branch

Approved by: D. M. Hannicutt 11-2-79
D. M. Hannicutt, Chief Date
Components Section II
Vendor Inspection Branch

Summary

Inspection on October 1-5, 1979 (99900063/79-02)

Areas Inspected: Implementation of 10 CFR 50, Appendix B, criteria and applicable codes and standards including actions on previous inspection findings, welding material control, control of welding, and equipment calibration. The inspection involved twenty-eight (28) inspector-hours on site by one (1) NRC inspector.

Results: In the four (4) areas inspected, no apparent deviations or unresolved items were identified in two (2) areas; the following deviations being identified in the remaining areas.

Deviations: Welding Material Control - 5/32 and 3/16 coated electrodes were mixed in one compartment in a holding oven (Notice of Deviation, Item A). Control of Welding - Welding had been accomplished although the Summary of Processes which defines the welding procedure had not been released (Notice of Deviation, Item B).

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DETAILS SECTIONA. Persons Contacted

- *D. J. Moyer, Quality Assurance Manager
- S. R. Grajenda, Welding Engineer
- D. Ausman, Welding General Foreman
- B. Thomas, Welder

*Denotes those attending the exit meeting.

B. Actions on Previous Inspection Findings

1. (Closed) Deviation (Inspection Report No. 79-02, Item A of Enclosure):
Welding was being performed outside the current and voltage range of the approved weld procedure specification.

The inspector verified that weld procedure specification No. 042-2-5780 had been revised to include the current and voltage range that was being used for welding on Order No. 50090, Item B02, and had been approved by the customer.

2. (Closed) Deviation (Inspection Report No. 79-01, Item B of Enclosure):
Distribution of weld procedure addendums not consistent with NRC and Code requirements.

The inspector verified that a closed loop record system had been initiated in the form of a document distribution transmittal sheet and a review of the Summary of Processes (SP) document and assigned procedure manuals did not reveal a similar discrepancy.

C. Welding Material Control1. Objectives

The objectives of this area of the inspection were to verify that measures are established to control the purchasing, storage, handling and issuance of weld materials in accordance with the manufacturer's QA program and applicable ASME Code and NRC requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of Chapter 7 of the Quality Assurance Manual, dated July 12, 1978.

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- b. Review of Procedure for the Issuance and Control of Welding Materials No. 112-1-0001-3, dated February 9, 1979.
- c. Inspection of the weld material crib area and three (3) holding ovens Nos. 8, 11, and 12.
- d. Inspection one (1) portable oven containing coated electrode.
- e. Review of four (4) purchase orders of weld material.
- f. Review of Qualified Organizational List, dated July 15, 1979.

3. Findings

a. Deviations from Commitments

See Enclosure, Item A.

b. Unresolved Items

None.

D. Control of Welding

1. Objectives

The objectives of this area of the inspection were to verify that:

- a. Weld operations are accomplished in accordance with qualified procedures and/or technique sheets.
- b. Weld procedure and/or instructions are available in the area where the weld operation is performed.
- c. Welding is accomplished by qualified personnel and qualifications are current for welding process used.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the Quality Assurance Manual, Chapters 5 and 7, dated July 12, 1978.
- b. Review of four (4) weld procedure specifications and applicable procedure qualification records.

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- c. Observation of welding performed on Order No. B49790, Item D07A for compliance to the applicable WPS.
- d. Review of records of welder qualification for operations observed.
- e. Verification of calibration status of equipment when required in the calibration program.

3. Findings

a. Deviations from Commitments

See Notice of Deviation, Item B.

b. Unresolved Items

None.

E. Equipment Calibration

1. Objectives

The objectives of this area of the inspection were to verify that a system has been established and is maintained to assure that tools, gauges, instruments and other measuring devices used in activities affecting quality are properly controlled, calibrated and adjusted at specified periods to maintain accuracy within required limits.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the Quality Assurance Manual, Chapter 11 dated July 12, 1978.
- b. Review of Procedure number 117-1-001
- c. Observation of eleven (11) OD micrometers, six (6) ID micrometers, and six (6) thread gauges for identification and current calibration stickers.
- d. Review of twelve (12) calibration record cards for micrometers and thread gauges.

3. Findings

Within this area of the inspection, no deviations from commitments or unresolved items were identified.

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F. Exit Meeting

An exit meeting was held by the inspector on October 5, 1979, with the following management and Authorized Inspection Agency representatives present:

- D. B. Harney, President
- D. J. Moyer, Quality Assurance Manager
- J. C. Patton, General Mfg. Manager
- C. Weisman, Inspection Specialist
State of California
- A. Herrington, ANI State or California

The inspector summarized the scope of the inspection and the findings. Management acknowledged the statements of the inspector and had no specific questions in regard to the findings as presented to them.

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