



Duquesne Light

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May 17, 1979

United States Nuclear Regulatory Commission
Region I
631 Park Avenue
King of Prussia, Pennsylvania 19406

ATTENTION: Mr. Robert T. Carlson, Chief
Facility Construction and Engineering Support Branch

SUBJECT: Beaver Valley Power Station Unit No. 2
Docket No. 50-412
USNRC IE Inspection Report No. 50-412/79-03

Gentlemen:

This is in response to the item of infraction cited in Inspection Report No. 50-412/79-03 and listed in Appendix A (Notice of Violation) attached to your letter to Mr. E. J. Woolever dated April 17, 1979.

NRC VIOLATION

10CFR 50, Appendix B, Criterion IX, states, in part: "Measures shall be established to assure that . . . welding (is) controlled and accomplished . . . in accordance with applicable codes . . ."

The Beaver Valley Power Station PSAR, Chapter 17, Quality Assurance, paragraph 17.1.9B, states in part: "Requirements of special processes are established in Erection and Procurement Specifications."

The Specification for Field Fabrication and Erection of Piping ASME Section 3, 2BVS-920, Addendum No. 1, states, in part: ". . . the installer for all ASME Section III piping, is responsible for code compliance . . . in accordance with ASME Section III - 1971."

The ASME Code, Section III, 1971 edition, for class 3 piping systems, paragraph ND-4110, directs that: ". . . components shall be . . . installed in accordance with the rules of NC-4000." NC-4110 also directs that: ". . . components shall be . . . installed in

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accordance with the rules of NB-4000. . ."
Paragraph NB-4425 states, in part: "When
components of different diameters are welded
together. . . the slope of the transition
shall be such that the length to offset ratio
shall not be less than 3 to 1. . ."

Contrary to the above, on February 1, 1979, the
welding inspector accepted a nuclear class 3
pipe-to-valve weld joint, as evidenced by the
ASME Weld Data Sheet 2 CHS-010-F02, with a
diameter transition slope of approximately
3 to 2.

RESPONSE

Resulting from the infraction reported above,
Nonconformance and Disposition No. 6142 was
initiated on Weld Joints CHS-010-F02 and CHS-
010-F03, the latter also failed to conform to
the requirement described.

A detailed inspection of completed welds with
similar weld configuration revealed no other
deviations from the referenced code.

A review of the applicable Inspection Plan
7.2.2, 9/5/78, indicated an omission of the
applicable attribute. As a temporary measure,
Memo DLC/SQC-#0530A dated 3/13/79 with descriptive
sketch, was issued instructing the Quality Control
Supervisor to incorporate the attribute in future
Inspections. The Inspection Plan 7.2.2 has now
been formally revised 4/9/79 with Attribute Number
ME-MS-009, Paragraph 4.4.3 and Attachment 3.4 to
fully describe the attribute.

In addition, the Training Course TCO VII NOP
Video Tape has been modified to include instruction
for this attribute and Quality Control Inspectors
certified to inspect to Inspection Plan 7.2.2 have
been retrained to this attribute and the method to
be applied and are currently inspecting to this
attribute.

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The condition of the 2 welds in questions give a weld transition taper of 2 to 1 rather than the 3 to 1 taper required by the applicable code. The condition will be corrected to conform to the applicable code. However, the original condition of the welds, although in violation, is not considered to have a safety implication.

DUQUESNE LIGHT COMPANY

By E. J. Woolever
E. J. Woolever
Vice President

COPIES TO: Dr. E. Volgenau (15)
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