

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

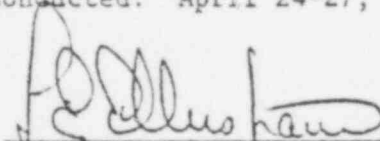
Report No. 99900209/79-02

Program No. 51300

Company: Bergen-Paterson Pipesupport Corporation  
48 Winnisquam Avenue  
Laconia, New Hampshire 03246

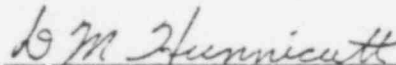
Inspection Conducted: April 24-27, 1979

Inspector:

  
E. Ellershaw, Principal Inspector, Vendor  
Inspection Branch

5/16/79  
Date

Approved by:

  
D. M. Hunnicutt, Chief, Components II, Vendor  
Inspection Branch

5/11/79  
Date

Summary

Inspection conducted April 24-27, 1979 (99900209/79-02).

Areas Inspected: Implementation of 10 CFR 50 Appendix B Criteria, and applicable codes and standards including: previous inspection findings; indoctrination and training; nonconformances and corrective action; manufacturing process control, and welding procedure specifications. The inspection involved twenty-eight (28) inspector-hours on site.

Results: In the five (5) areas inspected, three (3) deviations and one (1) unresolved item were identified.

Deviations: Indoctrination and Training - all departments have not developed training programs nor have they submitted 1979 training schedules to the QA Manager, and training sessions have not been conducted by the QA Manager for department managers, as required by Criterion V of Appendix B to 10 CFR 50 (Enclosure, Item A); Nonconformances and Corrective Action - an issued Hold Tag for nonconforming material was not listed in the Material Control Log, and certain nonconforming material was not identified with a Hold Tag, as required by Criterion XV of Appendix B to 10 CFR 50 (Enclosure, Item B); Manufacturing Process Control - Quality Control, even though signing-off and dating an NF Route Sheet, did not confirm that material conformed to

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requirements, in that the drawing specified SA-306 Grade 60, but the material being used was SA-36 (Enclosure, Item C).

Unresolved Item: Nonconformances and Corrective Action - it appears that the maintenance of the Corrective Action Report Log and the reviews of Corrective Action Reports (CAR) have been inadequate in that four (4) CARs remained open from September and October, 1978, without any apparent follow-up, and the four (4) CARs generated thus far in 1979 were not recorded in the Log, thus precluding follow-up (Details Section, paragraph D.3.b).

## DETAILS SECTION

(Prepared by L. E. Ellershaw)

A. Persons Contacted

G. E. Amsden, Quality Assurance Engineer  
C. Asmundson, Assistant Manager, Product Engineering  
W. T. Becksted, Manager, Quality Assurance  
B. Clifford, Assistant Weld Foreman  
M. L. Fontaine, Manager, Quality Control  
A. Lee, General Foreman  
W. Porter, Calibration Technician  
R. Stokes, Chief Examiner

B. Action on Previous Inspection Findings

1. (Closed) Deviation A (Report No. 78-01): This item dealt with Bergen-Paterson Pipesupport Corporations (B-P) quality program not addressing corrective action measures of subcontractors.

B-P does include corrective action measures applicable to subcontractors in their Purchase Specifications.

2. (Closed) Deviation B (Report No. 78-01): This item dealt with handling instructions or procedures not being established.

B-P has implemented their committed corrective actions in that procedures have been developed and implemented.

3. (Closed) Deviation C (Report No. 78-01): This item dealt with the failure to show NPT nameplate locations on component support drawings designed and prepared by B-P customers.

B-P has implemented their committed corrective actions in that procedure BP5-5 (Guide for location of NPT nameplates) was developed and submitted to its customers.

4. (Closed) Deviation D (Report No. 78-01): This item dealt with hold points being designated and signed-off by personnel other than Quality Control, and procedure revisions not being designated on Fabrication Records after fabrication was completed.

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B-P has implemented their committed corrective action in that the Fabrication Record was revised to accommodate the specified sign-offs, and a review of Fabrication Records revealed that procedure revisions are being designated.

5. (Closed) Deviation E (Report No. 78-01): This item dealt with drawing revisions not being incorporated into the master shop drawing book.

B-P has implemented their committed corrective action the use of the master shop drawing book has been eliminated and fabrication is now controlled through issue and retrieval of controlled drawings for specific jobs.

C. Indoctrination and Training

1. Objectives

The objectives of this area of the inspection were to verify that B-P had implemented the requirements for indoctrination and training of personnel whose activities affect quality in accordance with the QA Manual and applicable NRC and ASME Code requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of QA Manual Section 4, "Training", dated March 1, 1979.
- b. Review of Work Procedure BP-2-1, "Personnel Training", dated March 3, 1978.
- c. Review of individual Department procedures and schedules.
- d. Review training documentation.
- e. Discussions with cognizant personnel.

3. Findings

- a. Deviation From Commitment  
See Enclosure, Item A.
- b. Unresolved Item  
None.

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D. Nonconformances and Corrective Action

1. Objectives

The objectives of this area of the inspection were to verify that B-P had implemented the requirements for the control of nonconformances and corrective action in accordance with the QA Manual and applicable NRC and ASME Code requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of QA Manual Sections 14 and 15, "Nonconformance Control" and "Corrective Action" respectively, dated March 1, 1979.
- b. Review of Work Procedure BP-16-2, dated January 18, 1979, "Discrepant Materials Report."
- c. Review of Work Procedure BP-16-1, "Corrective Action."
- d. Review of "Hold Tag" Log maintained by the Material Control Foreman.
- e. Review of "Corrective Action" Log maintained by the Quality Control Manager.
- f. Observation of the nonconforming material hold areas and review of material located therein.
- g. Discussions with cognizant personnel.

3. Findings

a. Deviation From Commitment

See Enclosure, Item B.

b. Unresolved Item

The Manager of Quality Control maintains a log which is used to list and identify all corrective action reports that have been generated, and QA Manual Section 15 addresses the review of corrective action reports and the corrective actions taken.

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It would appear that the maintenance of the Log, and the reviews of corrective action reports (CAR) have been inadequate in that four (4) CARs remained open from September and October 1978, without any apparent follow-up, and the four (4) CARs generated thus far in 1979, were not recorded in the Log therefore precluding follow-up.

E. Manufacturing Process Control

1. Objectives

The objectives of this area of the inspection were to verify that B-P had implemented the requirements for the control of manufacturing processes in accordance with the QA Manual and applicable NRC and ASME Code requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of QA Manual Section 10, "In Process Control", dated March 1, 1979.
- b. Observation of in-process manufacturing operations.
- c. Review of Fabrication Records, drawings/sketches, Material Requisitions, and purchase orders associated with the observed in-process manufacturing operations.
- d. Discussions with cognizant personnel.

3. Findings

- a. Deviation From Commitment  
See Enclosure, Item C.
- b. Unresolved Item  
None.

F. Welding Procedure Specifications (WPS)

1. Objectives

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The objectives of this area of the inspection were to verify that B-P had implemented the requirements for the control of WPSs and their related Procedure Quality Records (PQR) in accordance with the QA Manual and applicable NRC and ASME Code requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of QA Manual Section 9, "Control of Special Processes", dated March 1, 1979.
- b. Review of Work Procedure BP-9-18, revision C, "Standard Operating Procedure for Weld/Welder Qualifications", dated October 7, 1977.
- c. Review of WPS 1-10, revision 1, and its supporting PQRs 1A, 1B, and 1C.
- d. Review of WPS 4A-WT, revision 1, and its supporting PQRs 4A and 4B.
- e. Review of WPSs 2-NF2, revision 0, and 1-NF 3, revision 1 and their supporting PQRs.
- f. Discussion with cognizant personnel.

3. Findings

- a. Deviation From Commitments  
None.
- b. Unresolved Item  
None.

G. Exit Meeting

A meeting was held at the conclusion of this inspection on April 27, 1979, with the following management representatives and the Authorized Nuclear Inspector:

G. R. Amsden, QA Engineer  
W. F. Becksted, Manager, Quality Assurance

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E. Cloutier, Assistant Plant Manager  
M. R. Fandetti, Manager, Manufacturing  
M. L. Fontaine, Manager, Quality Control  
V. J. Smith, Authorized Nuclear Inspector, The Hartford  
Steam Boiler Inspection and Insurance Company  
R. A. Stokes, Quality Control, Chief Examiner.

The scope and findings of this inspection were summarized. Management .  
acknowledged the statements relative to the findings.