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

Report No. 50-460/79-10 II
50-513/79-10 II

Docket No. 50-460, 50-513 Licensee No. CPPR-134, CPPR-174 Safeguards Group

Licensee: Washington Public Power Supply System

P. O. Box 968

Richland, Washington 99352

Facility Name: Washington Nuclear Projects Nos. 1 and 4 (WNP 1 & 4)

Inspection at: WNP 1 & 4 Site, Benton County, Washington

Inspection Conducted:

Inspectors: R J Dodds for 11/29/79
A. D. Toth, Resident Reactor Inspector Date Signed

Date Signed

Date Signed

Approved by: R J Dodds 11/29/79
R. T. Dodds, Chief, Engineering Support Section Date Signed

Summary:

Inspection during the period October 1-31, 1979 (Report Nos. 50-460/79-10 II and 50-513/79-10 II)

Areas Inspected: Routine, unannounced inspection activities by the resident inspector of construction activities including: containment concrete, spray pond concrete, structural backfill, pipe welding, pipe storage, pipe liquid penetrant examination, reactor vessel storage, reactor vessel internal storage, equipment storage, examination of licensee event reports and PSAR deviation records, and general work in progress.

Results: Of seven areas inspected relative to Unit #1, the inspector identified an item of noncompliance related to the placement of containment concrete (paragraph 8). Of six areas inspected relative to Unit #4, the inspector identified a deviation related to spray pond concrete work (paragraph 10).

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DETAILS

1. Personnel Contacted

The inspector interviewed various engineering, management, inspection, supervision, and craft personnel of the organization listed below. Key personnel, including those who attended the weekly management meetings, are specifically identified below.

a. Washington Public Power Supply System (WPPSS)

(2)	W. C. Bibb, Project Manager
(1, 4)	M. C. Carrigan, Construction Manager
(1, 3, 4)	T. J. Houchins, Project QA Manager
(2. 4)	W. M. Lazaer, Project QA Specialist
	J. W. Carson, Senior QA Engineer - Civil
(1)	W. C. Clemens, Construction Superintendent (Civil)
(4)	G. K. Dyekeman, Manager of Engineering
(4)	A. D. Edmondson, Field Engineering Supervisor

b. United Engineers and Constructors (UE&C)

(1)	R. S. Millne, Deputy Project Manager
(3, 4)	W. J. Taylor, Deputy Construction Manager
(1,2,3,4)	E. C. Haren, Deputy Project QA Manager
(1, 3, 4)	G. E. McIntosh, Assistant Deputy Project Manager
(1, 2, 4)	B. F. Brockett, Senior QA Engineer (ASME III-2)
	R. L. Murphy, Senior QA Engineer (Electrical)
(2. 3)	R. Siever, Senior QA Engineer (Mechanical)
	R. D. Bennett, Deputy Welding Superintendent
(1)	D. C. Leonard, Construction Supervisor (ASME III-2)
(4)	R. H. Bryans, Field Project Engineer Manager
(3)	N. D. Amaa, Field Project Engineer

c. G. F. Atkinson-Wright/Schuchart/Harbor (A-WSH)

M. Latch, QA Manager
T. Canning, Assistant QA Manager
J. Ivora, QC Supervisor

d. J. A. Jones Construction Company (JAJ)

R. Pope, Engineering Manager
B. Roe, Project QA Manager
B. Phillips, General Superintendent #1

e. Pacific Test Laboratories (PTL)

K. Blatso, Geotechnical Engineer
K. Johnson, Senior Supervisory Inspector

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f. Northwest Construction Company (NW)

C. Kinion, Superintendent
J. Mattoon, QA Representative

g. Babcock and Wilcox Construction Company (B&W)

L. Rafferty, Field Superintendent
D. Larson, Senior Site Representative

h. Hartford Steam Boiler Inspection and Insurance Company

Z. Zizak, Authorized Nuclear Inspector

i. George Grant Construction Company

W. Tillery, QA/QC Supervisor

j. University Nuclear Systems/University Mechanical

B. Sachs, QA Engineer

k. Shurtleff and Andrews

K. Engstrom, Assistant QA Manager

l. BEI/Royal Globe

K. Collins, Authorized Nuclear Inspector (ASME Section III Division 2)

(1) Denotes attendees at management meeting on October 9, 1979.
(2) Denotes attendees at management meeting on October 22, 1979.
(3) Denotes attendees at management meeting on October 29, 1979.
(4) Denotes attendees at management meeting on November 5, 1979.

2. Construction Status

The licensee reports that site construction work is approximately 31% complete for Unit #1 and 12% complete for Unit #4 as of October 31, 1979.

3. Plant Tours - Units 1 and 4

The inspector made plant tours during day and swing shifts at Unit #1 and Unit #4, at various times each week during this reporting period. He interviewed craftsmen, supervisors and inspectors as they were encountered in the various work areas, and he examined various in-process records such as work control forms, inspector logs, and equipment identification, calibration, and work hold/release tags. The tours included

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observations relative to compliance with general and specific codes and standards, regulatory guides and requirements and implementation of quality assurance program requirements. The results of detailed examination of work activities are described in other paragraphs of this report.

4. Followup on Licensee Reported Events

The inspector examined records and interviewed personnel regarding the licensee's letter to NRC related to the ommission of reinforcing steel from concrete structures dated October 8, 1979. On October 15, 1979 the licensee representative notified the inspector that engineering evaluation of the item had been completed and that it is not considered to be a reportable item. However, the inspector completed his review of the licensee's letter and addressed this matter as a previously identified unresolved item.

The licensee has corsidered all site contractors working on safety related structure reinforcing steel, and assessed the controls to assure that differences between design drawings and detailed placing drawings do not lead to omission of reinforcing steel. The licensee considered the following structures:

Contract	Structure
205 Hoffman Constr.	Containment Basemat
206 Boecon Constr.	General Service Building Walls
252 G. Grant Constr.	Spray Pond
253 A-WSH	Containment and Containment Interior
254 A-WSH	General Service Building

Some of these contractors had assured that this matter would be avoided since the QC inspectors perform inspections using design drawings, (contracts 205 & 252). The 206 contractor had performed redundant checking of design versus placement drawings by engineering and by QA organizations. For the other contracts (253 & 254) all design/placement drawings have been reviewed for consistency, except those prepared by AWSH for work above elevations where concrete work has not commenced. AWSH has been required to re-check such drawings as discussed in the licensee's letter of October 8, 1979. There were no instances where concrete has been placed in the containment shell with rebar omissions identified by the above reviews. The inspector had no further questions on this matter at this time. (Item closed)

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5. Licensee Application of ASME Code Case N-242

The inspector examined documents and interviewed personnel relative to the licensee's July 13, 1979 request for NRC approval of use of ASME code case N-242 for four atmosphere dump valves for Unit #4. The inspector ascertained that similar valves for Unit #1 were furnished by the same vendor (Component Controls International) and the status of their material certifications may be equivalent to those for Unit #4. This item is unresolved pending completion of the licensee's reivew and action. (460/79-10-01)

6. Records of PSAR Deviation Controls

The inspector examined the WPPSS thirteenth report of PSAR deviation status, dated October 13, 1979 and reviewed design change checklists and approval documents for two changes planned to be incorporated into the FSAR. The following two changes were considered relative to Criteria III, VI and XVII of Appendix B of 10 CFR50:

A. Deviation No. 8.3-2 regarding vertical flame tests on cable.
B. Deviation No. 9.5-1 regarding diesel generator qualification tests.

The reports included design and project engineering review by the licensee, and consideration of regulatory guides and applicable codes and standards as evidence of acceptability of the deviation to NRC. The control of these deviations appeared consistent with control requirements. No items of noncompliance were identified.

7. Containment Concrete Delivery, Placement, and Curing - Unit 1

The inspector observed work activities for concrete placement No. C2102 of the containment shell. He attended the preplacement meeting, examined the placement area prior to placement, observed concrete placement in-progress during the second shift, and observed subsequent curing operations. These activities were considered relative to the codes and standards requirements referenced in PSAR section 3.8.1.2, general quality assurance requirements discussed in PSAR section 17, and additional work standards provided in specification No. 253 section 3B.

The inspector observed laborers vacuuming water from the surface of the construction joint, but they did not attempt to vacuum water from under the reinforcing steel or near the liner plate. Water pools were present in depressions near the liner and in narrow slots between the liner and the concrete. The concrete placement was released to proceed, even though the contractor's quality control inspectors had not inspected the results of the vacuuming operation. Specification 253 part 10.2.3 called

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for saturation of the construction joint with water, but not subsequent removal of standing water. The failure to remove water from spaces to be occupied by concrete appears to be contrary to part CC-4252 of ASME Code Section III division 2 and part 6.4.1 of ACI-318-71. (460/79-10-02)

During the concrete placement activities the inspector observed handling of vibrators by 22 laborers, and he interviewed each. The inspector observed several instances of vibrators being inserted at angles of 30^{o}-45^{o} and instances of vibrators being thrown up to 6-feet and dragged through the concrete. The inspector observed five areas of insufficient consolidation near the liner plate. These were corrected in the presence of the inspector. The observed handling of the vibrators appears contrary to part CC-4226.1 of ASME code section III, part 7.1 of ACI-309-72, and part 10.4 of job specification no. 253 section 3B. (460/79-10-03)

During the concrete placement activities at night, the inspector observed that lighting for work within the forms consisted of 100-watt light bulbs spaced at about 10-feet, about 4-feet above the forms, and outside the outermost layer of reinforcing steel. Some of the lights were pulled through the steel network to provide improved lighting within the forms. In some areas the inspector judged lighting to be of questionable adequacy to permit observation of the visual indicators of adequate consolidation discussed in part 7.2 of ACI-309-72. In the opinion of the inspector, there was insufficient light for the laborers to observe consolidation of concrete in the vicinity of the liner plate.

Subsequently, the inspector observed on October 10 and 16, 1979 that localized construction lighting was improved for placement number C-2104. Small diameter vibrators were in use for assuring consolidation of concrete near the liner plate stiffeners, and QC inspectors were spending more time closer to concrete placement within the forms. Training sessions had been conducted for laborers regarding techniques of handling vibrators, and these were documented in UE&C surveillance report SR/CNR #C-792 and were witnessed by the ASME authorized nuclear inspector. These actions were summarized by the AWSH QA manager in an October 22, 1979 letter to WPPSS (ATUE-79-5760). The inspector had no further questions regarding lighting.

8. Containment Concrete Forms, Embedments, Reinforcing Steel - Unit 1 and Unit 4

The inspector observed work activities for placement of forms and embedments for concrete placement C-2104 of Unit #1, reinforcing steel cadweld splicing for the west wall of Unit #4, (including observations

at the splice test laboratory), and reinforcing steel bending at the fabrication yard for Unit #1 and Unit #4. These activities were considered relative to the codes and standards requirements described in PSAR Sections 3.8.1.2 and 3.8.1.6, general quality assurance requirements described in PSAR Section 17, and additional work standards provided in job specifications numbered 9779-253 Section 3D and AWSH-QCP-11. The inspection included the following aspects of the work:

a. Concrete forms clearances, tightness and cleanliness
b. Embedment fastening, freedom from rust and hardened spilled concrete and clearances from forms and between bar clearances
c. Reinforcing steel identification, bending specifications, bending quality control inspection and reject criteria and reject history
d. Cadweld splice crew (#100 and #225 specifically) qualification scope and frequency, test frequency, material control, record keeping, presence of quality control inspectors and inspection criteria, test laboratory equipment calibration and test result trends

No items of noncompliance or deviations were identified.

9. Lakes, Dams, Canals, Spray Pond - Unit #4

The inspector observed work activities on October 31, 1979 for placement of concrete in the Unit #4 spray pond southwest corner wall (placement #S-164, concrete order #217A). Activities were considered relative to the codes and standards requirements described in PSAR Section 3.8.4 and 3.12, general quality assurance requirements described in PSAR Section 17, work standards provided in job specifications numbered 252 and 211, and Pacific Testing Laboratories procedure QAP-XII-3 Revision 18. The inspection included the following aspects of the work:

a. Placement preparation - Cleanliness, leak tightness and anchoring of forms, and construction joint preparation.
b. Concrete delivery and placement - Specified mix, duration of hold time on trucks, temperature control of mix and ambient, testing for slump-air-strength (including testing technique and equipment calibration), adequacy of crew size and equipment and placing techniques (vibrator handling, free fall height of concrete, cleanliness control of rebar, and control of form pressure), presence and performance of QC inspectors.
c. Protected concrete curing of a north-end wall section.
d. Placement of moisture-loss prevention vapor barrier for a slap section of the spray pond.

The horizontal construction joint contained a key (full length depression 2-inches deep by 16-inches wide in center portion) in which about 2-inches of standing water was left during concrete placement. The concrete was placed so as to push the water before the concrete leading edge, except that placement from chutes about 4-feet ahead of the water trapped

the water between two leading edges, resulting in some mixing with the concrete. The vertical construction joint at the southwest corner of the spray pond wall, was wet down with water, but was not "coated with neat cement grout immediately before placing of new concrete." These practices deviate from the requirements of ACI-318-71, part 6.4.1, which is one of the applicable codes referenced in the PSAR. (513/79-10-01)

10. Foundations Preparation - Unit 1

The inspector observed work activities for placement and compaction of backfill for the area west of the general services building. The inspection included interviews with Northwest Construction Company QA and construction personnel and the UE&C contract supervisor for this contract, examination of test records, and observations of testing in progress for this placement (Phase VI - elevation 436+). These activities were considered relative to: the codes and standards requirements referenced in PSAR Section 2.5, Appendix 2P, and Section 17; the job specification #255 Section 2c; and Northwest Construction Company Procedures QAP-8 and CP-3. Requirements of ASTM-D2167-6 were considered for density testing on the field.

Records examined includes (1) proof tests performed on the base material prior to backfill (PTL compaction test results #300-2), (2) tests performed for each foot of compacted fill (PTL test results #301-2, 302-1A and 1B, 303-1A and 1B, 304-1A and 1B), (3) demonstration qualification compaction tests for Mikasa-MDR-9G and Wacker-74 hand operated compactors (Contract Waver Requests #W-008, W-010, W-011), (4) drawings #F-110018, F-110016, F-110019 and F-110008 for general consistency with the PSAR relative to boundaries for placement of Type A backfill in the phase VI area, and (5) Northwest Construction Company QA surveillance reports (#215 thru #219) for the phase VI work and two UE&C surveillance reports (SR/CNR-89 and 90) for this work.

No items of noncompliance or deviations were identified.

11. Safety-Related Piping Welding

The inspector observed welding in progress on two welds of the nuclear service water system. These were welds on carbon steel lines of 14-inch diameter and 24-inch diameter (#411530-FW-2 and #411537-FW-6). Also observed were weld joint preparation, argon purging in preparation for welding a stainless steel pipe joint (#411220-FW12), and availability and use of oxygen analyzers. The availability and use of purge gases for stainless steel pipe welding was checked during tours of the work areas.

The inspector checked the carbon steel welds for locations and identification on applicable isometric drawings in the field and examined the associated weld and NDE Record for identification of hold points and sign-off by QC inspection where required. The weld electrode requisit-

ions and electrode tags were verified to be as specified on the applicable drawing for the stage of completion of the welds observed. For the FW-2 weld, the inspector observed the fitup and tack welds, and checked the gap and mismatch of the pipe ends, and cleanliness of the joint.

The welders, fitters and firemen did not have pipe joint fitup gages, but they stated that QC inspectors did have such gages. No fitup deviations were observed by the NRC inspector. The welders did not have a copy of the weld procedure at the work area, nor did the foreman have copies of those procedures to be adhered to by welders working from his work station. The foreman stated that such procedures would be available in the main J. A. Jones control area in another area of the general services building. The availability of measuring tools required to perform proper weld joint fitup is unresolved (460/79-10-04), as is the availability of weld procedures to individuals performing welding activities (460/79-10-05).

The inspector examined QC inspection records and governing material specification No. 1310 relative to requirements of Regulatory Guide 1.71, PSAR Section 3.12 (1.71-I) and job specification #257. The specification requires that limited access ability of pipe welds involving materials described in the regulatory guide shall be radiographically examined. A J. A. Jones QC memorandum dated October 18, 1979 (Higgenbotham/All QV Personnel) demonstrated that the contractor had identified this item as requiring attention relative to part 4.4.4 of specification 257, and originated corrective action for examination of future work. However, there were no plans for review of limited access work accomplished to date. The licensee representatives subsequently stated that J. A. Jones staff will perform field inspections of completed welds and identify each weld where the limited access requirement applies and will document these on nonconformance reports to assure implementation of corrective action. The UE&C QA surveillance group has itself issued a contractor notification report (257/211-ISR/CNR-491) to assure followup on the field inspections, and clarification of JAJ procedure WI-016.1 part 4.4.20(b) requirements for advance notification to UE&C of limited access welds. The inspector had no further questions on this item. No items of noncompliance or deviations were identified.

12. Safety Related Piping (General)

The inspector observed work activities for general storage of Unit 1 and Unit 4 of piping in the laydown area, storage of Unit 1 nuclear service water piping in the general service building, temporary alignment of Unit 1 makeup water system piping on the makeup pumps, temporary supports/hoisting of Unit 1 makeup and nuclear service water piping, and temporary blocking/covering/protection of two pipe spools in penetration sleeves at Unit 4. These activities were considered relative to the ASME code Section III (1977) general quality assurance requirements described in PSAR Section 17, and additional work standards provided in

job specifications numbered 257 Section 15A.

The inspector's observations, records and personnel interviews included consideration of the following aspects of the work: (1) protection of weld end preparations and presence of pipe caps for cleanliness control; (2) hoisting methods to prevent stress to support structures (e.g. hangers) and damage to the pipe spools; (3) connections to rotating equipment to prevent cold-spring type stresses; (4) dunnage in storage areas, and (5) presence of pipe spool identification and QC release tags.

No items of noncompliance or deviations were identified.

13. Safety Related Piping Welding-Nondestructive Examination-Unit #1

The inspector observed work activities for second shift liquid penetrant testing of socket welds of stainless steel piping welded in the J. A. Jones on-site pipe fabrication shop. The inspector considered observations, records and personnel interviews in regard to at least the following aspects of the work: (1) certification of materials for halogen/sulphur content; (2) cleanness of the examination areas, suitability of the surfaces for examination; (3) temperature control of surfaces; (4) penetrant/developer application technique and timing, and (5) acceptance criteria used by the examiner. The routine presence of a UE&C surveillance engineer during such activities by on-site contractors was observed.

No items of noncompliance or deviations were identified.

14. Reactor Pressure Vessel Internals Storage - Unit 4

The inspector reviewed the NSSS supplier specification relative to storage of NSSS equipment, and inspected the internals for compliance with the specification relative to protective coverings, moisture control, and storage supports. The internals are stored in a separate locked building, with individual covers and dessicant and dessicant indicators, with bird and rodent controls. No items of noncompliance or deviations were identified.

15. Reactor Pressure Vessel Storage Protection - Unit 4

The inspector examined the storage conditions for the reactor pressure vessel to determine if (1) dunnage was adequate, (2) protective covering was not damaged, and (3) dessicant indicators showed adequate moisture control. The inspector also interviewed the responsible surveillance inspector and examined the inspector's record of surveillance-audits conducted. No items of noncompliance or deviations were identified.

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16. Reactor Pressure Vessel Protection After Installation - Unit #1

The inspector observed work activities for protection of the installed vessel at Unit #1, relative to environment and construction hazards. These activities were examined relative to the codes and standards requirements described in PSAR Sections 5.2.5 and 3.12 (1.38 and 1.39), general quality assurance requirements described in PSAR Section 17, and additional work standards provided in job specifications numbered FS-II-2 and FS-III-12.

The inspector considered observations, records and personnel interviews in regard to at least the following aspects of the work: presence of protective devices at nozzle, covers for prevention of access of contaminents to the stainless steel cladding and internal structures, fire retardant treatment of scaffold lumber and general construction hazard protection. The inspector also ascertained that the O-rings were stored as specified in shipping containers.

The inspector ascertained that water had entered the vessel during handling and in-place storage; this included concrete-curing water. The NSSS supplier has required that the water be removed and surface contamination swipe tests be taken to verify surface cleaning.

The inspector examined documentation of the observed conditions and control for resolution, in UE&C surveillance report #SR/CNR-70 (211) and nonconformance report 1-NCR-211-07. Swipe tests and cleaning of in-core tubes (capped) have not yet been accomplished. Examination of records and interview of UE&C QA personnel indicate that the nonconformance report has not yet been closed.

This matter is unresolved pending review of the licensee's evaluation of the swipe tests and completion of measures to prevent recurrance of water intrusion during in-place storage. (460/79-10-06)

17. Safety Related Components Storage, Handling, Protection - Units 1 & 4

The inspector toured the safety related equipment storage areas, which consisted of the warehouses at both Unit 1 and Unit 4, to determine if material protection requirements of the UE&C Quality Standards and Field General Construction Procedures were being implemented. Items examined included protective covers, identification, segregation of nonconforming material, protection of valve actuator devices, assignment and presence of quality control staff, and receiving/shipping/release controls.

No items of noncompliance or deviations were identified.

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18. Safety Related Components - Unit #4

The inspector observed work activities for protection and handling of components in Unit #4, including two shutdown cooling water heat exchangers (4-NSW-HX-1A and 2B), and associated pumps (4-NSW-PMP-1A and 2B). The inspector also examined the pump motors. These activities were examined relative to the codes and standards requirements described in PSAR Section 3.12 (1.38 and 1.39), general quality assurance requirements described in PSAR Section 17, and additional work standards provided in job specifications numbered 257 Section 15 Appendix C, and procedures numbered FGCP-16 and FQS-13.4.

The inspection included the following aspects of the work: handling cables used at designated lift points of the heat exchangers, labeling with component identification and dessicant content, dessicant indicator status, clearance from water pools, covering by tarps and wood roof structures, pump rotation and lubrication aspects of the preventative maintenance program, protection of anchor bolts, space heater activation on motors, and protection of equipment openings.

The inspector observed that the components were installed or in the process of being set onto anchor bolts in the lower level of the general services building. The areas were within the confines of the building walls, but absence of roof structures exposed the area to outdoor temperatures and weather. The heat exchangers were well wrapped except for the ends where covers were torn or removed. The condition was brought to the attention of the licensee and JAJ staffs, but replacement of the coverings was not effected prior to rain on November 4, 1979. The pumps and motors were covered with reinforced plastic tarps and were underneath a plywood roof on stilts. The motor space heaters were energized. Anchor bolts were exposed in the general area and where the components had been set. Corrosion was observed on heat exchanger heat bolts and equipment anchor bolts. This matter is unresolved pending review of the licensee's evaluation and disposition of the items described above. (513/79-10-02)

19. Electrical Components - Unit #1 and Unit #4

The inspector observed work activities for protection of the installed diesel generators at Unit #1 and Unit #4. Two machines are installed at each Unit, (stored in-place). These activities were considered relative to the codes and standards requirements described in PSAR Section 3.12 (1.38 and 1.39) and additional work standards provided in job specifications numbered 357 Section 15 Appendix C, and procedures numbered FGCP-16 and FQS-13.4.

The inspection included observations, records and personnel interviews in regard to the following aspects of the work: activation of space heaters

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in the generators, covers for openings, general coverings, and cleanliness control. He ascertained that this equipment was included in the periodic preventative maintenance program.

No items of noncompliance or deviations were observed.

20. Unresolved Items

Unresolved items are matters about which more information is required in order to ascertain whether they are acceptable items, items of noncompliance, or deviations. Unresolved items identified during this inspection are discussed in paragraphs 5, 7, 9, 11, 16 and 18.

21. Exit Interviews

The resident inspector met with licensee management representatives, and others invited by the licensee representatives, approximately weekly to discuss the scope of activities and inspection findings (October 9, 22, 29 and November 5, 1979) as detailed in this report. Attendees at these sessions are designated in Paragraph 1 of this report. Relative to unresolved items, the licensee lead representative conveyed the following commitments:

79-10-01: A review of Unit #1 atmospheric dump valves will be performed.

79-10-02: This item of noncompliance will be answered by correspondence to the regional office following receipt of NRC regional office notice of violation. However, corrective measures have already been initiated - implemented.

79-10-03: Same as 79-10-02 above.

79-10-04: This item will be replied to following correspondence from the NRC regional office. However, corrective measures have been initiated - implemented.

79-10-05: Weld joint fitup measuring instruments will be made available to welders/fitters.

79-10-06: Weld procedures will be made available to welders at a convenient location but not necessarily at the station where welding is in progress.

79-10-07: No comment.

79-10-08: The covers on the heat exchangers will be replaced, and action will be taken with the contractor (JAJ) to address this matter.

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