tinghouse Electric Corporation Power Systems

PA-78-033
Nuclear Fuel Division

Box 355
Pittsburgh Pennsylvania 15230

November 15, 1978

United States Nuclear Regulatory Commission
Office of Inspection and Enforcement
Region IV
611 Ryan Plaza Drive, Suite 1000
Arlington, Texas 76012

Attention: Mr. Uldis Potapovs, Chief
Vendor Inspection Branch

Gentlemen:

Inspection Report No. 99900005/78-02

This is in response to your letter of October 23, 1978, concerning the report of inspection conducted from October 2-6, 1978, at the Westinghouse Nuclear Fuel Division manufacturing plant in Columbia, South Carolina.

The enclosed Attachment I, "Response to Deviation Noted During Inspection of Westinghouse Nuclear Fuel Division" contains our response to the specific finding of the inspection as contained in the above referenced inspection report. Where appropriate, corrective actions taken, actions planned to prevent recurrence and estimated completion dates are included.

We have reviewed Inspection Report No. 99900005/78-02 and find that it contains no information which we consider proprietary in nature.

Should you have any questions concerning this letter, we would be pleased to discuss them with you.

Sincerely,

WESTINGHOUSE ELECTRIC CORPORATION

H. L. Russo, Manager
Product Assurance Department
Nuclear Fuel Division

cc: W. J. Dollard
Enclosure

7902050232

ATTACHMENT I

Response to Deviation Noted During Inspection of
Westinghouse Nuclear Fuel Division

The following contains the detailed response to the deviation noted in U.S. NRC Inspection Report No. 99900005/78-02. Where appropriate, corrective actions taken, actions planned to avoid recurrence and estimated completion dates are included.

Inspection Report No. 99900005/78-02

Notice of Deviation

The specification which controls inert-gas shielded-arc welding of austenitic stainless steels, 595215, Revision 6, paragraph 6.6.2, states in part, "In the event the electrode contacts base metal or filler wire during welding, extinguish arc immediately. . . if the electrode has become 'stuck', turn off weld generator and then remove the electrode from the work. Redress the electrode end as shown above. . . When electrode has contacted or 'stuck' on base metal or deposited weld metal, contact area(s) shall be ground to remove all electrode material."

Contrary to the above, control of welding was not maintained in that:

(1) The operating procedures used in assembly of control rod spiders, 732100, Revision 2, and welding of fuel assemblies, 732110, Revision 0, did not include the necessary instructions to assure compliance with paragraph 6.6.2 of the applicable specification.

(2) Welding operations were observed in which the electrode contacted or "stuck" to the parts and the welding arcs were not extinguished, electrodes were not redressed, or were contacted areas ground as is required by paragraph 6.6.2 of the applicable specification (see details, E.3.a.).

Westinghouse NFD Response

Westinghouse NFD concurs in the inspector's observations that operating procedures did not include the necessary instructions to assure compliance with the applicable specification, and that when electrodes "stuck" to parts being welded, the welding arc was not extinguished, electrodes were not redressed, or contacted area ground as required by applicable specifications. As a result of this observation, the following actions will be taken:

1. The referenced process specification will be revised to require that in the event the electrode inadvertently contacts or becomes stuck to the base metal during welding, the arc shall be extinguished by manually tapering, the electrode shall be removed from the work piece, the affected area visually examined, and any tungsten inclusion removed by grinding.

   This action will be completed by December 1, 1978.

2. A general welding operating procedure will be prepared and will include process specification welding requirements. This general operating procedure will describe required welding techniques and will be referenced in detailed welding procedures. Work place meetings will be held to instruct welders in the procedure requirements.

   This action will be completed by December 1, 1978.

3. Other pertinent process specifications will be reviewed to assure compatibility between specification requirements and operating instructions.

   This will be an ongoing effort and will be included in future internal audits.