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

Report No. 99900292/78-02 Program No. 44055

Company: Newport News Industrial Corporation
4101 Washington Avenue
Newport News, Virginia 23607

Inspection Conducted: October 23-27, 1978

Inspector: J. W Sutton 11/20/78
J. W. Sutton, Contractor Inspector, Vendor Inspection Branch Date

Approved by: V H Guntter Jr 11-20-78
D. W. Whitesell, Chief, Components Section I, Vendor Inspection Branch Date

Summary

Inspection on October 23-27, 1978

Areas Inspected: Implementation of 10 CFR 50, Appendix B criteria and applicable codes and standards including, action on previously identified items, calibration and nonconformance/corrective action. The inspection involved thirty-four (34) inspector-hours on site by the NRC inspector.

Results: In the three (3) areas inspected, no apparent deviations or unresolved items were identified in two (2) areas. The following was identified in the remaining area.

Deviations: Calibration. The QA Program does not prescribe a system for recalling/rechecking of previously inspected items, when an out-of-calibration tool, gage or instrument has been identified as required by Criterion XII of 10 CFR 50, Appendix B, NCA 4134.12(c) of Section III of the ASME Code and Section 11.3100(f) of the ASME accepted QA Manual.

Unresolved Items: None.

DETAILS SECTION

A. Persons Contacted

*M. R. Eshelman, Director of Engineering
*J. O. West, QA Manager
*C. O. Horton, Manager M57, QA, NNSD
*D. W. Rainey, QA Engineer, NNS
*E. H. Wright, QA Engineer
*P. K. Ryan, QA Engineer
*J. E. West, Engineering Supervisor, NNS
*M. V. Warren, QA Engineer
M. Crocker, Supervisor M57, Calibration
J. Whitmore, Calibration Recall Clerk
P. Salmon, Calibration Co-ordinator
P. Cross, Calibration Clerk
C. R. Appleton, Supervisor X31, NNS
J. R. Bolden, QA Shop Supervisor, NNS
C. Brown, QA Engineer

*Denotes those present at the Exit Interview.

B. Action on Previous Inspection Findings

1. (Closed) Deviation (Report No. 78-01): Failure to tag component parts as required by QA Manual. The inspector verified by review of documentation and inspection of inprocess materials that implementation of corrective action has been complied with as indicated in NNI's letter of June 16, 1978. Training sessions for all supervisory and inspection personnel has been completed. Materials observed in process were found to be properly tagged.

2. (Closed) Deviation (Report No. 78-01): The inspector verified by review of documentation and thermocouple installations that the corrective action stated in NNI letters of June 16 and July 31, 1978, has been implemented. Audits of the heat treating activity and thermocouple controls is being performed by QA on a scheduled basis.

C. Calibration

1. Objectives

The objectives of this area of the inspection were to verify that these activities were controlled in accordance with the QA Manual and applicable NRC and ASME Code requirements:

a. A system has been established and is maintained to assure that tools, gages, instruments and other measuring devices used in activities affecting quality are properly controlled, calibrated and adjusted at specified periods to maintain accuracy within specified limits.

b. Calibration records are kept for each instrument and that these records include the following information as required:

(1) Calibration history.

(2) Accuracy required and calibration results.

(3) Location for use.

(4) Present calibration interval and date due.

(5) All maintenance and repair details.

(6) Person or agency performing all calibration.

(7) Identification of each standard used to perform calibration.

(8) Number or name of the calibration procedure.

(9) Environmental conditions used during calibration.

(10) Equipment recall schedules.

2. Method of Accomplishment

The preceding objectives were accomplished by:

a. Review of the QA Manual, Section 11.000, Revisions C-E and F, to verify that provisions have been included to assure that equipment requiring calibration is identified and a calibration frequency is specified. The calibration standards and traceability of standards is specified and a recall system is in effect.

b. Review of calibration procedures, Q1022 calibration system, Revision C, February 18, 1977, UT, X03.7.12, February 1978, and Section E of 11.D.1.C2.9.

c. Review of Qualifications of calibrators.

d. Review of the current composite measurement equipment list dated July 18, 1978.

e. Review of the recall system files.

f. Review of calibration due notices and over due records.

g. Review of the card index systems.

h. Review of equipment certification standards for:

(1) Gage Blocks, SN-NNS-14.

(2) Current Transformer Standard, E 00842.

i. Inspection of the calibration facilities for mechanical, electrical and instrument calibration.

j. Review of the certification records for the following:

(1) Micrometers, MXAA 301-003, 307-009, 309-624, 307-006; MXDA 306-164; MXAB 302-026, MXAA 302-080, machine area.

(2) Depth gage 5433-77, X10 department.

(3) Thermocouple recorder, 066-11-0326, B63-751694-1.

(4) Weld machine 56496-F3.

k. Discussions with cognizant personnel.

3. Findings

From the documents and records reviewed, and observation of the nuclear work in progress, it was determined that the system prescribed for control and calibration of gages, tools and instruments is consistent with the NRC Rules and Code requirements. However, it was found that a system for identifying materials checked by out-of-Calibration Tools, gages or instruments, does not exist. Without positive identification of those materials examined by the above tools, gages or instruments, Section 13.1100(d) cannot be implemented, which could result in nonconforming material and or items being used inadvertently.

a. Deviations

See Enclosure.

b. Unresolved Items

None.

D. Nonconformance and Corrective Action

1. Objectives

The objectives of this inspection were to:

a. Verify that a system for control of nonconformances and corrective actions has been established and is consistent with NRC rules and the QA Program requirements; and

b. To verify that the system is properly implemented.

2. Method of Accomplishment

The objectives of this area of the inspection were accomplished by:

a. Review of the QA Manual, Section 13.0000, Revision F, titled, "Nonconformities and Corrective Action," to verify that procedures have been developed and approved for controlling nonconformances/deviations and also that the system provides for the following:

(1) The program and procedures provide for the identification and reporting of nonconformances; and

(2) The program delegates:

(a) Responsibilities for receipt, review, and analysis of nonconformance reports.

(b) Responsibility for recommending corrective action;

(c) Responsibility for approving recommended corrective action;

(d) Responsibility for follow-up to verify that corrective action has been implemented, is effective, and precludes recurrence;

(e) Management participates in the review of nonconformance report and corrective actions; and

(f) The nonconformances and corrective actions are reviewed by the ANI.

b. Review of nine (9) nonconformance reports to verify that the nonconformances were appropriately dispositioned and that;

(1) The assigned responsibilities are carried out by designated persons.

(2) The system for identifying and reporting nonconformances, and for evaluating and enacting corrective action, is timely and effective.

(3) That nonconforming items are properly disposed of.

(4) That corrective action follow-up was properly performed.

(5) That management participation is effective in minimizing recurrence.

c. Review of manufacturing problem reports, 946N-X10-22 and N465N-X10-113.

d. Review of the nonconformance log book.

e. Inspection of the segregation system.

f. Review of QA Audits of the nonconformity system conducted to date.

g. Discussions with cognizant personnel.

3. Findings

From the documents and records reviewed, and observation of the nuclear work in progress, it was determined that the system for controlling nonconformances and corrective action is consistent with the NRC Rules and Code requirements.

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

E. Exit Interview

The inspector met with management representatives (denoted in paragraph A) at the conclusion of the inspection. The inspector summarized the scope and findings of the inspection. The management representatives had no comment in response to the items discussed by the inspector.

The inspector reviewed the format to be used by the company when responding to inspection findings which requires corrective action to be initiated.