

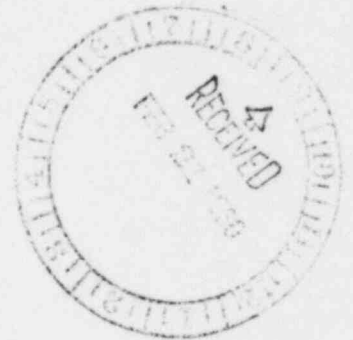
Washington Public Power Supply System  
A JOINT OPERATING AGENCY

P. O. Box 968 3000 GEO. WASHINGTON WAY RICHLAND, WASHINGTON 99352 PHONE (509) 375-5000

February 19, 1980  
G01-80-79

Nuclear Regulatory Commission  
Region V  
Suite 202, Walnut Creek Plaza  
1990 N. California Boulevard  
Walnut Creek, California 94596

Attention: Mr. G. S. Spencer,  
Chief Reactor Construction  
and Engineering Support Branch



Dear Mr. Spencer:

Subject: WPPSS NUCLEAR PROJECTS NOS. 1/4  
NRC INSPECTION - WNP-1/4  
DATES OF INSPECTION - DECEMBER 1-31, 1979  
DOCKET NOS. 50-460 AND 50-513  
CONSTRUCTION PERMIT NOS. CPR-134 AND 174

Reference: Letter from G. S. Spencer to N. O. Strand, NRC Inspection  
at WNP-1/4 Site, dated January 16, 1980.

The referenced correspondence delineated the results of the December 1-31, 1979 inspection of activities authorized by NRC Construction Permits Nos. CPPR-134 and 174. Further, the referenced correspondence identified a certain activity which was not conducted in full compliance with PSAR requirements set forth in the Notice of Violation enclosed as Appendix A. This item of noncompliance has been categorized into a level as described in your correspondence to all NRC licensees dated December 31, 1974. In addition, Appendix B identifies an item categorized as a deviation.

This letter is submitted in response to the referenced correspondence. The specific NRC finding, as identified, and the Supply System response is provided herewith as Appendices A & B.

Very truly yours,

D. L. Renberger  
Assistant Director, Technology

jds  
Attachment

cc: CR Bryant - BPA  
SB Barnes - UE&C, Phil.  
BD Redd - UE&C, Phil.  
J. Freeman - UE&C, Phil.  
AD Toth - NRC, Site-1/4

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## APPENDIX A

Washington Public Power Supply System  
P.O. Box 968  
Richland, Washington 99352

Docket Nos. 50-460  
Construction Permit No. CPPR-134

### NOTICE OF VIOLATION

Based upon the results of NRC inspection activities conducted by the resident inspector during the period of December 1-31, 1979, it appears that one of your activities was not conducted in full compliance with conditions of your NRC Construction Permit No. CPPR-134 as indicated below.

Criterion 9 of Appendix B of 10CFR50 requires that measures shall be established to assure that special processes, including welding..., are controlled and accomplished by procedures, in accordance with applicable codes, standards, specifications, criteria, and other special requirements. Section 17 of the PSAR describes implementation of Appendix B, and Section 3.12 describes Regulatory Guides 1.31 and 1.44. The WPPSS contract specification #257 Section 17A-3 item 3.1.2.1 requires that "Weld procedures shall include instructions governing heat input---bead width shall be maximum of 3 times the core diameter for the manual SMAW." The contractor procedure JAJ-WP-P8-1 includes instructions on weld technique, regarding oscillation, -- 3 times electrode core diameter. (i.e., 3/8-inch maximum weave.)

Contrary to the above, on December 17, 1979, examples where the maximum width of 3/8-inch weld weave was exceeded were identified in auxiliary feedwater and purification system piping in completed and inspected welds numbered F411499-021 and F411975-006. These welds contained excessive weaves of 3/4-inch and 5/8-inch respectively.

This is an infraction.

### SUPPLY SYSTEM RESPONSE

#### Corrective Actions Taken and Results Achieved

- a. CNCR's 1-CNCR-211-084 and 1-CNCR-257-493 were written by the Contractor to document excessive weld weave identified as an infraction.
- b. CNR 636 was issued to the Contractor requesting reinspection of all stainless steel welds welded by the SMAW process to verify conformance for weld weave width. Identified deficiencies will be controlled through the Contractor nonconformance program.

Corrective Actions Taken to Preclude Recurrence

- a. A training session was conducted by the Contractor on January 31, 1980 for all craft superintendents and QV personnel on requirements for weld bead width.
- b. The J.A. Jones Visual Weld Inspection Procedure NDE-008 will be revised to include weld weave width as an inspection point during final acceptance inspection.
- c. A general list of regulations for welders employed by J.A. Jones is presented to craft personnel as part of welder indoctrination. Specific limitations for weld weave technique for stainless steel and carbon steel have been stated.

Date of Full Compliance

March 17, 1980

APPENDIX B

Washington Public Power Supply System  
P.O. Box 968  
Richland, Washington 99352

Docket No. 50-513  
Construction Permit No. CPPR-174

NOTICE OF DEVIATION

Based on the results of an NRC inspection conducted during the period of December 1-31, 1979, it appears that one of your activities was not conducted in conformance with your commitments to the Commission as indicated below:

Contrary to ANSI-N45.2.2, parts 6.2.1 and 6.5, (applicable standard referenced in PSAR Section 3.12 under Regulatory Guide 1.38), provisions had not been provided to control and limit access to level C storage areas only to personnel designated by the responsible organization, during December, 1979.

This is a deviation.

SUPPLY SYSTEM RESPONSE

The Supply System has reviewed the provisions to control and limit access to level C storage areas only to personnel designated by the responsible organization and concluded that existing administrative and security controls are adequate.

To further ensure compliance, the Supply System will provide additional visibility to the control of access to storage areas by posting the following sign in prominent locations by March 31, 1980:

LIMITED ACCESS, AUTHORIZED PERSONNEL ONLY, VIOLATORS WILL BE TERMINATED