



Washington Public Power Supply System
A JOINT OPERATING AGENCY

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May 7, 1980
G01-80-140



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 - JANUARY 1-31, 1980
DOCKET NOS. 50-460 AND 50-513
CONSTRUCTION PERMIT NOS. CPPR-134 AND 174

Reference: Letter from G. S. Spencer to N. O. Strand, NRC Inspection
at WNP-1/4 Site, dated April 7, 1980.

The referenced correspondence delineated the results of the January 1-31, 1980 inspection of activities authorized by NRC Construction Permits Nos. CPPR-134 and 174. Further, the referenced correspondence identified certain activities which were not conducted in full compliance with PSAR requirements set forth in the Notice of Violations enclosed as Appendix A. These items of noncompliance have been categorized into a level as described in your correspondence to all NRC licensees dated December 31, 1974.

This letter is submitted in response to the referenced correspondence. The specific NRC findings, as identified, and the Supply System response is provided herewith as Appendix A.

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, WNP-1/4 Site

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APPENDIX A

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

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

NOTICE OF VIOLATION

Based on the results of NRC inspections conducted during the period of January 1-31, 1980, it appears that certain of your activities were not conducted in full compliance with conditions of your NRC Construction Permit No. CPPR-134 as indicated below:

- A. 10 CFR 50, Appendix B, Criterion V, states, in part, that "Activities affecting quality shall be prescribed by documented instructions, procedures or drawings, of a type appropriate to the circumstances..."

WPPSS Contract Specifications 211 and 257 for the installation of piping specifies that attachments to structural steel shall be done in accordance with the AWS Structural Welding Code D.1.1-1974. Part 8.14 of this code requires that temporary welds shall be subject to the same welding procedure requirements as final welds. Also, part 3.2 of this code requires cleaning of foreign material from surfaces to be welded.

Contrary to the above requirements, as of January 28, 1980, no documented instructions, procedures or drawings were provided to control the installation and removal of temporary attachment welds to structural steel of the Unit 1 general services building, a safety-related structure. Temporary attachments were welded to this structural steel without cleaning paint from the areas to be welded.

This is an infraction.

SUPPLY SYSTEM RESPONSE

Corrective Actions Taken and Results Achieved

J.A. Jones Construction Co. has initiated JAJ-W1-10.4 Rev. 0C titled Temporary Hangers and Supports. This procedure describes the requirements for attaching temporary welds and the cleaning of foreign material from surfaces to be welded. This procedure has been approved as noted on April 30, 1980.

SUPPLY SYSTEM RESPONSE (Cont'd)

Corrective Actions Taken to Preclude Recurrence

Procedure JAJ-W1-10.4 Rev. 0C has been implemented and unsatisfactory temporary attachment welds will be removed and documented on CNCR's as committed to in Contractor Notification Report 758.

Surveillances by WPPSS/UE&C QA will be performed to monitor implementation of the procedure.

Date of Full Compliance

April 30, 1980

- B. 10 CFR 50, Appendix B, Criterion V, states, in part, that "Activities affecting quality shall be prescribed by documented instructions, procedures, or drawings of a type appropriate to the circumstances and shall be accomplished in accordance with these instructions, procedures, or drawings...."

Contrary to the above, on January 3, 1980, pipe support Nos. MUS-103-SG-2 and DHR-036-SG-3 each had one fillet weld that was 1/16 inch undersize and pipe support DHR-035-SG-4 had one fillet weld that was 1/8 inch undersize from that shown on the support fabrication drawings. These welds had received quality control inspection at the vendor shop and were considered acceptable.

This is an infraction.

SUPPLY SYSTEM RESPONSE

Corrective Actions Taken and Results Achieved

The undersized welds identified during the inspection have been documented on nonconformance reports.

Project Quality Assurance is continuing to sample pipe supports fabricated by Huico. To date we have inspected one hundred twenty seven (127) hangers and noted only three (3) deficient welds. These deficient welds were documented on NCR's.

Corrective Action Taken to Preclude Recurrence

The hanger fabricator's QA Manager conducted a training session for welders and inspectors on February 6, 1980. Weld symbols and weld size were stressed during the training session.

The UE&C resident V/S representative visually inspected and gaged one hundred (100) fillet welds for proper size at the vendor's shop. No deficiencies were identified.

Weld sizes from Huico are typically oversized by approximately ten (10) to fifteen (15) percent, per approval of UE&C Engineering in Philadelphia.

Project Quality Assurance will continue to surveil for undersize welds on a routine basis. It appears that the undersized welds are isolated cases rather than a consistent pattern.

Date of Full Compliance

April 30, 1980