



SMUD

SACRAMENTO MUNICIPAL UTILITY DISTRICT □ 6201 S Street, Box 15830, Sacramento, California 95813; (916) 452

June 25, 1970

United States Atomic Energy Commission
Division of Compliance, Region V
2111 Bancroft Way
Berkeley, California 94704

Attention: Mr. R. W. Smith, Director

Dear Mr. Smith:

AEC Division of Compliance Audit
Rancho Seco Nuclear Generating
Station, Unit No. 1
May 26 through May 28, 1970



We have reviewed the construction discrepancies which were discovered on subject audit as set forth in your letter of June 18, 1970.

The District has taken action on these matters as follows:

1. AEC Audit Finding:

The Preliminary Safety Analysis Report, Appendix 5C, Section 4.0.f., states, with respect to Cadweld splices, that "A permanent line shall be marked 12 inches back from the end of each bar for a reference point to confirm that the bar ends are properly centered in the splice sleeve." Contrary to this statement, none of the Cadweld splices for the containment building walls observed during the inspection were marked in the manner described.

Corrective Action Taken:

The contractor was immediately notified of the discrepancies and had provided a written corrective action statement to the effect that the prescribed marking of the rebar will be re-instituted and continued through completion of all cadwelding on Rancho Seco.

Inspection planning which details all the requirements of cadwelding, including the marking, has been written to provide objective evidence that each cadweld has been properly inspected.

A sample of 13 of the approximate 90 cadwelds exposed were radiographed to assure proper centering had been achieved. All radiographs indicated that the cadwelds were properly centered.

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June 24, 1970

Follow-up audits have verified the effectiveness of the above corrective action.

2. AEC Audit Finding:

Section 8.4.2 of the Chicago Bridge and Iron Company quality control procedures relating to the welding of the containment vessel liner states, with regard to the care and control of low hydrogen E7018 electrodes, that "...welders will be instructed to remove only enough electrode from the heated storage oven to be used during one shift. Excess electrodes which have been exposed to the atmosphere shall be stored in the holding ovens." Section 8.5 (e) of the quality control procedures states that the Project Welding and QA Supervisor will exercise control over welding materials by "...policing work areas once a day to make sure that loose bundles of electrodes are removed."

Our inspector observed the following practices which are contrary to the procedural controls discussed above.

- a. Low hydrogen E7018 electrodes were stored in a cold storage bin rather than in a heated oven.
- b. Ten low hydrogen E7018 electrodes were found in an open container adjacent to a work area below the equipment hatch.

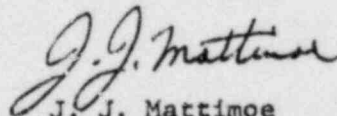
Corrective Action Taken:

- A. The contractor has been notified in writing of the deficiency on weld rod control. In addition, meetings have been held with Chicago Bridge & Iron management personnel emphasizing the need for stricter control of weld rod.
- B. Bechtel has instituted a more intensive after shift policing of this activity to avoid recurrence of this condition.

Follow-up audits have verified the effectiveness of the above corrective action.

Evidence of the above actions will be available upon your next visit to Rancho Seco.

Very truly yours,



J. J. Mattimoe
Assistant Chief Engineer