

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

Report No. 99900021/80-01

Program No. 51300

Company: Pullman Power Products
Division of Pullman Incorporated
P. O. Box 3308, Reach Road
Williamport, Pennsylvania 17701

Inspection Conducted: April 21-24, 1980

Inspector: *D. M. Hunnicutt* 4/30/80
for I. Barnes, Contractor Inspector Date
Components Section II
Vendor Inspection Branch

Approved by: *D. M. Hunnicutt* 4/30/80
D. M. Hunnicutt, Chief Date
Components Section II
Vendor Inspection Branch

Summary

Inspection on April 21-24, 1980 (99900021/80-01)

Areas Inspected: Implementation of 10 CFR 50, Appendix B, criteria and applicable codes and standards; including action on previous inspection findings, internal audits, heat treatment and nonconformances and corrective action. The inspection involved twenty-five (25) inspector-hours on site.

Results: In the four (4) areas inspected, no apparent deviations or unresolved items were identified.

DETAILS SECTIONA. Persons Contacted

- R. N. Babcock, Manager, Purchasing
- *A. Bair, QA Manager
- *E. L. Baker, Plant Manager
- W. L. Cox, Senior QA Auditor
- *T. Daniels, QA Director
- *J. A. Koch, Manager, Manufacturing Engineering
- *J. J. Krommenhoek, Production Manager
- *T. C. Myers, Welding Engineer
- *F. J. Richards, Welding Engineer
- *R. A. Stryker, QA/QC Supervisor
- J. R. Weaver, Project Engineer
- *H. J. Donlin, Authorized Nuclear Inspection Specialist,
Hartford Steam Boiler Inspection and Insurance Co.
- *D. Klose, Authorized Nuclear Inspector, Hartford Steam Boiler
Inspection and Insurance Co.

*Denotes those persons attending the exit meeting.

B. Action on Previous Inspection Findings

1. (Closed) Deviation (Item A, Notice of Deviation, Inspection Report No. 79-02): Use of chain slings on stainless steel sub-assemblies without prior wrapping in burlap or cloth.

The inspector verified that the committed directive had been issued to responsible supervision. Observation by the inspector of shop handling activities relative to stainless steel assemblies, revealed no further instance of deviation from QA program commitments.

2. (Closed) Deviation (Item B, Notice of Deviation, Inspection Report No. 79-02): Failure to fully provide applicable quality requirements on a certain purchase order and non-submittal to QA of two purchase order revisions for review and approval.

The inspector verified that the committed purchase order review and training session had been conducted.

C. Internal Audits1. Objectives

The objectives of this area of the inspection were to:

- a. Ascertain that a system has been prescribed and documented for auditing, which is consistent with the commitments of the QA program.

- b. Determine that the system has been properly and effectively implemented.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of Section XVIII, revision dated February 15, 1979, of the QA Manual, "Audits."
- b. Review of Williamsport Shop Procedure No. XVIII - IW, revision dated May 25, 1979, "Internal Auditing Procedure of Shop QA Programs by QEG."
- c. Examination of audit check lists used to perform audits in 1979 of the Williamsport plant.
- d. Verification that the audit check lists provided for adequate measurement of plant compliance with the documented QA program.
- e. Review of team leader qualifications and team orientation records.
- f. Verification of reporting of audit results to responsible levels of management.
- g. Review of follow-up actions regarding implementation of agreed corrective actions for audit findings.
- h. Review of audit frequencies relative to QA program commitments.
- i. Discussions with cognizant QA personnel relative to proposed scope of internal audit activities for 1980.
- j. Review of the results of the 1979 management audit of the Pullman Power Products, Williamsport Plant (PPPA) QA program and follow-up actions taken.

3. Findings

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

D. Heat Treatment

1. Objectives

The objectives of this area of the inspection were to verify that elevated temperature heat treatments were being performed in accordance

with written procedures and that the procedures were consistent with applicable code, customer and material specification requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of Section IX, revision dated February 15, 1979, of the QA Manual, "Control Of Special Process."
- b. Review of solution annealing requirements in Bechtel Specification No. X4AQ01, Revision 6, "Specification For Shop Fabrication Of Nuclear Service Piping For The Georgia Power Company Alvin W. Vogtle Nuclear Plant Burke County, Georgia Units 1, 2 And Common."
- c. Review of solution annealing requirements in PPPA Project Procedure IX-3-S75, revision dated November 17, 1977, "Fabrication & Field Installation Specification For Nuclear Power Plant Components, Piping Systems And Appurtenances - ASME Section III."
- d. Review of PPPA Shop Procedure No. X-14W, revision dated November 14, 1977, "Furnace Load Check."
- e. Examination of four (4) solution annealing charts and cooling certifications.
- f. Verification of calibration status of temperature recorders installed in the furnace utilized for solution annealing heat treatment.

3. Findings

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

E. Nonconformances and Corrective Action

1. Objectives

The objectives of this area of the inspection were to ascertain that:

- a. A system had been established for the control of nonconformances and for assuring effective corrective actions.
- b. The system was implemented.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of Section XV, revision dated February 15, 1979, of the QA Manual, "Nonconforming Materials, Parts or Components."
- b. Review of Section XVI, revision dated February 15, 1979, of the QA Manual, "Corrective Action."
- c. Review of PPPA Shop Procedure No. XV-IW, revision dated October 17, 1979, "Processing and Handling Nonconformances."
- d. Examination of 1979 Defective Material Reports and Nonconformance Reports with respect to:
 - (1) Identification of item.
 - (2) Description of nonconformance and identity of reporting party.
 - (3) Identification of party responsible for the nonconformance and party responsible for resolution.
 - (4) Verification that proposed dispositions were subject to QA program required reviews and that the dispositions were in accordance with ASME Code requirements.
 - (5) Evidence of Authorized Nuclear Inspector cognizance of nonconforming conditions.
 - (6) Performance of corrective action measures in accordance with approved dispositions.
- e. Verification of performance of required review by QA management of 1979 nonconformance reports.

3. Findings

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

F. Exit Meeting

The inspector met with the management and Authorized Inspection Agency representatives denoted in paragraph A. above on April 24, 1980, at the conclusion of the inspection. The scope and results of the inspection were summarized by the inspector. The inspector also informed the management

representatives present that his program assignment had been essentially completed at the Pullman Power Products Williamsport facility and another NRC inspector would most probably be assigned inspection responsibilities for the facility. Management acknowledged the statements of the inspector and had no specific questions regarding the information presented to them.