

Westinghouse Electric Corporation  
Pensacola Plant  
Docket No. 99900104/80-01

NOTICE OF DEVIATION

Based on the results of an NRC inspection conducted on April 21-25, 1980, it appeared that certain of your activities were not conducted in full compliance with NRC requirements as indicated below:

Criterion V of Appendix B to 10 CFR 50 states:

"Activities affecting quality shall be prescribed by documented instructions, procedures, or drawings, or a type appropriate to the circumstances and shall be accomplished in accordance with these instructions, procedures, or drawings. Instructions, procedures, or drawings shall include appropriate quantitative or qualitative acceptance criteria for determining that important activities have been satisfactorily accomplished."

Deviations from these requirements are as follows:

- A. ASME Code Section IX, Article II, QW-282.4 states in part, "Essential Variables . . . Plasma Arc Welding. The WPS shall be set up as a new WPS, and shall be completely requalified, when any of the following changes are made . . . . (g) A change in the voltage beyond the range specified. (i) . . . A decrease of 10 percent, or more, in the rate of flow of shielding gas or mixture."

WPS PAW-MA-385, revision 3, required the use of 14-18 volts and a shielding gas flow rate of 50 CFH.

Contrary to the above, the inspector observed in-process hard facing weld metal overlay operations, using WPS PAW-MA-385 on Shop Order PCZL 454, in which the following violations of essential variables occurred:

- (1) Welding was being performed using 26 volts.
  - (2) The shielding gas flow rate was 45 CFH.
- B. Procedure DMP-15-4-5524, revision 4, requires the placement of two thermocouples (one each on the upper and lower flanges) during postweld heat treatment (PWHT) of pressurizer nozzles.

Contrary to the above, the PWHT chart recording dated April 12, 1980, for a pressurizer nozzle, shop order 174, serial number W664 A01, revealed just one thermocouple was used.

Additional concerns were expressed by the inspector, relative to PWHT.  
(Detail Section, paragraph E.3.c.)