

**IHI** **ISHIKAWAJIMA-HARIMA**  
**HEAVY INDUSTRIES CO., LTD.**  
**YOKOHAMA NO. 3 WORKS**

1, SHIN-NAKAHARA-MACHI, ISOGO-KU, YOKOHAMA, 235, JAPAN  
TELEPHONE: 045-751-1231 TELEX: 3822386 J47758  
CABLE ADDRESS: IHICO THIRD YOKOHAMA

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  - Jakarta
  - Sydney
  - Teheran

QAG-OL-043  
March 31, 1980

United States  
Nuclear Regulatory Commission  
Region IV  
611 Ryan Plaza Drive, Suite 1000  
Arlington, Texas 76011  
U.S.A.

Attention: Mr. Uldis Potapous  
Chief, Vendor Inspection Branch

Reference: Docket No. 99900038/80-01

Gentlemen:

I received your letter referenced above on March 3, 1980.

Enclosed herewith please find and accept our written statement which responds to your "NOTICE OF DEVIATION".

Very truly yours,

Makio Amano  
Makio Amano  
General Manager  
Nuclear Power Division  
Ishikawajima-Harima Heavy  
Industries Co., Ltd.

Encl.







Written

Finding A-1

Corrective Action

Not Applicable.

Measure to Prevent Recurrence

Audit schedule for two full

Spring - 1980 Audit

Date: May 19, 1980 through

Lead Auditor: Mr. H. Kur

Autumn - 1980 Audit

Date: November 17, 1980

Lead Auditor: Mr. A. Kur

This schedule was submitted  
assigned Chief Engineer of  
activity of Quality Assurance

Date of Completion of Implementation

1. Corrective Action: N
2. Measure to Prevent Recurrence: N



Written Statement A-1

Finding A-1

Corrective Action

Not Applicable.

Measure to Prevent Recurrence

Audit schedule for two future audits was decided as follows.

Spring - 1980 Audit

Date: May 19, 1980 through May 23, 1980

Lead Auditor: Mr. H. Kumano

Autum - 1980 Audit

Date: November 17, 1980 through November 21, 1980

Lead Auditor: Mr. A. Kurokawa

This schedule was submitted to General Manager, and he assigned Chief Engineer of Division to watch the audit activity of Quality Assurance Group.

Date of Completion of Implementation

1. Corrective Action: Not Applicable
2. Measure to Prevent Recurrence: March 24, 80

K. Tomita  
Kyoze Tomita  
Manager, QA Group

3-31-80  
Date





配布先	溶接管理	工事番号	横浜第三工場品質管理部		
			検査	課	
品保 1	モニター報告書	工事名称	課長	主任	副主任
	Monitoring Report for Welding Control				

English Translation

日々モニター (実機溶接)

日付	モニター対象 溶接継手	使用WPS	合	否	確認者 証印	溶接士 クランクNo	合	否	確認者 証印	備考
///										
///										
///										
///										
///										
///										
///										
///										

合計

注記	コメント内容
1) 2) 3)	(NON No: _____)

English Translation

週モニター (溶材管理)

Addition

(溶接作業がなくてもモニターは実施すること)

Monitoring shall be kept even when welding is not performed.

要領書No: \_\_\_\_\_  
日付: \_\_\_\_\_  
報告者名: \_\_\_\_\_

○管理の状況

1) 溶材管理室  適切  不適切

2) 上記以外の溶材保管場所 (注記参照)  適切  不適切

注記	コメント内容
	(NON No: _____)

Written Statement A-2

Finding A-2

Corrective Action

Not Applicable.

Measure to Prevent Recurrence

1. All staff member were instructed by manager of QA Group not to fail to indicate the follow-up status in the audit finding report.
2. Follow-up Status Check Sheet was prepared and being used by manager of QA Group to monitor the follow-up activity.

Attached herewith is a copy of subject sheet.

Date of Completion of Implementation

1. Corrective Action: Not Applicable
2. Measure to Prevent Recurrence: March 24, 1980

*Kyozo Tomita*  
Kyozo Tomita  
Manager, QA Group

3-31-80  
Date



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Rotterdam  
Piranes  
Bangkok  
Beirut  
Paris  
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VENDOR SURVEY REPORT

REPORT NO. \_\_\_\_\_

VENDOR \_\_\_\_\_  
DIVISION/WORKS \_\_\_\_\_  
ADDRESS \_\_\_\_\_

SCOPE OF QUALIFICATION  
MATERIAL/SERVICES

*Addition*

SIZE

LIMITATION OF SCOPE  YES;  
 NO;

VENDOR'S PERSONNEL CONTACTED

NAME

TITLE

MEMBER OF SURVEY TEAM

NAME

TITLE

SURVEY DATE \_\_\_\_\_

VENDOR'S QA/QS MANUAL NO. \_\_\_\_\_ REV. \_\_\_\_\_

VENDOR'S CAPABILITY REPORT \_\_\_\_\_

EVALUATION

- ACCEPTABLE WITHOUT COMMENT
- ACCEPTABLE WITH COMMENTS
- UNACCEPTABLE
- ADDITIONAL SURVEY REQUIRED

DATE \_\_\_\_\_

QUALITY ASSURANCE DEPT.  
NUCLEAR POWER DIVISION

Written Statement B

Finding B

Corrective Action

QC monitoring of welding material control activities has been performed regardless the ASME Code welding is being done or not.

Measure to Prevent Recurrence

1. The note "monitoring shall be kept even when welding is not performed" was added to the Monitoring Report not to overlook.

Attached herewith is a copy of subject report.

2. The copy of Monitoring Report shall be distributed to Quality Assurance Group for verification.

Date of Completion of Implementation

1. Corrective Action: February 8, 1980
2. Measure to Prevent Recurrence: March 24, 1980

Kyozo Tomita  
Kyozo Tomita  
Manager, QA Group

3-31-80  
Date

配布先	不 具 合 処 置 通 知 書 DISPOSITION NOTICE				DN- REF.NON-	REV. REV.		
総設M	工事番号 WORK No.	工事名称 WORK NAME						
機器設M	部品/継手番号 PART/ JOINT No.	部品/継手番号 PART/ JOINT NAME						
管理G (RPV)	工程管理番号 PROCESS SHEET No.	チェックリスト番号 CHECK LIST No.						
化器設G	客先承認/連絡 CUSTOMER APPROVED/ INFOM'D	<input type="checkbox"/> 承認済 APPROVED	<input type="checkbox"/> 連絡済 INFORMED	<input type="checkbox"/> 不要 NOT REQ'D	官 庁 承認 連絡 検査機関 MITI APPROV ED/ INFOM'D	<input type="checkbox"/> 承認済 APPROVED	<input type="checkbox"/> 連絡済 INFORMED	<input type="checkbox"/> 不要 NOT REQ'D
第一工段M	手続図書番号: DOCUMENT No.			手続図書番号: DOCUMENT No.				
P G	不 具 合 概 要 DESCRIPTION OF NON CONFORMITY				CONCURRENCE by			
P G					協 議		Date	
P G								
第二工段M	処 置 と 確 認 DISPOSITION & VERIFICATION							
ラド設G	処 置 DISPOSITION		備 考 REMARKS		確 認 VERIFIED BY			
ブ設G	<input type="checkbox"/> 廃却にする (REJECT)							
第一造M	<input type="checkbox"/> 現状のまま使用する (LEAVE AS IT IS)							
管理G	他への影響 <input type="checkbox"/> 有り (YES)							
工場課	<input type="checkbox"/> 無し (NO)							
工場課	<input type="checkbox"/> 下記の要領で補修する REPAIR ACCORDING TO THE FOLLOWING PROCEDURE				日付	確 認 者		
第二造M	補 修 要 領 REPAIR PROCEDURE			確 認 VERIFICATION				
管理G	No.	作業手順 SEQUENCE	方案/図面番号 PROCEDURE/DWG.No.	備 考 REMARKS	記録番号 RECORD No.	確 認 VERIFIED BY		
工場課								
工技M								
SNG								
PHG								
生産M								
管								
発注G								
品保M								
品管M								
機 一								
機 二								
控	再発防止対策 CORRECTIVE ACTION TO PREVENT RECURRENCE		対策の内容: <input type="checkbox"/> 教育、訓練、注意等の指示 <input type="checkbox"/> その他					
合計	<input type="checkbox"/> Not Req'd <input type="checkbox"/> Req'd		添付資料 <input type="checkbox"/> 有り <input type="checkbox"/> 無し					
			Material Service					
			Verification of Vendor's DN					
	不 具 合 分 類		1. 設 計	2. 業 材 3. 調 入 加工外注	4. 加 工 ・ 組 立 ・ 無 処 理	5. 溶 接 6. 洗 浄 7. 検 査 塗装・保管		
	CLASSIFICATION OF NONCONFORMITY		a: 標準不良 b: 指示・連絡不良 c: 手順不良 d: 検計不良 e: 不注意 f: その他	a: 指示連絡不良 b: 材料・調入の不備 c: 手順不良	a: 標準不良 d: 検備不足 e: 指示・連絡不良 f: 検計不足 g: 設備不良 h: その他	a: 標準不良 d: 検備不足 e: 検計不足 f: 不注意		
	処 置 通 知		1					
	NOTIFICATION OF DISPOSITION		0					
	改正番号 REV. No.	発行日付 DATE	調 査 PREPARED BY	承 認 APPROVED BY	処 置 完 了	上記処置が全て完了した 事を確認する。		
					VERIFICATION OF DISPOSITION	DATE VERIFIED BY		

Written Statement C

Finding C

Corrective Action

Limitation of scope was added to the Vendors Survey Report.

Measure to Prevent Recurrence

The note "Limitation of Scope  yes,  No" was added to the column of Scope of Qualification on the Vendor Survey Report.

Attached herewith is a copy of subject report.

Date of Completion of Implementation

1. Corrective Action: February 15, 1980
2. Measure to Prevent Recurrence: March 24, 1980

Kyozo Tomita      3-31-80  
Kyozo Tomita      Date  
Manager, QA Group

LIST OF DRAWINGS

DWG. NO. \_\_\_\_\_ REV. <sup>1</sup>

SHEET 1 OF 6

*Addition*

Issuance of Document Revision Check List

IHL DWG. NO.	REV.	DWG. NO.	REV.	TITLE	LETTER NO.	DATE	
020K021	0	—	0	ORIGINAL PURCHASE ORDER	—	2-7-78	
	A						
	B						
	C						
	D						
"	A	—	0	CHANGE ORDER NO.1	—	6-20-78	2-15-80
	B						
	C						
	D						
"	B	—	0	CHANGE ORDER NO.2	—	10-18-78	2-15-80
	C						
	D						
"	C	—	0	CHANGE ORDER NO.3	—	1-11-79	2-15-80
	D						
"	D	—	0	CHANGE ORDER NO.4	—	2-14-79	2-15-80
"	E	—	0	CHANGE ORDER NO.5	—	2-6-79	2-15-80

Written Statement D

Finding D

Corrective Action

Not Applicable.

Measure to Prevent Recurrence

The note "Verification of Vendor's DN" was added to Disposition Notice (DN) for the follow-up of the nonconformity at Vendor.

Attached herewith is a copy of subject DN.

Date of Completion of Implementation

1. Corrective Action: Not Applicable
2. Measure to Prevent Recurrence: March 24, 1980

Kyoze Tomita      3-31-80  
Kyoze Tomita      Date  
Manager, QA Group



Addition

DWG. NO. REV.

SHEET 2 OF 6

DRAWINGS

LIST OF

IHI DWG. NO.	REV.	DWG. NO.	KEY	TITLE	LETTER NO.	DATE	Issuance of Document Revisions Check List 2-15-80
020K021	E	-	0	CHANGE ORDER NO. 6	-	7-6-79	
"	F	-		CHANGE ORDER NO. 7	-	9-4-79	2-15-80
"	F	-	0	CHANGE ORDER NO. 8	-	8-28-79	2-15-80
"	G	-	0	CHANGE ORDER NO. 9	-	1-11-80	2-15-80
"	H	-	0	CHANGE ORDER NO. 10	-	2-18-80	2-15-80

Written Statement E

Finding E

Corrective Action

Change Orders Nos. 1 through 10 to Customer Purchase Order No. 11-00000-3297 (for the supply of Equipment Hatches) were reviewed using Document Revision Check List and found that all activities performed are consistent with current change Order No. 10.

Measure to Prevent Recurrence

The column "Issuance of Document Revision Check List" was added to Design Input List, so that the status of Document Revision review can be clearly indicated.

Date of Completion of Implementation

1. Corrective Action: February 15, 1980
2. Measure to Prevent Recurrence: March 24, 1980

Kyozo Tomita  
Kyozo Tomita  
Manager, QA Group

3-31-80  
Date

IHI

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Beirut  
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Bangkok  
Singapore  
Hong Kong  
Taipei  
Manila  
Jakarta  
Sydney  
Teheran

QAG-OL-043  
March 31, 1980

United States  
Nuclear Regulatory Commission  
Region IV  
611 Ryan Plaza Drive, Suite 1000  
Arlington, Texas 76011  
U.S.A.

Attention: Mr. Uldis Potapous  
Chief, Vendor Inspection Branch

Reference: Docket No. 99900038/80-01

Gentlemen:

I received your letter referenced above on March 3, 1980.

Enclosed herewith please find and accept our written statement which responds to your "NOTICE OF DEVIATION".

Very truly yours,

Makio Amano

Makio Amano  
General Manager  
Nuclear Power Division  
Ishikawajima-Harima Heavy  
Industries Co., Ltd.

Encl.

Follow-up Status Check Sheet

AUTUMN AUDIT, 1979

Audit Finding Report No.	Promised Date	Follower	Month, 1980											
			Jan.	Feb.	Mar.	Apr.	May	Jun.	July	Aug.	Sep.	Oct.	Nov.	Dec.
1 勤勞-01	12/14/79	黒川			55 富田 3.24	COMPLETED. NO MORE ACTION REQ'D								
2 管理-01	12/14/79	黒川			55 富田 3.24	—	Do.	—	—	—	—	—	—	
3 生管-1/2	12/21/79	富田			55 富田 3.24	—	Do.	—	—	—	—	—	—	
4 生管-3/2	2/8/80	富田			55 富田 3.24	—	Do.	—	—	—	—	—	—	
5 1造-1/5	12/20/79	森崎			55 富田 3.24	—	Do.	—	—	—	—	—	—	
6 1造-2/5	12/20/79	森崎			55 富田 3.24	—	Do.	—	—	—	—	—	—	
7 1造-3/5	12/5/79	森崎			55 富田 3.24	—	Do.	—	—	—	—	—	—	
8 1造-4/5	12/6/79	南			55 富田 3.24	—	Do.	—	—	—	—	—	—	
9 1造-5/5	12/29/79	南			55 富田 3.24	—	Do.	—	—	—	—	—	—	