



POWER SYSTEMS
A MORRISON-KNUDSEN DIVISION

101 GELO ROAD / POST OFFICE BOX 1928
ROCKY MOUNT, NORTH CAROLINA 27801
PHONE (919) 977-2720 / TWX (510) 929-0725

8005190 217

April 8, 1980

United States Nuclear Regulatory
Commission, Region IV
611 Ryan Plaza Drive
Suite 1000
Arlington, Texas 76012

Attention: Mr. Uldis Potapovs, Chief
Vendor Inspection Branch

Reference: Docket No. 99900702/80-01

Dear Sir:

Reference is made to your letter dated March 4, 1980 transmitting the specific findings resulting from the inspection by your Mr. W. E. Foster of our facility at Rocky Mount, North Carolina on February 4-8, 1980.

The following information is in response to the findings and is presented in the same order they appear in your letter.

NOTICE OF DEVIATION

Item A Paragraph 3.4.3 of Quality Control Procedure N-7, Revision 3, dated November 28, 1979 . . .

Action taken to correct this deviation.

1. Receiving inspection reports, Form 600-033, from November 1, 1979 to the date of the NRC inspection, February 4-8, 1980, have been reviewed by the Quality Control Manager to assure the proper signature and date has been indicated on each receiving inspection report. Action completed March 30, 1980.

Action taken to prevent recurrence of the deviation.

1. Additional training has been given to the inspection personnel and the Quality Control Document Control Clerk to insure conformance with the requirements of QCP N-7, Revision 3, Procedure QCP 101, Revision 0. Action completed March 27, 1980.

Item B Paragraph 5.2 of Quality Control Procedure N-18, Revision 3, dated November 28, 1979 . . .

(Continued)

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Action taken to correct this deviation.

1. An internal audit of the complete Quality Assurance Program was conducted on March 12-14, 1980. Action completed March 14, 1980.

Action taken to prevent recurrence of the deviation.

1. The PSD Division Quality Assurance Manager or his designee will review the Schedule of Planned Internal Audits monthly to assure internal audits are performed on schedule. Action completed March 27, 1980.

Item C Paragraph 3.6 of Engineering Procedure EP No. 501, Revision 1, dated November 18, 1979 . . .

Action taken to correct this deviation.

1. Engineering Procedure EP No. 501, Revision 1, dated November 18, 1979 has been revised on March 27, 1980. (Copy attached) EP No. 501, Revision 2. Action completed March 28, 1980.

Action taken to prevent recurrence of the deviation.

1. Additional training has been given to the Engineering personnel to insure conformance to the revised procedure. Action completed March 31, 1980.

Item D Engineering Procedure No. 502, Revision 0, dated November 18, 1979 . . .

Action taken to correct this deficiency.

1. The referenced ECPs have been reviewed and properly executed in accordance with EP 502, 3.1.B. ECPs and PCPs issued subsequent to the implementation of Engineering Procedure No. ECP 502, Revision 0, have been reviewed for conformance to EP 502, 3.1.B and corrected as required.
2. Paragraph 3.2.C . . .

Engineering Procedure 502, Revision 0, dated November 18, 1979 has been revised on March 27, 1980. (Copy attached) EP 502, Revision 1.

(Continued . . .)

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Action taken to prevent recurrence of the deficiency.

1. Additional training has been given to the Engineering personnel to insure conformance to the revised procedure. Action completed March 31, 1980.

Item E Paragraph 3.7 of Engineering Procedure No. 201, Revision 2, dated November 21, 1979 . . .

Action taken to correct this deviation.

1. Component design specification no. 6022-304-1 has been signed by the Professional Engineer. The remaining current component design specifications have been reviewed and were forwarded to be properly executed in accordance with EP 201, 3.7, Revision 2 dated November 21, 1979. Action completed March 27, 1980.

Action taken to prevent recurrence of the deviation.

1. Additional training has been given to the Engineering personnel to insure conformance with EP 201, Revision 2, dated November 21, 1979. Action completed March 31, 1980.

Item F Shop Control Procedure No. 103, Revision 1, dated November 26, 1979 . . .

Action taken to correct this deviation.

1. Shop Control Procedure No. SCP 103, Revision No. 1 dated November 26, 1979 has been revised on February 11, 1980. (Copy attached) SCP 103, Revision 2.
2. An internal audit performed on March 14, 1980 verified conformance with the revised procedure.

Action completed March 14, 1980.

Action taken to prevent recurrence of the deviation.

1. Additional training has been given to the Production Supervisors who prepare the shop traveler revision sheets to insure continuing conformance with the revised procedure. Action completed March 27, 1980.

Item G Paragraph 3.2.3 of Shop Control Procedure No. 603, Revision 0, dated November 21, 1979 . . .

(Continued . . .)

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Action taken to correct this deviation.

1. Information has been received from the Manufacturer of the welding rod revising the temperature limits to be maintained by the holding oven. (Copy attached) It should be noted that the temperature recorded during the NRC inspection is well within these revised limits. Action completed March 30, 1980.

Action taken to prevent recurrence.

1. Additional training has been given to the personnel responsible for recording the temperature weekly to insure conformance with the requirements of Shop Control Procedure No. 603, Revision 0, dated November 21, 1979. Action completed March 27, 1980.

Unresolved Items:

"The final 10 CFR 50.55 Report regarding discrepancies at Hartsville Nuclear Plants . . ."

The Quality Assurance Manual has been revised subsequent to the work performed on the generator control panels (switchgear). The Quality Assurance Manual now has procedures that require evaluation, rework, and reinspection documentation. The procedures are:

- QAM-QCP N15 - Nonconformance Control September 28, 1979.
- QAM-QCP N16 - Corrective Action September 28, 1979.
- QCP-301 - Implementation Control Procedure November 28, 1979.

Action:

A training program shall be conducted on or before April 15, 1980 to indoctrinate personnel for compliance with the requirement.

Follow-up Items:

- (1) "The contractor has received information . . ."

TVA Watts Bar - Engine Thermocouple Wire and Conduit:

NCR 1823R-R1
NCR 1822R

(Continued . . .)

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During the audit, PSD was to respond to the above NCRs. A search of the PSD files did not turn up any of the NCRs and conclude that PSD never received the NCRs.

1. NCR 1822R - The thermocouples are used for monitoring purposes only and the failure of any would not affect the proper operation of the diesel generator. Since they have no Class 1E function, the NCR 1822R does not fall under the requirement of Title 10, Part 21 as a reportable defect. Field correction has been completed by TVA personnel.
2. NCR 1823R-R1 - The thermocouple junction boxes vibrated loose. The thermocouples (NCR 1822R) are for monitoring purposes and are not Class 1E. Even if the terminal box fell off, it would not degrade any 1E function and, therefore, is not reportable under Title 10, Part 21. Field correction has been completed by TVA personnel.
3. PSD Field Engineer, Mr. Jorgensen, has inspected the repair above and has verified the correction.

Corrective Action:

- (1) Implementation Control Procedure, QCP 102, "Electric Component Workmanship and Acceptance Standards", shall be revised on or before April 22, 1980 to include detailed requirements and acceptance criteria.
- (2) PSD engineering will review the thermocouple design with respect to:
 - a. Thermocouple terminations.
 - b. The method of securing the junction boxes.

The results of the review shall be completed on or before April 16, 1980.

Follow-up Items:

- (2) "The contractor has evaluated, reworked and inspected . . ."

Evaluation:

Power Systems Division of Morrison-Knudsen Company, Inc. performed a detailed inspection of the generator control panels at the Phipps Bend Nuclear Plant

(Continued . . .)

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on February 24, 1980 and at the Hartsville Nuclear Plant on March 10, 1980 to verify the reported discrepancies.

The results of the inspection report have been reviewed by PSD Engineering to evaluate the deficiencies to determine whether there is a possibility of a condition which could create a substantial safety hazard.

PSD concludes that the nature of some of the defects do present the possibility that could result in a substantial safety hazard. All switchgear produced by the International Controls and Switchgear Company of Rocky Mount, North Carolina may contain similar defects. We have identified the nuclear plants into which this manufacturer's switchgear is installed. PSD has notified the NRC and the other respective nuclear plants in accordance with the requirements of Title 10 CFR 21.

Corrective Action:

- (1) Corrective action was initiated to correct the discrepancies in the two switchgear units at Phipps Bend and the four switchgear units at the Hartsville Nuclear Plant. The corrective action has been performed and completed (with the exception of two long lead delivery items) at the respective sites by TVA personnel in the presence of the General Electric Hartsville Nuclear Plant Quality Control Engineer and under the direction and supervision of PSD/MK personnel.
- (2) PSD will establish an inspection schedule with the other respective nuclear plants to determine whether deficiencies exist in the switchgear and then follow with corrective action. The inspection schedule will be established after we have communicated with these plants.

Preventative Measures:

- (1) PSD Specification No. PSD-ECS1101, Control Panels, Revision 2, and Implementation Control Procedure, QCP-102, "Electrical Component Workmanship and Acceptance Standards," are in the process of being revised to include more detailed requirements and acceptance criteria. The schedule for completion is April 22, 1980.
- (2) A training program shall be scheduled on April 24, 1980 to personnel to prevent recurrence.

(Continued . . .)

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Unresolved Items:

"Paragraph 3.4.3 of Quality Control Procedure No. N-7,"

Corrective Action:

The Implementation Control Procedure, QCP-101, Revision No. 1, Receiving Inspection Procedure, 3.4.1 has been revised to include the statement:

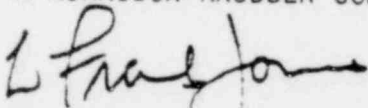
"The receiving report shall be reviewed and signed by the Quality Control Manager or his designee."

Action completed April 2, 1980.

It has been determined by PSD management that we would prefer that the uncontrolled copy of the PSD Quality Assurance Manual given to your Mr. Foster prior to his inspection be returned to this office.

Very truly yours,

POWER SYSTEMS DIVISION
A MORRISON-KNUDSEN COMPANY



W. Frank Jones
Vice President and Division Manager

WFJ:jc

Enclosures

~~8005190 220~~

March 27, 1980

Mr. Charles Chassaing
Power Systems Division
Morrison Knudson
P. O. Box 1928
Rocky Mt., N.C. 27801

Dear Mr. Chassaing:

I am writing in response to your recent telephone inquiry about the recommended holding oven storage temperature for opened cans of McKay 7018 and other McKay XX18 electrodes.

We recommend a minimum holding oven temperature of 175°F for our 7018 electrodes and a minimum of 275°F for McKay high strength XX18 electrodes such as the 11018-M electrode. These are the minimum recommended holding temperatures; some specifications such as AWS D1.1 specify a higher minimum holding temperature.

McKay XX18 electrodes, including the 7018 electrodes will not be harmed by long term storage at temperatures above our recommended minimum temperature up to and including holding at 400°F.

Holding oven temperatures above our minimum recommended temperatures are often beneficial in providing an extra margin of safety against moisture pickup.

Very truly yours,

Paul T. Corcoran

Paul T. Corcoran
Associate Director of Research
Welding Products Division

saf

cc: H. Falter
H. Loewe
J. Winstead
J. Barnes
J. Joyner
R. Witt

~~C. Chassaing~~

TITLE: ENGINEERING CHANGE NOTICE

No. EP-501

Rev. No. 2

Page 1 Of 4

Revision Date: 3/27/80

1.0 SCOPE

This procedure describes the functions of the Engineering Change Notice (ECN) Form No. E 1011 and defines the responsibilities for its preparation.

2.0 RESPONSIBILITY

2.1 The Engineering Department is responsible for the initiation and processing of all ECN's.

2.2 The Document Control Center is responsible for maintaining the ECN's as a documented change record.

3.0 PROCEDURE

3.1 An ECN (Exhibit 1) shall be the documented evidence of any changes occurring to PSD drawings as the result of an Engineering Change Proposal (ECP) or Production Change Proposal (PCP).

3.2 ECN's shall always be processed by the Engineering Department. The Engineer initiating the ECN shall check with the Document Control Center to ensure that all outstanding ECP's and PCP's are incorporated in the ECN.

3.3 The ECN is then forwarded to Drafting where the drawing is revised. The ECN shall reference all Production Change Proposals (PCP) and Engineering Change Proposals (ECP) by number.

3.4 Upon completion of the drawing change, the ECN and drawing is sent to Document Control for distribution of the drawing per the instructions on the ECN. The transmittal shall be accomplished with the Receipt Verification Form EF-2001.

3.5 The completed ECN shall be filed in the appropriate IWO Project In Plant Drawing log in the Document Control Center as a permanent record.

3.6 The ECN shall be completed in the following manner, in ink only or type written:

1. Job Number.

2. Engineer-Project or Chief Draftsman shall decide per Contract and/or Production requirements.

Prepared By:

Wesley B. S. S. S.

Date: 27 Mar 80

Approved By:

W. S. S. S.

Date: 3/27/80

QA/QC Concurrence By:

H. S. S. S.

Date: 3/27/80

TITLE: ENGINEERING CHANGE NOTICE

3. Engineer-Project or Chief Draftsman shall decide per contract and/or Production requirements.
4. Document Control shall determine the number of prints to be retrieved from records and make necessary entry.
5. Chief Draftsman shall make this decision. All overseas mailings to be folded only.
6. Enter drawing number, sheet number, revision number and date.
7. Enter full title.
8. Explain the change and the location on the drawing or by reference to appropriate Engineering Change Proposal (ECP) or Production Change Proposal (PCP) Number. If the changes are covering several Engineering Change Proposals (ECP) and Production Change Proposals (PCP), references shall be made to the respective ECP and PCP numbers.
9. Explain the reasons warranting this change such as customer comments, Engineering Change Proposal (ECP), Production Change Proposal (PCP). In case of ECP or PCP, identify by the serial number on the respective forms.
10. Engineer-Project shall assign:
 - A. The date this change becomes effective.
 - B. Check this block if all the units in the given IWO are affected by this change.
 - C. If this change is not affecting all the units in the given IWO check this block and identify the units affected. The drawing must clearly identify either the units that are affected or the units that are not affected.
 - D. Engineer-Project shall check this block if this change is to be considered for future contracts.
 - E. Use of this block is for use by Engineer-Project or Chief Draftsman for any special notation.
11. Engineer-Project or Chief Draftsman shall decide per contract and/or Production requirements.

Prepared By:
Wesley Batchelor
 Date: 27 MAR 80

Approved By:
W. K. Atter
 Date: 3/27/80

QA/QC Concurrence By:
Harry W. [Signature]
 Date: 3/28/80

TITLE: ENGINEERING CHANGE NOTICE

No. EP-501

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Revision Date: 3/27/80

12. Boxes A and B are no longer in use

Engineer-Project or Chief Draftsman shall decide which of the blocks C, D, E, and F is appropriate.

C. If this change is to correct drafting error, engineering error, manufacturing error or any error that needs correction.

D. Design or Process improvement.

E. If this change is reducing cost in any manner.

F. Any change that cannot be classified under C, D, and E above.

13. Engineer-Project or Chief Draftsman shall make appropriate decision as to the disposition of material on hand.

14. Signatures and dates, in ink, shall be affixed by the appropriate persons.

4.0 REFERENCES:

4.1 PSD QAM QCP-N3.

Prepared By:

Wesley Batchelor

Date: 3/27/80

Approved By:

V. A. Carlton

Date: 3/27/80

QA/QC Concurrence By:

Harvey W. [Signature]

Date: 3/27/80

TITLE: ENGINEERING CHANGE NOTICE

No. Ep-501
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Rev's 198
Date: 5/27/80

POWER SYSTEMS DIVISION ENGINEERING CHANGE NOTICE

IWO NO. ①

5963

DATE _____

(2) NO. OF COPIES
Blue line _____
Sepia _____
Mylar _____
Xerox _____
Other _____

(3) COPIES TO BE
Folded _____
Rolled _____
Other _____

(6) DWG. NO. _____ SHEET _____ REV. _____

(7) TITLE _____

(8) NATURE OF CHANGE:

COPIES TO BE STAMPED (3)
Issued _____
Check Print _____
Preliminary _____
For quote only _____
Production _____
For information only _____
Make Buy _____

**FOR EXAMPLE ONLY
FOR INFORMATION ONLY**

(9) REASON FOR CHANGE:

(4) OBSOLETE PRINTS RETURNED
Prod. _____ Copies _____
Q. C. _____ Copies _____
_____ Copies _____
_____ Copies _____

(2) CHANGE CLASS (A) I (B) II

- IMPERATIVE
- IMPROVEMENT
- COST REDUCTION
- OTHER

DRAFT _____ DATE _____

CHECKED BY _____ DATE _____

(14) PROJ. ENG. _____ DATE _____

ENG. MGR. _____ DATE _____

(10) TO BE FILLED BY ENGINEERING ONLY

EFFECTIVE DATE: (A) _____

- ALL UNITS
- FROM UNIT NUMBER _____ UP
- FUTURE CONTRACTS
- _____

(13) DISPOSITION OF MATERIAL N/A

- USE AS IS
- PARTS COMPLY
- NOT AFFECTED
- REWORK
- SCRAP SALVAGE

(11) COPIES TO BE DISTRIBUTED AS FOLLOWS

- Copies to REQUESTER _____
- Copies to PRODUCTION _____
- Copies to QUALITY CONTROL _____
- Copies to PURCHASING _____
- Copies to PROD. CONTROL _____
- Copies to GOV'T/CUST. _____
- Copies to _____

Prepared By: Wesley K. Johnson

Approved By: V. J. Co. King

QA/QC Concurrence By: Kenneth J. King

TITLE: ENGINEERING CHANGE PROPOSAL

1.0 SCOPE:

The purpose of this procedure is to describe the necessary steps to initiate a change to an existing drawing or document. An Engineering Change Proposal (ECP) can be initiated by any person working in the Power Systems Division (PSD). Problems identified by personnel other than PSD personnel, i.e. customers, vendors, and subcontractors, would be initiated by the Engineering Department.

2.0 RESPONSIBILITIES:

- 2.1 The Engineering Department is responsible for the processing of all ECP's.
- 2.2 The Document Control Center is responsible for the control and distribution of all ECP's.

3.0 PROCEDURES:

3.1 PREPARATION OF AN ECP (Exhibit No. 1):

- A. The initiator of an ECP shall describe in as much detail as possible the proposed change. The description shall include, if appropriate, a detailed sketch, part numbers, document identification and any vendor data applicable. The reason for initiating the change, the Disposition of Materials, and Effectivity sections, with the exception of the date, shall also be completed by the initiator.
- B. An ECP shall be completed in the following manner, in ink only or typewritten:
- (1) The job number (same as IWO) is entered by the initiator of the ECP.
 - (2) The date of initiating the ECP.
 - (3) The drawing or document affected by the change. If additional space is needed, list the document numbers and revisions on an attachment and reference the attachment in this space.
 - (4) Self-explanatory.
 - (5) The initiator of an ECP shall describe the proposed change in as much detail as possible. The description shall include as appropriate, a detailed sketch, part numbers, document identification and any backup material and applicable vendor data.

Prepared By:

Wesley KetchelDate: 27 MAR 80

Approved By:

V. D. SantosDate: 3-27-80

QA/QC Concurrence By:

Harry W. SalesDate: 3-27-80

TITLE: ENGINEERING CHANGE PROPOSAL

No. EP-502

Rev. No. 1

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Date: 3/27/80

- (6) The appropriate block is checked by the initiator or by the Department Head.
 - (7) The Disposition of Materials shall be checked by the initiator or the engineer reviewing the Form.
 - (8) If all units are affected for the given IWO, the Effectivity section shall be checked by the Initiator or Department Head and verified by the Engineer-Project.
 - (9) If the change is not affecting all units, identify the units that will be affected by the change.
 - (10) This may be the same date as approval of the ECP unless otherwise specified by the Department Head in consultation with the Engineer-Project.
 - (11) The initiator's signature. The printed name only is not acceptable.
 - (12) The department where the ECP is initiated.
 - (13) Self-explanatory.
 - (14) The signature and date of the Department Head. The printed name is not acceptable.
 - (15) Approval signatures and dates of approval. Printed names only are not acceptable. The Manager of Quality Control can sign for the Manager of Quality Assurance with the approval of the Manager of Quality Assurance.
- C. Once the initiator has completed the ECP, it is then forwarded to the initiator's Department Head for signature.

3.2 SUBMITTAL OF AN ECP:

- A. All ECP's shall be submitted to Document Control via the initiator's Department Head for coordination and distribution accompanied by Form EF-2001. Form EF-2001 is not required for Engineering submittal of ECP to the Document Control Center. The initiator shall retain his copy of the ECP.
- B. Once submitted, Document Control will acknowledge receipt of the ECP with Form EF-2001 and return the form to the initiator. Acknowledgement of EF-2001 is not applicable to Engineering.

Prepared By:

Wesley Bateelor

Date: 27 MAR 80

Approved By:

V. R. Katta

Date: 3/27/80

QA/QC Concurrence By:

Harry W. [Signature]

Date: 3/27/80

TITLE: ENGINEERING CHANGE PROPOSAL

- C. Once received, Document Control will log in all ECP's and route the ECP to Engineering for review and approval. A copy of the ECP shall be kept by Document Control in followup file.
- D. Upon completion of Engineering review, the ECP is returned to Document Control. Document Control to forward Engineering reviewed ECP to Manager of Quality Assurance with Form EF-2001.

3.3 REVIEW OF THE ECP:

- A. Once received by the Engineer-Project, an ECP will be reviewed and in an expeditious manner either approved or disapproved.
- B. When disapproved, an ECP is returned to Document Control for recording and distribution to the initiator.
- C. All changes shall go through a design review (Which is the processing and signing of ECP Form EF-1012 (Exhibit No. 1).
- D. When a Design Report revision is required, the change must be submitted to the Customer for approval prior to submitting to QA for approval and initiating the change to the existing drawing or document.
- E. If an ECP is proposing a change requiring no revision to the Design Report, the change will be approved by the Engineer responsible for the design and forwarded to QA for approval and distribution.
- F. During the review process, it is the responsibility of the Engineering Department to identify any impact or change this proposed change shall have on any other documents or drawings and take the appropriate action to include changes in the review also.

3.4 IMPLEMENTATION OF THE ECP:

- A. Once an ECP has been approved it will be returned to Document Control for recording and distribution.
- B. Document Control shall issue a copy of the approved ECP with Form No. EF-2001 to all internal holders of a "controlled" copy of the drawing/document. Acknowledged Form EF-2001 will be returned to Document Control. Person signing the Form EF-2001 is responsible for distribution of the document received.

Prepared By: [Signature]
Date: 27 Mar 80

Approved By: [Signature]
Date: 3/27/80

QA/QC Concurrence By: [Signature]
Date: 3-27-80

TITLE: ENGINEERING CHANGE PROPOSAL

- C. When the approved ECP is received by the holders of the affected drawing or document, it is to be attached to the drawing/document. It shall be noted, however, no markup of the drawing or document is permitted. This function will be completed with an Engineering Change Notice as delineated in Procedure EP-501 (ECN).
- D. Once the ECP is received in the Shop, the Shop Traveller, if affected, shall be revised according to the approved change.

4.0 REFERENCES:

4.1 PSD QAM QCP-N3.

Prepared By:
Wesley B. ...
 Date: 27 Mar 80

Approved By:
V. D. ...
 Date: 3/27/80

QA/QC Concurrence By:
Harry ...
 Date: 3/27/80

TITLE: ENGINEERING CHANGE PROPOSAL

No. EP-502

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ENGINEERING CHANGE PROPOSAL

2266

JOB NUMBER ① _____
DATE ② _____ DWG. NO. ③ _____ REV. ④ _____

THE FOLLOWING CHANGE IS REQUESTED ON THE DRAWING INDICATED ABOVE:

⑤

EXAMPLE ONLY

Special Instructions (Included Engineering Work Stoppage).

REASON: ⑥

- ENGINEERING ERROR
- DRAFTING ERROR
- MANUFACTURING ERROR
- MANUFACTURING REQUEST
- TO FACILITATE ASSEMBLY
- TO SUIT AVAILABLE TOOLING
- SPECIFICATION CHANGE
- OTHER (EXPLAIN)

DISPOSITION OF MATERIALS:

- ⑦ USE UP AS IS
- PARTS COMPLY
- NOT AFFECTED
- REWORK
- SCRAP
- SALVAGE

EFFECTIVITY:

- ⑧ ALL UNITS
- UNIT NO. ⑨ _____
- EFFECTIVE DATE ⑩ _____

REQUESTED BY ⑪ _____ DEPARTMENT ⑫ _____ DATE ⑬ _____

DEPARTMENT HEAD ⑭ _____ DATE _____

ACTION TAKEN: ⑮

- APPROVED PROJ. ENG. _____ DATE _____
- DISAPPROVED ENGR. MGR. _____ DATE _____
- Q. A. MGR. _____ DATE _____

EF-1012

EXHIBIT NO. 1

Prepared By:

Wesley Batcher

Approved By:

V. J. Hutton

QA/QC Concurrence By:

Harvey W. Sells

TITLE: SHOP TRAVELER REVISION SHEET

No. SCP-103

Rev. No. 2

Page 1 Of 1

Revision
Date: 2/11/80

1.0 SCOPE

This procedure describes the function of the Shop Traveler Rev. Sheet (STRS) and defines the responsibilities for its preparation.

2.0 RESPONSIBILITY

2.1 The Operations Department is responsible for the initiation of all STRS's.

3.0 PROCEDURE

3.1 All revisions to an approved and released shop traveler shall be listed on the shop traveler revision sheet.

3.2 All shop traveler revision sheets shall be reviewed by the Quality Control Manager for conformance to the Quality Control requirements prior to inclusion into the Shop Traveler package.

3.3 Shop Traveler Revision Sheets regarding items which are to meet the requirements of the ASME Code Section III Division 1 shall be reviewed by the Authorized Nuclear Inspector.

3.4 The STRS shall be the documented evidence of any changes occurring to PSD Shop Traveler as the result of an Engineering Change Proposal (ECP) or Production Change Proposal (PCP).

3.5 The completed STRS shall be filed in the Shop Traveler folder as a permanent record and becomes an integral part of the Shop Traveler.

Prepared By:

Richard L. Loew

Date: 2/11/1980

Approved By:

Richard L. Loew

Date: 2/11/1980

QA/QC Concurrence By:

Harry W. [Signature]

Date: 2/11/80

TITLE: RECEIVING INSPECTION PROCEDURE	No. <u>QCP-101</u>	Rev. No. <u>1</u>
	Page <u>1</u> Of <u>9</u>	Revision Date: <u>4/2/80</u>

(NOTE: THIS PROCEDURE WAS FORMERLY NUMBER QCP-708)

1.0 SCOPE

To establish a procedure for the inspection of Material, Parts, Components, and Equipment as they are received at Power Systems.

2.0 REFERENCES

- 2.1 ASME Boiler and Pressure Vessel Code, Section III.
- 2.2 Division 1, NCA 4134.14.
- 2.3 PS QAM N-14.
- 2.4 ANSI N 45.2.2.
- 2.5 PS QAM N-7.

3.0 PROCEDURE

- 3.1 Items received by the Receiving Clerk are placed in the designated receiving area.
- 3.2 Upon determination by the Receiving Inspector, concerning Code or non-Code use, the items are separated and placed in the designated Receiving Inspection area.
- 3.3 Based on the Quality Assurance documentation requirements as outlined on the Purchase Orders, and the specified dimensional requirement on the design drawing, the following inspections shall be performed and documented by the QC Receiving Inspector:
 - a. Quantity Ordered and Received.
 - b. Dimensional Examination.
 - c. CMTR's when applicable including Chemicals and Physicals in compliance with ASME Section III and applicable Addenda.
 - d. Heat numbers clearly visible.
 - e. General condition and workmanship.
 - f. Data plates, when applicable.
- 3.4 Accepted Items.

Prepared By:

Belmont Loeve

Date: 4/2/80

Approved By:

Belmont Loeve

Date: 4/2/80

QA/QC Concurrence By:

Harry W. Loeve

Date: 4/2/80

TITLE: RECEIVING INSPECTION PROCEDURE	No. <u>QCP-101</u>	Rev. No. <u>1</u>
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- 3.4.1 After completion of Inspection and acceptance of the item, the Blue Inspection Ticket, Exhibit #1, shall be completed, signed by the Inspector and attached to the accepted item. The Receiving Inspection Report, Exhibit #6, shall be completed, signed and dated by the Inspector. The receiving report shall be reviewed and signed by the Manager of QC or his designee. When applicable, the Receiving Check List, Exhibit #2, shall be completed, stamped and dated and attached to Form 600-033.
- 3.4.2 The accepted item then is routed to the proper storage area.
- 3.5 Items Found Unacceptable.
- 3.5.1 When one or more of the items as outlined in Paragraph 3.3, b through f, are found to be missing or unacceptable at the time receiving inspection is performed, the Receiving Inspector will:
- Prepare a Nonconformance Report, Exhibit #3, indicating those areas found unacceptable or indeterminate.
 - Complete and affix hold tag(s), Exhibit #4, to the item(s)
 - Have the item(s) placed in a designated hold area.
 - Note the NCR# on the Receiving Inspection Report.
- 3.5.2 The items shall remain in the Hold Area until all deficiencies are eliminated.
- 3.5.3 When all deficiencies noted have been properly approved, remove the Hold Tag and affix a completed signed and dated Blue Inspection Ticket. The Receiving Inspection Report shall be signed and dated by the inspector.
- 3.6 Rejected Items.
- 3.6.1 Complete applicable parts of the NCR and forward to Manager of Q.C. for approval.

Prepared By:

Approved By:

QA/QC Concurrence By:

Date: 4/2/1980Date: 4/2/1980Date: 4-2-80

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- 3.6.2 Complete Rejection Ticket, Exhibit #5, and affix to the rejected item. Place the item into the designated rejection area.
- 3.6.3 The Manager of Q.C. shall forward copies of the NCR to the Division Manager of Q.A. and after his concurrence to the proper department heads for final disposition.
- 3.6.4 The item shall remain in the rejection area until final disposition is received by the inspector.
- 3.6.5 Thereafter action shall be in accordance with the PSD Quality Assurance Manual Section No. QCP-N18, Paragraph 3.3 and Section QCP-N8.
- 3.7 Documentation
- 3.7.1 For reference purpose, the Receiving Inspector shall maintain a file of the following documents:
- Purchase Orders.
 - Daily Receiving Reports.
 - Receiving Inspection Reports.
 - Receiving Inspection Check List, (When Required).
- 3.7.2 Copies of the Receiving Inspection Reports and Checklists and any applicable NRC's will be filed in accordance with QCP-700, "Quality Assurance Records".

Prepared By: <u>Helmut Lorenz</u> Date: <u>4/2/80</u>	Approved By: <u>Helmut Lorenz</u> Date: <u>4/2/80</u>	QA/QC Concurrence By: <u>Harvey W. [Signature]</u> Date: <u>4/2/80</u>
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EXHIBIT #1

INSPECTION TICKET

ROW NO. _____ SHELF NO. _____ JOB NO. _____

ITEM NO. _____ BM NO. _____



PO NO. _____ SUPPLIER: _____

DESCRIPTION: _____

RECEIVED BY: _____ DATE: _____

INSPECTED BY: _____ DATE: _____

Prepared By:

Helmuta Laeme

Date: 4/2/80

Approved By:

Helmuta Laeme

Date: 4/2/80

QA/QC Concurrence By:

Harry W. Laeme

Date: 4/2/80

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EXHIBIT #3

QUALITY ASSURANCE PROGRAM NONCONFORMANCE REPORT (NCR)										
IWO NO.:	SYSTEM/SUBASSEMBLY:	REPORT NO.:								
		DATE:								
I TYPE OF NONCONFORMANCE:	FUNCTIONAL AREA CITED:	ORIGINATOR:								
NONCONFORMANCE REFERENCE: (Code of Spec. Section Violated)	NONCONFORMANCE DESCRIPTION:									
II PROPOSED DISPOSITION:										
<table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">SUPERVISOR _____</td> <td style="width: 33%;">DATE _____</td> <td style="width: 33%;">QC MANAGER _____</td> <td style="width: 33%;">DATE _____</td> </tr> <tr> <td>APPROVED: DIVISION QA MANAGER _____</td> <td>DATE _____</td> <td>APPROVED: MANAGER OF ENGINEERING _____</td> <td>DATE _____</td> </tr> </table>			SUPERVISOR _____	DATE _____	QC MANAGER _____	DATE _____	APPROVED: DIVISION QA MANAGER _____	DATE _____	APPROVED: MANAGER OF ENGINEERING _____	DATE _____
SUPERVISOR _____	DATE _____	QC MANAGER _____	DATE _____							
APPROVED: DIVISION QA MANAGER _____	DATE _____	APPROVED: MANAGER OF ENGINEERING _____	DATE _____							
III REINSPECTION OF DISPOSITIONED ITEM:	IV QUALITY ASSURANCE REVIEW:									
<input type="checkbox"/> ACCEPTED _____ DATE _____ <input type="checkbox"/> REJECTED _____ DATE _____ INSPECTOR _____ CONCUR: _____ DATE _____ QC MANAGER CONCUR: _____ DATE _____ ANI	<input type="checkbox"/> ISOLATED INCIDENT <input type="checkbox"/> C/A REQUIRED ASSIGNED CAR NO. _____ NCR CLOSED: _____ DIVISION QA MANAGER DATE OF CLOSURE _____									
COMMENTS:										

(REV 1 - 11/79)

Prepared By: Robert L. Laune
Date: 4/2/80

Approved By: Robert L. Laune
Date: 4/2/80

QA/QC Concurrence By: Harry W. Seal
Date: 4/2/80

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EXHIBIT #4

Part No. Job No.

Lot No. Lot Quan. Quan. Hold

Inspector

HOLD

HOLD DATE

DO NOT USE

Remarks

Released By

Date

PRODUCTION CONTROL HOLD TAG



Prepared By:

Approved By:

QA/QC Concurrence By:

Date: 4/2/80

Date: 4/2/80

Date: 4/2/80

Helmut Laeue

Helmut Laeue

Harvey W. [Signature]

TITLE:

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Revis Date:

EXHIBIT #5

REJECTION TICKET

JOB NO.

Rejection Notice No.

Item BM No.

P. O. No. Supplier

Date

Inspector



Prepare
John
Da

Prepared By:
John Doe
Date: 4/2/80

Approved By:
John Doe
Date: 4/2/80

QA/QC Concurrence By:
Harry W. [Signature]
Date: 4/2/80