

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

Report No. 99900023/80-01

Program No. 51300

Company: National Valve and Manufacturing Company
158 49th Street
Pittsburgh, Pennsylvania 15201

Inspection Conducted: February 25-29, 1980

Inspectors: H. W. Roberds
H. W. Roberds, Contractor Inspector
Components Section II
Vendor Inspection Branch

3/30/80
Date

Approved by: J. Barnes
for D. M. Hunnicutt, Chief
Components Section II
Vendor Inspection Branch

3/20/80
Date

Summary

Inspection on February 25-29, 1980 (99900023/80-01)

Areas Inspected: Implementation of 10 CFR 50, Appendix B Criteria and applicable codes and standards; including actions on previous inspection findings, training, audits, and equipment calibration. The inspection involved twenty eight (28) inspector-hours on site by one (1) NRC inspector.

Results: In the four (4) areas inspected, no apparent deviations or unresolved items were identified in three (3) areas; the following deviation being identified in the remaining area:

Deviation: Equipment Calibration: Calibration of automatic welding equipment not in compliance with Criterion V of 10 CFR 50, Appendix B and company Procedure CP-8.

DETAIL SECTIONA. Persons Contacted

- *W. C. Biddle, Sr. Vice President, Piping Division
- *J. H. Heinz, Chief Engineer
- *R. W. Jackson, Quality Assurance Manager
- *R. V. DeNardis, Special Projects Engineer
- *H. W. Claus, Production Manager
- *T. A. Kock, Quality Control Manager
- *H. E. Haller III, Projects Supervisor
- *J. A. Disney, Welding Engineer
- *R. T. Timpert, Supervisor Engineering Projects

*Attended Exit Meeting

B. Action on Previous Inspection Findings

1. (Closed) Deviation (Report No. 79-01, Item A) The welding Foreman did not enter the appropriate revision of a welding procedure used on his copy of the data sheet.

It was verified from records that an indoctrination and training session was given to welding foremen and a review of data sheets at various stages of fabrication did not reveal a similar deviation.

2. (Closed) Deviation (Report No. 79-01, Item B) The superintendent did not prepare a record of temporary attachment for the ring protectors welded to three (3) weld preps.

It was verified that a nonconformance notice had been issued concerning the affected welds and that a training session was held with respect to preparation and processing of records of temporary attachment forms.

3. (Closed) Deviation (Report No. 79-01, Item C) The QC Inspector did not indicate conformance of a heat treatment operation by initialing and dating the appropriate space on the QC copy of the QC data sheet.

It was verified that written instructions had been prepared relative to processing of material requiring heat treatment and a training session had been held with QC and production personnel.

C. Training1. Objectives

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

- a. Procedures have been prepared and approved by the company to prescribe a system for personnel training activities which is consistent with the commitments of the QA Program.
- b. The procedures for training activities are being properly and effectively implemented by the company.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the Quality Assurance Manual, Section 19, Revision 7, "Indoctrination and Training."
- b. Review of Course Outline "Indoctrination and Training, Navco Engineering Department."
- c. Review of Indoctrination and Training records for the Engineering Department for the years 1978, 1979 and 1980 to date.
- d. Review of Indoctrination and Training records for the Purchasing Department for the years 1978, 1979 and 1980 to date.
- e. Review of Indoctrination and Training records for the Production Department for the years 1978, 1979 and 1980 to date.
- f. Review of Indoctrination and Training records for the Quality Assurance Department for the years 1978, 1979 and 1980 to date.

3. Findings

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

D. Audits

1. Objectives

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

- a. Procedures have been prepared and approved by the company to prescribe a system for auditing which is consistent with the commitments of the QA Program.
- b. The audit procedures are being properly and effectively implemented by the company.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the Quality Assurance Manual, Section 18, revision 6, "Audits".
- b. Review of eleven (11) personnel audit certification and qualification record packages.
- c. Review of internal audits of all sections of the Quality Assurance Manual conducted at the Etna, 43rd Street and Johnstown plants for the years 1979 and 1980 to date.
- d. Review of Navco current approved vendors list.
- e. Review of five (5) audit check list and the results of the five (5) vendor audits.

3. Findings

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

E. Equipment Calibration

1. Objectives

The objectives of this area of the inspection were to verify that these activities were controlled in accordance with applicable NRC and ASME Code requirements and committed corrective actions.

- a. A system has been established and is maintained to assure that tools, gauges, instruments and other measuring devices used in activities affecting quality are properly controlled, calibrated and adjusted at specified periods to maintain accuracy within specified limits.
- b. The system has been adequately documented with approved procedures and that these procedures are being implemented.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the Quality Assurance Manual, Section 13 revision 7, "Control of Measuring and Test Equipment."

- b. Review of a computer tabulation listing equipment calibration schedule.
- c. Review of the calibration status and records of eight (8) micrometers I.D. and O.D.
- d. Review of the calibration status and records of nine (9) welding machines.

3. Findings

a. Deviations

Notice of Deviation, Item A.

b. Unresolved Items

None.

F. Exit Meeting

A post inspection exit meeting was held on February 29, 1980, with the management representatives denoted in paragraph A. above. The inspector summarized the scope and findings of the inspection. Management acknowledged the statements of the inspector with respect to the findings as presented to them and affirmed their commitments to the Quality Assurance program.