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**DIJKERS**

United States Nuclear Regulatory Commission  
Region IV  
611 Ryan Plaza Drive  
Suite 1000  
Arlington  
Texas 76012  
U.S.A.

Your ref

Our ref RJH/AZ/84

Date April 10, 1980

For the attention of Mr U. Potapovs.

Dear Sir,

In answer to your recent letter requesting additional information we would like to make the following comments.

Finding C

This finding is similar to finding A of your audit carried out at our facility in May 1979 (see your Docket no. 99300361/79-01). Information on how this discrepancy was handled can be found in our responses to this finding (see Dijkers letters RJH dated 790618 and RH/EG dated 790830).

The welding material specification EAM 29516.26.017 has been revised to include the production preheat and interpass temperature ranges. See attached specification.

Further, it is our intention to retest the batch of electrodes mentioned in your letter using a preheat temperature of 100-150°C and an interpass temperature of 100-260°C. This action is scheduled for completion 800430.

No further corrective actions are envisaged.

Finding D

The two Q.A. Engineers involved were instructed by memo dated 791121. A copy is attached.

Finding E

To ensure that the requirements for process control are being met the process control card traveller system is being audited on a monthly basis. The foundry and valve plant, being audited in alternate months.

Any discrepancies noted will be reported to the relevant Chief Inspector who will be required to respond in a written manner.

Further, a training lecture on process control was given by Mr J. Grobben to the relevant responsible persons involved on 800218.

This was not purely limited to those persons responsible for inspections.

To ensure that parts which have not been correctly controlled during manufacture cannot be released for assembly a system is being initiated whereby all route cards will be audited by a QA Engineer as the operation prior to transport of the finished part to store. This system is now being introduced on all code parts for Nuclear Orders.

I sincerely hope this information is adequate for completion of your review.

Yours sincerely,

  
R.J. Rowe/Technical Manager

Enclosures

# DIKKERS VALVES ENGINEERING CASTINGS

1	2	3	4	5	6	7	8	9	10	11	12	13
E	A	N	2	9	5	1	6	2	6	0	1	7

MATERIAL SPECIFICATION

REV NR **2**

COPY TO:

## ANALYSIS

	C	Si	Mn*	P	S	Ni*	Cr*	Mo*	V*	tot*	Cu
min	-	-	-	-	-	-	-	-	-	-	-
max	0.10	0.90	1.25	0.025	0.020	0.30	0.20	0.30	0.08	1.50	0.50

## TENSILE PROPERTIES

	$\sigma_{0.2}$ N/mm <sup>2</sup>	$\sigma_B$ N/mm <sup>2</sup>	Elong % dp +	R A % Y	Hardness	Charpy-V energy		
						temp °C	J	lateral expansion
min	414	496	22			27	40 mils*	
max						-30		

\*) at max. 0°C.

## CONDITION

Low hydrogen type covered arc-welding electrodes.

## STANDARD OF COMPLIANCE

ASME SFA 5.1  
AW Classification E 7015

## TESTS

1. Chemical analysis according to this specification.
2. Tensile testing according to ASME SFA 5.1 with the requirements of this specification.
3. Impact testing according to ASME Code III par. NB 2321.2 with the requirements of this specification.

**POOR ORIGINAL**

Manufacturer: Smitweld B.V.

PREPARED BY

J. Wits  
d d

Electrode: CONARC 47 C

ACCEPTED BY

K. Howe  
791011  
d d

APPROVED QA MANAGER

R. Howe  
791011  
d d

MATERIAL SYMBOL

DIKKERS CODE NUMBER

PAGE 1 OF 1

# DIKKERS VALVES ENGINEERING CASTINGS

1	2	3	4	5	6	7	8	9	10	11	12	13
E	A	M	Z	Y	S	L	B	Z	B	(	I	7

MATERIAL SPECIFICATION

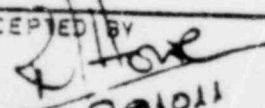
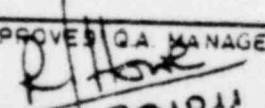
REV. NR. 2

COPY TO:

- 3.6 The ASME certificate number and expiration date when the material has been manufactured under provisions of an "ASME Material Certificate" per NA 3707.6.
- 3.7 All additional requirements of the Dikkers Purchase Order.
- 3.8 Those requirements which were not performed.
- 3.9 The applicable Purchase order number.
- 4. The above mentioned ASME Code Sections shall be the 1974 Edition plus the Addenda up to and including Summer 1976.
- 5. For welding and preparation of the mechanical test-coupons following welding date are applicable:
  - 5.1 Preheat temperature : 100-150°C  
Interpass temperature : 100-260°C.

POOR ORIGINAL

Electrode: GOMAKC 49 C

PREPARED BY J. Wilts dd 1479-00-14	ACCEPTED BY  dd 1479-00-14	APPROVED QA MANAGER  dd 1479-00-14	PAGE 3 OF 3
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# DIKKERS

VALVES  
ENGINEERING  
CASTINGS

1	2	3	4	5	6	7	8	9	10	11	12	13
E	A	N	Z	Y	S	I	b	Z	6	U	I	7

MATERIAL SPECIFICATION

REV. NR. 2

COPY TO

1. The testing of the all-weld metal tension specimen and the testing of the impact test specimen shall be performed after the following heat treatment:  
10 h at 600-620°C.  
The rate of the heating and cooling shall not exceed 5°C per hour above 425°C.
2. Marking of the packages shall be according to ASME Code Section III, par. NA 3706.6. (b). The caution label on the packages is not mandatory.
3. A Certified Material Test Report (CMTR) is required, showing:
  - 3.1 The actual results of:
    - 3.1.1 The chemical analysis
    - 3.1.2 The tensile Testing
    - 3.1.3 The impact testing at -30°C and at max. 0°C.
      - 3.1.3.1 Temperature
      - 3.1.3.2 Lateral expansion
      - 3.1.3.3 Absorbed energie
      - 3.1.3.4 Percentage of heat fracture
      - 3.1.3.5 Location and orientation
    - 3.2 The lot number
    - 3.3 Time and temperature of the heat treatment
    - 3.4 A statement that the material is manufactured in accordance with a QA Program per ASME III, par. NA 3700, approved by G. Dikkers & Co. N.V.
    - 3.5 A statement that the material meets the requirements of the ASME SPA 5.1 specification and the AWS classification E7015.

POOR ORIGINAL

Reference: GUNARC 49 C

PREPARED BY

ACCEPTED BY

APPROVED QA. MANAGER

PAGE 2 OF 3

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dd

dd

Van R.J. Howe

afd.

datum 21 november 1979

Aan HH. Grobben, Koers en Harberink

Betreft

DEFEKTBONNEN

Akte/Opm.

Tijdens Audit 18005 "Q.A. Engineering Files", is gebleken dat defektbonnen niet consequent zijn afgetekend door ANI.

Let u hier alstublieft in het vervolg op dat alle defektbonnen aan ANI worden aangeboden.

Alle defektbonnen die nog niet zijn afgetekend moeten alsnog aan ANI worden aangeboden.

R.J. Howe

**TRANSLATION:**

During internal audit 18005 "Q.A Engineering Files" it has been seen that NCL's are not always signed by the ANI for N-Stamp Orders.

In future please ensure that all NCL's for N-Stamp Orders are signed-off by the ANI.

All NCL's not yet signed-off must now be presented to the ANI

R.J. Howe  
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POOR ORIGINAL