

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

Report No. 99900314/80-01

Program No. 51300

Company: Colt Industries
Trent Tube Division of Crucible, Incorporated
141 Hammonds Street
Carrollton, Georgia 30117

Inspection Conducted: March 3-7, 1980

Inspector: R. E. Oller 3 25 80
R. E. Oller, Contractor Inspector
Components Section II
Vendor Inspection Branch
Date

Approved by: D. M. Hunnicutt 3/25/80
D. M. Hunnicutt, Chief
Components Section II
Vendor Inspection Branch
Date

Summary

Inspection on March 3-7, 1980 (99900314/80-01)

Areas Inspected: Implementation of 10 CFR 50, Appendix B Criteria and other applicable requirements including: action on previous inspection findings, internal audits, training, document control, material identification and control, welding control consisting of welding procedure specifications-welding material control-welder qualification, and qualification of NDE personnel. The inspection involved 27 inspector-hours on site.

Results: In the seven (7) areas inspected, no deviations or unresolved items were identified.

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DETAILS SECTION

A. Persons Contacted

- * D. Coppock, Plant Manager
- J. McDowell, Shipping and Finishing Foreman
- M. Newsom, Records Coordinator
- G. Sharp, ULS Operator
- J. Simpson, NDE Technician
- * J. Wehrle, Quality Assurance Manager

* Attended the exit meeting.

B. Action on Previous Inspection Findings

1. (Closed) Deviation A (Report No. 79-02): Failure to maintain an accompanying Rejection Tag and a Mill Order with four (4) stainless steel pipes held in a reject rack. Corrective action was implemented prior to the end of the inspection by attaching a copy of the Rejection (rework) Tag No. 4969 to the pipes to control the required rework. In the followup on preventive actions, the NRC inspector found that preventive action was implemented by requiring that plant foreman reinstruct employees under their supervision relative to the mandatory QA Program requirements regarding material control. A copy of Trent Tubes corrective action response letter dated 11/27/79 to the NRC, was sent to each Production and Inspection Foreman and Supervisor.
2. (Closed) Deviation B (Report No. 79-02): Failure to calibrate the voltmeters which control the two (2) automatic voltage control regulators used on the automatic girth welding machine No. 718. The NRC inspector found the voltmeters have been calibrated; calibration record cards for these meters are being maintained, and the calibration status of these specific meters was checked during the October 23, 1979 internal audit.
3. (Closed) Deviation C (Report No. 79-02): Failure to provide documented evidence that the furnace used in heat treating SA-358 class 1, ASME Code Section III Class 1 and 2, T-304 piping, was surveyed as required by the ASME Code NB/NC-2180. The inspector found a temperature uniformity survey was performed by Leeds and Northrup on August 31, 1979 and appropriate records of survey and calibration are available.
4. (Closed) Unresolved Item (Report No. 79-02): The QA Manual had not been revised to include specific details regarding the exclusion of procedure and revision numbers on Mill Order

travelers for operations such as: forming, pickling, passivating, planishing, and degreasing. The NRC inspector found that QA Manual Section 12.0 "Process Control," paragraph 12.2(c) was revised and now specifically deletes listing of procedure and revision numbers on the Mill Orders for the above operations.

C. Internal Audits

1. Objectives

The objectives of this area of the inspection were to verify that the following items were controlled in accordance with applicable NRC and ASME code requirements:

- a. A written system has been established to assure that internal audits are performed and controlled in accordance with applicable codes to verify compliance with all aspects of the QA program.
- b. Planned and periodic internal audits are performed in accordance with written procedures or checklists by qualified personnel not having direct responsibilities in the areas being audited.
- c. Audit results are documented and reviewed by management having responsibility in the area audited.
- d. Followup action, including reaudit of deficient areas, is taken where indicated.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual Section 20.0 "Audits."
- b. Review of records of the corporate management audit of the Carrollton Plant QA Program on November 15, 1979.
- c. Review of the 1979 Audit Schedule.
- d. Review of records of internal audits performed during the period of June through December, 1979.
- e. Review of the "Quality Assurance Semi-Annual Reports" by the QA Manager to the Plant Manager, for the periods of January through June, 1979, and July through December, 1979.

- f. Review of meeting minutes "Quality Assurance and Product Meeting" dated 2/21/80.
- g. Discussions with cognizant personnel.

3. Findings

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

D. Training

1. Objectives

The objectives of this area of the inspection were to verify that the following items were controlled in accordance with applicable NRC and ASME Code requirements:

- a. A written system has been established to assure that indoctrination and training of personnel performing activities affecting quality is implemented in accordance with applicable codes.
- b. Appropriate written agenda are used.
- c. Records of training sessions, agenda and attendance are maintained.
- d. The agenda includes subject matter adequate to provide an understanding of the general and detailed aspects of the QA program, codes, standards and applicable technical disciplines.
- e. The instructors are suitably qualified.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual Section 4.0 "Indoctrination and Training."
- b. Review of the following training documents.
 - (1) QA Training Schedule 1980/1981.
 - (2) Training Schedule document.

- (3) QA Program Requirements, procedure QCS-187.
 - (4) Material Specification (course outline).
 - (5) Quality System Program - New Employee.
 - (6) Welding Operator Training Program.
 - (7) Annealing Training Program.
 - (8) Cleaning and Degreasing S.S. Training Program.
 - (9) Inspector Training Program.
- c. Review of the QA Manager's summary report January-December, 1979, "QA Training Report."
 - d. Review of records of training for the following personnel:
 - (1) Welding Operators
 - (2) Inspectors
 - (3) Furnace Operators
 - (4) Pickling Operators
 - (5) Nondestructive Examination Technicians.
 - e. Discussions with cognizant personnel.

3. Findings

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

E. Document Control

1. Objectives

The objectives of this area of the inspection were to verify that the following items were controlled in accordance with applicable NRC and ASME Code requirements.

- a. A written system has been established to assure that document control is performed in accordance with applicable codes.

- b. The control of the issuance and disposition of documents, such as specifications, instructions and procedures, including changes thereto is implemented and documented in accordance with written instructions.
- c. The latest applicable documents, including changes, are reviewed for adequacy and approved for release by authorized personnel and distributed for use at the location where the prescribed activity is performed.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual Section 7.0 "Quality Document Control."
- b. Review of the following quality documents.
 - (1) Quality Document Handbook containing 24 process, inspection and nondestructive examination procedures.
 - (2) Index for the Quality Document Handbook.
 - (3) Raw Materials Specification Book.
 - (4) Distribution Chart/Log for QD procedures.
- c. Observation of QD procedures located at work stations.
- d. Discussions with cognizant personnel.

3. Findings

- a. Within this area of the inspection, no deviations or unresolved items were identified.
- b. Other Findings - Comment.
The definition of "Quality Document" in the QA Manual paragraph 7.1, does not appear to be consistent with the contents of the Quality Document Handbooks in that the definition includes both procedures and specifications, while the QD Handbooks contain only procedures.

F. Material Identification and Control

1. Objectives

The objectives of this area of the inspection were to verify that the following items were controlled in accordance with applicable NRC and ASME Code Requirements.

- a. A written system has been established to assure that material identification and control is performed in accordance with applicable codes.
- b. Documented measures have been used for identification and control of materials and items including partially fabricated assemblies.
- c. Identification is maintained either on the item or on records traceable to the item.
- d. Permanent or temporary identification marks or numbers are legible and are not detrimental to the item quality "or interfere" with the function of the item.
- e. All characteristics required to be reported appear on Checklists or Certified Material Test Reports, and the CMTRs have been received, reviewed and found acceptable.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual Section 10.0 "Material Control."
- b. Observations of material identification and control process documents in the following shop areas.
 - (1) Receiving hold area for cut stainless steel plate.
 - (2) Storage and identification marking on coils of stainless steel strip.
 - (3) Press Forming Station.
 - (4) Welding Machine Stations.
 - (5) Radiographic Station.
 - (6) Cutoff station.
 - (7) Final Inspection.
- c. Review of supplier certified material test reports and the related "Heat Analysis Card" use by Quality Control to release material.

- d. Review of the "Tube Number Assignment Log."
- e. Review of "Raw Material Release, Distribution and Inspection" form records for heats of plate and strip.
- f. Review of final "Inspection Tallys."
- g. Review of NM-1 Code Data Reports for finished pipes and tubes.
- h. Discussions with cognizant personnel.

3. Findings

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

G. Welding

1. Objectives

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

- a. A system has been established to assure that welding is controlled in accordance with the applicable codes.
- b. The welding procedure specifications (WPS) used in production welding are prepared, qualified and controlled in accordance with the QA program.
- c. That welding materials purchase, acceptance, storage, issuance and use are controlled and documented in accordance with detailed procedures.
- d. The welders are qualified in accordance with the ASME code.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual Section 13.0 "Welding."
- b. Observation of the locked welding wire storage cabinets.
- c. Review of the following control records for four (4) different heats of welding wire.

(1) Supplier Material Certifications.

- (2) Heat Analysis Cards.
 - (3) Welding Wire Releases.
 - d. Review of eight (8) welding procedure specifications and the related procedure qualification records, used in manufacture, by automatic welding, of SA-358 and SA-312 piping.
 - e. Review of records of qualification for thirteen (13) active welders and welder operators.
 - f. Review of Trent Tube's 90 day code requalification log for welders and welder operators.
3. Findings

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

H. Qualification of NDE Personnel

1. Objectives

The objectives of this area of the inspection were to verify that the following items were controlled in accordance with applicable NRC and ASME Code Requirements:

- a. A written system has been established to assure that measures to control the qualification of nondestructive examination personnel has been documented.
- b. The above system has been implemented such that the subject personnel are properly qualified in accordance with NRC, ASME and the manufacturer's requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual Section 14.0 "Nondestructive Examination."
- b. Review of records of SNT-TC-1A-1975 required written examinations, eye examinations and certifications of Level II NDE technicians for techniques as follows:
 - (1) Three (3) for ultrasonic examination.
 - (2) Four (4) for liquid penetrant examination.
 - (3) Two (2) for radiographic examination.

- c. Review of the SNT-TC-1A-1975 required written examination, eye examination, and certification of the Carrollton plant Level III Examiner (who is also the QA Manager) for the examination techniques of eddy current, radiography, ultrasonics, magnetic partical and liquid penetrant.
- d. Discussions with cognizant personnel.

3. Findings

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

I. Exit Interview

1. The inspector met with management representatives denoted in paragraph A, at the conclusion of the inspection on March 7, 1980.
2. The following subjects were discussed:
 - a. Areas inspected.
 - b. Status of previously identified deviations and the unresolved item.
 - c. The absence of deviations and unresolved items resulting from this inspection.
3. The manufacturer representative's indicated they did not have any question regarding the inspection.