

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

Report No. 99900710/80-01

Program No. 51300

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

Inspection at: Johnstown Plant

Inspection Conducted: March 10-13, 1980

Inspector: *D. M. Hunnicutt* *3/25/80*  
for H. W. Roberds, 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 10-13, 1980 (99900710/80-01)

Areas Inspected: Implementation of 10 CFR 50, Appendix B Criteria and applicable codes and/or standards; including welder qualification, joint fitup and welding, welding material control, welding procedure specification and manufacturing process control. The inspection involved twenty-one (21) inspector-hours on site by one (1) NRC inspector.

Results: In the five (5) areas inspected, no apparent deviations or unresolved items were identified in two (2) areas: the following deviations were identified in the remaining areas.

Deficiency: Compliance with 10 CFR 21 - Failure to comply with contractually invoked 10 CFR 21, relative to required posting of Section 206 of the Energy Reorganization Act of 1974 and procedures (Notice of Violation).

Deviations: Welder Qualification - Welder observed welding in a position not qualified in accordance with Criterion V of 10 CFR 50, Appendix B and Section IX of the ASME Code. (Notice of Deviation, Item A).

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Welding Procedure Specification - Use of a backing material not in accordance with Criterion V of 10 CFR 50 Appendix B and the applicable WPS (Notice of Deviation, Item B).

Manufacturing Process Control - Certification of a welding operation not in accordance with Criterion V of 10 CFR 50 Appendix B and Section 6 of the QA Manual (Notice of Deviation, Item C). Failure to record the NCN number on the QC Data Sheet not in accordance with Criterion V of 10 CFR 50 Appendix B and Section 10 of the QA Manual (Notice of Deviation, Item D).

DETAILS SECTIONA. Person Contacted

- \*N. D. Holcomb - General Manager
- \*L. R. Stone - Plant Superintendent
- \*R. Lamm - QC Manager
- \*R. Lobb - QA Supervisor
- \*H. Stone - Assistant Manager Engineering
- \*M. Barr - QC Supervisor
- \*F. Pero - QC Supervisor
- \*P. Scholar - Nuclear Engineering Group Leader
- \*R. Jackson - QA Manager

\*Attended Exit Meeting

B. Welder Qualifications1. Objective

The objective of this area of the inspection was to determine if welders and welding operators were qualified in accordance with Section IX of the ASME Code and NAVCO QA program.

2. Method of Accomplishment

The preceding objective was accomplished by:

- a. Review of the Quality Assurance Manual Section 8 revision 0, "Welding Control."
- b. Observation of welding being performed on shop Order 8595-PS-1 and 8002 CCH 402.
- c. Review of four (4) welder qualification record packages.

3. Findingsa. Deviation from Commitments

See Notice of Deviation, Item A.

b. Unresolved Items

None.

D. Joint Fitup and Welding

1. Objective

The objective of this area of the inspection was to determine if production welding was controlled in accordance with the NAVCO QA program and applicable ASME Code requirements.

2. Method of Accomplishment

The preceding objective was accomplished by:

- a. Review of the Quality Assurance Manual, Section 6, revision 0, "Process Control."
- b. Review of the Quality Assurance Manual, Section 9, revision 0, "Welding Control."
- c. Observation of production welding operations on shop Order 8595 PS-1 and 8002 CCH402 A, with respect to:
  - (1) Use of the welding process specification referenced by the applicable OC Data Sheets.
  - (2) Availability of the welding process specification at work location.
  - (3) Use of approved welding materials required by the welding process specification.
  - (4) Verification that the welding was performed within the parameters listed on the welding process specification.

3. Findings

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

C. Welding Material Control

1. Objective

The objective of this area of the inspection was to determine if welding material purchase acceptance, storage and handling was in accordance with the NAVCO QA program and applicable ASME Code requirements.

2. Method of Accomplishment

The preceding objective was accomplished by:

- a. Review of the QA Manual, Section 7, Revision 0, "Welding Material Control."
- b. Examination of weld material storage area.
- c. Examination of electrode ovens for material identification and temperature control.
- d. Review of Certified Material Test Report for weld material Heat Nos. 6149 and 7679.

3. Findings

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

D. Welding Procedure Specifications

1. Objectives

The objectives of this area of the inspection was to determine if the welding procedure specifications (WPS) used by NAVCO in production welding were being prepared, qualified and controlled in accordance with the NAVCO QA program and applicable ASME Code requirements.

2. Method of Accomplishment

The preceding objective was accomplished by:

- a. Review of the Quality Assurance Manual, Section 8, "Welding Control."
- b. Review procedure qualification records F-003 and F-004 with respect to:
  - (1) Listing of all required essential variables,
  - (2) Performance of all mechanical test required by the ASME Code, and
  - (3) Verification that mechanical test results comply with ASME Code requirements.

3. Findings

a. Deviation from Commitments

See Notice of Deviation, Item B.

b. Unresolved Items

None.

E. Manufacturing Process Control

1. Objectives

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

- a. Manufacturing is performed under a controlled system.
- b. Certain processes are accomplished by qualified personnel using approved procedures.
- c. Results are reported at the completion of a specific operation.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the Quality Assurance Manual, Section 6, "Process Control."
- b. Review of the Quality Assurance Manual, Section 10, "Control of Nonconformities and Corrective Action."
- c. Review of six (6) QC Data Sheets at various stages of fabrication.
- d. Observation of work in process at various stages of the fabrication cycle.

3. Findings

a. Deviations from Commitments

- (1) See Notice of Deviation, Item C.
- (2) See Notice of Deviation, Item D.

b. Unresolved Items

None.

F. Compliance with 10 CFR 21

1. Inspection Objectives

To ascertain that NAVCo, Johnstown plant, was in compliance with the posting requirements of 10 CFR 21 section 21.6.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Observation relative to posted notices in the facility.
- b. Interviews of accompanying personnel.

3. Findings Relative to 10 CFR 21 Section 21.6

See Notice of Violation.

G. Exit Meeting

A post inspection exit meeting was held on March 13, 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 inspectors with respect to the findings as presented to them and affirmed their commitment to the Quality Assurance Program.