

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

REGION III

Report No. 50-341/80-09

Docket No. 50-341

License No. CPPR-87

Licensee: Detroit Edison Company  
2000 Second Avenue  
Detroit, MI 48226

Facility Name: Enrico Fermi Nuclear Station, Unit 2

Inspection At: Fermi Site, Monroe, MI

Inspection Conducted: June 10-13, 1980

Inspector: *D. H. Danielson*  
for E. W. K. Lee

6/26/80

Approved By: *D. H. Danielson*  
D. H. Danielson, Chief  
Engineering Support Section 2

6/26/80

Inspection Summary

Inspection on June 10-13, 1980 (Report No. 50-341/80-09)

Areas Inspected: Reactor Coolant Pressure Boundary and Safety Related Piping welding activities, procedures and records; previously identified unresolved items. The inspection involved a total of 24 inspector hours onsite by one NRC inspector.

Results: No items of noncompliance or deviations were identified.

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## DETAILS

### Persons Contacted

#### Detroit Edison Company

\*T. A. Alessi, Project QA Director  
\*C. R. Bacon, Assistant Director - Field Engineering  
\*W. Everett, Project Superintendent  
\*W. Fahrner, Manager EF2  
\*E. Hines, Assistant Vice President QA  
\*R. S. Lenart, Startup Engineer  
\*J. P. Mullens, QA Engineer  
\*E. H. Newton, Plant QA Engineer  
\*H. A. Walker, Supervisor - Construction QA  
\*W. W. White, Superintendent - Operations

#### Daniel International Corporation

\*J. G. Bolt, Assistant QA Director  
\*D. F. Ferguson, Acting Project Manager  
\*J. Rotondo, QA Engineer

\*Denotes those attending the exit interview.

The inspector also talked with and interviewed several other licensee and contractor employees, including members of the Quality Control and craft.

### Licensee Action on Previous Inspection Findings

(Closed) Unresolved Item (341/79-08-03): Incorrect welding process. The inspector reviewed the new weld process data sheet for weld No. E11-3158-OW4 and established that this weld has been cut out and re-welded. The other welds with similar situation identified by Daniel International Corporation during their audit were also corrected by either requalifying the welder or the welding procedure and the DDRs were properly closed except DDR (W) 3423. The density of the RT film of the test coupon was in question and the licensee plans to reshoot the test coupon.

(Closed) Unresolved Item (341/79-20-01): Weld crown reinforcement. The inspector reviewed the DDR initiated for this item. It was determined that corrective action to prevent recurrence has been taken. However, the DDR is open because actual repair of the weld has not been completed.

### Functional or Program Areas Inspected

#### 1. Reactor Coolant Pressure Boundary Piping - Observation of Welding Activities

The inspector observed the following welding activities:

- a. Reactor Core Isolation Cooling System Weld No. 5WS7 on Sketch No. 05-DR1-MW-2192.
- b. Reactor Water Clean-up System welds No. 6 and 7, and No. 41 and 6 on drawing No. 6DI-G33-7222-1.
- c. Nuclear Boiler System weld No. 11 and 2 on drawing No. 6DI-B21-7264-1.
- d. Reactor Recirculating System weld No. 29SX33A(e) on drawing No. B31-7215-4.
- e. Standby Liquid Control System weld No. C41-2340-0 and 33 on drawing No. 6WM-C41-2340-1.

It was determined that (1) work was conducted in accordance with traveler; (2) proper welding materials were used; (3) welding procedure requirements were met; (4) work area was free of weld rod-stubs; and (5) physical appearance was acceptable.

No items of noncompliance or deviations were identified.

## 2. Safety-Related Piping Observation of Welding Activities

The inspector observed the following welding activities:

- a. Emergency Equipment Cooling Water System weld No. T on drawing No. 6WM-P44-3056-4.
- b. Containment Atmosphere System weld No. T48-04-2097-1WF1 on No. 6M721-2097-1 and weld No. T48-04-2095-0W20 on drawing No. 6M721-2095-1.

It was determined that (1) work was conducted in accordance with traveler; (2) proper welding materials were used; (3) welding procedure requirements were met; (4) work area was free of weld rod-stubs; and (5) physical appearance was acceptable.

No items of noncompliance or deviations were identified.

## 3. Reactor Coolant Pressure Boundary Piping -Observation of NDE Activities

The inspector observed liquid penetrant examination of Nuclear Boiler System weld No. OW2R1 on drawing No. 6M721-3258-1 and Reactor Water Cleanup System welds No. 18 and 19, No. 19 and 20, and No. 20 and 21 on drawing No. G33-7222-1. It was determined that: (1) surface condition was acceptable, (2) procedure requirements were met, (3) personnel were qualified and (4) weld No. OW2R1 was rejected due to unacceptable indication.

No items of noncompliance or deviations were identified.

4. Reactor Coolant Pressure Boundary and Safety Related Piping -Welding Material Control

a. Review of Documents

The inspector reviewed the following documents:

- (1) W&B Procedure No. WB-Q-101, Revision 10, "Control of Welding Material".
- (2) W&B Procedure No. WB-Q-115, Revision 3, "Receiving Inspection".
- (3) W&B Procedure No. WB-A-107, Revision 3, "Procurement of Permanent Material, Equipment and Services".
- (4) Receiving Inspection Report, Purchase Order and Material Certification for ER316L welding rod with heat No. 26886 and lot Nos. 21008 and 21016; E7018 electrode with heat No. 21660 and lot No. 02-2-S827P; heat No. 422C5071 and Lot No. 03-2-G831K.

It was determined that the above documents met the PSAR, 10 CFR 50, Appendix B and the applicable code requirements.

b. Control of Materials

The inspector toured W&B welding material issuing station. It was determined that (1) the welding materials are properly identified and segregated; (2) the temperature of the rod ovens is maintained; (3) records are properly kept; and (4) issuance and return of welding materials are controlled in accordance with approved procedures.

No items of noncompliance or deviations were identified.

5. Reactor Coolant Pressure Boundary and Safety Related Piping -Welder Qualification

The inspector reviewed the following documents:

- a. W&B Procedure No. WB-E-118, Revision 8, "Welder and Brazer Qualification".
- b. Seven qualifications records of welders who performed welds identified in Paragraphs 1 and 2 of this report.

The inspector determined that the above documents met the requirements of ASME B&PV Code Section IX.

No items of noncompliance or deviations were identified.

6. Safety Related Piping -Review of QA Manual

The inspector reviewed in the Region III office the Townsend and Bottum, Incorporated Nuclear Quality Assurance Manual dated April 7, 1980. It was determined that the manual met the PSAR commitments and 10 CFR 50, Appendix B requirements.

No items of noncompliance or deviations were identified.

Exit Interview

The inspector met with licensee representatives (denoted under Persons Contacted) at the conclusion of the inspection on June 13, 1980. The inspector summarized the purpose and findings of the inspection. The licensee acknowledged the findings reported herein.