

Appendix A

NOTICE OF VIOLATION

Based on the results of the NRC inspection conducted on May 27-30, 1980, it appears that certain of your activities were not conducted in full compliance with the conditions of your NRC Construction Permit No. CPPR-147 as indicated below:

Failure to Specify Appropriate Acceptance Criteria

10 CFR Part 50, Appendix B, Criterion V requires that procedures shall include appropriate acceptance criteria for determining that important activities have been satisfactorily accomplished.

Bechtel Specification No. 10466-M-204 specifies in paragraph 5.6.1:

"Welds joining flued heads or closure plates and penetration sleeve shall be considered Class 2 or Class MC welds and shall be full penetration welds. The welds installing the fuel transfer tube and the stainless steel fuel transfer tube sleeve and the welds joining the weld neck flange to the electrical penetration sleeve shall be made in accordance with NE-4000 and examined per NE-5000."

Paragraph NE-4426 of NE-4000 specifies limits for the maximum reinforcement of butt welds.

Contrary to the above:

The IE inspector determined that the limits for maximum reinforcement of butt welds specified in Daniel welding technique sheets N-1-1-BA-1, Revision 4 for welding carbon steel and N-1-8-BA-24, Revision 0 for welding carbon steel to stainless steel and Daniel Quality Control Procedure QCP-VII-200, Revision 5 for visual inspection are less restrictive than required in NE-4000, paragraph NE-4426 of ASME B&PV Code, Section III, 1974 Edition through Summer 1975 Addenda. For example, for a material thickness of one inch, NE-4426 limits the maximum reinforcement to 3/32 inch, whereas, the welding technique sheets and Quality Control procedure permit a maximum reinforcement of 3/16 inch.

This is an infraction.