

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

Report No. 99900316/80-01

Program No. 51300

Company: Gould, Incorporated  
Valves and Fittings Division  
6300 W. Howard Street  
Chicago, Illinois 60648

Inspection Conducted: May 28-30, 1980

Inspectors: R. E. Oller 6-6-80  
R. E. Oller, Contractor Inspector  
Components Section II  
Vendor Inspection Branch  
Date

Approved by: Uldis Potapovs 6/12/80  
Uldis Potapovs, Acting Chief  
Components Section II  
Vendor Inspection Branch  
Date

Summary

Inspection on May 28-30, 1980 (99900316/80-01)

Areas Inspected: Implementation of 10 CFR 50, Appendix B criteria, other NRC requirements, and applicable codes and standards including: action on previous inspection findings, nonconformances and corrective action, training, records and procurement control. The inspection involved 18 inspector-hours on site by one NRC inspector.

Results: In the five (5) areas inspected, no deviations or unresolved items were identified.

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DETAILS SECTIONA. Persons Contacted

- \*R. Haines, QA Manager
- \*J. Furfey, QA Engineer
- \*S. Kunka, Vice President Operations
  - J. Misek, Tool and Gage Inspector
  - R. Malone, QA Engineer

\*Attended the exit meeting.

B. Action on Previous Inspection Findings

1. (Closed) Deviation (Report No. 79-02): Failure to record the calibration results for the Bendix profilometer test plate on a tool and gage control card. The inspector found that calibration results for the subject test plate have been recorded on a tool and gage control card. Also that the tool and gage control card review was included in the QA Manager's audit performed on November 7, 1979.
2. (Closed) Unresolved Item (Report No. 79-02): Failure to have a copy of the instructions for using the Dead Weight Tester for calibrating the master pressure gage, in Plant No. 3 where the tester is located and used. The inspector found that a copy of the operating instructions for the Dead Weight Tester is now kept with the tester in Plant No. 3.

C. Nonconformances and Corrective Action1. 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 nonconformances are controlled and corrective action is taken.
- b. Documented procedures or instructions are implemented for identification, documentation, segregation and disposition of nonconforming materials, parts, or components, and notification to affected organizations.

- c. Nonconforming items are reviewed and accepted, rejected, repaired or reworked in accordance with documented procedures.
  - d. Conditions adverse to quality are promptly identified and corrected.
  - e. The causes of significant conditions adverse to quality are determined and corrected to preclude repetition.
  - f. The condition adverse to quality, the cause and the corrective action are documented and reported to appropriate levels of management.
2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual Section 14, "Nonconformities."
- b. Review of the approved procedure No. QCP-1, "Handling of Nonconformities," Revision 0.
- c. Observation of the Receiving Inspection Hold Area for valve parts and materials.
- d. Observation of nonconforming 5-way valve manifold bodies on hold status.
- e. Review of the Dimensional Inspection Checklist and Parts Drawing for the above valve manifold bodies.
- f. Review of in-process Material Rejection Reports.
- g. Review of Receiving Inspection Reports covering plant materials, and services for heat treating and welding repair.
- h. 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 18, "Training"
- b. Discussions with cognizant personnel.
- c. Review of QA program training schedules for 1979 and 1980 covering personnel in the following departments.
  - (1) Inspection
  - (2) Purchasing
  - (3) Engineering
  - (4) Production and Inventory Control
  - (5) Sales Engineering
  - (6) Management
- d. Review of the following records of QA program training completed during 1979 and 1980.
  - (1) Training Notices
  - (2) Agenda
  - (3) Attendance records including signature of attendees; instructors, hours of session, and date.

### 3. Findings

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

## E. Records

### 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 system has been established to assure that records required for Quality Assurance, fabrication and traceability are maintained.
- b. The file contains documents such as records of materials, manufacturing, examination, and test data taken before and during manufacture, and the procedures, specifications, and drawings used, fully identified by pertinent material or item identification numbers, revision numbers, and issue dates;
- c. The file also includes related data such as qualification of personnel, procedures equipment and repairs;
- d. Adequate measures are provided to suitably protect the files from deterioration and damage.

### 2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual Section 16 "Documentation and N-Stamping."
- b. Observation of Owner - permanent type and Internal - semipermanent type record storage files in Plant No. 3 and duplicate record storage files in Plant No. 1.
- c. Review of Internal-semipermanent record packages and Owner-permanent record packages for the following valve orders:
  - (1) Portland General Electric, Order N-15131, Item 1, Valve Assemblies SN-30709 through SN-30743.

(2) Mercury Company Order 64043-N18724 for Valve Assemblies SN-30309 through SN-30378.

- d. Review of Owner-permanent record package, only, for Bechtel Order V-4105063, Item 3, covering 250 valves.
- e. Discussions with cognizant personnel.

3. Findings

- a. Within this area of the inspection, no deviations or unresolved items were identified.
- b. Follow-up Item

It was determined that the Documentation Checklists (DCL) contained in the record packages did not include the process travelers which are considered an Internal-semipermanent record, since the travelers were included in the record packages, the DCL needs to be revised to include the travelers. This item will be followed up during a subsequent inspection.

F. Procurement Control

1. Objectives

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

- a. A written system has been established to assure that procurement control is performed in accordance with NRC and ASME Code requirements.
- b. Written procedures have been prepared and approved by the company to provide control of procurement documents, source selection, supplier performance, verification activities and product acceptance for materials, equipment and services, as applicable.
- c. The above procedures are being effectively implemented.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual Section 8 "Purchasing and Vendor Qualification," and Section 9, paragraph 9.5 "Receiving Inspection."



- b. Review of the qualified Nuclear Vendors List dated May 28, 1980.
- c. Review of procurement identity, i.e. Mill Heat Number and Purchase Order Number and Supplier, in the Heat Marking Symbol Log for nuclear fittings supplied on two (2) different purchase orders.
- d. Review of records of survey for three (3) subcontractors providing chemical and metallurgical test service and heat treating service.
- e. Review of purchase orders for silver plating and heat treating.
- f. Review of purchase orders for raw materials.
- g. Review of Gould Receiving Inspection Reports.
- h. Review of Certificates of Test, and Certifications of Heat Treatment for materials and services from various suppliers.
- i. Discussions with cognizant personnel.

3. Findings

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

G. Exit Interview

1. The inspector met with management representatives denoted in paragraph A, at the conclusion of the inspection of May 30, 1980.
2. The following subjects were discussed:
  - a. Areas inspected.
  - b. Status of corrective action for the previous inspection findings.
  - c. This inspection's findings.
3. The manufacturer's representatives indicated that they did not have any questions.