

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

Report No. 99900077/80-01

Program No. 51300

Company: Pullman Power Products  
14507 South Paramount Boulevard  
Paramount, California 90773

Inspection at: Paramount, California

Inspection Conducted: June 2-6, 1980

Inspector:

*H. W. Roberds*

H. W. Roberds, Contractor Inspector  
Components Section II  
Vendor Inspection Branch

*6/26/80*  
Date

Approved by:

*U. Potapovs*

U. Potapovs, (Acting) Chief  
Components Section II  
Vendor Inspection Branch

*6/26/80*  
Date

Summary

Inspection on June 2-6, 1980 (99900077/80-01)

Areas Inspected: Implementation of 10 CFR 50, Appendix B criteria and applicable codes and standards; including manufacturing process control, welding material control, joint fitup and welding and internal audits. The inspection involved twenty eight (28) inspector-hours on site by one (1) NRC inspector.

Results: In the four (4) areas inspected, no apparent deviations or unresolved items were identified.

Details SectionA. Persons Contacted

E. B. Curcio, Vice President and Plant Manager  
\*B. S. Saggi, Manager of Manufacturing Engineering  
\*H. W. Owen, Assistant Plant Manager  
\*S. L. Engler, Manager, Quality Assurance  
D. Obrion, Quality Assurance Supervisor  
J. R. Richards, Welding Foreman, Production  
J. Smith, Shipping and Heat Treatment Foreman  
R. Kuhn, Rod-room Clerk

\*Attended exit meeting.

B. Manufacturing Process Control1. 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 and completion of specific operations are reported and/or recorded.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual, Section V, "Instructions, Procedures, and Drawings."
- b. Review of the QA Manual, Section VIII, "Identification and Control of Materials, Parts, and Components."
- c. Review of the QA Manual, Section X, "Fabrication Control and Inspection."
- d. Review of Shop Standard Procedure No. IX-3P, "Fabrication Specifications for Nuclear Power Plant Components, Piping Systems and Appurtenances, ASME - Section III."
- e. Review of eight (8) process sheets and fabrication drawings at various stages of the manufacturing process.

- f. General observation of the fabrication area for cleanliness and handling of stainless materials.

3. Findings

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

C. Welding Material Control

1. Objectives

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

- a. Welding materials are purchased under a controlled system.
- b. Storage, handling and issuance of weld materials are controlled in accordance with the manufacturer's QA program.
- c. The QA Program meets the ASME Code and NRC requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual, Section IX, "Control of Special Process."
- b. Review of Procedure, No. VIII-2P, "Inventory Control of Nuclear Welding Material."
- c. Review of Procedure, No. VIII-3P, "Control of Welding Material Prior to Fabrication."
- d. Review of Procedure VIII-4P, "Control and Distribution of Nuclear Welding Material During Fabrication."
- e. Observation of weld material storage and issue area including examination of thirteen (13) coated electrode storage ovens.
- f. Review of four (4) weld material certification record packages.

3. Findings

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

D. Joint Fit-up and Welding

1. Objectives

The objective of this area of the inspection was to determine if production welding was controlled in accordance with the Pullman Power Products (PPP) QA Program and applicable ASME Code and NRC requirements.

2. Method of Accomplishment

The preceding objective was accomplished by:

- a. Review of the QA Manual, Section IX, "Control of Special Processes."
- b. Observation of five (5) pipe welds on Job No. 2830 fabrication sheets F-1041, F-491, F-263, F-269 and Job No. 2815, F-263 for the following:
  - (1) Completeness and correctness of documentations.
  - (2) Availability of welding procedures and instructions at the work stations.
  - (3) Verification that welding was performed within the limits of the applicable welding procedure specification.
- c. Measurement of preheat and interpass temperature in use to assure compliance with the applicable WPS.

3. Findings

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

E. Internal Audits

1. Objectives of this area of the inspection were to verify that:

- a. Procedures or policy documents clearly identify organizations responsible for audits and define their responsibilities and authorities.
- b. Measures have been established to assure that auditors are independent of any direct responsibility for performance of activities which they are auditing and that persons having direct responsibility for performance of activities being audited are not involved in the selection of the audit team.

- c. Guidelines and requirements are established for audit scheduling and that they take into consideration the status and importance of the activities to be audited.
- d. Sufficient instructions or guidance are available to the auditors in the form of checklists or procedures to perform the audits effectively and in accordance with the audit plan.
- e. Deficiencies identified by the audits are closed out by appropriate corrective action and timely follow-up, including reaudit of deficient areas.
- f. Audit records are collected, stored and maintained in accordance with applicable code and contract requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual, Section XVIII, "Audits."
- b. Review of internal audit results for the year 1979.
- c. Review of completed audit results for the year 1980.
- d. Review of current approved vendor list.

3. Findings

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

F. Exit Meeting

A post inspection meeting was held on June 6, 1980 with the management representatives denoted in paragraph a. above. The inspector summarized the scope of the inspection and informed management that there were no adverse findings.

Management had no comments.