



UNITED STATES
NUCLEAR REGULATORY COMMISSION
REGION V
1990 N. CALIFORNIA BOULEVARD
SUITE 202, WALNUT CREEK PLAZA
WALNUT CREEK, CALIFORNIA 94596

AUG 15 1980

Docket Nos. 50-508
50-509

Washington Public Power Supply System
P. O. Box 468
Richland, Washington 99352

Attention: Mr. N. O. Strand
Managing Director

Gentlemen:

Thank you for your letter dated July 11, 1980 informing us of the steps you have taken to correct the items which we brought to your attention in our letter dated June 9, 1980. Your corrective actions will be verified during a future inspection.

Your cooperation with us is appreciated.

Sincerely,

G. S. Spencer, Chief
Reactor Construction and
Engineering Support Branch

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Washington Public Power Supply System
A JOINT OPERATING AGENCY

P. O. Box 988 3000 GEO. WASHINGTON WAY RICHLAND, WASHINGTON 99352 PHONE (509) 375-5000

July 11, 1980
G03-80-1635

Nuclear Regulatory Commission, Region V
Suite 202, Walnut Creek Plaza
1990 N. California Boulevard
Walnut Creek, California 94596



Attention: Mr. G. S. Spencer
Chief Reactor Construction and
Engineering Support Branch

Subject: WPPSS NUCLEAR PROJECTS 3 and 3
NRC INSPECTION OF WNP-3 AND WNP-5
DOCKET NUMBERS 50-508 AND 50-509

Reference: 1) Letter, G.S. Spencer to N.O. Strand, same subject
date June 9, 1980.
2) Letter, D.F. Knuth to all AEC Licensees, "Criterion
for Determining Enforcement Action and Categories of
Noncompliance", dated December 13, 1974.

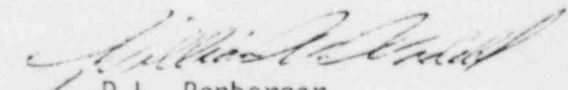
Dear Mr. Spencer:

This letter is in response to your letter of June 9, 1980, which discussed the results of the inspection conducted May 20-23, 1980 of activities authorized by Nuclear Regulatory Commission Construction Permit Numbers CPPR-154 and CPPR-155. The letter identified two items of noncompliance categorized in accordance with Reference 2 and required the Supply System to provide a response to these items.

The specific Nuclear Regulatory Commission Findings, as stated in your letter, and the Supply System responses are provided in Attachment I to this letter.

Should you have any questions to desire further information, please feel free to contact me directly.

Very truly yours,


for D.L. Renberger,
Assistant Director, Technology

Attachment

cc: D. Smithpecer, BPA
V. Stello, NRC
WNP-3/5 Files

DUP

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ATTACHMENT I

NUCLEAR REGULATORY COMMISSION FINDING A

10 CFR 50, Appendix B, Criterion V, as implemented by Section 17.4.5 of the Quality Assurance Program documented in the approved PSAR deviation 18-WP, states, in part, that "Activities affecting quality...shall be accomplished in accordance with...instructions, procedures or drawings".

Specification No. 3240-4, titled "Piping and Piping Supports - WPPSS Quality Class I, II, and G" in Division 2, Section 2A, paragraph 6.04h states that "All pipe welds except socket welds and where otherwise stated on the contract drawings shall be full penetration welds."

Contrary to the above requirements, the inspector observed on May 20 and 22, 1980, that piping subassembly No. 3-3CC12-0095A-1 had incomplete root penetration on the inside diameter of a pipe to elbow weld, specified to be a full penetration weld, in three areas for a total circumferential distance of approximately 2.5 inches to 3 inches and that piping subassembly No. 3-3CC24-0675B-8 had incomplete root penetration on the inside diameter of a pipe weld, specified to be a full penetration weld, for a total circumferential distance of approximately 12 inches. The above piping subassemblies are carbon steel and destined for service in the Unit 3 Component Cooling Water System and had been accepted by Ebasco receipt inspection.

This is an infraction.

NUCLEAR REGULATORY COMMISSION FINDING B

10 CFR 50, Appendix B, Criterion V, as implemented by Section 17.4.5 of the Quality Assurance Program documented in the approved PSAR deviation 18-WP, states, in part, that "Activities affecting quality...shall be accomplished in accordance with...instructions, procedures or drawings."

Specification No. 3240-4, titled "Piping and Piping Supports - WPPSS Quality Class I, II and G" in Division 2, Section 2A, paragraph 6.01a states that "All fabrication covered by this specification shall be in accordance with ASME Section III" and further states in paragraph 6.01d-iii that "The ends of pipe-to-pipe, pipe-to-fitting and pipe-to-valve joints shall be aligned as accurately as practical within the existing commercial codes and standards tolerance of pipe diameters, pipe wall thickness and out-of-roundness." The ASME B&PV Code, 1974 Edition, Summer 1976 Addenda, Subsection NO, Figure ND4233-1 requires 1/32" maximum uniform mismatch around joints with concentric centerlines and a 3/32" maximum mismatch at any one point around the joint for pipe joints with offset centerlines.

Contrary to the above requirements, the inspector observed on May 20-23, 1980, that certain piping subassemblies stored at the Saginaw storage area contained weld joints with offset in excess of ASME B&PV Code requirements. The discrepant piping subassemblies has been accepted by Ebasco receipt inspection. The findings are summarized on the next page.

<u>SUBASSEMBLY NO.</u>	<u>DISCREPANCY</u>
(1) 3-3CC24-0405B-5	Inside diameter offset of approximately 5/32" for about 6" of circumferential distance of one weld
(2) 3-3CC24-0205A-1	Inside diameter offset of approximately 3/16" for about 3" of circumferential distance on pipe/elbow weld
(3) 3-3CC24-0675B-4	Pipes at one weld joint were approximately 5/32" offset in inside diameter due to misalignment for a circumferential distance of about 6".
(4) 3-3CC24-03-SA-2B	Inside diameter offset of approximately 5/32" due to misalignment of pipes to be joined for about 6" and 8" of circumferential distance on first and second welds respectively from elbow opening.

This is an infraction.

For both items of Noncompliance, the following actions apply.

CORRECTIVE STEPS WHICH HAVE BEEN TAKEN:

Nonconformance Report number 11934 was prepared on May 22, 1980 to disposition the pipe spools which were identified by the NRC as exceeding offset limits or which exhibited incomplete weld penetration. The NCR disposition was to return the spools to the vendor.

The Supply System issued Stop Shipment Order number 04001 on June 20, 1980 which requires Supply System evaluation and approval of Associated Piping & Engineering Corporation's (AP&E) corrective action plan and the action taken to prevent recurrence prior to release of any further shipments.

The Supply System has established a hold point to perform 100% visual receipt inspection of all accessible interior/exterior ASME Section III spool welds. This receipt inspection will determine the acceptability of weld joint offset and weld penetration, and shall remain in effect until such time that sufficient inspection has been performed with acceptable results to obtain a satisfactory confidence level.

CORRECTIVE STEPS WHICH WILL BE TAKEN TO AVOID FURTHER VIOLATION:

AP&E will visually inspect all accessible welds on ASME Section III pipe spools now at the WNP-3/5 site. Inspections will determine the acceptability of weld joint offset and weld penetration based on contract requirements. Unacceptable

spools will be dispositioned to either be reworked at the site by AP&E utilizing approved procedures or be returned to AP&E's facility for appropriate action.

The Supply System will perform a sample receipt inspection on other prepurchased materials/components containing similar attributes. Sampling will remain in effect until such time that a sufficient sample size has been inspected with acceptable results to obtain a satisfactory confidence level.

DATE WHEN FULL COMPLIANCE WILL BE ACHIEVED:

Full compliance will be achieved upon receipt and approval of AP&E's corrective action plan and action taken to prevent recurrence.