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APPENDIX A

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

Docket No. 50-508

NOTICE OF VIOLATION

Based on the results of an NRC inspection conducted during the period of May 20-23, 1980, it appears that certain of your activities were not conducted in full compliance with conditions of your NRC Facility Construction Permit No. CPPR-154 (Unit 3) as indicated below.

- 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. 3-3CC12-009SA-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.

- 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."

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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 Sect on III" and further states in paragraph 6.01d-iii that "The ends of the 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 ND, Figure ND4232-1 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 and 22, 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 had been accepted by Ebasco receipt inspection. The findings are summarized below.

<u>SUBASSEMBLY NO.</u>	<u>DISCREPANCY</u>
(1) 3-3CC24-040SB-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" off set in inside diameter due to misalignment for a circumferential distance of about 6"
(4) 3-3CC24-030SA-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.