



Washington Public Power Supply System
A JOINT OPERATING AGENCY

P. O. Box 968 3000 GEO. WASHINGTON WAY RICHLAND, WASHINGTON 99352 PHONE (509) 375-5000

August 19, 1980
G01-80-231

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

Gentlemen:

Subject: WPPSS NUCLEAR PROJECTS NOS. 1/4
NRC INSPECTION - WNP-1/4
DATES OF INSPECTION - JUNE 2-9, 1980
DOCKET NOS. 50-460 AND 50-513
CONSTRUCTION PERMIT NOS. CPPR-134 AND -174

Reference: Letter from G. S. Spencer to N. O. Strand, NRC Inspection
at WNP-1/4 Site, dated July 17, 1980.

The referenced correspondence delineated the results of the June 2-9, 1980 inspection of activities authorized by NRC Construction Permits Nos. CPPR-134 and -174. Further, the referenced correspondence identified a certain activity which was not conducted in full compliance with PSAR requirements set forth in the Notice of Violation enclosed as Appendix A. This item of noncompliance has been categorized into a level as described in your correspondence to all NRC licensees dated December 31, 1974.

This letter is submitted in response to the referenced correspondence. The specific NRC finding, as identified, and the Supply System response is provided herewith as Appendix A.

Very truly yours,

D. L. Renberger
Assistant Director, Technology

jds
Enclosure (1)

cc: JR Lewis - BPA
CR Bryant - BPA
V. Mani - UE&C, Phil.
V. Stello - Director of Inspection and Enforcement - NRC

Boo!
s
1/1

8008270

546

APPENDIX A

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

Docket No. 50-460
Construction Permit No. CPPR-134

NOTICE OF VIOLATION

Based on the results of NRC inspections conducted during the period of June 2-9, 1980, it appears that one of your activities was not conducted in full compliance with conditions of your NRC Construction Permit No. CPPR-134 as indicated below:

10 CFR 50, Appendix B, Criterion V, as implemented by Section 17.1.5 of the quality assurance program documented in the PSAR and the WPPSS QA Program Manual Procedure QAP-2, Paragraph 3.1, states, in part, that "Activities affecting quality shall be prescribed by documented instructions, procedures or drawings, of a type appropriate to the circumstances and shall be accomplished in accordance with these instructions, procedures or drawings"

Allied-Capitol Joint Venture Drawing No. FCN-495, Revision 1, specifies 5/16-inch fillet welds for structural steel column No. 2270A and a 1/2-inch fillet weld for the attachment clip on column No. 2283. Contract specification No. 207 requires these columns to be fabricated in accordance with requirements of the AWS D1.1 structural welding code. This code permits fillet weld size to underrun the specified nominal fillet weld size by 1/16-inch without correction provided that the underrun does not exceed ten percent of the length of the weld.

Contrary to the above, on June 2, 1980, the sizes of fillet welds on column No. 2270A were less than 1/4-inch over the full length of the welds and the attachment clip fillet weld on column No. 2283 was 3/8-inch or less over the full length of the weld.

This is an infraction.

SUPPLY SYSTEM RESPONSE

Corrective Action Taken and Results Achieved

An indepth review of the Contract 207 drawing indicates that structural member 2283, as referenced in this report, is actually 2283A.

The undersized welds on structural members 2270A and 2283A are documented on Nonconformance Report No. 4-NCR-207-056 dated June 4, 1980. The aforementioned Nonconformance Report also includes four (4) additional structural members that contained undersized welds (piece marks 22, 67A, 2271A, 2348A and 3259A). All of the affected structural members have been appropriately hold tagged.

SUPPLY SYSTEM RESPONSE (Cont'd)

Corrective Action Taken and Results Achieved (Cont'd)

Nonconformance Report No. 4-NCR-207-056 is pending Engineering evaluation. Disposition action as required will be accomplished after our current labor situation is resolved.

As a result of this Notice of Violation, the Supply System initiated a re-inspection of all structural steel members in the WNP-1 and WNP-4 storage areas. In addition, similar inspections of accessible erected steel in the general services buildings and containment buildings are in progress. All defective welds will be identified, and appropriately tagged. Nonconformance reports will be initiated, as required.

Action Taken to Preclude Recurrence

Project Quality Assurance and UE&C Vendor Surveillance met with Capital Steel Corporation personnel on August 5-8, 1980 to review acceptance criteria practices in the shop and to inspect the balance of structural steel for shipment.

All future shipments will receive a 100% inspection instead of the random sampling by the UE&C Vendor Surveillance Representative.

All structural members in the storage areas that require rework will be reinspected by Project Quality Assurance personnel prior to release for installation.

Date of Full Compliance

Full compliance will be achieved when the current labor situation is resolved. We will advise you of the date of full compliance by written communication.