

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

REGION IV

Report No. 50-445/80-17; 50-446/80-17

Docket No. 50-445; 50-446

Category A2

Licensee: Texas Utilities Generating Company
2001 Bryan Tower
Dallas, Texas 75201

Facility Name: Comanche Peak, Units 1 and 2

Inspection at: Comanche Peak Steam Electric Station, Glen Rose, Texas

Inspection Conducted: July 14-18, 1980

Inspectors: *R. E. Martin*
for L. E. Martin, Reactor Inspector, Projects Section
(Paragraphs 1, 2, 3, & 6)

7/31/80
Date

R. E. Hall
for L. D. Gilbert, Reactor Inspector, Engineering Support
Section (Paragraphs 4 & 5)

7/31/80
Date

Approved: *W. A. Crossman*
for W. A. Crossman, Chief, Projects Section

7/31/80
Date

R. E. Hall
R. E. Hall, Chief, Engineering Support Section

7/31/80
Date

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Inspection Summary:

Inspection on July 14-18, 1980 (Report No. 50-445/80-17; 50-446/80-17)

Areas Inspected: Routine, unannounced inspection of construction activities including site tour; Reactor Coolant Pressure Boundary piping - Unit 2; safety-related piping - Units 1 and 2; and electrical system equipment and components. The inspection involved sixty inspector-hours by two NRC inspectors.

Results: Of the four areas inspected, one item of noncompliance was identified in one area (infraction - failure to follow drawing for weld prep details - paragraph 4).

DETAILS

1. Persons Contacted

Principal Licensee Personnel

- *R. G. Tolson, TUGCO, Site QA Supervisor
- *J. R. Ainsworth, TUGCO, QE Supervisor
- *J. T. Merritt, TUSI, Engineering & Construction Manager
- L. M. Popplewell, TUSI, Project Electrical Engineer
- W. H. Benkert, TUGCO, Quality Engineer

Other Personnel Contacted

- R. Barber, Welding Foreman, Gibbs & Hill (G&H)
- W. Gregory, Pipefitter Foreman, Brown & Root (B&R)
- R. Schultz, Pipefitter Foreman, B&R
- D. Farley, Welding Foreman, B&R
- C. Lawrence, Lead QC Inspector, B&R
- J. Meyer, System Engineer, Westinghouse (W)
- R. Moller, Project Manager, W

The IE inspectors also interviewed other licensee and contractor personnel during the course of the inspection.

*Denotes those attending the exit interview.

2. Site Tour

The IE inspectors walked through Units 1 and 2 Containment Buildings, Auxiliary Building, the Control Complex Areas, the Essential Service Water Building, and various yard laydown areas to observe construction activities in progress. Particular attention was given to housekeeping practices.

No items of noncompliance or deviations were identified.

3. Electrical Systems and Components

a. QA Audit Review

The IE inspector reviewed TUGCO corporate QA audits of Comanche Peak Audit TCP-8 and Gibbs & Hill, New York Audit TGH-13. The audits covered electrical equipment installation and qualifications.

The scope of these audits was adequate and the findings corroborate each other and indicate several areas which require attention and action at the site and Gibbs & Hill in both areas of equipment mounting and equipment qualification.

The responses to these two audits had not been completed as of this inspection and will be reviewed for implementation during subsequent NRC inspections.

b. Record Review

The IE inspector reviewed Material Receiving Records (MRRs CP3642 & CP2129) and Receiving Inspection Reports (RIR 8396 & 6110), including purchase orders for three pieces of electrical equipment (480V Motor Control Center (MCC) CPX-PMCEB-06, 120 VAC Inverter TBX-ESELIV-04, and 480/120 VAC Bypass Transformer CP1-ECTRET-02).

The IE inspector reviewed the QC records for 480 volt MCC CPX-EPMCEB-06 including receiving, installation, and module change out documents. The following documents were reviewed for this MCC:

RIRs 08957, 10416, 13089, 13090, 13091, 13092 and 13087

MRRs 4050 and CPJ27

Inspection Reports E5960, E13841, E13849 and E13699

Design Change Authorization 3068 R1

NCRs E2037 & E2036

Travelers EE80-030-02AJ, EE-104-02AJ, and R79-121-0200

No items of noncompliance or deviation were identified.

4. Reactor Coolant Loop Piping - Unit 2

The IE inspector reviewed the weld data card information for field welds FW 8 and FW 23 on Reactor Coolant Loop Piping Isometric Drawing RC 2-520-001. Both welds were at the root stage. The root weld of FW 23 was complete including an acceptable surface condition suitable for liquid penetrant examination. During installation of field weld FW 8, the root weld cracked; welding engineering evaluated the problem and provided repair instructions on Repair Process Sheet IP-R-1. The repair was in process at the time of the inspection.

For both field welds, the IE inspector verified that the welders were qualified to requirements of ASME, Section IX; the weld material Heat Numbers 434788 and 4282R308L were traceable to certified material test reports; and the QC weld inspectors were certified for performing Level II examinations.

While inspecting the internal root condition of field welds FW 3 and FW 24, the IE inspector measured the counterbore taper on pipe spools 5Q1 and 15Q1 and determined that the weld prep counterbore transition tapers did not conform to Westinghouse Drawing 271C950, Revision 2. The 10° maximum

counterbore taper required by the drawing was actually 30° on spool 5Q1 and 33° on spool 15Q1.

This is an apparent item of noncompliance, in that, 10 CFR Part 50, Appendix B, Criterion V requires that activities affecting quality shall be accomplished in accordance with the prescribed drawings.

5. Safety-Related Piping - Units 1 and 2

The IE inspector observed welding activities in Unit 1 associated with installation welding of two ASME, Section III, Class 1 field welds in the Safety Injection Piping System. The first weld, designated field weld FW 1-1 on Drawing SI-1-RB-060-3, was welded using WPS 88023 with weld rod type ER 308 of Heat No. 463638. The second field weld, designated FW 7 on Drawing SI-1-RB-037-1, was welded using WPS 88025 with weld rod type ER 316 of Heat No. 762550.

The IE inspector also observed welding activities in Unit 2 associated with installation of a Class 3 field weld in the Containment Spray Piping System. The field weld, designated FW 9 on Drawing CT-2-SB-057-0, was welded using WPS 88021 with weld rod type ER 308 of Heat No. 463638.

In the areas of weld identification, filler material traceability, welding process, welder qualification and QC verification; no discrepancies with requirements of the Construction Procedure CP-CPM-6.9 were noted.

No items of noncompliance or deviations were identified.

6. Exit Interview

The IE inspectors met with licensee representatives (denoted in paragraph 1) at the conclusion of the inspection on July 18, 1980. The IE inspectors summarized the purpose, scope and findings of the inspection. The licensee representatives acknowledged the statements by the inspectors with regard to the item of noncompliance.