

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

Report No. 99900313/80-01

Program No. 51300

Company: Murdock Incorporated
51300 South Avalon Blvd.
Compton, California 90220

Inspection Conducted: July 28-31, 1980

Inspectors: V. H. Hunter
V. H. Hunter, Contractor Inspector
Components Section I
Vendor Inspection Branch

8-27-80
Date

Approved by: D. E. Whitesell Jr.
D. E. Whitesell, Chief
Components Section I
Vendor Inspection Branch

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Summary

Inspection on July 28-31, 1980 (99900313/80-01)

Areas Inspected: Implementation of 10 CFR 50, Appendix B Criteria and applicable codes and standards, including nonconformance and corrective action, Authorized Nuclear Inspector interface. Weld specifications, weld material control, and procurement. The inspection involved Twenty-Eight (28) inspection hours on site.

Results: In the five (5) areas inspected, there were no apparent deviations or unresolved items identified.

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DETAILS SECTIONA. Principal Persons Contacted

- H. G. Murdock, President
- *W. J. Parker, Vice President
- *S. M. Wallenman, Quality Assurance Manager
- B. C. Hill, Purchasing Manager
- W. T. Ulco, QC Supervisor
- G. Hill, Authorized Nuclear Inspector

*Denotes those present at the exit interview meeting.

B. Nonconformance and Corrective Action1. Objectives

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

- a. Procedures had been developed and approved by the vendor that prescribes a system for control of nonconformances and assuring effective corrective action in a manner consistent with NRC rules and regulation, ASME Code requirements, and the vendor's commitments in the ASME accepted Quality Assurance Program.
- b. The nonconformance and corrective action procedures are properly and effectively implemented by the vendor.

2. Method of Accomplishment

The objectives of this area of the inspection were accomplished by:

- a. Review of the ASME accepted Quality Assurance Manual, Section 13.0 titled "Nonconformities" to verify that the vendor had established procedures that prescribed a system for identifying and reporting nonconformances and requires corrective action.
- b. Review of the following procedures titled:
 - (1) "Review and classification of nonconformities"
 - (2) "Material Review Board"
 - (3) "Corrective Action Program"

to verify the system of nonconformance provides identification of inspection points, personnel responsible for identification,

inspection method, acceptance criteria, personnel responsible for nonconformance and for resolution, segregation of item, and distribution of report.

c. Review of the following procedures titled:

- (1) "Discrepant Material Dispositions"
- (2) "Disposition"

to verify the system of corrective action procedures have been approved and are consistent with the ASME accepted Quality Assurance Program and identifies the responsibility for receipt and analysis of nonconformance reports, recommending corrective action, approving corrective action, & follow-up to assure corrective action is effective and precludes recurrence. Also, verify the corrective action procedures provide for management participation in nonconformance report and corrective action review.

- d. Review of fourteen (14) nonconformance reports to verify that the nonconformance and corrective action procedures were properly implemented in that the assigned responsibilities were carried out, the identification and reporting of nonconformances and the evaluation and enacting of the corrective action was timely and effective, nonconforming items were properly disposed of, corrective action followup was effectively performed, management participation was active and effective.
- e. Interviews with personnel to verify they were aware of and had access to the nonconformance and corrective action procedures.

3. Findings

a. The inspector verified that:

- (1) Procedures had been developed and approved by the vendor that prescribed a system for control of nonconformances and assured effective corrective action in a manner consistent with NRC rules and regulations, ASME Code requirements, and the vendor's commitments in the ASME accepted Quality Assurance Program.
- (2) The nonconformance and corrective action procedures were properly and effectively implemented by the vendor.
- (3) There was no apparent deviations from commitments or unresolved items.

C. ANI (Authorized Nuclear Inspector) Interface

1. Objectives

The objectives of this inspection were to verify that:

- a. The ANI has direct contact with the cognizant plant QA/QC representative.
- b. The ANI has free access to all parts of the plant concerned with supply or manufacture of ASME Code work.
- c. All applicable documents are available to the ANI for review,
- d. The ANI identifies and signs off on witness hold points or process control documents and witnesses the qualification of special NDE procedures.
- e. The ANI maintains a log of activities reviewed and/or witnessed.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of Section 12.0 of the ASME accepted QA Manual.
- b. Discussion with the ANI.
- c. Review of the ANI log book of inspection activities.

3. Findings

- a. The ANI is a Kemper Insurance itinerant inspector who is assigned to this shop on an as needed basis.
- b. All necessary documents are made available to the ANI. The ANI has access to all plant facilities related to his work.
- c. Review of the ANI inspection log established it was consistently maintained.
- d. Within this area of the inspection, no deviations from commitment or unresolved items were identified.

D. Control of Special Processes
Welding Procedure Specification

1. Objective

The objective of this area of the inspection was to determine if the welding procedure specifications used by the vendor in production

welding had been prepared, qualified and controlled in accordance with the applicable NRC regulation, the ASME accepted Quality Assurance Program, and ASME Code requirements.

2. Method of Accomplishment

The objective of this area of the inspection was accomplished by:

- a. Review of the ASME accepted Quality Assurance Manual, Revision; Section 7.0, to verify whether the vendor had established procedures for the preparation, qualification, certification, distribution, and revision of welding procedure specifications.
- b. Review of Welding procedure 3007-CS-4, and 3007-CS-11, to verify that all essential variables, supplementary essential variables and nonessential variables are in accordance with the applicable Sections of the ASME Code.
- c. Review of Certification 1874 and 1739 to verify that:
 - (1) The procedures had been qualified in accordance with Section IX of the ASME Code and the supporting procedure qualification records were on file.
 - (2) The procedures qualification records had been certified by the vendor and the mechanical test results meet or exceed the minimum ASME Code requirements.
 - (3) The procedure qualification record lists the essential variables for the specific welding processes and the values and ranges of the variables are consistent within the limits of Section IX of the ASME Code.
- d. Review of the Welding Procedure Specifications and Procedure Qualification Records listed in paragraphs b. and c. above to verify that:
 - (1) All mechanical tests, required by Sections III and IX of the ASME Code, had been completed and are properly documented in the procedure qualification records.
 - (2) Changes and/or revisions of essential variables in any welding procedure specification, is supported by requalification documents.
 - (3) Changes in the nonessential variables of the welding procedure specification are properly identified and documented.

- f. Observation in the shop to verify that the welding procedure specifications are available to the welders and the specifications are properly followed.
- g. Interviews with personnel to verify they are knowledgeable in the procedures applicable to welding.

3. Findings

- a. The inspector verified that the welding procedure specifications used by the vendor in production welding had been prepared, qualified and controlled in accordance with the applicable NRC regulations the ASME accepted Quality Assurance Program, and the ASME Code.
- b. Within this area of the inspection no deviations or unresolved items were identified.

E. Manufacturing Process Control Welding Material Control

1. Objective

The objective of this area of the inspection was to verify that welding material is identified and controlled until it is consumed in the welding process in accordance with the applicable NRC rules and Regulations and the ASME accepted Quality Assurance Program.

2. Method of Accomplishment

The objective of this area of the inspection was accomplished by:

- a. Review of the ASME accepted Quality Assurance Manual Sections:
 - (1) 7.8 - "Storage"
 - (2) 7.12 - "Reserve Welding Material Control"
 - (3) 7.13 - "Qualification of Welding Material"

to verify that procedures had been established for purchasing, receiving, distribution and handling of welding materials.

- b. Review of welding records and parts being welded, to verify that distribution of the welding material is being controlled in accordance with approved procedures, and that unused welding materials are scrapped, or recycled, in accordance with the procedures.

- c. Observation in the shop welding area and storage area, to verify that:
 - (1) Welding materials are clearly identified at all times in accordance with the approved procedures, and that the identification of acceptable materials was being maintained through-out the storage and manufacturing operations, until the material is consumed in the welding process.
 - (2) Welding material requiring environmental control is held at the appropriate storage, and/or baking temperatures, for the time specified in the procedure.
- d. Interviews with personnel to verify they are knowledgeable of the vendors procedures applicable to Welding Material Control.

3. Findings

- a. The inspector verified that welding material is identified and controlled until it is consumed in the welding process in accordance with NRC regulations, the ASME accepted Quality Assurance Program.
- b. Within this area of the inspection no deviations or unresolved items were identified.

F. Procurement Document Control

1. Objectives

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

- a. Procedures had been prepared and approved by the vendor that prescribes a system for procurement document control which is consistent with NRC rules and regulations, ASME Code, and the vendor's commitments in the ASME accepted Quality Assurance Program.
- b. The procurement document control procedures are properly and effectively implemented by the vendor.

2. Method of Accomplishment

The objective of this area of the inspection was accomplished by:

- a. Review of the ASME accepted Quality Assurance Manual, Section

3.0 titled "Procurement Document Control to verify that the vendor had established procedures that prescribed a system for procurement document control.

b. Review of the following procedures:

- (1) 3.3 - "Purchase Orders"
- (2) 3.6 - "Approved Vendor List"
- (3) 3.11 - "Subcontracted Services"

to verify they have been prepared by the designated authority, approved by responsible management and reviewed by QA.

c. Reviewed these selective purchase orders; 2265M, 25407M, 27712M, 19082M, 19467M, 20656M, 23687M, and 30253M to verify that the scope of work to be performed is identified, the technical requirements are specified, test and inspection criteria is identified, special instructions and requirements identified, suppliers are required to have a documented QA program, and procurement documents are reviewed prior to release for bid and/or contract award.

d. Review of the following selective documents:

- (1) Procurement documents
- (2) Purchase requisitions
- (3) Purchase orders
- (4) Technical documents

to verify the procurement procedures are being properly and effectively implemented in accordance with the procedures, and that distribution for procurement documents had been established and was current.

e. Interviews with personnel to verify they were knowledgeable in the procedures applicable procurement document control.

3. Findings

a. The inspector verified that:

- (1) Procedures had been prepared and approved by the vendor that prescribed a system for procurement document control which is consistent with NRC rules and regulations, ASME

Code, and the vendor's commitments in the ASME accepted Quality Assurance Program.

- (2) The procurement document control procedures were properly and effectively implemented by the vendor.
- (3) There was no apparent deviations from commitments or unresolved items.

G. Exit Interview

The inspector met with management representatives at the conclusion of the inspection on July 31, 1980. The inspector summarized the scope and findings identified during the inspection. Management acknowledged the inspector's comments regarding the scope and findings as presented.