

Armco Incorporated
Advanced Material Division
Docket No. 99900268/80-02

NOTICE OF DEVIATION

Based on the results of an NRC inspection conducted on September 9-12, 1980, it appears that one of your activities was not conducted in accordance with NRC requirements.

Criterion V of Appendix B to 10 CFR 50 states:

"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. Instructions, procedures, or drawings shall include appropriate quantitative or qualitative acceptance criteria for determining that important activities have been satisfactorily accomplished."

Operating Procedure No. 10 and Welding Procedure Specification No. 5, Revision 3, require that for pipe fabricated from plate with a wall thickness of one half inch or greater, that the ID seam weld edge bevel must be 5/16 inch in depth.

Contrary to the above, two (2) formed and tack welded, SA-358-1, ASME Section III, Class I, pipes, No. SN9-8351-6P and No. SN9-8351-7P, having a wall thickness of 1.018 inch, were determined by measurement to have ID weld edge seam bevels one fourth inch and less in depth.