

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

Report No. 99900255/80-01

Program 51300

Company: Pacific Scientific
Kin-Tech Division
1346 S. State College Boulevard
Anaheim, California 92803

Inspection
Conducted: February 4-8, 1980

Inspector: H. W. Roberds
H. W. Roberds, Constructor Inspector
Components Section II
Vendor Inspection Branch

3/4/80
Date

Approved by: D. M. Hunnicutt
D. M. Hunnicutt, Chief
Components Section II
Vendor Inspection Branch

3/4/80
Date

Summary

Inspection on February 4-8, 1980 (99900255/80-01)

Areas Inspected: Implementation of 10 CFR 50, Appendix B, Criteria and applicable codes and standards, including Manufacturing Process Control, Nondestructive Examination (Magnetic Particle), Nondestructive Examination (Liquid Penetrant) and Special Processes Personnel Qualification (Non-destructive Examination). The inspection involved twenty-eight (28) inspector hours on site.

Results: In the four (4) areas inspected, no apparent deviations or unresolved items were identified in three (3) areas; the following were identified in the remaining one (1) area:

Deviations: Manufacturing Process Control - Heat treatment chart trace was not identified with an individual piece, the location of the thermocouple was not given on the piece, or the location of the piece in the furnace (Notice of Deviation, Item A); The ANI did not review and approve a change to the Master Manufacturing Outline as required (Notice of Deviation, Item B); A QA holdpoint had been bypassed on the manufacturing outline (Notice of Deviation, Item C).

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DETAILS SECTIONA. Persons Contacted

- *P. A. Hadnagy, Manager Quality Assurance
- *B. Jenkins, Quality Engineer
- G. DeGrove, NDE Level III
- W. Eakin, Chief Inspector
- J. Trentin, Lead Inspector
- T. Roche, NDE Level II
- C. Wharton, NDE Level II

*Denotes persons attending exit meeting.

B. Manufacturing Process Control1. Objectives

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

- a. Manufacturing is performed under a controlled system.
- b. Certain processes are accomplished by qualified personnel using approved procedures.
- c. Results of specific operation are reported.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the Quality Assurance Manual, Section 10.0 "Control of Material During Fabrication."
- b. Review of the Quality Assurance Manual, Section 5.0 "Preparation and Approval of Manufacturing Outlines."
- c. Review of Bechtel Power Corporation Specification S023-409-2, SEC No. 4129 dated September 1, 1974.
- d. Review of Standard Practice Procedure SP-344-PSCO Revision 0, "Postweld Heat Treatment."
- e. Review of six (6) Manufacturing Outlines for the following:
 - (1) Review and approvals by designated personnel.

- (2) Signoff of certain operations by qualified personnel.

3. Findings

- a. Deviations from Commitments

- See Notice of Deviation, Item A.

- See Notice of Deviation, Item B.

- See Notice of Deviation, Item C.

- b. Unresolved Items

- None.

- C. Nondestructive Examination (Magnetic Particle)

1. Objectives

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

- a. Nondestructive examination is performed in accordance with approved procedures.
 - b. Nondestructive examination procedures met the requirements of Section V of the ASME Code and applicable NRC requirements.
 - c. Test results are interpreted by qualified personnel.

2. Method of Accomplishment

- The preceding objectives were accomplished by:

- a. Review of the Quality Assurance Manual, Section 9, "Control of Purchased Parts and Special Processes."
 - b. Review of the Quality Assurance Manual, Section 16, "Examination and Testing."
 - c. Review of procedure No. PSCO 10.22, "Magnetic Particle Examination of Parts and Materials for Nuclear Power Plant Products."
 - d. Review of daily log of test results for magnetic particle bath concentration.

3. Findings

Within this area of the inspection, no deviations from commitments or unresolved items were identified.

D. Nondestructive Examination (Liquid Penetrant)

1. Objectives

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

- a. Nondestructive examination is performed in accordance with approved procedures.
- b. Nondestructive examination procedures meet the requirements of the ASME Code and applicable NRC requirements.
- c. Test results are interpreted by qualified personnel.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the Quality Assurance Manual, Section 16, "Examination and Testing."
- b. Review of Procedure No. PSCO 10.21 "Penetrant Examination Parts and Materials for Nuclear Power Plant Products."
- c. Observations of penetrant dip tanks and review of chemical analysis for water content.

3. Findings

Within this area of the inspection, no deviations from commitments or unresolved items were identified.

E. Special Processes Personnel Qualification (Nondestructive Examination)

1. Objectives

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

- a. The employer, Pacific Scientific, has developed a written practice for control and administration of NDE personnel training, examination, and certification in accordance with applicable NRC and ASME Code requirements.

- b. Personnel records are complete and are current.
- c. Personnel performing nondestructive examinations are qualified for the method used and have current eye examinations as defined in SNT-TC-1A.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the Quality Assurance Manual, Section 16, "Examination and Testing."
- b. Review of five (5) personnel qualification and certification record packages including results of eye examinations.
- c. Interviews with cognizant personnel.

3. Findings

Within this area of the inspection, no deviations from commitments or unresolved items were identified.

F. Exit Meeting

A post inspection exit meeting was held on February 7, 1980, with the management representatives denoted in paragraph A above. The inspector summarized the scope and findings of the inspection. Management acknowledged the statements of the inspector with respect to the findings as presented to them and affirmed their commitment to the quality assurance program.