



UNITED STATES
 NUCLEAR REGULATORY COMMISSION
 REGION II
 101 MARIETTA ST., N.W., SUITE 3100
 ATLANTA, GEORGIA 30303

Report No. 50-364/80-33

Licensee: Alabama Power Company
 600 North 18th Street
 Birmingham, AL 35202

Facility Name: Farley

Docket No. 50-364

License No. CPPR-86

Inspection at Farley, site near Dothan, Alabama

Inspector: *A. R. Herdt*
 by B. R. Crowley

9/16/80
 Date Signed

Approved by: *A. R. Herdt*
 A. R. Herdt, Section Chief, RCES Branch

9/16/80
 Date Signed

SUMMARY

Inspection on August 25-27, 1980

Areas Inspected

This routine, announced inspection involved 20 inspector-hours onsite in the areas of licensee action on previous inspection findings; IE Bulletin 79-13; steam generator modification.

Results

Of the three areas inspected, no items of noncompliance or deviations were identified in two areas; one item of noncompliance was found in one area (Deficiency - Failure to follow RT procedure, Paragraph 5.a).

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DETAILS

1. Persons Contacted

Licensee Employees

- *W. G. Hairston, Plant Manager
- *R. G. Berryhill, Performance & Planning Superintendent
- D. L. Vines, Level III Examiner
- G. S. Waymire, Junior Engineer
- *J. W. McGowan, Manager, Operations QA
- *H. M. McClellan, General Plant Engineer
- *J. W. Kale, Jr., QA Engineer

Other Organizations

- E. R. Burns, PSI&ISI Coordinator, (Southern Company Services)
- *J. J. Churchwell, Assistant Engineer (Southern Company Services)
- R. H. Baulig, Site Manager (Westinghouse)
- S. W. Rausch, Mechanical Engineer (Westinghouse)
- *R. L. Rowley, Systems Performance Group (Bechtel Corporation)

NRC Resident Inspectors

- *W. H. Bradford
- J. P. Mulkey

*Attended exit interview

2. Exit Interview

On August 27, 1980, the inspector met with the licensee representatives noted in paragraph 1 above and summarized the scope and findings of the inspection of actions on previous inspection findings, IE bulletin 79-13 and steam generator modification to add handhole/inspection port. The noncompliance of paragraph 5.a. was discussed. The licensee stated that the Level III examiner who read the film had not yet been contacted and the conditions relative to the problem would be investigated in detail. Any relevant information and the scope of the problem would be transmitted to RII. The inspector pointed out to the licensee that since the PSI report was not yet available for review, the licensee should officially notify the NRC-RII of acceptable completion of the PSI prior to fuel loading. The licensee agreed to furnish either a letter confirming acceptable completion of the PSI or the completed PSI report. This is identified as inspector followup item 364/80-33-02, Report confirming acceptable completion of PSI.

3. Licensee Action on Previous Inspection Findings

- a. (Open) Unresolved Item No. 364/80-20-01, Reflector Designs in UT Calibration Blocks. This item pertains to the use of calibration blocks with side drilled holes for UT of pipe welds as required by the

1974 edition, S75 addenda of ASME Section XI versus the use of blocks with notches as required by the 1977 Edition, S78 addenda of Section XI. By paragraph 50.55a(g)(3)(v) of the Code of Federal Regulations, the later code requirements (UT technique from 1977 Edition, S78 addenda) can be used. Therefore, the licensee is revising the PSI program and the FSAR to clarify pipe weld UT inspection requirements to indicate the use of later code requirements.

- b. (Closed) Unresolved Item No. 364/80-20-02, Inspection of set points on pipe supports. The licensee has verified that the construction QC program, the inspection program developed to satisfy IEB 79-14 and the preoperational snubber and spring hanger verification test program more than satisfy the requirements of ASME Section XI requirements for PSI. This information is being included in the PSI report. This item is considered resolved.

4. Unresolved Items

Unresolved Items were not identified during this inspection.

5. IE Bulletins (IEB)

(Open) IEB 79-BU-13, Cracking in Feedwater System Piping. The inspector performed a followup inspection of radiography which was performed to meet the requirements of the bulletin. The radiography was performed in accordance with General Maintenance Procedure FNP-O-GMP-51, "Non-destructive Examination Procedure". Evaluation was in accordance with paragraph NC-5000 of the 1977 edition of the ASME Boiler and Pressure Vessel Code to the 2T quality level. The inspector reviewed film for the following welds:

Loop A:	Weld A-1 (Nozzle to Reducer) Weld A-2 (Reducer to Pipe/Fitting)
Loop B:	Weld B-1 (Nozzle to Reducer) Weld B-2 (Reducer to Pipe/Fitting)
Loop C:	Weld C-1 (Nozzle to Reducer) Weld C-2 (Reducer to Pipe/Fitting)

It should be noted that only the nozzle to reducer welds were required to be radiographed after hot functional testing. The other welds out to the first support are to be inspected at the first refueling outage.

In addition to the review of the film, the inspector reviewed the NDE certifications and eye examination records for the examiner who reviewed the film. During review of the film the inspector noted the following problems:

- a. The density in portions of the area of interest of welds C-1, C-2, and B-2 was more than 30 percent darker than the density through the penetrometer. This violates paragraph 6.9.4.1 of Farley procedure

FNP-O-GMP-51. Also, the density in part of the area of interest for weld A-2 was greater than 4.0. However, as noted above welds A-2, B-2, and C-2 were not required to be radiographed at this time. Therefore, only weld radiograph C-1 is considered to be in noncompliance. This failure to follow procedure for RT of weld C-1 is considered to be noncompliance with Criterion V of Appendix B to 10 CFR 50 as implemented by paragraph 17.2.5 of the FSAR and is identified as item number 364/80-33-01, Failure to Follow RT Procedure. Based on the fact that the density did not meet procedure requirements in only one view in one small area and the area could be examined for the purpose of the bulletin, this item has minimal safety significance and therefore is a deficiency. The one view was re-radiographed during the inspection and acceptable film were obtained.

- b. The inspector noted a questionable area in view 30-40 of weld A-1. The area in question was visually examined and re-radiographed using a more sensitive technique. The questionable indication was not present in the more sensitive film. The conclusion was that the area was probably a film artifact.

Within the areas inspected, no items of noncompliance or deviation except as noted in paragraph a. above were identified.

6. Steam Generator Modifications - Addition of Handhole/Inspection Ports

The inspector reviewed records as described below for the modification to the secondary side of the steam generators which added handhole/inspection ports. This work was accomplished under the authority of the inservice inspection (ISI) code, ASME B&PV Code, Section XI, 1974 Edition including Addenda through S75 to the requirements of ASME B&PV Code, Section III, 1971 Edition. The inspector reviewed the following documents and records:

- a. Westinghouse Drawing 1513E34 - Details of Weld Buildup for Handhole
- b. Cooperheat Procedure CH0097 - Control of Preheat and PWHT
- c. Welding Procedure NPT-13
- d. Procedure SP 2.7.2 APR - Sequence of Operations
- e. For Steam Generator "C" -
 - . "Nuclear Power -Quality Control Welder Log & Patrol Inspection"
 - . "Certificate of Test for MT Inspection"
 - . "Weld Ultrasonic Examination for UT Inspections"
 - . Records of Preheat and Interpass Temperature Documentation

The above records were not reviewed in detail, but only for general sequence of welding, heat treatment and nondestructive testing operations.

Within the areas inspected, no items of noncompliance or deviations were identified.