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

REGION IV

Report No. STN 50-482/80-20

Docket No. STN 50-482 Category A2

Licensee: Kansas Gas and Electric Company
P. O. Box 208
Wichita, Kansas 67201

Facility Name: Wolf Creek, Unit No. 1

Inspection at: Wolf Creek Site, Coffey County, Burlington, Kansas

Inspection conducted: October 7-10, 1980

Inspector: _____ 10/22/80
for L. D. Gilbert, Reactor Inspector, Engineering Support Section Date

Approved: _____ 10/22/80
W. A. Crossman, Chief, Projects Section Date

_____ 10/22/80
R. E. Hall, Chief, Engineering Support Section Date

Inspection Summary:

Inspection on October 7-10, 1980 (Report No. STN 50-482/80-20)
Areas Inspected: Routine, unannounced inspection of construction activities including site tour and observation of work and review of records for welding of Reactor Coolant Pressure Boundary piping. The inspection involved seventeen inspector-hours by one NRC inspector.
Results: No items of noncompliance or deviations were identified.

DETAILS

1. Persons Contacted

Principal Licensee Personnel

*D. W. Prigel, Assistant QA Manager
*G. W. Reeves, QA Engineer
*C. A. Snyder, Construction
*J. Stokes, Construction

Daniel International (Daniel) Personnel

*C. Phillips, Engineering Manager
*R. Schofield, Welding Engineer
*W. E. Hitt, Project Manager
*R. Scott, Construction Manager
*C. R. Patterson, QA Engineer
*N. Criss, Audit Response Coordinator
*M. D. Pfeifer, QC Engineer
D. Dennison, Assistant QC Manager
C. Chavis, QC Senior Receiving Inspector

*Denotes those present at the exit interview.

The IE Inspector also interviewed other contractor personnel during the course of the inspection.

2. Site Tour

The IE inspector walked through the Reactor Building to observe construction activities in progress and housekeeping practices.

No items of noncompliance or deviations were identified.

3. Reactor Coolant Pressure Boundary Piping

a. Review of Procedures

The IE inspector reviewed the Daniel Procedure for welding stainless steel, Procedure CWP 507, Revision 10, which included the Welding Technique Sheet(WTS) being used for machine welding the Reactor Coolant Loop piping, WTS NM-8-8-B-1, Revision 4 and its supporting procedure qualification tests, PQT-111 and PQT-180.

In the areas reviewed, no discrepancies with the requirements of the ASME Code Section III-NB or Section IX 1974 edition including Summer 1975 addenda were noted.

During the inspection, it was noted that CWP 507 and WTS NM-8-8-B-1 were being used for welding base material specification SA 351 Grade CF8A (P No. 8) to base material consisting of Type 308L filler metal (A No. 8) buttered onto base material specification SA 216 Grade WCC (P No. 1), when neither material is listed in Table I of CWP 507 for determining the type of filler metal to be used for welding the combination, e.g., field weld F 304 on Drawing I-Loop 3(Q). Since the ASME Code is not clear concerning the qualification of procedures for welding P No. 8 material to A No. 8 material, this item shall be considered unresolved pending a revision of the procedure as supported by a code clarification.

b. Observation of Welding Activities

The IE inspector observed activities associated with fit up, welding and inspection of six field welds in the Reactor Coolant Loop piping. The field welds and the activities observed were as follows:

Field Welds	Drawing	Activity
F 205	I-Loop 2 (Q)	Fit Up
F 405	I-Loop 4 (Q)	Fit Up
F 304	I-Loop 3 (Q)	Welding
F 404	I-Loop 4 (Q)	Welding
F 201	I-Loop 2 (Q)	Repair Welding
F 402	I-Loop 4 (Q)	ISI Weld Prep

During the inspection, field welds F 304 and F 404 were in the process of being machine welded using the gas tungsten-arc process in accordance with WTS NM-8-8-B-1. The filler metal observed being used for welding was type ER 308 identified as Heat No. 464176 for field weld F 304 and Heat No. 464802 for field weld F 404.

The repair welding of field weld F 201 was observed being accomplished using filler metal type ER 308 (Heats No. C3547R308 and D3547R308) and the gas tungsten-arc process in accordance with WTS N-8-8-B-8.

In the areas inspected, no discrepancies were noted concerning traveler documentation, welder qualification, procedure compliance and material control and certification.

No items of noncompliance or deviations were identified.

4. Unresolved Items

Unresolved items are matters about which more information is required in order to ascertain whether they are acceptable items, items of non-compliance, or deviations. One unresolved item related to procedure qualification is discussed in paragraph 3a.

5. Exit Interview

The IE inspector met with licensee representatives (denoted in paragraph 1) on October 10, 1980, and summarized the purpose, scope and findings of the inspection.