

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

Report No. 99900302/80-02

Program 51300

Company: Western Piping and Engineering Company, Inc.
1485 Yosemite Avenue
San Francisco, California 94124

Inspection
Conducted: July 14-18, 1980

Inspector: J. W. Sutton
J. W. Sutton, Vendor Inspector
Components I Section
Vendor Inspection Branch

8-7-80
Date

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

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Summary

Inspection on July 14-18, 1980.

Areas Inspected: Implementation of 10 CFR 50, Appendix B Criteria and Applicable Codes and Standards, including action on previous inspection findings, Quality Assurance manual review (organization-program), control of Special Processes, Welding, and Training. The inspection involved twenty eight (28) inspector hours on site by one (1) NRC inspector.

Results: In the four (4) areas inspected no apparent deviations or unresolved items were identified in three (3) areas. The following was identified in the remaining area.

Deviation: Special Processes, Welding: Required WPS not at welding station and, welder not following welding procedure requirements.

Unresolved Items:

None.

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DETAILS SECTIONA. Western Piping and Engineering Company, Inc. (WP&E)

- *J. C. Flaherty, Vice President
- *K. Friedman, President
- *R. M. Haytack, QA Manager
- J. Korteum, QA/QC Trainee
- *M. Wright, Project Manager

Department of Industrial Safety, State of California

- *R. M. Johnson, Safety Engineer, Authorized Nuclear Inspector (ANI)

B. Action on Previous Inspection Findings

1. (Closed) Deviation A (Inspection Report 80-01)

Failure to take committed corrective action (audits). The inspector verified that the audits committed to in WP&E letter of March 11, 1980 have been performed. A system to control and schedule audits has been developed and is being implemented.

2. (Closed) Deviation B. (Inspection Report 80-01)

Quality Assurance manager not reviewing all nuclear Purchase Orders., Vendors not on approved Vendor's List. The inspector verified by review of current nuclear Purchase Orders (PO) that the PO's are being reviewed by the QA manager. Records of training of Projects and Procurement personnel were reviewed.

Vendors supplying services for nuclear contracts have been surveyed and are now listed on the approved vendors list.

3. (Closed) Deviation C. (Inspection Report 80-01)

Non-conformance Reports (NCR) not being prepared as required by QA manual, (NCR's) not retrievable within Specified Time.

The inspector reviewed and verified that the WP&E procedure P-1501-002-0 has been developed and is being implemented. Training sessions have been held as indicated in WP&E's letter of inspection confirmation dated March 11, 1980. The inspector verified that NCR's can be retrieved in a timely manner, and reviewed internal audits of the NRC control system, to verify that procedure P-1501-002-0 is being implemented properly.

C. QA Program Review (Organization - Program)

1. Objectives

The objectives of this area of the inspection, were to ascertain whether the QA Program has been documented in writing, and that it is being correctly implemented in a manner that will ensure that components manufactured are in compliance with code requirements, and meet the prescribed quality standards. Also, to ascertain whether the program is consistent with NRC regulations, contract, and code requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of WP&E QA manual - dated March 10, 1980, Sections 1 & 2.
- b. Review of appropriate organization charts to verify that the QA staff is independent from the pressures of cost and scheduling and has access to upper management.
- c. Review of the documents concerning the authority, duties, and responsibilities of the Quality Assurance staff, to verify that they have the independence to identify quality problems, initiate appropriate corrective action, and have the authority to stop work.

3. Findings

a. Deviations

None.

b. Unresolved Item

None.

c. General

The inspector was informed and shown a completely revised QA manual which has been presented to the AIA for approval. The Proposed Revised Manual has major changes. The revised QA manual will be reviewed after approval by the AIA, on a subsequent inspection.

D. Control of Special Processes, Welding Procedure Specifications Use and Control

1. Objectives

The objectives of this area of the inspection were to verify that welding procedure specifications used for production welding are controlled and use in accordance with the WP&E QA Program and NRC contract and Code requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of WP&E QA manual, Section 9.4 "Control of Welding Processes."
- b. Review of WP&E Procedures
 - (1) D-0904-002-0, welder and welding operator qualification record.
 - (2) P-0904-001-0, weld material Job Checklist.
 - (3) P-0901-001-0, identification, storage, and control of weld material.
- c. Review of ten (10) welding procedures and specifications, and qualification records (PQR).
- d. Review of current qualified welders list, specifically the review of welder's W2 and W4 qualifications.
- e. Review of weld material storage facilities.
- f. Review of Weld Material certification for Hts No. 21073, 4354L, 05845-76179J, 05845.
- g. Review of Shop Travelers Nos. 211056 and 100067.
- h. Review of Heat Treating requirements, QA manual, Section 9.5.
- i. Observation of welding activities in the shop area.
- j. Review of welding equipment calibration requirements.
- k. Discussions with shop personnel.

3. Findings

a. Deviations

See Enclosure.

b. Unresolved Item

None.

c. General

Time did not permit all welding activities to be completely reviewed. Further review of this activity will be performed during a subsequent inspection.

E. Training and Indoctrination

1. Objectives

The objectives of this area of the inspection were to verify that a formal documented program had been established for the indoctrination and training of personnel performing activities affecting quality, and that a training organization functions, NRC Regulations, contract and code requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the WP&E QA manual, Section 2.5, covering training.
- b. Review of WP&E Procedure D-0200-001-0 dated 5-5-80, "Training."
- c. Review of Training Records and Schedules for Management and Shop Personnel.
- d. Review of QA/QC Personnel Training records.
- e. Interview with personnel.

3. Findings

a. Deviations

None.

b. Unresolved Items

None.

c. General

The vendor is in the process of expanding the scope of its training program. This area of the QA program will be reviewed during future inspections.

F. Review of Vendors Activities

1. Objectives

The objectives of this area of the inspection were:

- a. To update the Vendors Activities to assess the impact on future IE inspections.
- b. Review of the current and projected workload.

2. Method of Accomplishment

The foregoing objectives were accomplished by discussions with the vendors management personnel and a review of future nuclear orders and nuclear orders being process.

The vendor is currently processing eight (8) Commercial Nuclear Contracts for Penetration Support Guides, Filters, and Strainers. This represents approximately Forty-Five (45%) percent of the total Commercial Nuclear work load for Domestic use.

G. Exit Interview

The inspector met with management representatives (denoted in paragraph A) at the conclusion of the inspection. The inspector summarized the scope and findings of the inspection. The management representatives had no comment in response to the items discussed by the inspector.