Westinghouse Electric Corporation
Nuclear Components Division, Tampa Plant
Docket No. 99900047/80-02

NOTICE OF DEVIATION

Based on the results of an NRC inspection conducted on September 8-12, 1980, it appeared that certain of your activities were not conducted in full compliance with NRC requirements as indicated below:

A. Westinghouse Tampa Plant (WTP) letter of corrective action dated May 13, 1980, relative to segregation and identification of welding materials while located in holding ovens states in part, "It is the intent of Material Services to maintain segregation of electrodes in the ovens in accordance with the map on the oven doors. We believe that this was an isolated instance of noncompliance. However, the need for segregation and compliance with procedure was reviewed with all Storeroom personnel on April 16, 1980 . . . ."

Contrary to the above, the segregation of electrodes in ovens in accordance with maps on oven doors has not been adhered to, nor does it appear to be an isolated instance of noncompliance, as indicated above, in that this type deviation has been identified during three consecutive NRC inspections. (See Details Section I, paragraph B.6.).

B. WTP letter of corrective action dated May 13, 1980, relative to thermal gradients states in part, "MRR 034572 was reviewed and dispositioned by Design Engineering and verified that thermal stresses were analytically acceptable and that the intent of PS 83032 GY had not been violated.

Contrary to the above, while MRR 034572 was reviewed and dispositioned, it did not provide verification of the analytical acceptability of thermal gradients in a longitudinal direction, addressing circumferential thermal gradients only. (See Details Section I, paragraph B.2).

C. Criterion V of Appendix B to 10 CFR 50 states, "Activities affecting quality shall be prescribed by documented instructions, procedures, or drawings, or 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."

1. Deviations from these requirements are as follows:

ASME Code Section III, Subarticle NB-2420 states in part, "The required tests shall be conducted . . . for each combination of heat of bare electrodes and lot of submerged arc flux . . . ."

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NB-2432.1 states in part, "A-No. 8 welding material to be used with other than the GTAW and PAW processes . . . shall have chemical analysis performed on a weld deposit of the material or combination of materials being certified . . . ."

Contrary to the above, the required chemical analysis of certain combinations of heats of A-No. 8 wire and lot numbers of flux had not been performed for materials used to perform submerged arc buttering of steam generator channel head nozzles (See Details I, paragraph B.6).

2. Section 5.0 of the Quality Assurance Program Manual, paragraph 5.3.1 states in part, "Manufacturing, inspection and test activities are performed in accordance with approved work instructions, feeder travelers and drawings . . . ."

Contrary to the above, manufacturing on Shop Order No. XART 3094, Item AAD, Mid-Deck Plate, was not performed in accordance with approved work instructions, as evidenced by:

a. A total of 202 2½ inch diameter flow holes was required by the applicable drawing (1513E87 Sub. 2) referenced by the feeder traveler.

b. The mid-deck plate was actually manufactured with 208 2½ inch diameter flow holes. (See Details Section II, paragraph E.3. a.(2)).

3. Drawing Control Procedure PQ2-001.1, paragraph 5.4 states in part "Reproduction center, upon receipt of an Engineering drawing accompanied by the official release document will: . . . Send one (1) copy of each release document to both Product Planning and to Product Assurance.

Contrary to the above, a copy of the release document for Drawing No. 1513E87 sub. 3, which had been received by the Reproduction Center on August 29, 1980, had not been sent to Product Assurance as of this inspection.