

## Appendix A

NOTICE OF VIOLATION

Based on the results of the NRC inspection conducted on October 8, 1980, it appears that certain of your activities were not conducted in full compliance with the conditions of your NRC Construction Permit No. CPPR-126 as indicated below:

Failure to Follow Procedure in Making Full Penetration Welds

10 CFR 50, Appendix B, Criterion V states in part, "Activities affecting quality shall be prescribed by documented instructions, procedures, or drawings, of a type appropriate to the circumstances and shall be accomplished in accordance with these instructions, procedures, or drawings."

Brown & Root (acting as an agent for the licensee) Sub-contract No. 35-1195-0578 states, "Pipe Whip Restraints shall be fabricated in accordance with Specification 2323-SS-16B, 'Structural Steel (Category 1),' except as modified by the notes appearing on Drawing 2323-SI-0581, 'R. B. Internal Structure Pipe Whip Restraints'." Note 6 of the General Notes states, "All steel welded joints shall be complete penetration welded unless noted or shown otherwise." Detail 29, Sections 29c-c and 29b-b show five structural steel stiffener plates welded to the M-29 assembly with no notes and no indication of the weld required, hence the welded joints should be complete penetration types.

Contrary to the above:

The Resident Reactor Inspector examined two of the three portions of assembly M-29 on October 8, 1980, and found that the welds connecting the stiffener plates to the balance of the assembly were not complete penetration welds as evidenced by the lack of any weld metal on the back side of the single side bevel groove welds. The two portions of the assembly examined were identified by Chicago Bridge & Iron Company (sub-contractor and fabricator) as Numbers 82105-152A-1 and -2. The Resident Reactor Inspector was also able to insert the point of a pocket knife blade under the stiffener connection back side of the welds in a few instances, also evidencing a lack of complete weld penetration.

This is an infraction.