

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

Report No. 99900048/80-02

Program No. 51300

Company: Anchor/Darling Valve Co.  
24747 Clawiter Road  
Hayward, California 94545

Inspection Conducted: October 6-9, 1980

Inspector: V. H. Hunter 10-24-80  
V. H. Hunter, Contractor Inspector Date  
Components Section I  
Vendor Inspection Branch

Approved by: D. E. Whitesell 10-30-80  
D. E. Whitesell, Chief Date  
Components Section I  
Vendor Inspection Branch

Summary

Inspection on October 6-8, 1980 (99900048/80-02)

Areas Inspected: Implementation of 10 CFR 50, Appendix B, criteria and applicable codes and standards including action on previous findings, nonconformance and corrective actions, calibration, and records storage. The inspection involved twenty seven (27) inspector hours on site.

Results: In the four (4) areas inspected there were no apparent deviations or unresolved items identified.

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DETAILS SECTIONA. Principal Persons Contacted

D. P. Gilbert, Plant Manager  
J. J. Chappell, Quality Assurance Manager  
G. Rose, Manufacturing Manager  
D. Solyan, Contracts Supervisor  
J. T. Rose, Materials Manager  
L. G. Fortier, Welding Engineer  
J. Carroll, Authroized Nuclear Inspector

All of the above personnel attended the exit meeting.

B. Vendor Activities

The Anchor/Darling Valve Company consists of fabricating facilities in Hayward, California (ADVH) and Williamsport, Pennsylvania, with Corporate Headquarters located in Bala CYNWYD, Pennsylvania.

The Hayward facility (ADVH) is comprised of approximately 42,000 square feet under cover within a total area of 4.3 acres and is self contained in that all ASME required services such as design, welding, machining, hydrostatic testing, NDE, and heat treating are provided.

ADVH holds ASME Certifications N-1742(N) for Class 1, 2, & 3 valves and N-1743(NPT) for Class 1, 2, & 3 valves and appurtenances. These certificates expire on May 20, 1983. Principal products are 2.5" thru 5.4" gate, globe, and check valves with associated activators. ADVH has supplied such products to most nuclear projects under construction and/or in operation.

The current distribution of workload is nuclear - 80%, government - 10% and comercial - 10%.

The National Board Inspection Agency is the Lumberman's Mutual Casualty with one one (1) inspector on a full time basis.

C. Action on Previous Findings

(Closed) Deviation (Notice of Deviation, Inspection Report 80-01):  
Corrective actions for audit findings were not accomplished within the prescribed 30 day time frame.

The inspector verified that the specified corrective actions have been accomplished. In addition, all audits performed since the last inspection were reviewed and found to be current as to corrective actions.

D. Nonconformance and Corrective Action

1. Objectives

The objectives of this area of the inspection were to verify that:

- a. Procedures had been developed and approved by the vendor that prescribes a system for control of nonconformances and assuring effective corrective action in a manner consistent with NRC rules and regulation, ASME Code requirements, and the vendor's commitments in the ASME accepted Quality Assurance Program.
- b. The nonconformance and corrective action procedures are properly and effectively implemented by the vendor.

2. Method of Accomplishment

The objectives of this area of the inspection were accomplished by:

- a. Review of the ASME accepted Quality Assurance Manual, Section 4.0 titled "Quality Control" to verify that the vendor had established procedures that prescribed a system for identifying and reporting nonconformances and requires corrective action.
- b. Review of the following procedures:
  - (1) NQA-020, revision B titled "Material Certification Review."
  - (2) NQA-004, revision P titled "Tool and Gage Control."

to verify the system of nonconformance provides identification of inspection points, personnel responsible for identification, inspection method, acceptance criteria, personnel responsible for nonconformance and for resolution, segregation of item, and distribution of report.

- c. Review weld material records, MRB action reports, and observed nonconformances and corrective actions in process to verify the system of corrective action procedures have been approved and are consistent with the ASME accepted Quality Assurance Program and identifies the responsibility for receipt and analysis of nonconformance reports, recommending corrective action, approving corrective action, and follow-up to assure corrective action is effective and precludes recurrence. Also, verify the corrective action procedures provide for management participation in nonconformance report and corrective action review.

- d. Review of fifteen (15) nonconformance reports to verify that the nonconformance and corrective action procedures were properly implemented in that the assigned responsibilities were carried out, the identification and reporting of nonconformances and the evaluation and enacting of the corrective action was timely and effective, nonconforming items were properly disposed of, corrective action followup was effectively performed, management participation was active and effective.
- e. Interviews with personnel to verify they were aware of and had access to the nonconformance and corrective action procedures.

### 3. Findings

- a. The inspector verified that:
  - (1) Procedures had been developed and approved by the vendor that prescribed a system for control of nonconformances and assured effective corrective action in a manner consistent with NRC rules and regulations, ASME Code requirements, and the vendor's commitments in the ASME accepted Quality Assurance Program.

## F. Quality Assurance Records

### 1. Inspection Objectives

The objectives of the inspection were to verify that quality assurance records were maintained for fabrication, manufacturing, or installation and provide traceability, and the records contained as a minimum documents pertaining to materials manufacturing, examination and test data, procedures, drawings and Stress Report, qualification of personnel, procedures and equipment, and these records are maintained in a manner that allows ready access.

### 2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of Section 4.0 of the ASME accepted QA Manual.
- b. Review of selective QC plans and checklists.
- c. Review of completed data packages for required records.

3. Inspection Findings

There were no deviations or unresolved items identified.

G. Calibrationa. Inspection Objectives

The objectives of this inspection were to:

- (1) Ascertain that a system has been established and is maintained to assure that tools, gages, instruments and other measuring devices used in activities affecting quality are properly controlled, calibrated and adjusted at specified periods to maintain accuracy within specified limits.
- (2) Verify that the system described in (1) above, has been adequately documented with approved procedures and that these procedures are being implemented.

b. Objectives Accomplished by:

- (1) Review of Section 4.0 of the ASME accepted QA Manual.
- (2) Review of calibration master file.
- (3) Review of identifying codes and tool recall system.
- (4) Visual observation of calibrated tools and gages in all major work stations.
- (5) Interviews with cognizant technical and management personnel.

c. Inspection Findings

The objectives of the inspection were met with no deviation from commitments identified.

H. Exit Interview

The inspector met with management representatives at the conclusion of the inspection on October 9, 1980. The inspector summarized the scope and findings identified during the inspection. Management acknowledged the inspector's comments regarding the scope and findings as presented.