

Colt Industries



Trent Tube Division
Crucible Inc
Hammond Street
Carrollton, Ga. 30117
404/832-9047

April 3, 1981

United States
Nuclear Regulatory Commission
Region IV
611 Ryan Plaza Drive
Suite 1000
Arlington, TX 76011

ATTENTION: Uldis Potapovs

Gentlemen:

In compliance with your letter of March 12, 1981 we have taken the corrective action outlined below.

Nonconformance Identified Under A.1:

1. A sticker was attached to the pyrometer (SN R-22428) during the NRC Inspection as stated in the report.
2. A procedure (QCS-312) was written and issued to Plant personnel responsible for calibration instructing them to make sure instruments and equipment that are calibrated by sub-contractors have a proper calibration sticker attached. If the sub-contractor only provides a certificate of calibration the procedure requires the responsible plant personnel attach a proper Trent Tube calibration sticker.
3. Corrective Action completed April 2, 1981. Special emphasis will be given to checking total calibration compliance during internal audits.

Nonconformance Identified Under A.2:

1. A calibration sticker with dates corresponding to the sub-contractor's certificate of calibration was put on the hardness tester (SN 87481) and the Trent Tube calibration sticker removed.
2. Procedure QCS-312 has been prepared and issued to Plant personnel responsible for calibration. The procedure states that the calibration performed by the sub-contractor is considered the official calibration under our Q.A. Program and that only the sticker corresponding to the sub-contractor's latest calibration shall be attached to the equipment or instrument. Secondary calibration data will be maintained in a log.
3. Corrective Action complete as of April 2, 1981. Special emphasis will be given to checking calibration of equipment and instruments during internal audits.

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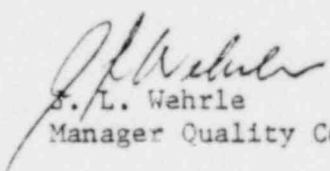
Nonconformance Identified Under B:

1. The correct Welding Procedure Revision Numbers were added to Mill Orders 5C5-35067-1 and 3C5-50469-0. The welding reports on Mill Orders 2C5-50514-0 and 3C5-50469-0 were reviewed relative to the procedure used and subsequent revision. The essential and non-essential variable of both revisions had been met since the revisions were for clarification relative to technique and customer's comments.
2. Written instructions requiring review of the Welding Procedure (WPS) Index for each order has been issued to personnel responsible for putting the correct welding procedure and revision on the mill orders. The index will be approved by the Manager Q.A. each time its contents is changed relative to new procedures and revision numbers.
3. Corrective Action complete as of April 2, 1981. The Q.A. Manager will review this area for compliance on a monthly basis.

Nonconformance Identified Under C:

1. The correct and latest revision of all applicable welding procedures has been put at each work station. The revisions to TWP-22A and TWP-8 were for clarification purpose and the essential and non-essential variable for the welding of Mill Orders 5C5-35067-1 and 4C3-01563-0 were within the limits of revisions involved.
2. Written instructions have been issued to the Quality Control and Welding Personnel (Supervisors and Welding Technicians) involved, directing them to make sure that the Mill Orders show the latest Welding Procedure Revision and that the required procedure is at the work station.
3. Corrective Action completed as of April 2, 1981. The Records Coordinator will send a copy of the Welding Procedure Index to the Welding Technicians on a monthly basis who in turn will check for proper revisions at the work station then return the approved Index to Quality Control for review and file.

Yours truly,


S. L. Wehrle
Manager Quality Control