

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

Report No. 50-482/81-03

Jocket No. 50-482

Category A2

Licensee: Kansas Gas & Electric Co.  
P. O. Box 208  
Wichita, Kansas 67201

Facility Name: Wolf Creek Generating Station

Inspection at: Wolf Creek Site

Inspection conducted: March 1981

Inspector:

T. E. Vandel  
T. E. Vandel, Resident Reactor Inspector,  
Projects Section No. 3

4-15-81  
Date

Approved:

W. A. Crossman  
W. A. Crossman, Chief, Projects Section No. 3

4/16/81  
Date

Inspection Summary:

Inspection During March 1981 (Report No. STN 50-402/81-03)

Areas Inspected: Routine, announced inspection by the Resident Reactor Inspector (RRI), including follow up to previous inspection findings; inspection of safety-related construction activities of welding of primary coolant piping; storage and handling of safety-related piping; welding & testing of CRDM to the vessel closure head; and handling and setting of electrical control panels in the control room. This inspection involved 58 inspection-hours by one NRC inspector.

Results: No violations or deviations were identified.

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DETAILS1. Persons ContactedPrincipal Licensee Employees

- \*P. M. Burck, QA Engineer
- \*M. E. Clark, QA Manager Site
- \*D. W. Prigel, Asst. QA Manager Site
- \*N. L. Hill, Start up Manager
- N. W. Hottel, Start up QA Supervisor
- \*G. W. Reeves, QA Engineer
- \*R. M. Stambaugh, QA Engineer
- \*J. L. Stokes, Project Support Supervisor

Contractor Personnel

- \*J. M. Ayres, QA Engineer, Daniel International (Daniel)
- \*L. D. Bryant, Quality Manager, Daniel
- \*N. J. Criss, Audit/Procedures Coordinator, Daniel
- C. R. Cook, Regional Quality Manager, Daniel
- D. R. Dennison, QC Manager, Daniel
- C. Light, Radwaste Area Superintendent, Daniel
- \*W. W. Wais, Asst. Engineering Manager, Daniel
- \*L. F. Warrick, Project Manager, Daniel
- \*G. P. Robertson, Project Manager, Peabody Testing Co.
- \*R. C. Slovic, Lead Site Liaison Engineer, Bechtel
- \*P. S. Manley, Plant Design Liaison, Bechtel
- E. Suvak, Mechanic Engineer, Westinghouse
- T. Graves, QA Engineer and Level II, Westinghouse
- R. Hopkins, Welding Engineer, Westinghouse
- B. Nelson, QA Engineer and Level II, Westinghouse
- J. Harrell, Project Manager, Multi-Amp Testing Services
- T. Kozkowski, Electrical Test Supervisor, Multi-Amp

The RRI also contacted other licensee and Daniel employees during the inspection period including both craft personnel and QA/QC employees.

\*Denotes those in attendance during one or more of the management meetings held on March 9, 12, 23, and 26, 1981.

2. Licensee Action on Previous Inspection Findings

(Open) Unresolved Item (81-01-03) Adequacy of the Reactor Pressure Vessel (RPV) Protection: On March 23, 1981, the NRC Inspector visited the Daniel Preventative Maintenance Section to review record information regarding the RPV installed protection. Daniel Procedure RMI-W-105,

Revision 5, applicable to the RPV, was reviewed. A section entitled "Maintenance Requirements Following Installation" provided in paragraph 5 for surveillance and maintenance requires that a daily check is to be made of air filters with replacement as required. In addition, the procedure requires verification that the fan is operable.

Current surveillance records showed that a check had been made on February 4 and again on February 24, 1981, with the notations that the filters have been removed and that the fan is not being operated. In response to questioning, the Preventative Maintenance Superintendent stated that they are waiting for instructions from Westinghouse.

This matter will remain open, pending resolution and correction of the problem.

### 3. Licensee and Contractor Management Changes

The licensee informed the RRI that effective March 15, 1981, Mr. M. E. Clark, Manager, Quality Assurance (site) will assume the role of Nuclear Coordinator reporting to the Vice President Nuclear in the Wichita, Kansas corporate office. Mr. D. W. Prigel, presently Assistant Manager Quality Assurance (site), will succeed Mr. Clark as Manager, Quality Assurance (site).

It was additionally learned that Mr. L. F. Warrick reported to the Wolf Creek site on March 16, 1981, as the new Project Manager for Daniel International Corporation.

### 4. RPV Closure Head

The RRI conducted an inspection of the Westinghouse activities involving installation of the Control Rod Drive Modules (CRDM) to the closure head adapter tubes. Observation of work activities and review of procedures and records were as follows:

- a. Automatic TIG Welding Procedure Number 8-8-GT-4 for Welding Procedure Specification WPS No. G-WPS-6, Rev. 1, and the Procedure Qualification G-PQR-#6, Rev. 1, were reviewed. It was learned that the revised PQR #6 (Rev. 1) was approved on March 9, 1981, after having been revised and requalified at the site. Production welding started under the original procedure, experienced three weld blow holes out of the first 15 welds performed. These blow holes were a result of voltage fluctuations at the welding machine causing welding current surges beyond WPS limits. The original current limits of 121-124 amps (high range) and 58-60 amps (low range) were

modified to 111-125 amps (high range) and 53-62 amps (low range) and were qualified with mid-range values (115 amps and 55 amps). Only two more blow holes were experienced through the completion of all welding. All blow holes were successfully repaired utilizing a qualified welding repair procedure (ND. 8-8-GT-3).

- b. Weld fit-up was observed. The CRDM-to-adapter joint is a threaded joint, and seal welded by the automatic TIG process with a consumable insert tacked to the CRDM threaded head.
- c. The automatic weld out of two CRDM-to-adapter welds were observed (Adapters No. 47 & 21).
- d. Liquid Penetrant Examination Procedure WC-NDE-200, Revision 0, dated September 5, 1980, was reviewed. The RRI observed the inspection of several completed welds (adapters No. 47 & 21, plus two others the Level II inspector was inspecting at the same time).
- e. The Hydrostatic Test Procedure SAP-M-001, Revision 0, dated March 2, 1981, was reviewed and the RRI observed the performance of the test on three CRDM-to-adapter housings (No. 41, 49 & 37). It was also observed that the water used for the tests is supplied fresh daily by Daniel with a certification as to its purity.
- f. Westinghouse drawings reviewed included:
  - (1) Closure Head Assembly No. 1455E85, Revision 1
  - (2) General Arrangement Plan, Sheet 1 of 2, No. 11173-171-005, Revision 1

In addition, the CRDM and Capped Latch Housing Installation Checklist was reviewed with appropriate documentation and test results sign-off being observed.

- g. Calibration of test equipment as well as the automatic TIG Welding Machine was inspected and it was determined that all equipment requiring calibration is current in calibration.

The NRC Inspector was informed by Westinghouse representatives that the ASME, Code N Stamp recertification team had visited the site on March 30-31, 1981 and had observed the welding of the last two seal welds as part of their recertification review with acceptable results.

No violations or deviations were identified.

## 5. Safety-Related Piping

During the conduct of a piping storage inspection on March 23, 1981, the RRI observed that of a number of stainless steel piping spools being stored together in the radwaste piping laydown yard, three spools had QC Hold Tags attached. It was learned that all of the piping was for the EC-04 piping system (Fuel Pool Cooling and Cleanup System) and was being stored together until the spools, on hold, were cleared. The holds tags were on piping spools 1-EC 04-.S001, -.S002, and -.S003 and they all indicated that nozzle-to-pipe welds were unacceptable for undercut, cold lap, arc strikes and spatter. Review of the SNUPPS FSAR established that the fuel pool cooling and cleanup system was quality group classification C (safety-related) in Table 3.2-1, paragraph 2.5.

During observation of the spools at a later time on March 24, 1981, the NRC Inspector observed that the QC Hold Tags had been removed from the three spools and had been replaced by Engineering Hold Tags (non safety-related). The Engineering Hold Tags listed deficiency report numbers IND 6211M, IND 6213M and IND 6214M for the same spools. Review of the three Deficiency Reports (DR) established that the spools originally had been identified as safety class spools, that classifications had been changed to nonsafety-related on March 24, 1981.

In response to the inspector's concern, a copy of drawing M-03EC04(Q), Rev. 3, "Piping Isometric Fuel Pool Cooling and Clean Up System Fuel Building" was provided to the NRC Inspector. The inspector determined that even though the drawing was classified as safety-related and the FSAR stated that the piping system was Quality Class C, the piping spools in question were being treated as nonsafety-related. This classification was justified by virtue of the piping being located inside of the fuel pool itself as inlet water headers at the rim of the pool. Loss of a piping nozzle, or rupture of a pipe would have no adverse affect on the pool cooling. The piping class changes from the non safety to safety-related at two field welds, F-006 and F-005 at the edge of the pool. The RRI indicated that he had no further questions.

## 6. Plant Tours

One or more plant areas were toured several times during the reporting period to observe general construction practices, area cleanliness and storage conditions of plant equipment. Some of the specific areas and items observed include the following:



- a. Primary coolant piping automatic welding was observed on two occasions. Since resumption of welding, it was observed that the weld operators were paying careful attention to welding in progress and the weld puddle appeared good.
- b. The RRI observed setting of electrical equipment in the control room on two separate occasions, once during the setting of the main control board (panels RL011 through R2028), and another time during the handling and setting of the seismic recorder, tag no. 42249. Good handling equipment was used in both cases and adequate manpower also was available.
- c. The electric relay testing building was visited by the RRI. The inspector met supervisory personnel of Multi-Amp Testing Services and discussed their utilization of procedures during testing. The RRI reviewed several sets of books, all containing individual procedures for relay testing and recording of results.

No violations or deviations were identified.

7. Entrance and Exit Meetings

The RRI participated in entrance and exit interviews on March 9, 12, 23, and 26, 1981 with licensee representatives and site personnel identified in paragraph 1. The inspector outlined the scope of inspection activity by the RRI and the results thereof.