

APPENDIX A

NOTICE OF NONCONFORMANCE

Woolley Manufacturing Division
Docket No. 99900390/81-01

Based on the results of an NRC inspection conducted on October 19-23, 1981, it appears that certain of your activities were not conducted in accordance with NRC requirements as indicated below:

Criterion V of Appendix B to 10 CFR Part 50 states: "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. Instructions, procedures, or drawings shall include appropriate quantitative or qualitative acceptance criteria for determining that important activities have been satisfactorily accomplished."

Woolley Manufacturing Division Quality Assurance Manual, Section 6.0., "Instructions, Procedures, and Drawing Control," states that, all documents shall be reviewed by the QA Department to assure compliance with the QA requirements.

Quality Assurance Manual Section "Definitions," states that reviewing of documents shall always require signing or stamping and dating by the authorized reviewer, either on the document or on records traceable to the document.

Contrary to the above, QA signatures signifying approval were not in evidence on drawings, fabrication change notices, in-process sheets or shop order supplements for two nuclear contracts.

ORGANIZATION: WOOLLEY MANUFACTURING DIVISION
CANTON, OHIO

REPORT NO.: 99900390/81-01 INSPECTION DATE(S): 10/19-23/81 INSPECTION ON-SITE HOURS: 31

CORRESPONDENCE ADDRESS: Woolley Manufacturing Division
ATTN: Mr. C. A. O'Deay
Quality Assurance Manager
P. O. Box 1388, Station C
Canton, Ohio 44708

ORGANIZATION CONTACT: Mr. C. A. O'Deay, QA Manager
TELEPHONE: (216) 477-4585

PRINCIPAL PRODUCT: Air Locks, Equipment Hatches, Nuclear and Section VIII Vessels, Steel Plate Fabrications.

NUCLEAR INDUSTRY ACTIVITY: Eight contracts representing approximately 75% of the total workload.

ASSIGNED INSPECTOR: Ross L. Brown
Ross L. Brown, Components Section (CS)

11/9/81
Date

OTHER INSPECTOR(S):

APPROVED BY:

U. Potapovs
U. Potapovs, Acting Chief CS

11/9/81
Date

INSPECTION BASES AND SCOPE:

- A. BASES: 10 CFR Part 50, Appendix B, 10 CFR Part 21 and other applicable standards.
- B. SCOPE: Management meeting and implementation of 10 CFR Part 50, Appendix B, including change control, manufacturing process control, personnel training and qualification, status of previous inspection findings, and 10 CFR Part 21 inspection.

DESIGNATED ORIGINAL

Certified By

Rheanne Joubert

REPORT NO.: 99900390/81-01

INSPECTION RESULTS:

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A. VIOLATIONS:

None

B. NONCONFORMANCES:

Contrary to Criterion V of 10 CFR Part 50, Appendix B and Woolley Manufacturing Division (WMD) Quality Assurance Manual (QAM) Sections 6.0. and Definitions, the QA approval signature or initials and date were not in evidence on quality related drawings, fabrication change notices (FCN), in-process sheets (travelers), and shop order supplements.

C. UNRESOLVED ITEMS:

None

D. STATUS OF PREVIOUS INSPECTION FINDINGS:

(Closed) Unresolved Item C.3.c. (80-02): The vendor did not have procedures to completely implement the indoctrination and training program requirements.

Section 3.0. of the QAM and Standard Operating Procedures (SOPs) No. 39, establishes guidelines and assigns the responsibility for the qualification and certification of personnel performing quality activities.

Review of indoctrination and training schedule and 16 records of training sessions conducted between November, 1980, and October, 1981, verified that training of engineers, welders, inspector's (QA/QC), purchasing, and production personnel had been performed.

E. OTHER FINDINGS OR COMMENTS:

1. Change Control - Review of drawings, fabrication change notices, in-process sheets, and SO supplements for SO's 27000-N and 23551-N verified conformance with the program requirements relative to identification, justification, engineering approval, distribution, and identification of obsolete documents.

However, QA approval signature and date were not in evidence on the documents or on a record traceable to the documents (see Paragraph B).

2. Manufacturing Process Control - Review of the in-process sheets, in-process inspection reports, and nondestructive examination (MT and hydrostatic) reports for shop orders SO-27000-N and SO-23551-N verified conformance with the QAM requirements.
3. Personnel Training and Qualification (NDE) - The review of the personnel qualification files, one RT report, two PT reports, and four MT reports verified that the nondestructive examinations were performed by persons qualified in accordance with SNT-TC-1A-1975 Edition and ASME Code.

ORGANIZATION: WOOLLEY MANUFACTURING DIVISION
CANTON, OHIO

REPORT NO.: 99900390/81-01

INSPECTION RESULTS:

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4. 10 CFR Part 21 Inspection - Review of Standard Operating Procedure No. 36, memorandum to all employees issued by the Vice President of Manufacturing, and two employees bulletin boards verified compliance with the regulatory requirements.

5. Company Name Change:

February, 1981, the company name was changed:

From: Irwin Steel Fabricators

To: Woolley Manufacturing Division

PERSONS CONTACTED

Company WOOLLEY MFG. DIV. (WMD)

Dates 10/19-23/81

Docket/Report No. 77100390/81-01

Inspector ROSS L. BROWN

Data Sheet Page 1 of 6

NAME(Please Print)	TITLE(Please Print)	ORGANIZATION(Please Print)
* K. L. HLADEK	VICE PRESIDENT OF MANUFACTURING	WMD
* R. E. LOWER	PLANT SUPERINTENDENT	"
* D. L. CARLSON	QA SPECIALIST	"
* G. S. RIDOLFI	CHIEF MANUFACTURING ENGINEER	"
* G. A. EARTHART	PROCESS ENGINEER	WMD
* D. J. HALL	PROCESS ENGINEER	"
* H. G. WESTON	PRODUCTION CONTROL	"
* M. RITZMAN	PROCESS ENGINEER	"
* W. P. IRWIN	INSPECTOR	"
* G. KNIERICH	QC SUPERVISOR	"
* W. E. DAUGHERTY	PURCHASING MANAGER	"
* C. SPROUSE	SHOP SUPERVISOR	WMD
J. REANI	SHOP SUPERVISOR	"
* J. D. PAULUS	WELDING SUPERVISOR	"
* L. T. HAMMER	PRODUCTION SUPERVISOR	"
* D. C. HARBERT	SALES ENGINEER	"
* L. J. MILLER	PROJECT ADMINISTRATOR	"
* B. ALGERI	NDE- X-RAY	WMD
D. MORRIS	PRODUCTION SCHEDULER	"
* W. J. ALGERI	NDE- XRAY	"
* E. A. O'DEAY	QA MANAGER	"
* ATTENDED EXIT MEETING		

[illegible]

Document Types:

1. Drawing
2. Specification
3. Procedure
4. QA Manual

Columns:

1. Sequential Item Number
2. Type of Document
3. Date of Document
4. Revision (If applicable)

Scope/Module MANUFACTURING PROCESS CONTRACTS DOCUMENTS EXAMINED

WOOLLEY MFG. DIV.

[illegible]

Document Types:

1. Drawing
2. Specification
3. Procedure
4. QA Manual

5. Purchase Order
6. Internal Memo
7. Letter
8. Other (Specify)

Columns:

1. Sequential Item Number
2. Type of Document
3. Date of Document
4. Revision (If applicable)

Inspector Ross L. Brawn

Scope/Module INDEXTATION AND TRAINING
(UNRESOLVED ITEM C.3.2-80-02)

DOCUMENTS EXAMINED

WOOLLEY MFG. DIV.

[illegible]

Document Types:

1. Drawing
2. Specification
3. Procedure
4. QA Manual

5. Purchas Order

6. Internal Memo
7. Letter
8. Other (Specify-if necessary;

Columns:

1. Sequential Item Number
2. Type of Document
3. Date of Document
4. Revision (If applicable)

Inspector Ross L. Brown
Scope/Module PERSONNEL TRAINING (NDE)

WOOLLEY MFG. DIV.

[illegible]

Document Types:

1. Drawing
2. Specification
3. Procedure
4. QA Manual

5. Purchas Order

5. Purchase Order
6. Internal Memo
7. Letter
8. Other (Specify)

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