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:

L. Brown, Components Section (CS)

9/81

OTHER INSPECTOR(S):

APPROVED BY:

U. Potapovs, Acting Chief

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.

BESIGNATED ORIGINAL

certified By Chlanne

ORGANIZATION: WOOLLEY MANUFACTURING DIVISION

CANTON, OHIO

REPORT NO.: 99900390/81-01 INSPECTION RESULTS: PAGE 2 of 3

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:

 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).

- Manufacturing Process Control Review of the in-process sheets, inprocess inspection reports, and nondestructive examination (MT and hydrostatic) reports for shop orders S0-27000-N and S0-23551-N verified conformance with the QAM requirements.
- 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:

PAGE 3 of 3

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 Wouley MIRG. DIV, (WMD)

Docket/Report No. 97700390/81-01

Dates 10/19-23/81

Inspector Ross L. Brown

Data Sheet Page / of 6

NAME(Please Print)	TITLE(Please Print)	ORGANIZATION(Please Print)
* K.L. HLADEK	VICE PRESIDENT OF MANUFACTURES	IN/MO
* R. ELOWER	PLANT SUPERINTENDENT	.,
* D.L. CARLSON	QA SPECIAUST	
+ G.S. RIDOLFI	CHIEF MANUFACTURING ENGINEER	,,
* G, A, EARHART	PROCESS ENGINEER	WMD
+ .D. J. HALL	PROCESS ENGINEER	
* H.G. INESTON	PRODUCTION CONTROL	. /
* M, RITZMAN	PROCESS ENGINEER	"
XW.P. IRWIN	INSPECTOR	"
Y G. KNIERIEN	QC SUPERVISOR	"
XIN.E. DAUGHERTY	PURCHASING MANAGER	.,
* C. SPROUSE	SHOP SUPERVISOR	LEMD
J. REAM	THOP SUPERVISOR	,,
X J. D. PAULUS	WELDING SUPERNISOR	.,,
* L, T, HAMMER	PRODUCTION SUPERVISOR	**
+ D.C. HARBERT	SALES ENGINER	
+ L.J. MILLER	PROJECT ADMINISTRATOR	
+ B. ALGERI	NDE-X-RAY	WMO
D. MORRIS	- PRODUCTION SCHEDULER	/ /
* W.J. ALGERI	NDE-XRAY	,,
* e. A. O'DEAY	QA MANAGER	n
* ATTENDED EXIT	MEETING	

Inspector Ross L. BROWN

Scope/Hodule CHANGE CONTROL

DOCUMENTS EXAMINED

Data Sheet Page 2 of 6

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60										2/14/21	3/44/81				
TITLE/SUBJECT	DRAWING NO. 34589	FABRICATION CHANGE NOTICES (FCN) FOR SMOP CROORS	(50) 27000-N, 23551-N, 11249, 11259, 29011-N, 11254	29010-N, 1125/620 26900-N.	IN- PROCESS SHEETS FOR SON 27000-N and 23551-N	MACNETIC PARTICLE FEST (MT) PROCEDURES NOG-MC-MT3	AND NOE-MIC-MTI	CHECKLIST ON RECEIPT OF ORDER	WARD QUALITY ASSURANCE MANUAL (DAM) SECTION 6.0	INSTRUCTIONS PROCEDURES AND DRAWING CONTROL	1 0/1				
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- Document Types:
 1. Drawing
 2. Specification
 3. Procedure
 4. QA Manual
- Purchas Order Internal Memo 87.00
- Letter Other (Specify-if necessary)

Columns:

- Sequential Item Number
 Type of Document
 Date of Document
 Revision (If applicable)

Inspector Ross L. 1320WA

9900590 Report No.81-01

Data Sheet Page 3 of

Scope/Module MANGEREING PROCESS CONTROL DOCUMENTS EXAMINED

2	TITLE/SUBJECT	3	4
7	WMD-GAM SECTION 8,0, CONTROL OF PURCHASGO MATORIA	44	
	Equipment AND SERVICES	3/24/81	0
7	WIMO-GAM SECTION TO DENTIFICATION AND CONTROLOS		
	MATERIALS. PARTS. 440 COMPONENTS; PROCESS CONTROL!		
	AND INSPECTIBLY	3/24/81	0
00	IN. AROCESS INSPECTION REPORT FOR 5027000 AND 5023557		
16	(NSPECTION REPORTS (NDE-MT AND HYDRO).		
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00	(N. PROCESS SHEETS FOX SO. 27000-N MNO 50 23551-N		
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Document Types:
1. Drawing
2. Specification
3. Procedure
4. QA Manual

Purchas Order Internal Memo Letter Other (Specify-if necessary) 8.4.5

Columns:

Sequential Item Number
Type of Document
Date of Document
Revision (If applicable)

Inspector Ross L. Brown

(UNRESOLVED ITEM C.3. R-80-02) Scope/Module MOCCTRINATION AND TRAINING

DOCUMENTS EXAMINED

Data Sheet Page 4 of 6

1	2	TITLE/SUBJECT	3	4
,	3	WNO. GAM SECTION 3.0 (NDOCTRINATION, FRAIMING AND		
		Qualification"	3/24/81	P
1	n	STANDARD SPERATING PROCEDURE (SOR) 16, 39 CERTIEI-		
		CATION AND QUALIFICATION OF INSPECTION EXMINATION	>	
		AND TESTING PERSONNEL	12/9/80	0
W	S	16 IMPOCTRIMATION AND TRAINING RECORD FOR SESSIONS		
		COMPURTED BETWEEN MODENTSOR 1980 AND CETOBER 1981		
y	w	INDOCTRINATION AND TRAINING SCHEDULE		

Document Types:
1. Drawing
2. Specification
3. Procedure
4. QA Manual

Purchas Order Internal Memo 8,765

Other (Specify-if necessary,

Columns:

Sequential Item Number
Type of Document
Date of Document
Revision (If applicable) -2.6.4

Inspector Ross L. BROWN

Scope/Module PERSONNEL TRAINING (NDE)

DOCUMENTS EXAMINED

Data Sheet Page 3 of 6

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N MEC D.

-	2	TITLE/SUBJECT	3	7
,	7	WIMO - DAM SECTION 10.0 PARAGRAPH 10.4, NONDETRUCTIVE	JE	
		EXAMINERTION	3/24/81	0
7.	do	SIX PERSONNEL QUALIFICATION RECORDS FOR MIPTET		
		UT AKID VT.		

Columns:

Document Types:
1. Drawing
2. Specification
3. Procedure
4. QA Manual

Purchas Order Internal Memo

Other (Specify-if necessary) 8.7.6.5

Sequential Item Number
Type of Document
Date of Document
Revision (If applicable)

BROWN Inspector Rass L. Scope/Module locate DARTAI INSPECTION

DOCUMENTS EXAMINED

Data Sheet Page & of &

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	2	TITLE/SUBJECT	3	4
	2	STANDARD OPERATING PROCEDURE, NO. 36, 10 ENTIFICATION		
		AND PROCUREMENT OF SHEETY RELATED ITEMS TO MEET		
		18 CFZ NART ZI REQUIREMENTS"	3/10/81	0
7	9	NoTICE TO ALL EMPLOYEES		
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Document Types:
1. Drawing
2. Specification
3. Procedure
4. QA Manaal

Purchas Order Internal Memo 8,100

Other (Specify-if necessary)

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