

U.S. NUCLEAR REGULATORY COMMISSION

REGION III

Report No. 50-329/82-04(DETP); 50-330/82-04(DETP)

Docket No. 50-329; 50-330

License No. CPPR-81; CPPR-82

Licensee: Consumers Power Company
1945 W. Parnell Road
Jackson, MI 49201

Facility Name: Midland Plant, Units 1 and 2

Inspection At: Midland Site, Midland, MI

Inspection Conducted: March 2-4, 1982

Inspector: *DH Danielson*
for K. D. Ward

3/10/82

Approved By: *DH Danielson*
D. H. Danielson, Chief
Materials & Processes Section

3/10/82

Inspection Summary

Inspection on March 2-4, 1982 (Report No. 50-329/82-04(DETP); 50-330/82-04(DETP))

Areas Inspected: Reports and radiographs of shop welds; previous inspection findings; nondestructive examination (NDE) personnel certifications of CPCo individuals; allegation. The inspection involved a total of 30 inspection-hours onsite by one NRC inspector.

Results: No items of noncompliance or deviations were identified.

DETAILS

Persons Contacted

Consumers Power Company (CPCo)

*B. Marguglio, Director QA
*W. Bird, Manager QA
*R. Whitaker, Section Head - Fluids and Mechanical QA
*R. Davis, NDE/Welding Group Supervisor QA
M. Curland, QA Superintendent

Bechtel Power Company (BPCo)

*E. Smith, QC Engineer
*M. Dietrich, Project QA Engineer
D. Fredianelli, LWQCE
W. Creel, LPMQCE
A. Van Den Bosch, CQCE
A. McClure, PQAE

The inspector also contacted and interviewed other licensee and contractor employees.

*Denotes those attending the exit interview.

Licensee Action on Previous Inspection Findings

(Closed) Deviation (329/80-01-02; 330/80-01-03): "No positive way of tracking design changes and assuring that completed work is modified in accordance with design changes and no procedure for handling design changes made after completion of work." The inspector reviewed the final response to RIII from CPCo dated May 15, 1980 and the following procedures which state the required information.

- . Bechtel, Design Change Packages Interim Drawing Changes Notices, EDP14.47.1
- . Bechtel, Functional Turnover of Systems, Subsystems and Items, AAPD/PSPG-11.1

(Open) Unresolved Item (329/80-17-02; 330/80-19-02): "Radiographic linear indications of welds in two borated water storage tanks." In the Summer of 1982, the tanks may be drained and made available for radiography.

(Open) Unresolved Item (329/81-21-01): Possible altered radiographs. Waiting results of RIV inspection of Grinnell. Four welds of altered radiographs were found out of 46,505 shop radiographic views reviewed on site.

Functional or Program Areas Inspected

1. Allegations

- a. Region III received allegations indirectly from an individual who was previously employed at the Midland site by Bechtel Power Corporation for the purpose of training to be a Level I weld inspector in accordance with Bechtel Quality Control Instruction, Level I Fabrication, Welding, Heat Treating and Nondestructive Examinations of ASME Section III - Piping, PW-100. The individual failed the Level I test two times and was terminated.

The allegations were as follows:

- . Socket welds not being completely welded.
- . A steam line weld had concavity.
- . Problems in containment liner plate weld radiography.

BPCo had previously identified questionable areas in the inspection efforts of one QC welding inspector assigned to inspect socket welds. CPCo was notified of the problem March 2, 1982. BPCo is going to review 100% of the one QC welding inspector's efforts and random sample other inspector efforts in inspecting socket welds. CPCo may monitor the BPCo program. This is considered an unresolved item (329/82-04-01; 330/82-04-01) and the inspector will review this in depth at the next inspection.

The inspector visually examined the following socket welds in accordance with ASME Section III, 1971 Edition, Summer 1973 Addenda.

<u>Line #</u>	<u>Field Weld #</u>	<u>Diameter</u>
FSK-M-1HBC-58-2	FW50	2"
"	51	2"
"	56	2"
"	61	1"
"	62	1"
"	63	1"
"	64	2"
"	65	2"
"	88	2"
"	89	2"
"	90	2"
"	91	2"
FSK-M-1MBC-57-5	10	2"
"	11	2"
"	12	2"
"	13	2"

<u>Line #</u>	<u>Field Weld #</u>	<u>Diameter</u>
FSK-M-2HBC-57-1	118	2"
"	122	2"
"	123	2"
"	124	2"
"	125	2"
"	126	2"
"	127	2"
FSK-M-2HBC-57-1	128	2"
"	129	2"
"	130	2"
"	131	2"
"	132	2"
"	133	2"

The inspector visually examined steam line 2ELB-11 field weld 1, 36" diameter, nominal wall thickness 2.375". There is a slight offset which met ASME Section III, 1971 Edition, Summer 1973 Addenda. The weld has been blended for inservice inspection and appeared to be acceptable.

CPCo recently contracted Hartford Steam and Boiler/NDT Engineering, a company with qualified/certified radiographic film interpreters, to interpret the shop weld radiographs of Units 1 and 2 containment liner plates 100%. This consisted of approximately 900 views. The results of the review found that approximately 20 welds had weld quality or radiographic technique problems. The results are documented in nonconformance report #M-01-9-2-025 issued February 19, 1982.

- b. CPCo received four allegations concerning B&W NDE work from an individual previously employed at the Midland Site (File 16.0, Serial 98FWA80, dated April 11, 1980). Three of the allegations were closed (Reference NRC Report No. 50-329/80-27; 50-330/80-28 and No. 50-329/81-06; 50-330/81-06). The fourth allegation has not been resolved to date. CPCo management in Jackson, Michigan is reviewing the allegation and has hired Teledyne Engineering Services to analyze the as-welded conditions for acceptability.

No items of noncompliance or deviations were identified.

2. Radiographic Review of Shop Radiographs (See NRC Report No. 329/81-21; 330/81-21)

The inspector reviewed several nonconformance reports on the 46,505 shop radiographs reviewed in 1981. Approximately 50 items that were radiographed were found to be unacceptable in weld quality or radiographic techniques. The items are to be resolved in the near future.

No items of noncompliance or deviations were identified.

3. NDE Personnel Certifications

The inspector reviewed the following CPCo NDE personnel certifications in accordance with SNT-TC-1A, 1975 Edition:

<u>Name</u>	<u>RT</u>	<u>PT</u>	<u>MT</u>
R. Davis	II	II	II
T. Charette	II	II	

No items of noncompliance or deviations were identified.

4. Review of Shop Radiographs

The inspector reviewed radiographs and reports of the following shop components.

- a. Radiography performed by ARMCo for Guyon Alloy Company in accordance with ASME Section III, 1977 Edition, Winter 1978 Addenda.

<u>System</u>	<u>Weld</u>	<u>Diameter</u>	<u>Thickness</u>	<u>Date RT</u>
SNO-8842	1P	12"	1.371"	8/8/80
SNO-8843	1P	12"	1.371"	8/8/80

- b. Radiography performed by Peabody Testing, X-Ray Engineering Company for Bechtel Corporation in accordance with ASME Section III, 1974 Edition, Summer 1974 Addenda.

<u>Component</u>	<u>Diameter</u>	<u>Thickness</u>	<u>Date RT</u>
5346-14-1-8 Gate Valve	4"	1/8" - 1 1/2"	10/13/76

- c. Radiography performed by Taylor-Bonney Division for McJunkin Corporation in accordance with ASME Section III, 1977 Edition, Winter 1978 Addenda.

<u>Component</u>	<u>Weld</u>	<u>Diameter</u>	<u>Thickness</u>	<u>Date RT</u>
90 Ell 802352	14	18"	0.395	12/17/79

- d. Radiography performed by ITT Grinnell Industrial Piping Inc. for CPCo in accordance with ASME Section III, 1971 Edition, Summer 1973 Addenda.

<u>System</u>	<u>Weld</u>	<u>Diameter</u>	<u>Thickness</u>	<u>Date Rt</u>
2CCB-6-S-604-9-L	E	4"	0.593"	1/25/77
2HCB-2-5-613-5-11	CR3	18"	0.437"	8/9/76

2HCC-84-S-604-18-1	B	2 1/2"	0.192"	9/26/77
2ELB-11-S-632-1-1	BUZ	36"	1.379"	10/30/78
2HCB-16-S-604-6-2	C	6"	0.156"	6/22/77
2FCB-18-S-604-5-9	A	6"	0.312"	4/25/77

No items of noncompliance or deviations were identified.

Unresolved Matters

Unresolved matters are items about which more information is required in order to ascertain whether they are acceptable items, items of noncompliance, or deviations. Unresolved items disclosed during this inspection are discussed under the paragraph 1.a.

Exit Interview

The inspector met with site representatives (denoted in Persons Contacted paragraph) at the conclusion of the inspection. The inspector summarized the scope and findings of the inspection noted in this report. The inspector has been going on inspections to Midland since September 1978 and this was the most hostile exit interview ever encountered. The acting NDE and Welding Supervisor, Section Head, Fluids and Mechanical QA and the new Site QA Superintendent were very concerned with the socket weld problem noted in paragraph 1.a. The Site QA Superintendent informed the inspector prior to the exit that CPCo would establish an overview program to check into the welding and inspection of socket welds and qualification of QC personnel. However, at the exit this program was completely unacceptable to the QA Manager and Director. This matter is an unresolved item and this area will be reviewed indepth during a subsequent inspection.