



Pullman Power Products

XV-2

DOCUMENT NO

PREPARED BY: J. MALONEY

APPROVED BY: H. HINKLEY

NDH

12/28/84

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PROJECT PROCEDURE

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PROCEDURE FOR HANDLING
NONCONFORMANCES AND LIMITED
WORK AUTHORIZATION (FIELD)

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PULLMAN POWER PRODUCTS

HEADQUARTERS AT

WILLIAMSPORT, PENNSYLVANIA

RECEIVED UE&C
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UE&C CODE
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23 11/04/85	J. Maloney	H. Hinkley	NDH	Inc. IPRs R22-1 at Para. 7.2.3; R22-2 at App. A (pg.1) & L (pg.7); R22-3A at Para. 9.1.1 and App. L (pg.9); Revised Para. 2.2, 14.1, 14.3 thru 14.8 and App. D (2Pgs), J (Pg 2) & O (Pg 1); Added Para. 14.9

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1.0 SCOPE

- 1.1 This procedure defines the necessary action required to process nonconformances in accordance with Section XV of the Company's Quality Assurance Manual.
- 1.2 Nonconformances in ASME Section I, III, and VIII items, and items designated as safety-related (ie: AWS Whip Restraints, etc.) shall be identified and processed in accordance with this procedure.

2.0 POLICY

- 2.1 Nonconformances in items may be detected at source inspection, receiving inspection, in-process inspection or surveillance during fabrication or installation, at final inspection, examination or during testing.

- 2.1.1 Nonconformance Reports shall be classified as either minor or major.

- A. A Minor Nonconformance is one which may be dispositioned as restore (rework) or scrap. An NCR for contractor supplied material that is dispositioned "return to supplier" is considered in the same category as "scrap". Documentation deficiencies (except customer supplied equipment type) are considered in the same category as "restore" disposition. UE&C evaluation/disposition is not required for Minor Nonconformance Reports.

- B. A Major Nonconformance is one which can not be classified as minor. UE&C evaluation/disposition is required for all Major Nonconformance Reports.

- 1. Nonconforming conditions identified in N-Stamped components and their supports shall be classified as Major Nonconformances.

- 2.2 Nonconformances associated with non-Code and non-safety related items are reported and controlled in accordance with NNS Project Procedure IV-2 NNS, with the exception of welding non-conformances in NNS Project Procedures IX-3 NNS and IX-63 NNS.

- 2.3 Nonconformances identified during receipt inspection and documentation review of materials and items furnished by UE&C are not included in the scope of this procedure. The unacceptable material, items and/or documents will be rejected by the Company and shall be handled through the UE&C Nonconformance Procedure, as described in Sections VII and VIII of the Company's Quality Assurance Manual.

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2.4 Prior to implementation of QA Manual, revision 12/13/84 and Procedure XV-2, rev. 21 (12/28/84), Nonconformances were reported, processed and closed on Pullman Power Products NCR Forms (Appendix Q). These forms, initiated prior to implementation of the above Manual/Procedure revisions, shall continue to allow work, rework and/or restoration, and to document closure of the reported nonconformance(s).

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2.5 ABBREVIATIONS

- ANI - Authorized Nuclear Inspector
- ASME - American Society of Mechanical Engineers
- AWS - American Welding Society
- CDEG - Central Data Entry Group
- CCT - Change Document Tracking System
- CPR - Contractor Problem Report
- DFS - Discipline Field Supervisor
- DOS - Discipline Office Supervisor
- DSCC - Discipline Site Change Coordinator (UE&C)
- DVC - Document Verification Center
- EA/FG - Engineering Administrator/Field Group
- EA/OG - Engineering Administrator/Office Group
- LWA - Limited Work Authorization
- NC - Nonconformance
- NCR - Nonconformance Report
- QA - Quality Assurance
- QC - Quality Control
- STD - Startup and Test Department (Owner's Agent)
- SWO - Stop Work Order
- UE&C - United Engineers and Constructors
- UT - Ultrasonic Test

3.0 RESPONSIBILITY

- 3.1 It is the responsibility of the QA Manager for the implementation of this procedure through his examination, inspection and testing personnel.
- 3.2 The Chief Field Engineer and the QA manager shall provide the disposition of all Minor NCRs as follows:
- 3.2.1 The Chief Field Engineer, or his designee, shall be responsible for scrap/reject type dispositions. In addition, he shall disposition "Restoration/Documentation" type deficiencies which are hardware related.
 - 3.2.2 The QA Manager, or his designee, shall be responsible for "Documentation" type deficiencies involving correction or regeneration of documentation.



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2.5 ABBREVIATIONS

ANI - Authorized Nuclear Inspector
ASME - American Society of Mechanical Engineers
AWS - American Welding Society
CDEG - Central Data Entry Group
CCT - Change Document Tracking System
CPR - Contractor Problem Report
DFS - Discipline Field Supervisor
DOS - Discipline Office Supervisor
DSCC - Discipline Site Change Coordinator (UE&C)
DVC - Document Verification Center
EA/FG - Engineering Administrator/Field Group
EA/OG - Engineering Administrator/Office Group
LWA - Limited work Authorization
NC - Nonconformance
NCR - Nonconformance Report
QA - Quality Assurance
QC - Quality Control
STD - Startup and Test Department (Owner's Agent)
SWO - Stop Work Order
UE&C - United Engineers and Constructors
UT - Ultrasonic Test

3.0 RESPONSIBILITY

3.1 It is the responsibility of the QA Manager for the implementation of this procedure through his examination, inspection and testing personnel.

3.2 The Chief Field Engineer and the QA manager shall provide the disposition of all minor NCRs as follows:

3.2.1 The Chief Field Engineer, or his designee, shall be responsible for scrap/reject type dispositions. In addition, he shall disposition "Restoration/Documentation" type deficiencies which are hardware related.

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3.3 UE&C shall provide the disposition of all Major NCRs, per this procedure.

3.4 It is the responsibility of the Company, as the NA Certificate holder, to obtain the ANI concurrence for the disposition of ASME NCRs initiated by the Company.

3.5 The QA Manager, or his designee, shall evaluate all nonconformances for applicability for reporting under 10 CFR 50.55 (e) to the Customer. This evaluation shall also take into consideration the Company's obligations to report defects or noncompliances under 10 CFR 21 (Ref: Procedure IV-3).

3.6 The QA Manager or his designee, upon evaluation of the NCR, will indicate the corrective action to be taken as described in Paragraph 16.0.

3.6.1 The corrective action will be implemented as soon as possible, to prevent repetition of the nonconformance.

4.0 APPLICABILITY OF NONCONFORMANCE REPORT (NCR)

4.1 Unacceptable conditions will exist that do not require an NCR. These conditions are those that can be corrected at the time of discovery or during subsequent in-process operations, when the correction or repair will be in compliance with applicable Code and procedure or standard (Appendix L) repair specifications. All activities shall be performed under the control, and to the satisfaction of a qualified QC Inspector who will ensure that they are controlled by operations detailed in Process Sheets or Repair Orders issued by him, per Procedure JS-IX-14 or Procedure IX-71.

4.1.1 These unacceptable conditions may be removed by additional grinding or machining, without an NCR, provided the requirements of subparagraph A through D below are met. In the event they cannot, they shall be reported on an NCR as described in Paragraphs 4.2 and 4.3.

A. The remaining section thickness is not reduced below the required minimum thickness.

1. When the minimum thickness is suspect, UT or mechanical measurements shall be employed for thickness verification.

B. The depression, after unacceptable condition elimination, is blended uniformly into the surrounding surface.



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C. After removal of the unacceptable condition, the area is reexamined by magnetic particle, liquid penetrant or visual methods, as required by JS-IX-14 to assure that the unacceptable condition has been removed or reduced to an acceptable size.

D. Areas ground to remove oxide scale or other mechanically caused impressions for appearance or to facilitate proper ultrasonic testing need not be examined by magnetic particle or liquid penetrant test methods.

4.1.2 Unacceptable conditions not requiring an NCR include, but are not limited to: Additional grinding of welds or base materials to attain required crown height or dimension, elimination of surface imperfections as may be required for nondestructive examination and removal and repair of unacceptable indications in welds prior to final acceptance.

A. These conditions shall be corrected in accordance with Procedure JS-IX-14, "Defect Removal and Repair by Welding", and/or the applicable NDE procedure.

4.2 A major NCR (Appendix D) shall be initiated under, but not limited to, the following conditions:

4.2.1 Incomplete or incorrect acceptance of documentation or identification of Owner/UE&C furnished equipment or material, identified after receipt inspection acceptance.

4.2.2 Repairs required in welds or base metal after third cycle of weld repair.

4.2.3 Misalignment of components beyond Code, procedure or specification tolerances, which can not be corrected by "Pull weld Repair" per Procedure JS-IX-14.

Repair welding following final leak (Hydrostatic/Pneumatic) testing, or final heat treatment.

4.2.4 Repairs or additional work required to be performed on vendor produced welds (with the exception of supports which are discussed in Procedure JS-IX-6).

A. It shall be the responsibility of UE&C to determine the repair and heat treat status of vendor weld and to report how many additional repair cycles may be accomplished. The NCR Disposition shall reflect the new field weld number. Process Sheets issued as a result of an NCR will have the NCR referenced to enable tracking of heat cycles.

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4.3 An NCR, classified as major or minor in accordance with the provisions of this procedure, shall be initiated under, but not limited to, the following conditions:

4.3.1 Incorrect materials (i.e., type, size, schedule, etc.,) that are in conflict with engineering design documents and/or Code.

4.3.2 Conditions which do not meet the requirements established by Project Procedures, Code, or specifications.

4.3.3 Weld repairs of base metal exceeding 1/3 of nominal thickness.

4.3.4 Weld repairs required to end preparations. (See Appendix L, Specification No. 4).

4.3.5 Improper pressure retaining dimensions (minimum wall deviations) where weld repairs are not authorized.

4.3.6 Any damage, tampering, defect or deficiency in permanent plant equipment, installed by the Company, that will render it inoperable or unable to meet the original design requirements.

B. Any similar conditions in equipment installed by others shall be reported on a Contractor Problem Report per Procedure IX-57, not on an NCR.

4.3.7 Any inability to meet fit-up at closure joints on piping runs without the use of any external forces, as outlined in Project Procedure X-9.

4.3.8 Repairs for correction of damaged or nonconforming urethane liners.



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5.0 IMMEDIATE ACTION

- 5.1 When a nonconformance is discovered, an NCR shall be initiated and the item involved shall be segregated, when possible. The NCR Initiator shall obtain an NCR number from the NCR Controller. In accordance with Procedure XV-4, a QC Inspector/QC Tag Coordinator shall place a "Hold Tag" (Appendix G) on the item or adjacent to the operation (as in the case of welding). Simultaneous to the application of the Hold Tag, the QC Inspector/QC Tag Coordinator shall locate the applicable Field Process Sheet (Appendix E) or Field Weld Process Sheet (Appendix F), if one exists. It is the responsibility of the NCR Initiator (i.e. QC Inspector, Field Engineer etc.) to record the NCR number on the Process Sheet adjacent to the operation sequence step where the violation occurred. The NCR Initiator is also responsible for assuring that the Process Sheet is returned to the Document Verification Center (DVC). QC shall retain the responsibility for the application of Hold Tags which are controlled through the NC Log (Ref: Paragraph 12.1).
- 5.2 Prior to issuing an NCR number, the NCR Controller shall be furnished the following information: The Initiator's name and group identification; the NCR classification (major or minor); the BIP; the building; the unit; the system; and the description.
- 5.3 The NCR form shall be initiated in a timely manner in accordance with instructions contained in Appendix A and forwarded to QA for processing. When issued, a copy of the NCR will be forwarded to CDEG for inputting into the CDT.

6.0 LIMITED WORK AUTHORIZATION (LWA)

- 6.1 Limited Work Authorization (LWA) is the controlled release of an item which has a Hold Tag affixed.
- 6.1.1 The Hold Tag indicates the status of items placed on "Hold" as the result of a Nonconformance Report (NCR), etc. The purpose of the LWA Request is to permit specifically defined movement or unrelated work to proceed on an item affected by a Hold Tag, concurrent with resolution of the cause for the Hold. In no case shall the LWA Request authorize work which may affect, or be affected by the condition described in the initiating document (i.e. NCR). The LWA Request shall not allow work to proceed to a point which would render any immediately adjacent item inaccessible for inspection or restoration. For Major NCRs, these conditions shall be evaluated by JE&C prior to approval of the LWA Request.



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6.1.2 An LWA Request (Appendix J) will be prepared by the responsible Field Engineer. It shall delineate the specific LWA Request scope of work and cross reference document number(s) which are related to the Hold Tag.

- A. The responsible Field Engineer shall submit the LWA Request to the Chief Field Engineer, or his designee, and the QA Manager, or his designee, for review and approval.
- B. Upon approval as required in "A" above, the LWA Request, for Major NCRs only, shall be submitted to UE&C Responsible Site Engineer for review and approval.
- C. Each LWA Request for AS&E items shall be submitted to the AMI for his review prior to performance of work.

6.1.3 Upon approval of the LWA Request, the QA Manager, or his designee, shall initiate the LWA Tag. Suitable control logs, indicating LWA Request status shall be maintained by him. Any Field Process Sheet(s) which may have been withdrawn will be reviewed and revised, if necessary. The approved LWA Request will cover the scope of work, (i.e., the operations to be performed) and/or the "From" and "To" move locations. A copy of the approved LWA Request will be submitted to the field through the individual who requested it.

6.1.4 Concurrent with release to the field of an approved LWA Request, and prior to item work or movement, a QC Inspector will affix an LWA Tag (Appendix H) adjacent to the Hold Tag on any affected item(s).

6.1.5 After the LWA Request work has been performed, the LWA Request shall be forwarded to QC Inspection. Inspection and acceptance of LWA Request scope of work will be defined in procedures called out on applicable Field Drawings, Field Process Sheets, or on the LWA Request.

6.1.6 Upon completed inspection of the scope of work, the applicable QC Inspector will remove the LWA Tag and return it to the QA Office. At the QA Office he will sign off the original LWA Request signifying completion of work. All other documentation pertaining to the LWA Request scope of work shall remain with the Process Sheets.



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6.1.7 If action has been taken which allows removal of the Hold Tag prior to completion of the Request scope of work, the field copy of the LWA Request will be withdrawn by the QC Inspector. The Inspector will destroy the field copy of the LWA Request, remove the LWA Tag and Hold Tag and return them to the QA Department to enable updating of the respective logs. The Inspector will note on the original LWA Request the last element of work scope which was completed and sign the LWA Request as completed. All other documentation pertaining to the last element of LWA Request scope of work completed, shall remain with the Process-Sheet(s).

7.0 CONTRACTOR PROBLEM REPORT (CPR)

7.1 The Contractor Problem Report (CPR) shall be used to report a nonconforming/deficient condition that is the responsibility of another contractor or in another discipline area of responsibility. The CPR is directed to the applicable contractor's QA/QC organization for evaluation and possible conversion to an NCR. The report may be initiated by personnel having non-quality function responsibilities as well as personnel having quality function responsibilities.

7.2 Nonconforming conditions for equipment which has been turned over to STD but has not been "N" stamped shall be handled as follows:

7.2.1 Nonconformance reports shall be issued by the "NA" (Pullman) Certificate Holder for ASME Systems until they are "N/NA" stamped.

7.2.2 At the time of initiation of an NCR on "Turned-Over" ASME System, the Initiator shall notify the Startup Manager or designee of the NCR's origination. This notification may be by telephone, with the notifier documenting the telecon in the description section of the NCR. The telecon must denote the authorized STD representative's name and the date of notification.

7.2.3 Prior to placement of a "Hold" tag on the nonconforming condition, a STD Status Indicator (Appendix P) must be placed on the Hold tag by either STD or the applicable QA/QC organization. The status indicator will be considered STD's acknowledgement that they have been notified.

7.3 The Initiating group shall maintain a log which indicates when the CPR is issued and when it is closed. Verification shall take place when the closed CPR is returned.

7.4 CPR's that are initiated by others against Pullman items shall be controlled and maintained after receipt until they are resolved and closed. The QA Manager or designee shall evaluate each CPR. The Initiator shall be forwarded a copy of each closed CPR.

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8.0 PROCESSING AND EVALUATION OF NONCONFORMANCE REPORTS

- 8.1 The initiator, upon discovery of a condition believed to require a Nonconformance Report, shall initiate an NCR in accordance with this procedure (See Paragraph 5.0 and Appendices A & D) and forward it to the QA Manager's designee (QA-NCR).
- 8.2 Upon receipt, QA-NCR shall verify that Hold Tag(s) have been assigned. For instances where they have not, and are required, steps shall be taken to assign Hold Tag(s) and arrange for their application in a timely manner.
- 8.3 The NCR shall then be reviewed by QA-NCR and Engineering to determine if it is, or is not, a nonconforming condition requiring reporting as an NCR, or can be handled by other established methods.
 - 8.3.1 If this review determines that the condition does not warrant reporting as an NCR, or should be reported by other means (i.e.: non-Code reporting procedures), the NCR shall be voided per paragraph 14.0 of this procedure.
- 8.4 A nonconformance which requires reporting shall be reviewed for compliance with Appendix A requirements, and that it adequately and accurately describes the nonconformance and establishes the cause for its occurrence.
- 8.5 Engineering shall be responsible for stating the final disposition of Minor NCRs to include a detailed description of justification (as warranted) as noted in Paragraph 3.2.1. The QA Manager, or designee, shall be responsible for dispositioning minor NCRs for documentation type deficiencies involving correction or regeneration.
- 8.6 The proper signatures shall be obtained from the Chief Field Engineer (or designee), the QA Manager (or designee), and the ANI. The NCR Controller shall notify the ANI when the NCR is ready for review.
- 8.7 Distribution shall be made as required, and controlled through the use of the NC Log. Approvals shall be obtained as outlined in Paragraph 10.0.



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9.0 PROPOSING DISPOSITION OF NONCONFORMANCE REPORTS

9.1 The proposed disposition of a nonconformance will be reviewed by the Chief Field Engineer, or his designee, who will accept the recommendation of the originator (if provided) or propose a disposition of his own. The proposed disposition shall be reviewed for proper classification (i.e. Major or Minor per Para. 2.1) and for Code compliance by the QA Manager, or his designee. If in this review the QA Manager or his designee does not concur, the NCR will be returned for reevaluation and/or revision of the classification or proposed disposition. Acceptable Major NCR dispositions, and their limitations, are defined in 9.2 through 9.6, below. Acceptable Minor NCR dispositions are limited to Scrap, per paragraph 9.2 and Restoration (Rework) per Paragraph 9.5.

9.1.1 For nonconformances which do not meet Code requirements, the item may be scrapped, returned for replacement, restored or repaired to a Code acceptable condition.

9.1.2 For nonconformances which meet Code requirements, but deviate from Customer requirements, the item may be scrapped, returned for replacement, restored, repaired to bring it into specification or accepted to "Accept-As-Is".

9.1.3 Approved dispositions to NCRs will be documented and controlled in accordance with Para. 11.0.

9.2 "Scrap" Disposition or "Reject" with scrap instructions.

9.2.1 Scrap is normally defined as totally discarding an item or material. A "Scrap" disposition is used when a item does not meet Code and/or specification requirements and Repair or Restoration is impractical or impossible.

9.2.2 Upon receipt of an NCR dispositioned Scrap/Reject, the Field Engineer or his designee will assure that the material is marked "Scrap" and segregated for removal. He shall have the item discarded or returned to UE&C per Procedure VIII-2.

9.2.3 The Chief Field Engineer, or his designee, will initiate (or cause to be initiated) the required documents for replacement, if necessary.

9.3 "Return" Disposition, or "Reject" with return instructions.

9.3.1 Return is normally defined as requiring removal and shipment back to the originating party.

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9.3.2 Upon receipt of an NCR dispositioned Return/Reject, the QA Engineer responsible for Materials will arrange for the return of the item.

9.4 Repair Disposition

9.4.1 Repair is normally defined as the process of returning an item to an acceptable condition, in conformance with Code, drawing and/or specification requirement, but may not conform to the original design requirements.

9.4.2 When "Repair" disposition involves a changed or new Special Process requirement, new or revised Process Sheets shall be initiated per Project Procedures III-4 and VI-5. Work may commence when the required documents are prepared, approved and received by the Field Engineer.

9.4.3 Repair of Weld Metal Defects

A. Unacceptable field weld defects and base metal defects detected by those methods required by the applicable Code, shall be eliminated and repaired in accordance with Procedure JS-IX-14 or IX-71, as applicable.

B. In addition to the above requirements, all repair(s) of base metal defects shall be performed in accordance with NX-4450.

9.5 "Restoration" (Rework) Disposition

9.5.1 Restoration is normally defined as the process of restoring an item to an acceptable condition in conformance with Code, drawing and specification requirements using a previously approved procedure.

9.5.2 When "Restoration" disposition involves a changed or new Special Process requirement, the Company shall initiate new or revised Process Sheets per Project Procedures III-4 and VI-5. Work may commence when the required documents are prepared, approved and received by the Field Engineer.

9.5.3 A Documentation type deficiency shall be classified as a "Restoration" disposition when it is not related to customer supplied equipment.



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9.6 Accept-as-is Disposition (Synonymous with Use-as-is)

9.6.1 "Accept-as-is" is normally defined as the acceptance of a deviation when it can be established that the discrepancy will result in no adverse condition and the item will meet Code and Design Specification requirements.

9.6.2 Upon receipt of an NCR dispositioned "Accept-as-is" the QA Manager, or his designee, will arrange for removal of the Hold Tag.

10.0 FORMAL DISPOSITIONING/APPROVAL OF NCRs

10.1 All Major NCRs shall be reviewed, dispositioned and approved by UE&C as outlined in 11.0 below.

10.2 All Minor NCRs shall be reviewed, dispositioned and approved by the Chief Field Engineer and QA Manager as outlined in 11.0 below.

10.3 Disposition of all NCRs shall be reviewed by the QA Manager, or his designee and the ANI. This review will be performed and documented during the review and approval cycle of required process sheets per Project Procedure VI-5. The ANI shall also indicate review/concurrence in the "interdiscipline review" block of the NCR form.

10.3.1 ANI review is not required for non-code safety-related NCRs.

11.0 CONTROL OF DISPOSITION (INTERIM ACTION/WORKING TOWARD FORMAL DISPOSITION OF NCR)

11.1 Major NCR Dispositions

11.1.1 Disposition shall be documented by UE&C on a Nonconformance Report (NCR).

11.1.2 The original approved NCR and support documents will be transmitted to QA-NCRs. QA-NCR will record receipt of the dispositioned NCR in the QC Log and review the disposition for Code conformance. If acceptable, a copy of the NCR noted "INFO ONLY" shall be distributed per Procedure VI-1. A copy of the NCR shall be forwarded to the Company Engineering Department. After processing, the original NCR shall be forwarded to Records.

11.1.3 The Chief Field Engineer, or his designee, shall review the NCR per the requirements of Procedure III-4. NCR's affecting Field Drawing reproduces processed to the MCC/PCC shall be forwarded to the MCC/PCC as applicable per the requirements of Procedure III-4.



Pullman Power Products

XV-2

DOCUMENT NO

PREPARED BY: J. WALONEY

APPROVED BY: H. HINKLEY

MDH

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A. If the NCR affects Field Drawings for which the reproducible has been received and processed, then the NCR shall be forwarded to and processed by the MCC/PCC per Procedure III-4.

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11.1.4 If the NCR is rejected by Engineering or QA, QA-NCRs will process a revised NCR which states the reason(s) for rejecting the NCR. The revised NCR will be submitted to UE&C. UE&C will issue a revised disposition. Revised NCRs will be received and processed the same as the original. Original, rejected NCR's will be retained in QA Records. Each NCR revision shall be complete and will supercede prior revisions. All contents of the superceded NCRs which are still valid, shall be included in the revised NCR.

11.2 Minor NCR Dispositions

11.2.1 Disposition shall be documented by the Chief Field Engineer or his designee (or QA Manager per Paragraph 8.5) on the Nonconformance Report form (NCR). He shall include sketches as necessary.

11.2.2 QA-NCRs will enter the date of the disposition on the NC Log and review the disposition for Code compliance. If the disposition is acceptable, and is "restore", a Repair Tag will be prepared and applied by QC, per paragraph 11.4. Unacceptable dispositions will be returned to Engineering. "Information Only" copies of the NCR may be distributed per Procedure VI-1. A copy of the NCR shall be forwarded to the Company Engineering Department. The original NCR after processing, shall be forwarded to QA Records.

11.2.3 For Engineering, QA and AMI reviews, refer to paragraphs 11.1.3, 11.1.3 A and Procedure III-4. Dispositioned NCRs, if rejected by any of the reviews, shall be corrected by Engineering and re-reviewed.

11.3 Interim Action

11.3.1 Upon evaluation of an NCR for disposition, the Chief Field Engineer/UE&C may determine that complete disposition cannot be made without additional/supplemental information.

11.3.2 When such interim action is required, an NCR disposition shall be issued explaining in detail the scope of the interim action, including documentation requirements. If any "Interim Action" should be referenced in the Disposition, an interim disposition shall be processed the same as a normal dispositioned NCR except when interim action requires work to be done to hardware.



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IV-2

DOCUMENT NO

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A. When an interim disposition NCR affects hardware, only the scope of work required by the disposition shall be completed. At the completion of the required scope of work the responsible QC Inspector shall remove the Repair Tag and reapply a Hold Tag.

11.3.3 The completed interim disposition NCR Package shall be forwarded to the DVC. There the original Process Sheets will be pulled from the package and transmitted to Records. For supports, only Process Sheets which have been totally completed should be removed from the DVC package. "Information only" copies of the Process Sheets will be placed in the package, and the package will be forwarded to QA-NCRs.

11.3.4 QA-NCRs will revise the NCR to reflect the completion of the required interim action. The original NCR can then be closed based on the new revision. The revised NCR will be attached to the completed, interim disposition NCR package and processed under the same controls established for the original NCR.

11.4 Repair Tags

11.4.1 Upon receipt of a dispositioned NCR involving repair or restoration, QA-NCR shall notify the QC department that repair/restoration/other activity may be invoked through the timely application of a Repair Tag (Appendix K).

11.4.2 The responsible QC Inspector/Tag Coordinator shall obtain a QA/QC Repair Tag from the QA Supervisor, or his designee, who controls their issuance through maintenance of an NC Log.

A. Prior to issuing the tag, the QA-NCR Engineer, or his designee, shall complete the top portion of the Repair Tag and record the necessary information in the NC Log.

B. Work cannot proceed until a dispositioned NCR is issued (except by LxA). A Repair Tag shall be applied to the item in a timely manner prior to the start of work.

11.5 After completing the bottom of the Repair Tag (by signing and dating) the responsible QC Inspector shall remove the previously applicable Hold Tag and apply the Repair Tag in its place. The Hold Tag shall be returned to the authorized individual maintaining the NC Log as required in Puller Procedure 11.3, Paragraph 5.0.



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EV-2

DOCUMENT NO

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11.6 Upon satisfactory completion and follow-up inspection of the activities required to fulfill the disposition which invoked the Repair Tag, the responsible QC Inspector shall remove or forward the Repair Tag to the QA NCRs, so that the NC Log may be updated. After the log has been updated, the Repair Tag may be destroyed.

A. The Inspector removing the Repair Tag shall assure himself that any other action required by the NCR disposition Process Sheet, etc. has been performed and verified.

B. If work was performed to an interim dispositioned NCR, the QC Inspector shall reapply a Hold Tag to the affected item. (See Paragraph 10.3.2.A).

12.0 DOCUMENTING

12.1 The QA Manager, or his appointed NCR Controller, shall be responsible for the control of nonconformances. Through the use of the NC Log, the NCR Controller will assign NCR numbers. This log will also contain such information as initiator's name and date initiated, brief description of the nonconformance, NCR classification (Major or Minor), BIP, Building/Unit/System, Hold Tags applicable, Repair Tags applicable, and status information. NCR's and the NC Log shall clearly identify the official building abbreviation and unit designation. (See Appendix A)

12.2 Upon disposition of an NCR by UE&C or Chief Field Engineer as applicable, the QA Manager, or designee, shall retain a copy in QA Records, and forward copies to the Chief Field Engineer and the Construction Superintendent.

12.3 When the disposition actions are completed, verified and properly documented, QA Records will document these actions by completing the "Field work Complete" portion of the NCR and entering "N/A" signifying not required. In lieu of signature in the "Work Completed" and "Accepted/Rejected" portion of the NCR.

04/29/85

13.0 RECORDS

13.1 Records of all nonconformances and their disposition shall be maintained under the supervision of the QA Manager. NCR's shall be easily retrievable for review.

13.2 In the cases where disposition is to "Repair", records associated with the disposed item shall be properly noted as to disposition and retained.

13.3 In the cases where "Return for replacement" is decided, the records shall be returned to the item.



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13.7 A copy of each Field Work Complete/Void Minor NCR shall be forwarded to UE&C Central Data Entry Group (CDEG) for entry into the CDT.

14.0 VOIDING NONCONFORMANCE REPORTS

11/04/85

14.1 If it becomes necessary to void an NCR prior to dispositioning, it shall be voided only by the QA Manager, or his designee. It shall be stamped "Void" and the reason for voiding shall be identified in the "Disposition" section of the NCR along with the QA Manager (or designee) signature and date. The number assigned to the voided NCR shall not be reused.

14.2 Concurrence with the action shall be obtained from the Chief Field Engineer (or designee) when his previous review and signature was obtained (per paragraph 8.6). Concurrence shall be documented by signing and dating the voided NCR.

11/04/85

14.3 If the NCR is voided before disposition, it shall be distributed to each person or designee who had previously reviewed the NCR prior to it being voided. The QA Manager or designee shall forward a copy of the void NCR to the NCR originator and UE&C to account for the NCR number sequence.

11/04/85

14.4 If the NCR had been dispositioned by Engineering and distributed before being voided, the NCR shall be revised to void and processed in the same manner as the previous issue. "Issue Date" space shall be filled in.

11/04/85

14.5 If the NCR has been dispositioned "VOID" by UE&C Engineering (Major) or by P-H Engineering (Minor), such action shall require concurrence of the Chief Field engineer and the QA Manager or their designees and of the AHI. A new NCR shall be issued to include all valid NCR conditions which were voided by this action.

11/04/85

14.6 The initiator of an NCR which is subsequently voided shall be advised of the action, through issuance of an information copy of the voided NCR.

11/04/85

14.7 Voided NCRs containing the information specified in paragraphs 14.1, 14.2 and 14.4 above, shall be retained as permanent records.

11/04/85

14.8 The QA-NCR shall ensure that any Hold, LWA and/or Repair Tags, issued as a result of a voided NCR, are removed.

11/04/85

14.9 NCR control numbers are assigned upon initial reporting of suspected nonconforming conditions. After further evaluation, the originator may determine the condition not to be nonconforming and not requiring reporting as an NCR. In such cases, the originator will notify QA-NCR so that, if concurrence (per Paragraph 8.6) has not yet been obtained, the NCR control number may be deleted from the NC Log. Deleted NCR control numbers are not considered "voided" NCRs and the control numbers may be reused.



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IV-2

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15.0 REVISING MCRs

- 15.1 Technical changes shall be made and identified by revising the MCR, using a capital letter after the MCR number (ie: B is the first revision).
- 15.2 Changes shall be "clouded" with a delta revision letter next to the cloud.
- 15.3 Each MCR revision shall be complete and will supersede prior revisions. All contents of the superseded MCR which are still valid shall be included in the revised MCR.
- 15.4 MCR revisions shall be controlled, processed and dispositioned in the same manner as the original.
- 15.5 Any "Closed" or "Voided" MCR shall not be reopened or revised. If changes are necessary, a new MCR, referencing the original MCR number, shall be issued.

16.0 REVIEW AND STEPS TO PREVENT RECURRENCE

- 16.1 The QA Manager, or his designee, shall review all Major and Minor MCRs for implementation of appropriate remedial and preventative corrective action, per Procedure XVI-2.
- 16.2 In order to minimize the recurrence of repetitive MCRs, the QA Manager shall evaluate MCRs in accordance with the Pullman Procedure for Trend Analysis, XVI-3.



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INSTRUCTIONS FOR COMPLETING NONCONFORMANCE REPORT

The numbers used in these instructions are the same as the numbers shown on the sample form, Attachment 1.

04/29/85

1. REPORT TYPE/NUMBER

Indicate the type of report being dispositioned (NCR) (Major or Minor). The first two digits (Contractor ID) are the Contractor Discipline Codes. For Pullman, the code is "73". The next six characters are the NCR numbers which are assigned by NCR Controller. The last position is alpha for revision level. The initial issue shall be "A". The preparer shall obtain a number from the NCR-Controller of the NCR Group upon preparation of the NCR.

1/04/85

2. BUILDING, UNIT AND SYSTEM

Insert Building Code, Unit Code and System Code (Appendix A). If an NCR applies to both Units 1 and 2, or a building common to both units, indicate Unit 0. Codes shall be identical to those delineated in this appendix. Indicate whether the system or component has been turned over to STD (Yes or No).

3. CODE DESIGNATION

Mark the applicable box to show code designation.

11/04/85

4. CORRECTIVE ACTION REPORT

QA Engineer-NCR's will check applicable box if the nonconforming condition does or does not require a CAR to be initiated.

11/04/85

5. POTENTIAL SIGNIFICANT DEFICIENCY 50.55(e)

QA Engineer NCR's will check the "Yes" block only if they are certain the item meets the requirements of a potential or actual 10CFR 50.55(e). Engineering has the final responsibility to evaluate an NCR for a potential significant deficiency. The "No" block is reserved for Engineering use in their evaluation.

04/29/85

6. NONCONFORMANCE/DEFICIENCY DESCRIPTION

The DESCRIPTION section contains 92 shaded blocks which are used to concisely identify the item (i.e., Vessel Number or Pipe ISO, Line Number, the Line ID, the elevation (EL), and problem description). This is considered the essential NCR information and it must be planned to fit into the shaded blocks.

04/29/85

7. PREPARED BY

The preparer shall sign name, show title and print name and date.



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XV-2

DOCUMENT NO

PREPARED BY: J. MALONEY

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8. REVIEW AND APPROVAL OF NONCONFORMANCE/DEFICIENCY

The QA Engineer-NCRs shall clarify, if necessary, and approve the description of the nonconformance. The approver shall sign name, show title and print name and date.

04/29/85

9. DISPOSITION

The dispositioning engineer shall check applicable disposition action to be taken.

04/29/85

10. ACTION TO BE TAKEN BY

It is the Engineer's responsibility (UE&C for Major NCR/Pullman for Minor NCR) to assign the responsible Discipline/Contractor for implementation of the Disposition.

04/29/85

11. DISPOSITION SPACE

The disposition to Major NCRs shall be provided by UE&C. The disposition to Minor NCRs shall be provided shall be provided by Pullman Engineering and must be concise, accurate, and complete. Technical justification shall be included as applicable. The NCR disposition shall be reviewed for generic implications and retrofit requirements. If more space is required, additional sheets shall be added. Any sketches, letters, supporting documents, etc. shall be attached and added to the NCR by listing the NCR type and number and page (sequential) of (total no. of pages) on each page. Include the NCR form, as page 1, in the total.

04/29/85

12. KEYWORDS

Enter the BIP number only.

04/29/85

13. REFERENCE DOCUMENTS

Enter the applicable Pullman Procedure and revision level violated.

04/29/85

14. AFFECTED DOCUMENTS

The UE&C Engineer shall list all design documents and latest revision number covering the component specifically modified by the NCR disposition. Both units 1 and 2 documents shall be listed, if applicable.

04/29/85

15. INTERDISCIPLINE REVIEW

Interdiscipline review shall be performed by UE&C for Major NCRs. Interdiscipline review by UE&C of Minor NCRs is not required.



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RV-2

DOCUMENT NO.

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FORM

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16. REQUIRED SIGNATURES

Major NCRs

The UE&C preparer and checker of the disposition will print their names, sign, and date. A "UE&C Approver" will review the design, print his name, sign, and date the disposition. If Westinghouse or Y&EC (for Section XI) review is required, an approval signature and date will be obtained after required UE&C reviews have been completed.

04/29/85

Minor NCRs

The Engineer shall print name and date and sign the disposition of Minor NCRs. For spaces marked "checked by" and "approved by", enter N/A.

04/29/85

ASME NCRs

The ANI shall indicate his review of dispositioned ASME NCR's by signing and dating the ANI review signature line.

04/29/85

17. DISPOSITION DATE

Major NCR's

The UE&C Engineer (Approver) shall enter the date the NCR is issued for working disposition.

Minor NCR's

The QA Engineer-NCR shall enter the date the NCR is issued for working disposition.

04/29/85

18. WORK COMPLETED

(See 19 below.)

04/29/85

19. FIELD WORK COMPLETE

QA Records shall check and sign off this block once an NCR disposition has been documented, verified and accepted. QA Records shall also, at this time enter "N/A" in lieu of a title/signature/date in the "Work Completed" portion (Number 18) of the NCR.



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XV-2

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NO.

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LIST OF SYSTEM ABBREVIATIONS (From U&C DWG M-500006)

ABBREVIATION

SYSTEM

AAH	Administration Services Bldg. Air Handling
AB	Auxiliary Boiler (All Systems)
ACT	Acetyne
AM	Argon Methane
AN	Argon
AR	Condenser Air Evacuation
AS	Auxiliary Steam
ASC	Auxiliary Steam Condensate
ASH	Auxiliary Steam Heating
BRS	Boron Recovery System
BWR	Building Water Return --Guardhouse Heat Pump
BWS	Building Water Supply
CAS	Chemical Analysis & Addition System
CAH	Containment Air Handling
CAP	Containment Air Purge
CBA	Control Bldg. Air Handling
CBS	Containment Bldg. Spray
CC	Component Cooling Water Primary
CCW	Condenser Water
CD	Carbon Dioxide (ALL PLANT USAGE)
CGC	Combustible Gas Control
CHW	Chilled Cooling Water
CLA	Chlorination Building H & V
CO	Condensate
COP	Containment on Line Purge
CP	*Rod Control & Position
CPA	Check Point Air Cond. System
CL	Chlorination System
CS	*Chemical & Volume Control
CT	Chemical Treatment & Sec. Chemistry
CW	Circulating Water
CWA	CW Pump House Air Handling
CG	Compressed Gasses (ALL EXCEPT H2, N2, CO2)
DCV	Contaminated Waste Vent
DCW	Contaminated Waste



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ABBREVIATION

SYSTEM

DG	Diesel Generator (ALL SYSTEMS)
DGA	Diesel Gen. 1A (EQUIP. PKG.)
DGB	Diesel Gen. 1B (EQUIP. PKG.)
DAH	Diesel Generator Air Handling
DF	Drains Floor
DM	DeminerIALIZED Water
DR	Drains Roof
DS	Drains Sanitary
EAM	Containment Enclosure Air Handling
ED	Electrical Distribution
EDE	Electrical Distribution -- EMERGENCY
EHC	Turbine Electro Hydraulic System
EPA	Emer FW P House Air Handling
ES	*Electrical Systems
EX	Extraction Steam
FAH	Fuel Storage-Bldg. Air Handling
FH	*Fuel Handling - Reactor
FO	Fuel Oil
FP	Fire Protection
FPA	Fire Pumphouse Air Handling
ETA	Elec. Tunnel Air Handling
FW	Feedwater (INCL. *FC)
GAH	Guard House Air Handling
GSC	Generator Stator Coolant
HD	Heater Drains
HE	Helium
HF	Hydraulic Fluid for EHC
HT	Heat Tracing
HGG	Hydrogen Gas at Generator
HHD	G.E. Turbine Hydrogen Seal Oil Drain
HWR	Hot Water Heating Return
HWS	Hot Water Heating Supply
IA	Instrument Air
IC	*Incore Instrumentation
IH	Isobutane - Helium
LO	Lube Oil (ALL APPLICATIONS INCL. PURIFICATION)
LD	Leak Detection System
MAP	Map Gas
MD	Moisture Sep. & Reheater Drains
ME	Miscellaneous (NOT SYS. ORIENTED) EQUIP.
MS	Main Stream (INCL. TURB. BYPASS STEAM)
MSS	Mechanical Seal Supply
MSD	Main Stream Drains
MVD	Miscellaneous Vents - Drains -



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ABBREVIATION

SYSTEM

NG	Nitrogen Gas
NI	Nuclear Instrumentation
NO	Nitrous Oxide
OG	Oxygen
PAC	Public Address Communications
PAH	PAB Air Handling
PAM	Post Accident Monitoring
PP	Propane
PW	Potable Water - CITY WATER
PWH	Potable Water - HOT
PWR	Potable Water - RECIRCULATING
RC	*Reactor Coolant
RH	*Residual Heat Removal
RM	Radiation Monitoring
RMW	Reactor Make-Up Water
RS	Resin Sluicing
SA	Service Air Systems
SAA	Service Air C-4A (EQUIP. PKG.)
SAB	Service Air C-6B (EQUIP. PKG.)
SAC	Service Air C-1A (EQUIP. PKG.)
SAD	Service Air C-1B (EQUIP. PKG.)
SAE	Service Air C-1C (EQUIP. PKG.)
SAH	Sanitary Sewer
SB	Steam Generator Blowdown
SC	Station Info. & Alarm Computer
SCC	Secondary Component Cooling
SCW	Screen Wash Water
SF	Spent Fuel Pool Cooling
SGA	Non-Essential Switchgear Air Handling
SI	*Safety Injection
SO	Seal Oil-Generator
SPC	Sound Powered Communications
SY	Switchyard
SM	Seismic Monitoring System
SS	Sample System
SSS	Turbine Steam Seal System
STO	Storm Sewer
Sw	Service water
SwA	Sw Pump House Air Handling
Tan	Turbine Bldg. Air Handling
TDA	SGRP Turbine Drive A (EQUIP. PKG.)
TDB	SGRP Turbine Drive B (EQUIP. PKG.)
T-	Turbine Generator
TPC	Telephone Communications
TSI	Turb. Supervisory Instrumentation



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IV-2

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ABBREVIATION

SYSTEM

WAH	Waste Processing Air Handling
VG	Vents
WG	Waste Processing - GASEOUS
WL	WP - LIQUID
WLD	WP - LIQUID DRAINS (ALL TYPES)
WS	WP - SOLID
WT	Water Treatment
WW	Well Water
XI	Process Instrumentation
VB	Vibration Monitoring System
NSA	No System Applicable

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LIST OF BUILDING ABBREVIATIONS

ABBREVIATION

BUILDING

AB	Administration and Service Building
AT	Architectural Treatment
BD	Blow Down
CD	Control and Diesel Generator Building
CE	Containment - Enclosure Building
CI	Containment - Internals
CL	Chlorination Building
CS	Containment - Structure, Including Seismic Analysis
CT	Service Water Cooling Towers
CH	Service and Circulating Water - Pump House
EF	Aux. Feedwater House & Electrical Penetration Area
EM	Tunnels - Pipe, Electrical and Passage
FB	Fuel Storage Building
FF	Fire Pump House and Tanks
GC	General Construction
S	Guardhouse
MA	Miscellaneous Areas
MP	Mainsteam and Feedwater Pipe Chase and Pipe Bridge
MT	Yard Tanks and Missile Shields - Yard work
PA	Primary Auxiliary Building
SE	Non-Essential Switchgear Room
SS	Substation
SW	Site work - Excavation, Grading, etc
TA	Main and Auxiliary Transfer Area
TB	Turbine Building
TC	Service and Circulating Water - Marine work
TE	Service and Circulating Water - Tunnels
WP	Waste Process - Including Tank Farm Area



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IV-2

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(1 cont'd)

NONCONFORMANCE REPORT CONTRIBUTION SHEET REVISION

(12)

PROPOSED	
NO	DESCRIPTION

REFERENCE DOCUMENTS			
NO	DESCRIPTION	DATE	REV

(13)

APPROVED EXCLUSIONS			
NO	DESCRIPTION	DATE	REV

(14)

Disclaimer: This information is not to be used as a CSF basis. The user is only to refer to the information.

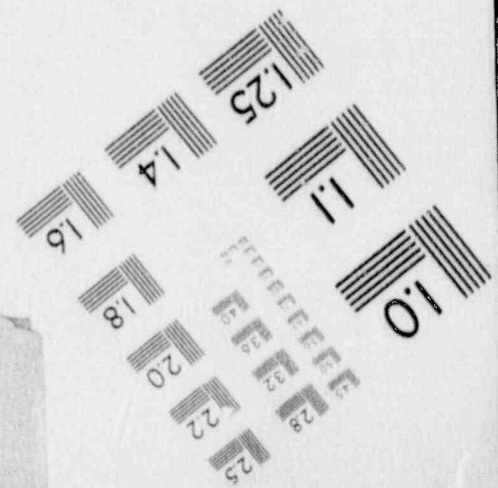
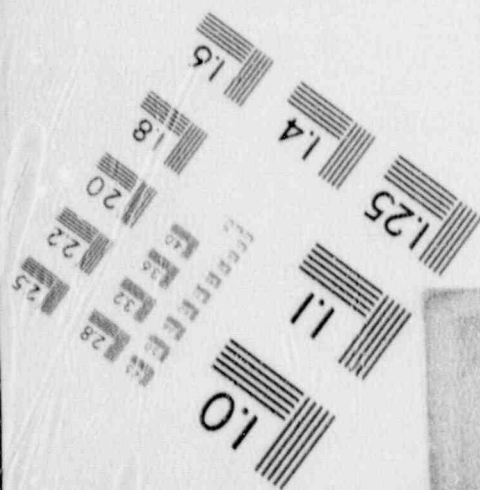
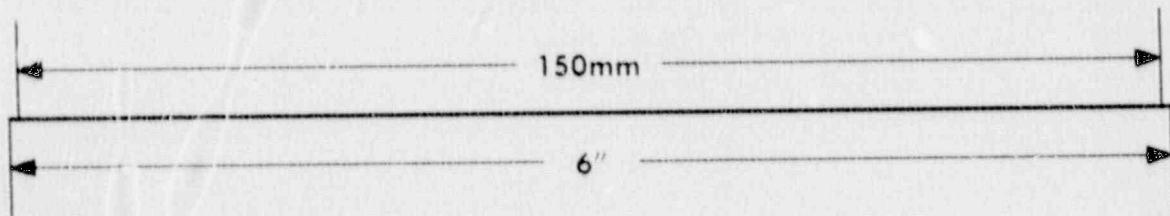
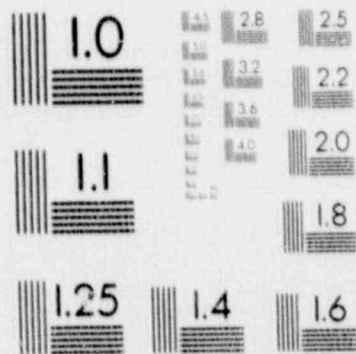
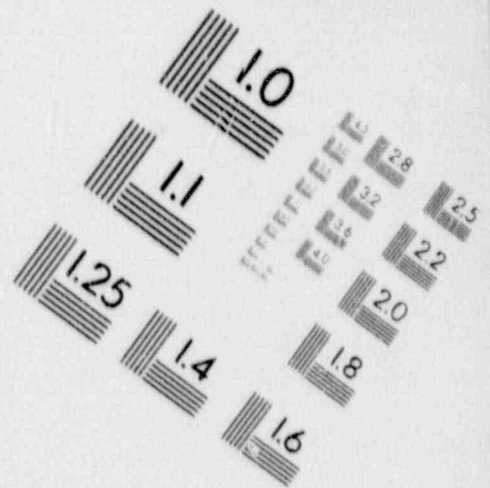
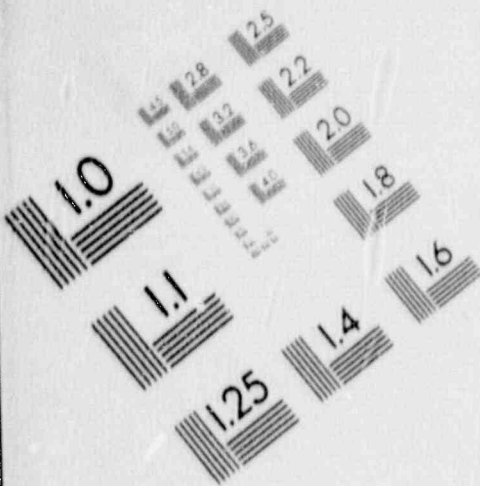
(6)

Disclaimer: This information is not to be used as a CSF basis. The user is only to refer to the information.

(11)

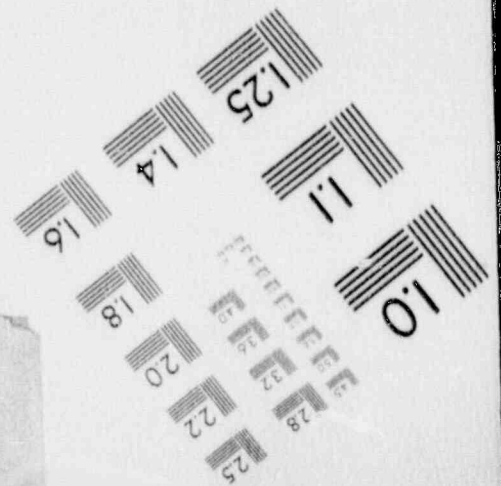
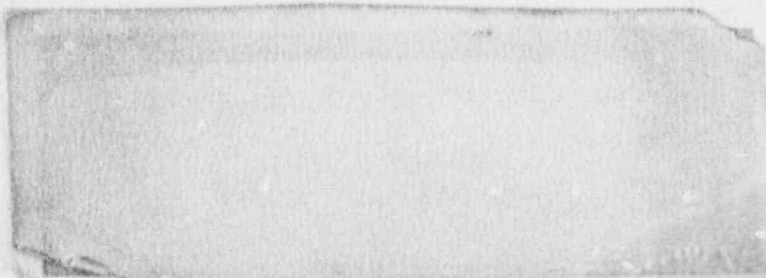
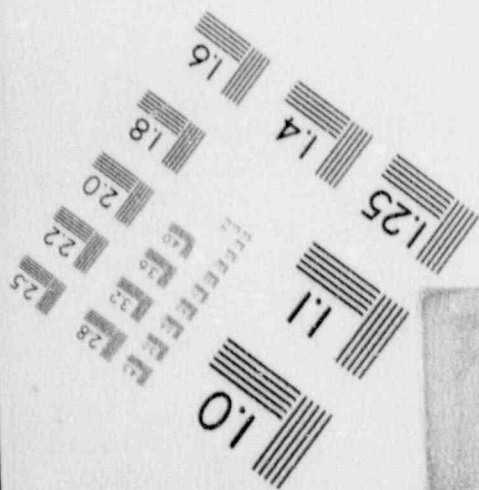
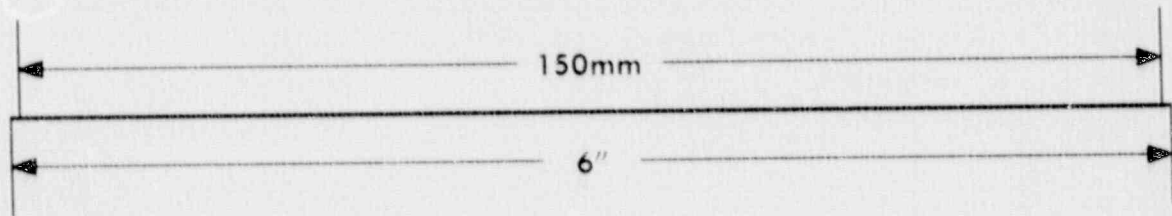
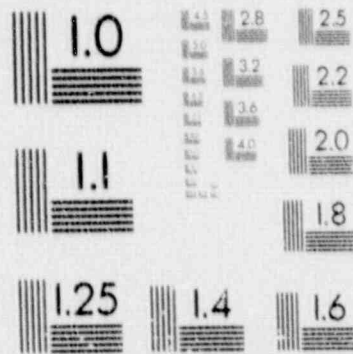
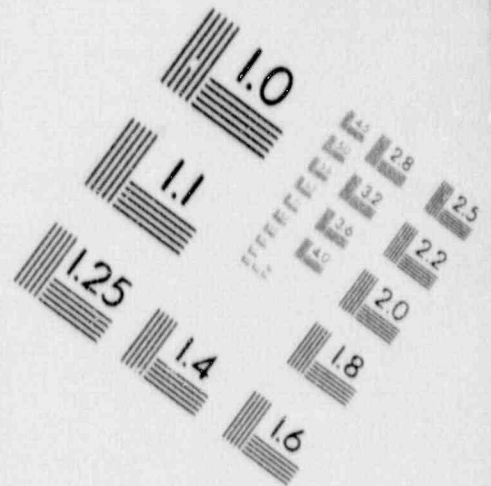
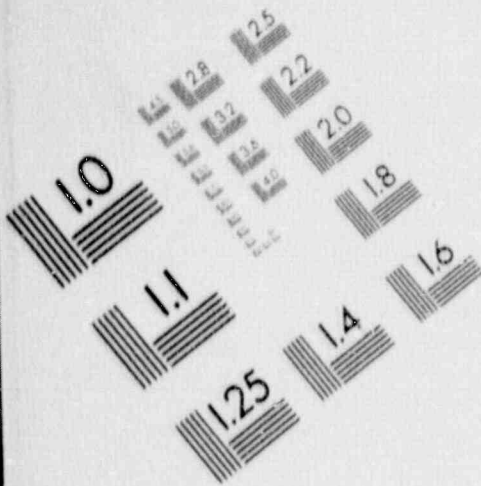
1

IMAGE EVALUATION TEST TARGET (MT-3)



1

IMAGE EVALUATION TEST TARGET (MT-3)





Pullman Power Products

EV-2
DOCUMENT NO

PREPARED BY: J. MALONEY

APPROVED BY: H. HINLEY

ISSUE DATE: 12/28/84

SEABROOK
PROJECT PROCEDURE

TO BE USED
ONLY ON JOB # 7035

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01-01-12

JOB NO. <u>7035</u>	PO <u>201</u>
ITEM NO. <u>U.218</u>	HEAT OR SERIAL NO. <u>K-1246</u>

HOLD

NCR 3512

DATE 2/17/83

- HOLD FOR INSPECTION
- WAIT FOR TEST REPORT
- WAIT FOR - NCR - REPORT
- RETURN TO VENDOR
- WAIT FOR ENGINEERING SPEC OR DRAWING CLARIFICATION
- _____ INSPECTED BY IG/ldm

DISPOSITION

Return on Hold Disposition reports
are returned and advised

man - 3512 - N/A

SSF-36 (2/17/83)



Pullman Power Products

KV-3

DOCUMENT NO

PREPARED BY: J. MALONEY

APPROVED BY: H. BINKLEY

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PULLMAN POWER PRODUCTS
SEABROOK STATION

LIMITED WORK
AUTHORIZATION

001

ITEM IDENTIFICATION

SW-1818-01

Spauld Piece 2518-316

~~SECRET~~
SECRET OF LWA

To Complete Field
Weld F0106

APPLICABLE FOR
JOB NO. 7035 ONLY

QA INSP Zickler DATE 5-7-79

TO BE ATTACHED OR REMOVED
BY QC PERSONNEL ONLY

557-58 (1-13-83)



Pullman Power Products

IV-2

DOCUMENT NO.

PREPARED BY: J. MALONEY

APPROVED BY: H. HINKLEY

HOW

ISSUE
DATE:

12/28/84

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PROJECT PROCEDURE

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LWA COMPLETION

NOTE: Contractor may use his own tag which status "Limited Work" OR "Repair" to a nonconforming/deficient condition.

1. QA shall assign the LWA number
2. Initiator shall list the related NCR
3. The initiator shall list related drawings and specifications
4. The initiator shall enter "Pullman" in PO/Contractor box
5. The initiator shall fill in the key words
6. The initiator shall fill in the reason for request and the organization requesting the request
7. Initiator for LWA shall have individual responsible for disposition of NCR approve and list the limitations and precautions, as applicable
8. QA Manager or designee shall approve and issue
9. The LWA requestor shall sign ACTION COMPLETE when the work stipulated on the LWA is complete
10. Signature of QA/QC person verifying ACTION COMPLETE
11. If the ACTION COMPLETE block is not signed off prior to NCR closure, the LWA will be closed based on the NCR closure



Pullman Power Products

XV-2
SECTION NO.

PREPARED BY: J. MALONEY

APPROVED BY: H. HINKLEY

KDH

DATE: 12/28/84

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PULLMAN POWER PRODUCTS

SEABROOK STATION Job 7035

QA/QC REPAIR

TAG #

15

REWORK

SAMPLE

REPAIR

OTHER ACTIVITY

APPLICABLE FOR
JOB NO. 7035 ONLY

NCR #

753

HOLD TAG #

1015

REMARKS

REPAIR SHOWN EVIDENCE

QA/QC INSPECTOR

[Signature]

DATE APPLIED

SEP-84 14-12-84

(COLOR-BLUE)

OF 106 07-84



PREPARED BY: J. MALONEY

APPROVED BY: H. HINKLEY

MDM

ISSUE DATE: 12/28/84

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PROJECT PROCEDURE

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STANDARD REPAIR SPECIFICATION No. 1

for

DAMAGED CEMENT LINING *

BACKGROUND

Selected classes of prefabricated piping contain a cement lining which may become damaged during construction activities. The repair of their lining may be conducted in accordance with this specification.

DESCRIPTION OF THE CONDITION TO BE REPAIRED

Cement lining has cracks which exceed specification allowances ($1/32"$), is loosened, missing or otherwise damaged or which in the contractor's judgement is not sound. Use of this specification is limited to areas less than the full circumference of the pipe for a length along the pipe equal to 3 pipe diameters. Larger areas requiring repair shall be documented by nonconformance report.

STANDARD REPAIR CRITERIA

Single cracks up to $1/16"$ in width wherein cement lining appears to be tightly bonded to pipe may be accepted as-is.

Cement lining containing cracks wherein the lining appears not to be tightly bonded to the pipe shall be removed as required and shall be replaced by application of Sikadur Low-mod gel. Sikadur gel to be applied in accordance with the requirements of Pullman Procedure IX-30 (FP-42268) reflecting the requirements of Spec. 248-51. Interior finish of cement lining to be blended smoothly with the contour of existing cement lining.

Following completion of cement lining repair, conduct a visual inspection utilizing the inspection check list for cement lining and grouting as contained in the referenced procedure.

Record the location and extent of repairs on documents to be submitted to UE&C Construction Manager for record purposes.

TECHNICAL JUSTIFICATION

Acceptance of cracks up to $1/16"$ do not violate manufacturer's recommendation. Cracking in excess of specification tolerances is possible due to the extension of long term storage period beyond anticipated 6 months.



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IV-2

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7035

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Repair of loose cement lining is required to obtain tightly adhering bond between pipe and lining to preclude subsequent lining failure.

Repair in accordance with approved procedures does not jeopardize material quality or system design criteria.



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XV-2

DOCUMENT NO.

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APPROVED BY: M. HINKLEY

ISSUE DATE:

12/28/84

SEABROOK
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STANDARD REPAIR SPECIFICATION NO. 2

for

IMPROPER WELD PREP COUNTERBORE TRANSITION

BACKGROUND

The piping fabricator is permitted to perform a "skim cut" counterboring operation on end preparations which otherwise do not require a counterbore but because of minor ovality in the pipe, the end prep land cannot be satisfactorily applied. "Skim cutting" of this nature was not recognized by project specifications prior to the issuance of ECA 19/0153A and selected pipe spools may arrive onsite with end preps containing the "skim cut" when it is not called for by the end prep detail drawings. This type of apparently improper end prep shall be repaired in accordance with this specification. Also the pipe fabricator on occasion has not conformed to Dwg. 5000-F-1382 for transition angles.

DESCRIPTION OF THE CONDITION TO BE REPAIRED

Undocumented presence of a counterbore where not called for by end preparation details. Counterbore usually contains a sharp transition to nominal pipe inside diameter which violates code thickness transition criteria. Or, counter-bore transition did not conform to Dwg. 5000-F-1382 or applicable code.

STANDARD REPAIR CRITERIA

Installing contractor shall confirm that the end preparation, other than the counterbore is acceptable. The counterbore may be left as-is but the transition to the nominal pipe I.D. shall be ground as required to meet applicable code requirements for transitions. Care shall be taken to preclude injury to the pressure boundary. No appreciable reduction of wall thickness is permitted.

Following grinding, the affected area shall be examined visually, and by suitable surface exam technique (MT or LP). A wall thickness measurement shall be conducted where visual exam reveals potential wall thinning. Wall thickness less than T_m as shown in Dwg. 5000-F-1382 shall be reported via nonconformance report.

TECHNICAL JUSTIFICATION

The existence of transition angles which do not comply with Dwg. 5000-F-1382 are not injurious provided it complies with code requirements for transition angles. Repair as described herein accomplishes code compliance without jeopardizing material quality or system design criteria.

REF: ECA 19/0032



Pullman Power Products

ZV-2

DOCUMENT NO.

PREPARED BY: J. MALONEY

APPROVED BY: M. HINKLEY

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SEABROOK
PROJECT PROCEDURE

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STANDARD REPAIR SPECIFICATION NO. 3

for

DAMAGED EXTERNAL COATING & WRAPPING

BACKGROUND

The external coating and wrapping on pipe received on site may become damaged due to shipping, handling or storage operations. The repair of damaged coating and wrapping shall be conducted in the field in accordance with the requirements specified herein.

DESCRIPTION OF THE CONDITION TO BE REPAIRED

Visible damage to external coating & wrapping, or its failure to pass electrical holiday detector examination. Where damage to the coating is contiguous with damage to the pipe pressure boundary, the pipe condition shall be reported and repaired in accordance with a contractor nonconformance report prior to commencing and coating repairs.

STANDARD REPAIR CRITERIA

Field repairs to external coating and wrapping shall be conducted in accordance with approved procedures reflecting the requirements of article 3.5.5 of specification 9763-248-51.

As an alternate, field repairs may be conducted in accordance with approved contractor procedures for application of hot-applied tape coatings such as Tapecoat 20 or engineer approved equal.

TECHNICAL JUSTIFICATION

Sound external coating and wrapping is required for proper corrosion protection of pipe pressure boundary. Repair in accordance with approved procedures does not jeopardize material quality or system design criteria.

PREP. COA 10/0032



Pullman Power Products

IV-2

DOCUMENT NO.

PREPARED BY: J. MALONEY

APPROVED BY: H. HICKLEY

NO.

ISSUE DATE:

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PROJECT PROCEDURETO BE USED
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7035

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STANDARD REPAIR SPECIFICATION NO. 4

for

MINOR DAMAGE TO PIPE WELD END PREPARATIONS *

BACKGROUND

Due to some manufacturing processes as well as handling and shipping, pipe weld end preparations may be received on site with minor end preparation damage. In certain cases, the damage may be inconsequential enough so as not to jeopardize base or weld material or impair joint fit-up and weld out provided a single repair is performed. In these instances, repair may be made and welding continued in accordance with the criteria of this specification.

DESCRIPTION OF THE CONDITION TO BE REPAIRED

Any damage to a pipe weld end preparation which can be accommodated by the welding operator without appreciable additional risk to the successful completion of the weld. Mild grinding may be used but weld repair is prohibited (except to replace backing rings).

Examples of these conditions are:

- a. Machined end preparation which is out of round because the fabrication process clamped the pipe during machining.
- b. A small irregularity in the machined area which does not require weld repair.
- c. Insufficient counterbore length.
- d. A bent backing ring which can be straightened without weld repair or which can be replaced.
- e. Blend grind performed on counterbore transitions for the purpose of achieving the required code counterbore.

STANDARD REPAIR CRITERIA

Normal fit-up clamps may be used to round up a end preparation to achieve fit-up. Excessive force resulting in permanent deformation or local irregularities in the pipe and hydraulic jacking are prohibited.

* REF: ECA 19 0232



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IV-2

DOCUMENT NO

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PROJECT PROCEDURE

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STANDARD REPAIR CRITERIA (continued)

Any inconsequential dent or other irregularity in a machined surface which after grinding or buffing would not affect base material thickness or impair the welding operator's ability to perform a sound weld may be repaired accordingly. Weld repair is prohibited. All grinding shall be followed by appropriate surface examination.

Where a counterbore does not extend sufficiently far into a spool it may be re-machined in the field to the original specifications. All remachined areas shall be followed by surface examination and wall thickness measurements.

Bent backing rings may be straightened by use of hand tools. Heating and peening is prohibited. As an alternate, a damaged backing ring may be removed and a new one conforming to the applicable material specification may be installed. Removed tack welds shall be ground flush and given a surface examination. Any reductions in wall thickness is prohibited.

TECHNICAL JUSTIFICATION

The conditions described herein are minor in nature and are readily recognized and repaired without risk of additional damage to the fabrication. Repair as described herein does not jeopardize material quality or system design criteria.



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XV-2

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SEABROOK
PROJECT PROCEDURE

TO BE USED
ONLY ON JOB # 7035

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STANDARD REPAIR SPECIFICATION NO. 5

for

MATERIAL LOST IN THE FIELD *

BACKGROUND

Occasionally an item received onsite cannot be located and retrieved from the Contractor's storage facility. Some of these items are readily replaceable from field bulk stock.

DESCRIPTION OF THE CONDITION TO BE REPAIRED

An item known to have been received on site but which cannot be retrieved from the Contractor's storage facility.

STANDARD REPLACEMENT CRITERIA

A lost item may be replaced with a new item taken from undesignated field stock provided:

- 11/04/85 a. For ASME or similar code items, the replacement item exactly duplicates the lost item or is of higher quality.
- 11/04/85 b. The item is not a part of an N-Stamped component. Parts of N-Stamped items shall be replaced per ASP-9.
- c. The replacement item possesses the same or higher documentation.
- d. The replacement item is retagged, where appropriate, in accordance with the approved site procedures.

Should a lost item be retrieved after a replacement has been installed, the item shall be placed in field stock.

TECHNICAL JUSTIFICATION

Replacement of lost material with an exact duplicate taken from field stock does not jeopardize material quality or system design criteria.

* REF: ECA 19/0232



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8V-2

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PROJECT PROCEDURE

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STANDARD REPAIR SPECIFICATION No. 6

for

RELOCATION OF CODE DATA PLATES AND COMPONENT I.D. PLATES *

BACKGROUND

ASME Section III components and other pre-purchased materials may have code data plates or component identification plates attached. Where the location of the code data plates is in conflict with project requirements or where modification to pipe spools or components causes the code data plate to be discarded, the plates may require relocation in the field in accordance with the requirements specified herein.

DESCRIPTION OF THE CONDITION TO BE REPAIRED

The presence of a code data plate or component I.D. plate which either is in a location which is unserviceable because of interference or has been completely removed due to pipe spool or component modification.

STANDARD REWORK CRITERIA

For welded attachments, remove the data plate(s) by grinding with a mild grinding wheel in a manner which precludes injury to the pipe pressure boundary. Blend the ground area to the contour of the surface.

Conduct an examination to assure that grinding does not reduce the wall thickness below the minimum thickness (T_m) as stated on UFGC DWG. 5000-F-1382 for piping or more than 5% of nominal thickness of other members. This examination may be a visual examination using a straight edge held against the contour of the pipe to verify that grinding does not result in a appreciable reduction of the wall thickness. Where this examination is not conclusive, a UT wall thickness measurement shall be conducted.

04/29/85

Conduct a surface examination of all areas affected by the grinding operation for ASME Class 1, 2 & MC only; MT examination for ferromagnetic materials, RP examination for others. Removal areas on Class 3 materials need only be visually examined.

All NDE shall be performed by qualified Quality Assurance inspectors.

For riveted attachments (allowed in pipe support components only) the removal and reinstallation of rivets shall be per approved contractor procedures in accordance with the rivet manufacturer's instructions.

* REF: ECA 19/0232



Pullman Power Products

IV-2

DOCUMENT NO.

PREPARED BY: J. MALONEY

APPROVED BY: H. HINKLEY

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Relocate the data plate(s) in accordance with the following criteria:

In Piping:

- a. Review UE&C support isometric drawings and support detail drawings to select a location of the spool which will not interfere with a support.
- b. Review applicable sleeve drawings to select a location not within a sleeve.
- c. Review Dravo fabrication sketches and isometric sketches to determine if the affected pipe spool is to be subjected to in-service inspection. If not, select a convenient new location for the plate(s). If in-service inspection is required, select a new mounting location which satisfies the criteria of 9763-IS-1 titled Design Guidelines for In-Service Inspection of Piping Systems.
- d. If the data plate(s) are welded at the new location then treat the data plate(s) as a minor permanent attachment and follow the rules of WB/NC/ND-4635 for ASME piping. The code data plate may be reattached to the component by stainless steel bands with the approval of the ANI.
- e. As an alternative to a. through d. above code data plates removed due to an interference need not be reattached; however, the positive identification and traceability requirements of paragraph 10.1, Procedure X-21 shall apply.

IN SUPPORT COMPONENTS

- a. Review the support design detail drawing and select a convenient location which satisfies the access criteria.

In all cases, the plate shall be readily visible for examination. Plates shall be oriented in a workmanlike manner leaving their top edge either parallel or perpendicular to the major axis of the member. All work shall be in accordance with approved procedures.

Identify the exact location of the relocated data plate on as-built drawings. ** As-built location and drawing to be verified by authorized nuclear inspection.

TECHNICAL JUSTIFICATION

The location of data plates is arbitrary, provided it satisfies the criteria referenced herein. Relocation (rework) in accordance with the Code as described herein per approved procedures does not jeopardize material quality or system design criteria.

** The location of the Data Plate may be established/identified by use of an On-the-Spot ICA. REF: Project Procedure II-4.

11/04/85

11/04/85



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SV-2
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APPROVED BY: H. HINCKLEY

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PROJECT PROCEDURE

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NO. 1 of 1

11/04/85

CONTRACTOR PROBLEM REPORT

Director's Organization		CPB No.	Issued To:	Contract No.
Item Identification:		Location:	Qty.	of
			of	
Description of Problem:				
Generated By: _____				
	Title	Signature	Date	
Evaluation:				

	Title	Signature	Date	
The following action has been taken:				
DISCREPANCIES:				
<input type="checkbox"/>	W's Co.			
<input type="checkbox"/>	DE Co.			
<input type="checkbox"/>	O/A			
Approved By: _____				
	Title	Signature	Date	

FD-357 (Rev. 01-27-83)



Pullman Power Products

XV-2

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PREPARED BY: J. MALONEY

APPROVED BY: M. HINKLEY

MDH

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PROJECT PROCEDURE

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NO. 1 of 1

STD Status Indicator

THIS EQUIPMENT
UNDER START UP
JURISDICTION

← BLUE

SSF-346 (12/12/86)



Pullman Power Products

SV-2
DOCUMENT NO

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APPROVED BY: H. HINKLEY

IDM

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PROJECT PROCEDURE

TO BE USED
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1 of 1

4/29/85

Pullman Power Products

(B)
NONCONFORMANCE REPORT

(A)

(1a)	(1b)	(1c)	(1d)	(1e)	(1f)	(1g)
(2a)	(2b)	(2c)	(2d)	(2e)	(2f)	(2g)
(3a)	(3b)	(3c)	(3d)	(3e)	(3f)	(3g)
(4a)	(4b)	(4c)	(4d)	(4e)	(4f)	(4g)
(5a)	(5b)	(5c)	(5d)	(5e)	(5f)	(5g)
(6a)	(6b)	(6c)	(6d)	(6e)	(6f)	(6g)
(7a)	(7b)	(7c)	(7d)	(7e)	(7f)	(7g)
(8a)	(8b)	(8c)	(8d)	(8e)	(8f)	(8g)
(9a)	(9b)	(9c)	(9d)	(9e)	(9f)	(9g)
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(13a)	(13b)	(13c)	(13d)	(13e)	(13f)	(13g)
(14a)	(14b)	(14c)	(14d)	(14e)	(14f)	(14g)
(15a)	(15b)	(15c)	(15d)	(15e)	(15f)	(15g)
(16a)	(16b)	(16c)	(16d)	(16e)	(16f)	(16g)
(17a)	(17b)	(17c)	(17d)	(17e)	(17f)	(17g)
(18a)	(18b)	(18c)	(18d)	(18e)	(18f)	(18g)
(19a)	(19b)	(19c)	(19d)	(19e)	(19f)	(19g)
(20a)	(20b)	(20c)	(20d)	(20e)	(20f)	(20g)

157 101 85-24-85

JOB NO.		PURCHASE ORDER		FOREIGN PRINT NO.		VENDOR DRAWING OR DOCUMENT NO.		REV NO.		C.D.		P.D.	
8-7-50		348005		144972211		BRXIV-2		22219					
DESCRIPTION										VENDOR'S NAME			
PROC HAND NONCONF										LVM WRK AUTH-FIELD			
LINE 1										LINE 2			
LETTER TO VEBC										CHECK D			
VEBC LOG-IN DATE		CLIENT'S REVIEW TO CLIENT		LEBC REVIEW FROM CLIENT TO VENDOR		FINAL DISTRIBUTION DATE				CHK		CHK	
35-24		35-24		35-24		35-24				35-24		35-24	
35-803052085 TO 2744 TV 33915										SPN			
UNITED ENGINEERS & CONSTRUCTORS INC. Standard may be printed throughout the world... in all parts of the world... in all parts of the world... in all parts of the world...										<input checked="" type="checkbox"/> PROCEED AS PER PD ON... <input type="checkbox"/> REVISIONS... <input type="checkbox"/> SEND UNAPPROVED... BY: [Signature] DATE 6-1-85			