



Pullman Power Products

XV-2

INITIALS BY: R.G. DAVIS

APPROVED BY: H. HINKLEY

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SEABROOK PROJECT PROCEDURE

TO BE USED ONLY ON JOB #

7035

LATEST REV. DATE
3/5/82

PROCEDURE FOR HANDLING
NONCONFORMANCES (FIELD)

PART OF F.P. 41497 13

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PULLMAN POWER PRODUCTS

RECEIVED
U.E. & C. INC.

MAR 18 1982

UEKC
CODE

13

HEADQUARTERS AT

WILLIAMSPORT, PENNSYLVANIA

SEABROOK
STATION

REVISION	PREPARED BY	APPROVED BY	INITIALS	DESCRIPTION
03 6/22/79	R.G. Davis	H. Hinkley	MDH	Extensively Revised for Seabrook
04 8/24/79	R.G. Davis	H. Hinkley	MDH	Revised para. 6.1, 7.1.2, 7.1.3, 7.1.6, 8.2.1, 8.2.2, App. C Line 11; Added para. 6.2, 7.1.7; Deleted para. 6.1.1, 6.1.2 & 6.1.3
05 1/18/80	R.G. Davis	H. Hinkley	MDH	Added para. 7.1.2.B
06 2/8/80	D. Walker	H. Hinkley	MDH	Revised para. 7.1.2.B
07 7/6/80	R.G. Davis	H. Hinkley	MDH	Added para. 4.1.1.A, A1, B.C.D, 4.1.2; Revised para. 4.1.1 & App. L
08 9/19/80	C.R. Geske	H. Hinkley	MDH	Revised para. 8.1, 11.1, App. C; Corrected typos 7.1.2, 8.4.3A, 9.5.1; Added para. 6.3
09 12/9/80	R. Donald	H. Hinkley	MDH	Added Section 8.6, App. N & O; Revised para. 7.1.3, 7.1.5, 7.1.6 & 7.1.7
10 7/1/81	R. Donald	H. Hinkley	MDH	Revised Appendix K
11 9/24/81	H. Hinkley	A.A. Eck	AAE	Added Appendix O, R, S, T, U; Revised para. 4.2.1 & 6.2
12 12/15/81	H. Hinkley	A.A. Eck	AAE	Revised para. 4.0.1, 4.3, 7.1.4, 7.1.6, 7.1.7 & Appendix Q thru U
13 3/5/82	H. Hinkley	A.A. Eck	AE	Added page 2 of Appendix T

SF 1.01 (02-79)



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DOCUMENT NO.

6/22/79

TECHNICAL
PROJECT PROJECT FORM

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MR/

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1.0 TITLE

1.1 This procedure defines the necessary action required to process nonconformances, NCR's, in accordance with Section XV of the Company's Quality Assurance Manual.

2.0 POLICY

2.1 Nonconformances in items may be detected at Source Inspection, Receiving Inspection, In-Process Inspection during fabrication or installation, at Final Inspection or during testing.

3.0 RESPONSIBILITY

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

3.2 The Field QA Manager 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.

4.0 APPLICABILITY OF NONCONFORMANCE REPORT (NCR)

4.1 Unacceptable conditions will exist that do not require an NCR. These conditions can be corrected at the time of discovery under the control and to the satisfaction of the inspector, or which will be corrected during the course of subsequent operations as outlined on the Process Sheet

7/8/80

4.1.1 Unacceptable conditions may be removed by additional grinding or machining, provided the requirements of subparagraph A thru D below are met. In the event they cannot, they shall be handled as described in paragraph 4.2.

7/8/80

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

7/8/80

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

7/8/80

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

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4.0 APPLICABILITY OF NONCONFORMANCE REPORT (NCR) (Cont'd)

4.1.1 Continued

7/8/80

C. After removal of the unacceptable condition, the area is re-examined by Magnetic Particle and/or Liquid Penetrant method, to assure that the unacceptable condition has been removed or reduced to an acceptable size.

7/8/80

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 method.

7/8/80

4.1.2 Unacceptable conditions 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.

4.2 An NCR shall be initiated under, but not limited to, the following conditions:

12/15/81

4.2.1 Incorrect materials (i.e. type or size, etc. that are in conflict with engineering documents and/or codes), incomplete or incorrect acceptance documentation or identification, improper pressure retaining dimensions, evidence of special process out of control, serious misalignment during installation, permanent plant items which fracture during or after installation (examples of the type of item which should be reported are bolts and concrete expansion anchors), or when required by another procedure. In no case shall a condition described in 4.2 be processed as detailed in 4.1.

12/15/81

4.3 In addition to the NCR required in 4.2, if the condition is the responsibility of another contractor, a Contractor Incident Interface Report (App. M) shall be completed and forwarded to the UE&C Construction Manager.

5.0 IMMEDIATE ACTION:

5.1 When a nonconformance is discovered, the items involved shall be segregated when possible by a QC Inspector and a "Hold Tag" (App. H) will be placed on them or adjacent to the operation (as in the case of welding) and the Field Process Sheet (App. F) or Field Weld Process Sheet (App. G) shall be withdrawn. The QA/QC Inspector will note on the Process Sheet the NCR number, when applicable.

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6.0 IMMEDIATE ACTION - CONTINUED

6.2 The Process Sheet is then returned to the Field QA Department. Once the nonconformance has been resolved, the original Process Sheet, revised if necessary, or a copy Process Sheet together with revised drawings, if applicable, are returned to resume work.

6.0 CUSTOMER OWNER INVOLVEMENT IN NONCONFORMANCE REPORTS (NCR)

9/24/79

6.1 All Section III NCR's shall be reviewed, dispositioned, and approved by the Construction Manager through the Nonconformance Review Board (NCRB).

9/24/80

6.2 All B31.1 NCR's, with the exception of those that may be dispositioned by the "Standard Repair Specifications" (ref. App. O thru U), shall be reviewed, dispositioned and approved by the Construction Manager.

9/19/80

6.3 All AWS-D1.1 NCR's shall be handled as described in 6.2 above.

7.0 LIMITED NCR AUTHORIZATION (LWA)

7.1 LWA is the controlled release of an item which has a Hold Tag affixed.

7.1.1 The Hold Tag indicates the status of the Stop Work Order (SWO) (ref. Drawing & Design Control Procedure III-4), a Nonconformance Report (NCR), etc. of items placed in a "Hold" condition. The purpose of the LWA is to permit specifically defined movement or related 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 authorize work which may affect or be affected by the condition described in the document which necessitated the placing of the Hold Tag on the item.

9/19/80

7.1.2 An LWA Request (App. L) will be prepared by the responsible Field Engineer. It shall delineate the specific LWA 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 and the QA Manager or his designee for review and approval.

B. Upon approval as required in "A" above, the LWA Request for NCR only shall be submitted to UE&C Resident Construction Engineer for review and approval.

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7.0 LIMITED WORK AUTHORIZATION (LWA) - CONTINUED

12/9/80

7.1 Continues:

7.1.3 Upon approval of the LWA Request, the QA Manager or his designee responsible for maintaining a log of LWA's, shall initiate the LWA Tag. Any Isc's, 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 specific Process Sheet(s) and 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.

12/15/81

7.1.4 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 I), adjacent to the Hold Tag on any concerned item(s).

12/9/80

7.1.5 After the LWA work has been performed, the LWA Request shall be forwarded to Q.C. Inspection. Inspection and acceptance of LWA scope of work will be that associated with procedures called out on applicable Isc's, Field Process, etc.

12/15/81

7.1.6 Upon completed inspection of the scope of work, the applicable Q.C. Inspector will remove the LWA Tag and return it along with the LWA Request to the QA Office. All other documentation pertaining to the LWA scope of work shall accompany the Process Sheets when they are returned to the QA Office.

12/15/81

7.1.7 If action has been taken which allows removal of the Hold Tag prior to completion of the LWA scope of work, the field copy of the LWA Request will be withdrawn by the Q.C. Inspector. The Inspector will note on the withdrawn LWA Request the last element of work scope which was completed, remove the LWA Tag, Hold Tag and return them along with the LWA Request to the originating QA Department so their respective logs may be updated. All other documentation pertaining to the last element of LWA scope of work completed shall accompany the process sheet(s) when it is returned to the QA Office.

8.0 PROCESSING OF NON-CONFORMANCE REPORTS

8.1 Non-Conformance Reports shall be processed in accordance with the instructions contained in Appendix C and this procedure. The Proposed Disposition of the non-conformance will be determined by the Field Engineering Department in conjunction with Quality Assurance or by the Construction Manager, if necessary. If applicable, the Proposed Disposition shall be reviewed for Code compliance by the Field QA Manager and the Authorized Nuclear Inspector. If in this review, the



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8.0 PROCESSING OF NON-CONFORMANCE REPORTS - CONTINUED

8.1 Continued

Field QA Manager or Authorized Nuclear Inspector do not concur, the NCR will be returned to the originator for re-evaluation of the Proposed Disposition. In all cases, the final disposition of the NCR shall be reviewed by the QA Manager, or his designee, for Code compliance and concurrence by the AII. This review shall be conducted and documented during the review and approval cycle of required Process Sheets per Project Procedure VI-5.

8.1.1 For non-conformances which do not meet the Code, the item may be scrapped, returned for replacement, repaired, or reworked to bring it within the Code requirements.

8.1.2 For non-conformances which do meet the Code, but deviate from Customer requirements, the item may be scrapped, returned for replacement, reworked, repaired to bring it into specification, or accepted to "Use-As-Is".

8.2 Scrap

4-79

8.2.1 When "Scrap" is the Proposed Disposition, the NCR will be forwarded to the Customer/Owner for approval. Upon return of the approved NCR, the QA Engineer Materials will mark the material "Scrap" and segregate in the designated scrap area. He will also complete Line #13 of the NCR.

4-79

8.2.2 The Chief Engineer will initiate the required documents for replacement, if necessary.

8.3 Return

8.3.1 When "Return" is the Disposition, the Chief Field Engineer shall retain a copy, send a copy to the QA Engineer Materials and return the original to the Field QA Manager.

8.3.2 The QA Engineer Materials will arrange for the return of the item and complete Line 13 of the NCR.

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B.0 PROCESSING OF NON-COMPLIANCE REPAIRS - CONTINUED

B.4 Repair

B.4.1 When repair is the Proposed Disposition, the Chief Field Engineer shall indicate on the NCR, the extent of the repair. He shall also prepare instructions, drawings, repair procedures, and other documents as may be required to implement a Process Sheet. These shall be reviewed and approved per paragraph 6.0.

B.4.2 The Field QA Manager shall review the Proposed Disposition for compliance to Code, Customer specification and obtain the concurrence of the Authorized Nuclear Inspector. After review and approval, the Chief Engineer will prepare a Repair Process Sheet and submit through its respective review cycle. (See Procedure VI-5, Control of Process Sheets and Weld Rod Requisitions).

B.4.3 Repair of Weld Metal Defects

- A. Unacceptable weld defects detected by the methods required by the applicable subsections of the ASME Code, Section III, (Div. 1), shall be eliminated and repaired in accordance with the following; specific approval must be obtained for repair welds after the third cycle of repair. If the joint has not received final acceptance after the third repair cycle, the weld will be cut out 100%, including the heat affected zone and prepared in accordance with IX-3 Installation Procedure. The joint will then be rewelded in accordance with the requirements of the original welding procedure.
- B. In addition to the above requirements, all repair(s) of weld metal defects shall be performed in accordance with NB-4450, NC-4450, ND-4450.
- C. When Pullman Power Products makes a repair weld, a report shall be prepared which shall include a chart that shows the location and size of the prepared cavity, the welding material identification, the welding procedure, the heat treatment and the examination results of repair welds exceeding in depth the lesser of 3/8" or 10% of the section thickness. The location and size of the prepared cavity shall be included on the weld repair order (App. K).

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APPROVED BY: H. HINDLEY

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8.0 PROCESSING OF NON-COMFORMANCE REPORTS - CONTINUED

8.5 Use-As-Is

8.5.1 When an item conforms to the Code, but deviates from Customer specifications, the Chief Field Engineer shall obtain approval from the Customer/Owner to "Use-As-Is".

8.5.2 The Field QA Manager will arrange for removal of the Hold Tag.

8.6 QA/QC Repair Tag

8.6.1 Upon disposition of the condition described in the document which necessitated the placing of the Hold Tag, the QA Manager or his designee shall notify the Quality Control Department that rework/repair/other activity may be invoked through the use of a Repair Tag (Appendix A).

8.6.2 The responsible QC Inspector shall obtain a QA/QC Repair Tag from the QA Engineer Records or his designated representative, who controls their issuance through maintenance of a QA/QC Repair Tag Log. (Appendix D).

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

8.6.3 After completing the bottom of the Tag (by signing and dating), the responsible QC Inspector shall remove the applicable Hold Tag and apply the QA/QC Repair Tag in its place. The Hold Tag shall be returned to the Authorized individual maintaining the Hold Tag Log as required in Pullman Procedure XI-4, Paragraph 8.0.

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

A. The Inspector removing the QA/QC Repair Tag shall assure all other action required by the NCR, Process Sheet, etc. has been performed and verified.

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8.0 PROCESSING OF NON-COMFORMANCE REPORTS - CONTINUED

8.6 Continued

8.6.5 In cases where a hold, NCR, etc. were initiated during receiving inspection, the required disposition has been satisfactorily completed and the Repair Tag removed, an Accept Tag shall be applied in its place by responsible QA/QC inspection personnel.

9.0 RECORDS

9.1 Records of all non-conformances and their disposition shall be maintained under the supervision of the Field QA Manager. NCRs shall be easily retrievable for review.

9.1.1 In the cases where decision is made to "Scrap", all associated records to the scrapped item shall be properly noted as to disposition and retained.

9.1.2 In all cases where "Return" for replacement is decided, the records shall be returned with the item.

10.0 REVIEW AND RECURRENCE PREVENTION

10.1 The Field QA Manager or his designee shall initiate and record the necessary steps to prevent recurrence of all non-conformities.

10.2 In order to control and eliminate the possible recurrence of a non-conformance, the Field QA Manager shall review the NCR's on a monthly basis.

10.2.1 In cases of repeated non-conformances, the Field QA Manager shall report in writing to the Director of Quality Assurance explaining the corrective action taken to stop recurrence of specific non-conformances and solicit the recommendations of the Director of Quality Assurance. A copy of this report shall be forwarded to the Customer/Owner.

11.0 DOCUMENTING

11.1 The Non-Conformance Report withdrawn process sheets, when applicable, shall be forwarded to the Field QA Manager or his designee for assignment of an NCR number and indexing. The Index (Appendix D) shall contain the date initiated, NCR number, brief description and status. The Field QA Manager shall retain a copy and forward to the Chief Field Engineer.

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DESIGNED BY: R.G. DAVIS

APPROVED BY: H. HINCHLEY

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APPENDIX A NONCONFORMANCE CODES

MECHANICAL

- 020 Material Identification
- 021 Identification, Tagging
- 022 Installation
- 023 Equipment Alignment
- 024 Welding
- 025 Minimum Wall
- 026 Missing or Inadequate Hangers, Supports, or Snubbers
- 027 Dimensional

COATINGS

- 030 Contaminated
- 031 Improper Adhesion
- 032 Pot Life
- 033 Incorrect Coating
- 034 Thickness Not Adequate
- 035 Not Coated
- 036 Visible Damage
- 037 Climate
- 038 Surface Preparation
- 039 Curing

TESTING EXAMINATION

- 061 Instrument/Certification/Calibration
- 062 Dimensional/Visual
- 063 Operator Certification/Qualification
- 064 Leak Test
- 065 Mechanical Operational Test

MISCELLANEOUS AND GENERAL

- 100 Testing
- 101 Qualification
- 102 Calibration
- 103 Documentation
- 104 Inspection
- 105 Storage and Handling
- 106 Cleanliness
- 107 Damage
- 108 Contamination

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APPENDIX "B"

CAUSE CODES

OPERATIONS

- 01 Operator Error
- 02 Inadequate Indoctrination and Training
- 03 Unqualified Personnel
- 04 Incorrect/Inadequate Planning
- 05 Poor Workmanship
- 06 Carelessness

DESIGN

- 10 Wrong Material Called Out on Drawing
- 11 Specification - Wrong Revision
- 12 Specification - Misinterpretation
- 13 Drawing - Wrong Revision
- 14 Drawing - Misinterpretation
- 15 Inadequate Procedure
- 16 Improper Installation (Drawing or Specification)

GENERAL

- 21 Environmental
- 22 Damage - By Others
- 23 Malfunction/Failure of Construction, Instruction, or Test Equipment
- 24 Vendor Supply Problem
- 25 Material Inadequate
- 26 Mishandling
- 27 Improper Storage
- 28 Inadequate Status Control
- 29 Inadequate Documentation
- 30 Lack of Identification
- 31 Improper Cure
- 32 Equipment
- 33 Violation of Procedure
- 34 Indeterminate/Unknown

FUNCTIONAL

- 40 Failed Test

EQUIPMENT

- 51 Inadequate or Incorrect Tools/Equipment
- 52 Measuring Device out of Calibration

SUPERVISION

- 61 Inadequate Supervision
- 62 Supervisor Gave Wrong Instructions
- 63 Supervisor Failed to Follow Instructions

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APPENDIX C

Non-Conformance Report Form Instructions

LINE NO.

INSTRUCTIONS

- 1 Enter NCR number and revision, sheet number, numerical identification of item, name of item, quantity, & unit no.
- 2 Completed by Originator
- 3 Source: Vendor, Owner or Company as applicable
Current Status: Hold, Reject, Installed, in Storage, Location, etc.
As specific as possible (including Elevation)
- 4 Enter the Company Name, and applicable Spec. No. and Revision
- 5 Category: Possible significance of Reporting.
(1) NA
(2) 10 CFR 50 Part 21
(3) 10 CFR 50 para. 55(e)
Type: As applicable
- 6 Enter specification, code procedure, etc. as applicable.
- 7 Refer to Appendix A and enter the NC code. Provide a clear, concise description of the nonconforming condition detailed adequately to facilitate formulation of a disposition and resolution of the nonconformance. Include drawings, sketches, photographs, examination reports, etc., as appropriate, to describe the condition thoroughly. If this is not practical, a statement to that effect and the supportive reasoning shall be included in the description portion of the report.
- 8 Detailed cause of non-conformity. Enter Cause Code. (Refer to Appendix A).
- 9 Nonconformance Reports shall not be routed for review and approval without a proposed disposition or a statement indicating why a proposal has not been included. The Field Engineering Department may resolve a nonconformance by accepting the recommendation of the QA Manager, by instituting a solution of its own or by obtaining a solution from the Customer.

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PREPARED BY: D.G. DAVIS

APPROVED BY: H. HARTLEY

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APPENDIX C

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(Cont'd) The Field Engineering Department, in conjunction with the Field Quality Assurance Department, shall provide the technical content of all proposed dispositions. Nontechnical content of dispositions, if applicable, shall be originated by Project Management after consultation with UE&C Construction Management, if necessary.

If, in the opinion of the Field Engineering Department, it is not practicable to provide a technical Proposed Disposition, then the circumstances making that proposal impracticable shall be clearly stated in the description of the Nonconformance, Line 7.

10 Describe in detail the corrective measures taken or to be taken to prevent recurrence of the non-conformance.

11 The following shall review and approve:

- Chief Field Engineer
- Field Quality Assurance Manager
- Customer/Owner
- Authorized Nuclear Inspector (when required)
- Others (when required)

8/24/79

12 Review required - Pullman, Customer/Owner will require review Board at his discretion
Decision - leave blank
Review Board Signatures - leave blank

Disposition	Verified by
Scrap	QA Engineer - Materials
Return	Field Purchasing Agent
Repair	QC Inspection
Use-As-Is	N/A

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FORM 17

DOCUMENT NO.

PREPARED BY: L. G. DAVIS

APPROVED BY: J. HINCHLEY

DATE: 6/22/79

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APPENDIX E

APPENDIX E

TO BE USED ONLY FOR THE NO. 7035

PULLMAN POWER PRODUCTS		NONCONFORMANCE REPORT	
NO. 7035	DATE 1/17/79	REV. 2	DATE 1/17/79
DESCRIPTION	OF TEST	LOCATION	DATE
	OF TEST	Pullman Power Prod	2/21/79
TESTER	FIELD	FIELD	FIELD
RESPONSIBLE PERSON	SITE ORGANIZATION		
			UG
CONTAINING REQUIREMENT	INCLUDE ACCEPTABLE CRITERIA AND DOC WT NO.	ELECTRICAL SUPPLIED	
NONCONFORMANCE DESCRIPTION	NO. CODE	107 LINE NO. 8	
Gauge is pipe, 4" from weld head (on 2000 series) approx 1/2" deep + 3/4" excess			
CAUSE OF NONCONFORMANCE	CAUSE CODE	37	
Cause unknown			
SAMPLE			
PROPOSED DISPOSITION	SCRAP	REPAIR	USE AS IS
Blend gaged area, perform PT to base metal, weld area using WPS B-211-PP-2, visual inspect weld & PT finished area			
SEE NRSPE SA NCR #011 "REPAIR"			
NEED TO PREVENT REOCCURRENCE	Cause unknown		
NEW ORL APPROVAL	[Signature]		
DESIGN	[Signature]		
INSPECTOR	[Signature]		

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FORM 10
DOCUMENT NO.

DESIGNED BY T. G. DAVIS	APPROVED BY W. Hinkley	DATE 6-20-76
STANDARD PROJECT PROCEDURE	PROJECT NO. 7035	PAGE NO. 1 OF 1

APPENDIX F

24-20-002

PULLMAN POWER PRODUCTS

APPENDIX F

FIELD PROJECT SHEET

CUSTOMER Ludlow Service Co. #101	SYSTEM - LINE NO. 511 - 200	ISSUE NO. F12
PROJECT NO. 7035	DATE 6-20-76	COO. W. Hinkley
OPERATION	W/A PROJ. NO.	
CUTTING OPERATING FOR 1/2" PIPE WITH WALL THICKNESS GREATER THAN 3/4"		
FIELD WELD NO. F12401		
1. PREPARE AREA TO BE CUT. 20045 MAIL	W/A PROJ. NO.	
2. CUT PIPE	W/A PROJ. NO.	
3. WELD JOINT	W/A PROJ. NO.	
REPAIR TO EXISTING AREA	N/A	
4. PREPARE 20045 MAIL	W/A PROJ. NO.	
5. FINISH UP BY WELDING	W/A PROJ. NO.	
G.A. APPROV. DATE: 6-20-76		
JAN Review DATE: 6-20-76		
Final Check		
G.A. II W/A PROJ. NO. DATE: 6-20-76		
Originator Code: 11-52		
Revised Type: 41-5-00-003		
SPC Issue No.		

TO BE USED ONLY FOR THE PROJECT NO. 7035



Pullman Power Products

FORM 19
DOCUMENT NO.

PROJECT NO. 41497

APPROVED BY: [Signature]

DATE: 6/22/74

SHARE OF
PROJECT DEVELOPMENT

TO BE PAID
ONLY ON DEMAND

7085

PAGE APPENDIX C
NO. 1 OF 1

APPENDIX C

NO.	DESCRIPTION	QTY	UNIT PRICE	TOTAL PRICE
1
2
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100

7085
SHEETS

5/25/74

PART OF F.P. 41497 13



Pullman Power Products

FORM 100

DOCUMENT NO.

PREPARED BY R.G. DAVIS

APPROVED BY H. HINLEY

[Signature]

DATE 6/22/78

SEABROOK
PROJECT PROCEDURE

TO BE USED
ONLY ON JOB #

7035

PAGE
NO. 1 of 1
APPENDIX H

APPENDIX H

REVISION

JOB NO 7026 PO 201
ITEM NO N218 HEAT OR SERIAL NO K-1246

HOLD

NO 12

DATE 2/13/78

- HOLD FOR INSPECTION
- WAIT FOR TEST REPORT
- WAIT FOR - NCR - REPORT
- RETURN TO VENDOR
- WAIT FOR ENGINEERING SPEC OR DRAWING CLARIFICATION
- _____

SAMPLE

[Signature]
INSPECTED BY

DISPOSITION

Retain in Hold Area until reports are received and approved

REVISION SL N/A

PART OF F.P. 41497 13



Pullman Power Products

Form #1

ISSUANCE NO.

PREPARED BY R. G. DAVIS

APPROVED BY H. HENNING

DATE 6/22 79

SEABROOK
PROJECT PROCEDURE

TO BE USED
ONLY ON JOB #

7085

PAGE APPENDIX 1
NO 1 of 1

APPENDIX 1



PULLMAN POWER PRODUCTS
SEABROOK STATION

LIMITED WORK
AUTHORIZATION

001

ITEM IDENTIFICATION

SW-1810-01

Spark Plug

SCOPE OF LWA.

TO COMPLETE FIELD
WELD F0106

QA INSP Z/linby DATE 5-7-79
TO BE ATTACHED OR REMOVED
BY QC PERSONNEL ONLY

PART OF F.P. 41497 1.3



Pullman Power Products

ST 01.0

DOCUMENT NO.

PROJECT NO. 100-1000

APPROVED BY: H. H. Miller

DATE: 6-22-79

MEASUREMENT
PROJECT PROCEDURE

TO BE USED
ONLY ON JOB #

7035

PAGE APPENDIX J
NO 1 of 1

APPENDIX J

Pullman Power Products
NON CONFORMANCE REPORT - WATER LOG AND STATUS

Name	Date	Description	ENTER DATE IN EACH COLUMN				REMARKS
			REPORT	IN	FIELD	COMPLETED	
022	5-20-79	Design Dept. Design	UCC				
			Report	5-21-79	6-6-79		

PART OF F.P. 41497 13



Pullman Power Products

XV-2
FORM 70
1-1-60

PREPARED BY: <i>[Signature]</i> APPROVED BY: <i>[Signature]</i>	DATE: <i>[Date]</i>	PAGE: <i>[Page]</i>
NO. OF PARTS: <i>[Number]</i> NO. OF LOTS: <i>[Number]</i>	NO. OF LOTS: <i>[Number]</i>	PAGE NO: <i>[Page No]</i>

Only Code: *[Code]*
 Rec. Type: *[Code]*
 I M S Index: *[Code]*
 Actual Wall Thickness: *[Code]*

SEABROOK STATION
 PULLMAN POWER PRODUCTS
 WELD REPAIR ORDER
 JOB NO. 7035
 DATE: *[Date]*

Part No: <i>[Part No]</i> Shop No: <i>[Shop No]</i> Material: <i>[Material]</i> Size: <i>[Size]</i> Date: <i>[Date]</i>	CAVITY Prepared By: <i>[Name]</i> Date: <i>[Date]</i>
INDICATION Prepared By: <i>[Name]</i> Date: <i>[Date]</i> <i>[Handwritten notes: excessive reinforcement, over the side, good]</i>	APPLICABLE FOR JOB NO. 7035 ONLY



Pullman Power Products

FORM 39
DOCUMENT NO.
6 00 75

PROJECT NO. 7035

APPROVED BY W. HINLEY

SEABEAM
PROJECT PROCEDURE

TO BE USED
ONLY ON JOB #

7035

PAGE
NO

APPENDIX L
1 of 1

7/5/80

APPENDIX L

SEABEAM
PROJECT PROCEDURE
FORM 39

7. Pullman Power Products SEABEAM STATUS

LIA No. 01
DATE 7/11/80
PAGE 1 of 1

LIMITS AND AUTHORITY

A. ITEMS RANGE/IDENTITY (INCLUDE UNIT, SYSTEM, ISOLING, AS APPLICABLE)

IDENTITY RELATED TO HOLD TAG

Base lock order (BLO) _____ Number/Name Lock (NOL) _____
Isolation Request (IR) _____ Isolating "BOLT" Instruction Number _____

B. REASON FOR LMA ELEMENT To move general pieces of stock area to tag line
For use of 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100

C. SCOPE OF WORK WHICH WILL BE PERFORMED (INCLUDE SPECIFIC PROCESS DELETED) AND OPERATIONS TO BE PERFORMED AND/OR THE "FROM" AND "TO" MOVE LOCATION.

From stock storage area to tag line, tag of 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100

Equipment (as identified) will be inspected, tested, and repaired as needed before stock area after use.

Signature of Field Engineer _____ DATE _____

D. STATUS OF ITEMS HAS BEEN REVIEWED INCLUDING ALL IDENTIFICATION RELATED TO HOLD TAG AND LMA IS APPROPRIATE. INSPECTION AND TESTING SHALL NOT BE PERFORMED AND WORK SHALL NOT PROCEED UNTIL THE FOLLOWING POINTS TO POINTS ARE SATISFACTORY TO STUDENT:

1. ALL LMA HAS BEEN DISMISSED BY THE STUDENT DATE 7/11/80

2. ALL LMA HAS BEEN DISMISSED BY THE STUDENT DATE 7/11/80

LMA CANCELED FOR THE FOLLOWING REASONS:

Approval Chief Engineer _____ DATE 7/11/80

Disapproval _____

Approval Field or Manager _____ DATE 7/11/80

Disapproval _____

Approval VEC Inspector _____ DATE 7/11/80

Disapproval _____

E. LMA CANCELED IF FULL PERFORMANCE BY WORK STOPPED.
KEEP TAG LMA TERMINATED BY REMOVAL OF HOLD TAG. LAST ELEMENT OF LMA SCOPE COMPLETED.

QC INSPECTOR SIGNING LMA TAG _____ DATE _____

CHECKED BY OR OFFICE: _____ SIGNATURE _____ DATE _____

PART OF F.P. 41497 13



Pullman Power Products

UEAC Form
1-1061
(REV. 10-78)

PREPARED BY: T. G. DAVIS

APPROVED BY: L. Hinkley

L.H.

DATE: 6-22-79

SEABROOK
PROJECT PROCEDURE

TO BE USED
ONLY ON THIS

7035

PAGE NO. APPENDIX M
1 OF 1

FORM NO. 1-1061
REV. 1-78

PROJECT NO. 2

TO: T. G. DAVIS

DATE: 6/22/79 SIGNATURE: L. Hinkley

FROM: T. G. DAVIS
RESPONSIBLE CONTRACTOR

SUBJECT: SEABROOK SERVICE WATER PIPE

DESCRIPTION OF INCIDENT

REPORT BY 2ND SHIFT SUPERVISOR ON BACKFILL OF GROUND THAT HAD AN SECTION OF 32" PIPE THAT IS LYING UPSE NORTH OF BY" ON SOUTHERLY SIDE. LOCATION OF MARKS ARE IDENTIFIED BY RED MARKED CIRCLES. MARKS ARE NOT PIPE COATING. NO KNOWLEDGE OF WHEN INCIDENT OCCURED.

CC: UEAC REC
UEAC Safety Dept. ✓

R. DAVIS
SIGNATURE

6/11/79
DATE

TO: R. DAVIS
PULLMAN - WIGGINS
RESPONSIBLE CONTRACTOR

UNIT NO. 2 SIGNATURE: L. Hinkley

SUBJECT: 32" SERVICE WATER PIPE
NORTH OF COOLING TOWER

FROM: J. F. VOGHUT

DISPOSITION:

A NON-CONFORMANCE REPORT SHOULD BE WRITTEN AGAINST THE DAMAGE TO THE PIPE COATING. THIS REPORT SHOULD STATE THAT THE COATING BE REMOVED TO ALLOW FOR INSPECTION OF PIPE FOR POSSIBLE DAMAGE. ANY DAMAGE TO THE PIPE SHOULD BE REPAIRED AND REPORTED PER II-14. THE COATING SHOULD THEN BE REPAIRED AND INSPECTED PER II-27. IT IS UNDERSTOOD THAT THE ABOVE STEPS ARE ALREADY IN PROGRESS.

CC: UEAC REC
RESPONSIBLE CONTRACTOR
S. KELLY
YAC-CA
J. F. VOGHUT

J. F. VOGHUT
SIGNATURE

6/12/79
DATE



Pullman Power Products

YV-2

DOCUMENT NO

PREPARED BY: D.C. DAVIS

APPROVED BY: H. HINKLEY

[Signature]

DATE: 12-9-80

SEABROOK PROJECT PROCEDURE

TO BE USED ONLY ON JOB # 7035

PAGE NO

APPENDIX I:
1 OF 1

QA/QC REPAIR TAG

PULLMAN POWER PRODUCTS

SEABROOK STATION JOB 7035

QA/QC REPAIR

TAG # _____

- REWORK
- REPAIR
- OTHER ACTIVITY

NCR # _____


HOLD TAG # _____

REMARKS _____

QA/QC INSPECTOR _____ DATE APPLIED _____

PART OF F.P. 41497 13

PART OF F.P. 41497 13

 Pullman Power Products		XV-2
PREPARED BY: H. HINKLEY	APPROVED BY: A.A. ECK	DATE: 9/24/81
SEABROOK PROJECT PROCEDURE	TO BE USED ONLY ON JOB # 7035	PAGE NO. APPENDIX D 1 OF 1

STANDARD REPAIR SPECIFICATION No. 1

for

DAMAGED CEMENT LINING

ECA 19/0200

12/15/81

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 (1/16" 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 fuel circumference of the pipe for a length along the pipe equal to 3 pipe diameters. Larger areas requiring repair shall be documented by nonperformance 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 (77-42163) 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" does 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.

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.

 Pullman Power Products		XV-2 DOCUMENT NO.
DESIGNED BY H. HINKLEY	APPROVED BY A.A. ECK	DATE 9/29/81
SEABROOK PROJECT PROCEDURE	TO BE USED ONLY ON JOB # 7035	PAGE NO. APPENDIX P 1 OF 1

EQA 19/0202

STANDARD REPAIR SPECIFICATION No. 1

for

IMPROPER WELD PIPER COUNTERBORE TRANSITION

12/15/81

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 EQA 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.

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.

STANDARD REPAIR CRITERIA

Installation 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 to a suitable 10° taper (30" in E31.1) and blended to the contour of the pipe. 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 drawing 9/01-7-1081 shall be reported via nonconformance report.

TECHNICAL JUSTIFICATION

The existence of the "skim cut" counterbore is not injurious provided it complies with code requirements for thickness transition. Repair as described herein accomplishes code compliance without jeopardizing material quality or system design criteria.



Pullman Power Products

XV-2

PREPARED BY H. HINKLEY

APPROVED BY A.A. ECK

DOCUMENT NO.

DATE 9/24/81

SEABROOK
PROJECT PROCEDURE

TO BE USED
ONLY ON JOBS

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NO 1 OF 1

ECA 19/0231

12/15/81

STANDARD REPAIR SPECIFICATION NO. 2

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 Tapcoat 30 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.

PART OF F.P. 4:497 13



Pullman Power Products

XV-2

DESIGNED BY H. HINKLEY

APPROVED BY A.A. ECF

GC

REVISED BY
DATE 1-2-61

SEABROOK
PROJECT PROCEDURE

TO BE USED
ONLY ON JOBS

7035

APPENDIX T
1 OF 2

ED. 19/0100

12/11/01

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 simple 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.

STANDARD REPAIR CRITERIA

PART OF F.P. 41497 13

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.



Pullman Power Products

XV-2

DOCUMENT NO

REVISION BY H. HINCHLEY

APPROVED BY A.A. ECK

DATE 9/24/81

SEABROOK
PROJECT PROCEDURE

TO BE USED
ONLY ON JOB #

7035

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NO 2 OF 2

3/15/82

ECA 19/0230

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 shall be followed by surface examination and wall thickness measurements.

Bent backing rings may be straightened by use of hand tools. Basting 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.

PART OF F.P. 41497 13

 Pullman Power Products		XV-2 DOCUMENT
DESIGNED BY: M. HINKLEY	APPROVED BY: A.A. ECK	DATE: 9/24/81
SEABROOK PROJECT PROCEEDING	TO BE USED ONLY ON JOB # 7035	PAGE NO APPENDIX U 1 OF 1

ECA 19/0101

STANDARD RETAIR SPECIFICATION NO. 1

12/15/81

FORMATERIAL LOST IN THE FIELDBACKGROUND

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 onsite but which cannot be retrieved from the Contractor's storage facility. The items shall not have a value in excess of \$500.00.

STANDARD RETAIR CRITERIA

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

- the replacement item exactly duplicates the lost item.
- the replacement item possesses the same or higher quality documentation.
- 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.

In each case instance of lost material, the U&S Piping Superintendent shall be notified verbally prior to installation of a replacement.

TECHNICAL JUSTIFICATION

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

JOB NO.		PURCHASE ORDER		FOREIGN POINT NO.		VENDOR DRAWING OR DOCUMENT NO.		REV NO.		REV DATE	
A776301/242005/41497/31188XV-2								12219			
DESCRIPTION								VENDOR'S NAME			
LINE 1								LINE 2			
PROC FOR HANDLING NONCONFORM								P-H			
LETTER TO VEGC		VEGC LOG-IN DATE		CLIENT'S REVIEW TO CLIENT		VEGC REVIEW FROM CLIENT TO VENDOR		FINAL DISTRIBUTION DATE		CHECK OFF	
35-3821222R/PP6576		TF16448		B121DR							
UNITED ENGINEERS & CONSULTANTS INC. PROJECT AS PER P.O. OR CONTRACT BEING SUBMITTED SEPARATELY FOR RECORD								DATE 2/14/82 [Signature]			

INFORMATION ONLY