

ORGANIZATION: PULLMAN POWER PRODUCTS
PARAMOUNT, CALIFORNIA

REPORT NO.: 99900077/82-01	INSPECTION DATE(S) 6/14-18/82	INSPECTION ON SITE HOURS: 32
CORRESPONDENCE ADDRESS: Pullman Power Products Division of Pullman, Inc. ATTN: Mr. H. W. Owen, Plant Manager 14507 South Paramount Boulevard Paramount, California 90723		
ORGANIZATION CONTACT: D. E. Obrion, Quality Assurance Manager TELEPHONE: (213) 531-1370		
PRINCIPAL PRODUCT: Nuclear Piping Subassemblies		
NUCLEAR INDUSTRY ACTIVITY: The Paramount plant nuclear piping fabrication represents approximately 2% of the plant workload.		
ASSIGNED INSPECTOR: <u>H. W. Roberds</u> H. W. Roberds, Reactive and Component Program Section (R&CPS)		<u>7/22/82</u> Date
OTHER INSPECTOR(S):		
APPROVED BY: <u>I. Barnes</u> I. Barnes, Chief, R&CPS		<u>7/22/82</u> Date
INSPECTION BASES AND SCOPE: A. <u>BASES</u> : 10 CFR Part 50, Appendix B B. <u>SCOPE</u> : Manufacturing process control, welding material control, weld procedure specifications, joint fitup and welding, and NDE personnel qualification.		
PLANT SITE APPLICABILITY: Palo Verde Nuclear Station, Docket No. 50-530		
DESIGNATED ORIGINAL Certified By <u>Rheanne Jouts</u>		

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A. <u>VIOLATIONS:</u> None		
B. <u>NONCONFORMANCES:</u> None		
C. <u>UNRESOLVED ITEMS:</u> None		
D. <u>OTHER FINDINGS OR COMMENTS:</u>		
1. Manufacturing Process Control - The inspector reviewed five sections of the Pullman Power Products, Paramount Facility, Quality Assurance Manual, which were applicable to control of material, operations, inspections, and test of the nuclear piping subassembly throughout the fabrication cycle. To verify that fabrication and inspections were controlled and documented in accordance with requirements, a review was made of four process sheets for main steam piping for the Palo Verde Nuclear Generating Station. Within this area, no nonconformances to NRC, customer, or QA program requirements were identified and no unresolved items were noted.		
2. Welding Material Control - The inspector reviewed Document No. VIII-3P, "Control of Nuclear Welding Material Prior to Fabrication," and Document No. VIII-4P, "Control of Nuclear Welding Material During Fabrication." Observations were made of the welding wire, flux, and coated rod storage area, and hot ovens maintained in the weld material issue crib. To verify that weld material issuance was controlled and documented, discussions were held with the personnel performing the material issuance and a review of records of weld rod requisition slips for process sheet F-712 and the list of approved welding materials for job number 2825. Within this area, no nonconformances to NRC, customer, or QA program requirements were identified and no unresolved items were noted.		
3. Weld Procedure Specifications - The inspector reviewed Document No. VI, "Control of Welding Procedures Assigned to Fabrication Drawings" and Document No. IX-10P, "Repairs of Base Material Defects."		

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To verify that weld procedure specifications (WPS) were controlled and in compliance with Section IX of the ASME Code, the inspector selected four WPS form drawings for review. Each WPS was reviewed to assure that all essential variables and applicable nonessential variables were listed and the WPS was in compliance with the supporting procedure qualification record.

Within this area, no nonconformances to NRC, customer or QA program requirements were identified and no unresolved items were noted.

4. Joint Fitup and Welding - The inspector reviewed Section IX of the QA Manual, "Control of Special Process" and Document No. IX - 10P, "Repair of Base Material Defects." To ascertain that joint fitup and welding is controlled in accordance with the QA Program requirements, the inspector reviewed and observed the following: (1) review of four process sheets for identification of welder/weld operator and weld material; (2) observation of four welding machines for current calibration stickers; (3) observation of weld procedure stipulated on the drawings at four weld stations; (4) review of calibration records; and (5) observation of current and voltage during GTAW process welding.

Within this area, no nonconformances to NRC, customer or QA program requirements were identified and no unresolved items were noted.

5. NDE Personnel Qualification - The inspector reviewed Section IX, paragraph 9.3 of the QA Manual, "Nondestructive Examination".

To verify that NDE personnel were trained, qualified, and certified in accordance with requirements, a review was made of the procedures governing these activities and current records consisting of: NDE education and experience, written SNT-TC-1A examination, Certification history including current eye examinations for two NDE level II technicians for liquid penetrant and magnetic particle examination.

Within this area, no nonconformances to NRC, customer or QA program requirements were identified and no unresolved items were noted.

DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
1	4	QA Manual, Sections V, IX, X, XI & XIV	4/15/81	
2	3	Weld Procedures JS 673, JS 674, JS 675 & JS 677		
3	8	Weld Procedure Qualification Records LA 510, LA 548, LA 539, LA 558, LA 572, LA 553, LA 534, LA 001 & LA 548		
4	3	Document No VIII-3P "Control of Nuclear Welding prior to fab"	7/22/80	
5	3	Document No VIII-4P "Control of Nuclear Weld material during fabrication"	7/22/80	
6	1	Drawings Nos. F 247, F 714, F 712 & F 37		
7	3	Document No VI Control of welding procedures assigned to fabrication drawings	6/11/80	
8	3	Document No IX-107 repair of Base Material Defects	8/25/82	
9	8	Record Packages for No 2825 - F-247, F-714, F-712 & F-37		

- Document Types:
- 1. Drawing
 - 2. Specification
 - 3. Procedure
 - 4. QA Manual
 - 5. Purchas Order
 - 6. Internal Memo
 - 7. Letter
 - 8. Other (Specify-if necessary)

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