

ORGANIZATION: WESTERN PIPING AND ENGINEERING COMPANY, INC.
SAN FRANCISCO, CALIFORNIA

REPORT NO. 99900302/82-01	INSPECTION DATE(S): 5/17-21/82	INSPECTION ON-SITE HOURS: 28
CORRESPONDENCE ADDRESS: Western Piping and Engineering Company, Inc. ATTN: Mr. K. A. Friedman President 1485 Yosemite Ave. San Francisco, CA 94124		
ORGANIZATION CONTACT: Mr. R. Haytack, Quality Assurance Mgr. TELEPHONE: (415) 822-6464		
PRINCIPAL PRODUCT: Class 1, 2, & 3 nuclear components - vessels and supports. NUCLEAR INDUSTRY ACTIVITY: Commercial nuclear production of Western Piping and Engineering Company, Inc. (WP&E), San Francisco, California, totals 80% of all production. Seven contracts are presently in-house for current and future production. WP&E ASME Certificate of Authorization expires in 1984.		
ASSIGNED INSPECTOR:	<u>J. W. Sutton</u> J. W. Sutton, Reactive & Components Program Section (R&CPS)	<u>7-28-82</u> Date
OTHER INSPECTOR(S):		
APPROVED BY:	<u>J. T. Conway / for</u> J. Barnes, Chief, R&CPS	<u>7/20/82</u> Date
INSPECTION BASES AND SCOPE: A. <u>BASES</u> : 10 CFR Part 50, Appendix B and 10 CFR Part 21. B. <u>SCOPE</u> : This inspection was made to review the status of previous inspection findings, Part 21 inspection, nonconformances - corrective action, machining, calibration, and vendor activities.		
PLANT SITE APPLICABILITY: Not identified		

DESIGNATED ORIGINAL
Certified By Cheranne Jantz

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INSPECTION
RESULTS:

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A. VIOLATIONS:

None

B. NONCONFORMANCES:

Contrary to Criterion V of Appendix B to 10 CFR Part 50 and Section 12 of the QA Manual, measuring instruments were not being entered in the Inspection Usage Log prior to use by the QC inspector for final acceptance inspection.

C. UNRESOLVED ITEMS:

None

D. STATUS OF PREVIOUS INSPECTION FINDINGS:

1. (Closed) Deviation (81-01): Vendor was not determining the chlorine content of the medium for the hydrostatic test of stainless steel items.

The inspector reviewed the corrective action taken by WP&E as outlined in their March 2, 1981, reply to NRC's deviation notice of February 2, 1981. It was further verified that a chloride test kit had been purchased, a chloride test procedure (P-1332-001) has been generated, and a log of the medium testing is being maintained to prevent recurrence. The preventive action taken by WP&E was found to be acceptable.

2. (Open) Nonconformance (81-02): No documented evidence that the threaded fasteners, attaching ears to the load distribution plate of support clamps, had been provided with locking devices to prevent loosening during service.

The vendor has not submitted his corrective action to the NRC as of the date of this inspection.

E. OTHER FINDINGS OR COMMENTS:

1. 10 CFR Part 21 Inspection - The inspector reviewed WP&E's written policy used for the reporting of identified component defects that could be reportable under 10 CFR Part 21 requirements. The inspector reviewed WP&E reporting procedure P0200-001, Rev. 2, issued February 14, 1981. Posting of Part 21 requirements was checked and found to be in order. The inspector determined that the requirements for reporting and posting under 10 CFR Part 21 has been complied with as required by the regulations.

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<p>2. Nonconformance/Corrective Action - The inspector reviewed WP&E's QA manual section 15.0, "Nonconforming Items or Services," and section 16.0, "Corrective Action". Four NCR's and System Discrepancy Reports (SDR's), and associated documentation were reviewed to determine compliance to QA program requirements. The corrective action taken to prevent recurrence was examined for implementation. Segregated areas designated for storage of nonconforming items were inspected. Relative to the documents examined, the inspector determined that activities were in conformance with the QA program requirements and were being implemented as required.</p> <p>3. Manufacturing Control (Machining) - The inspector reviewed WP&E's QA manual section 9.0, "Control of Fabrication Processes," and witnessed ongoing machine work within the shop. The inspector reviewed shop orders, procedures, drawings, and related documentation for three jobs in progress. As a result of the review of this documentation, the inspector determined that machining operations were being performed as required by the QA program requirements.</p> <p>4. Calibration - The inspector reviewed WP&E's QA manual section 12.0, "Control of Measuring and Testing Equipment." Measurement tools being used for final acceptance were checked for calibration dates and compliance to QA procedures. During the course of the inspection, it was observed that the measurement equipment being used for final acceptance of a component, had been calibrated as required, but the equipment had not been entered in the Inspection Usage Log as required by the QA program requirements (see section B of Inspection Results).</p>		

Scope/Module Previous Inspr. Findings -
Part 21 - Inspector
Nonconformance/Corr Action

DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
1	3	chloude analysis of water - P-1332-001-	3-17-81.	
2	8	Test Kit - Chlauride - Model CD-DT.	-	-
3	7.	water analysis Rept - S.F. water Dept.	1-21-81.	
4	8	Monthly Rept Form. water analysis -	2-14-81.	
5	3	Part 21 procedure - P 0200-001-	5-5-81.	
6	4	Sections - 15.0 - 16.0		
7	3	IPD Index - N.C.		
8	5	205-AM 674-		
9	8	NCR - 01-02-03-4-5-6-7-		
10	3.	P 1500-001-0- P 1500-001-2-0, P-1600-01-	9-11-80	
11	5.	YV 127 - STM. Guide.	3-21-80	
12	2	240977- 0.1 to 18. 2		
13	5	P.O 8031-M-170 Ac. 01-- 07- 2.41056--		
14	8	NCR'S - W987-13-14.		
15	8	SDR'S - W987- 61-62.		

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)

Inspector J. W. Sutton
 Scope/Module Control of Fabrication Process - machinery -
Control of test & measuring equipment -
 DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
1.	4.	Section 9.0 1	8-5-81	Revo
2	3	D-0903-001-0 Handling of Shop Drawings.	1-7-80	
3	3	P-0000-001-	4-14-82	
4	5.	205-AN-674- Part # 01 16050-D-1 - Serial 1199.		
5	8	JUL 24 0269 - Change Controls -		
6.	5	10-20050-04 - Serial 1191.		
7.	5	08-24050-04 Ser. 1225		
8	3.	D-1501-002-01 Quarters Area -	10-23-81	
9	4	Section 5.0. Instructions, Procedures - Drawings -		
10	4.	Section 12.0 - Control of test & measuring Equip.		
11.	8	measuring Equipment - 022 - 226 - 0036 - 0028-0206 - Various Various - Calibration Station		
12	8	Audit - Calibration Dept - QA	4-30-82.	

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