

ORGANIZATION: YORK ELECTRO-PANEL CONTROL COMPANY, INC.
YORK, PENNSYLVANIA

REPORT NO.: 99900713/82-01	INSPECTION DATE(S) 5/18-20/82	INSPECTION ON-SITE HOURS: 24
CORRESPONDENCE ADDRESS: York Electro-Panel Control Company, Inc. ATTN: Mr. Don Eckert, President York County Industrial Park P. O. Box 1702 York, PA 17405		
ORGANIZATIONAL CONTACT: Mr. J. M. Myers, QA Manager TELEPHONE NUMBER: (717) 764-9864		
PRINCIPAL PRODUCT: Instrument control panels, boards, and racks. NUCLEAR INDUSTRY ACTIVITY: Approximately 20%.		
ASSIGNED INSPECTOR: <u>I. Barnes</u> for R. E. Otter, Reactive & Components Program Section (R&CPS)		<u>7-14-82</u> Date
OTHER INSPECTOR(S):		
APPROVED BY: <u>I. Barnes</u> I. Barnes, Chief, R&CPS		<u>7-14-82</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> : Manufacturing process control, internal audits, nonconformances and corrective action, and reporting of defects.		
PLANT SITE APPLICABILITY: Bellefonte Unit 1 (50-439), Seabrook Unit 1 (50-443).		

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INSPECTION
RESULTS:

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A. VIOLATIONS:

None

B. NONCONFORMANCES:

None

C. UNRESOLVED ITEMS:

None

D. OTHER FINDINGS OR COMMENTS:

1. Manufacturing Process Control - The inspector reviewed four sections of the vendor's QA Manual, Revision 0, which were applicable to fabrication, assembly, inspections, and tests of instrumentation panels and racks. Observations were made of panel and rack welding fabrication in Plant No. 2, and instrumentation mounted racks in Plant No. 1.

To verify that panels and racks were fabricated, and the instruments were mounted, inspected and tested, and the results documented, in accordance with requirements, a review was made of: 5 standard operating procedures governing inspections and tests; in-process records for a reactor level transmitter rack; welding control documents consisting of personnel qualifications and certifications, welding wire records, and a welding procedure and its qualification records; 2 customer purchase specifications; release records for 20 instrument racks for TVA-Bellefonte Unit 1; 10 record packages for completed and shipped instrument control racks, and 9 record packages for the nine sections of the main control board shipped to United Engineers and Constructors, Seabrook Unit 1.

Within this area, no nonconformances or unresolved items with respect to NRC, or QA program requirements were identified.

2. Internal Audits - The inspector reviewed Section 15, "Audits," of the vendor's QA Manual.

To verify that planned periodic audits of all aspects of the QA program are performed, and followup action is taken where indicated

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a review was made of: two internal audit schedules for the period of October 1980 through September 1982; 19 internal audit reports (checklists) for audits performed during the same period; and qualification requirements for auditors and the certification records for two auditors.

Within this area, no nonconformances or unresolved items with respect to NRC or QA program requirements were identified.

- 3. Nonconformance and Corrective Action - The inspector reviewed Section 11, "Deficiencies During In-Process Manufacturing," of the vendor's QA Manual.

To verify that nonconforming items are reviewed and accepted, rejected, repaired, or reworked; and that conditions adverse to quality, including the cause, are promptly identified and corrected; a review was made of: 3 deficiency reports and the related red hold tags for in-process manufacturing nonconformances; 10 receiving inspection disposition reports and the related yellow hold tags for nonconforming purchased items; and 6 inspection test punch lists identifying nonconformances and their subsequent dispositions found during in-process inspections and tests.

Within this area, no nonconformances or unresolved items with respect to the NRC or QA program requirements were identified.

- 4. Reporting of Defects - The inspector reviewed the vendor's standard operating procedure No. 128, revision 0, "Compliance with 10 CFR part 21," to verify that documented measures are available to meet the reporting requirements of 10 CFR Part 21. Observation was made of the above procedure and other required documents posted on the bulletin board, as required by 10 CFR Part 21.

Within this area, no violations were identified.

Inspector R.E. Oller

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Scop/Module Manufacturing
Process Control

DOCUMENTS EXAMINED

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1	2	TITLE/SUBJECT	3	4
1	4	York Electric Panel Control Co. (Y.E.P.) QA Manual, Rev. 0, sections V "Manufacturing Process Control", X "Inspection and Testing", XIII "Welding Control", and XIV "Control of Special Projects or Processes"	1/76	0
2	3	Following standard Operating Procedures applicable to Contract Y-3996 (1) No. 103, "Hydrostatic Test" (2) No. 104, "Pressure Test Piping and/or Tubing Systems" (3) No. 114, "Electrical Insulation Tests Performed With High-Voltage Insulation Tester" (4) No. 115, "Continuity Test Performed With Circuit Tester" (5) No. 121, "Class B Cleaning and Testing"	8/76 4/82 2/79 2/79 2/76	1 2 0 0 0
3	8	Following in-process records for the reactor level transmitter rack for Contract No. Y-3994 (UE+C, Indian Point Unit 1) (1) Project Inspection Traveler (2) Test Performance Record	Current "	N/A "

(cont)

Document Types:

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

Column Nos.

- 1. Sequential Item No.
- 2. Type of Document
- 3. Date of Document
- 4. Revision No., if applicable

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1	2	TITLE/SUBJECT	3	4
		(3) Drawings	Current	N/A
		(4) Balance of records	"	"
4	8	Following in-process records for a local Instrument Control Rack No. IIX-ILPT-113 for TVA Bellefonte unit 1.		
		(1) Materials List	"	"
		(2) Wiring Diagrams	"	"
		(3) QA Inspection List Supplement	"	"
		(4) Instrument List (with TVA identification of instruments.)	"	"
		(5) In-Process Inspection Report (traveler)	"	"
		(6) Special Tests Sheet List	"	"
		(7) Cleaning Certification	"	"
5	8	Following records for in-process nuclear work in the No. 2 fabrication shop.		
		(1) weld wire Log	copy in 5	"
		(2) welder Log		

(Cont.)

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1	2	TITLE/SUBJECT	3	4
		(3) Certification Record No. R-173, Welding Gas, for Contract Y-3875	7/19/82	N.A.
		(4) Weld Wire Certification of Analysis for Contract Y-3875	Current	"
		(5) Retension Traceability Number Sheet for welding & brazing materials	"	"
6	3	Welding Procedure Specification No. WPS-500 (GMAW, semi-automatic, for welding P-1 to P-1 steel) and its supporting PQR-600.	11-1881	2
7	8	Performance Qualification Records for six welders (Nos. 40, 41, 42, 44, 47 and 62) for the process of GMAW (WPS-500) in the horizontal, vertical and overhead positions	Current	N.A.
8	2	TVA Purchase Specification No. 2290 "Controls and Metering for Bellefonte Units 1 and 2, Contract No. Y-3996, and Appendix A QA Requirements	"	"
9	2	United Engineers & Constructor's Specification No 6604-221-252-1 for P.O. No IP-P0-572 for one Seismic Category I Instrument Rack for Indian Point Unit 3.	8.31.81	"

(Cont.)

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1	2	TITLE/SUBJECT	3	4
10	8	Following record of release for 20 instrument racks, contract 4-3974, Bellefonte Unit 1		
		(1) TVA Vendor QA Release	Current	N.A.
		(2) Y.E.P. QA Review	"	"
		(3) TVA Release No. 6	4/29/82	"
		(4) Y.E.P. Drawing and Material Release Status Report	Current	"
11	8	Ten record packages for instrument racks shipped to TVA, contract no. 4-3974, consisting of the following records:		
		(1) Inspection Checklist	Current	"
		(2) Individual Panel Releases	"	"
		(3) In-Process Inspection Report	"	"
		(4) Tubing Test Report	"	"
		(5) TVA "Shipshot" authorization letters	"	"
		(6) Cleaning Certifications, and Drawings	"	"

Document Types:

- 1. Drawing
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- 3. Procedure
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1	2	TITLE/SUBJECT	3	4
12	8	Nine record packages for maine control board sections A through I to GE4C - Seabrook Unit 1, contract 4-3637, each record packages consisting of (1) Certificate of Compliance (2) Test Performance Record (3) Project Inspection Traveler	Current " "	N.A " "

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1	2	TITLE/SUBJECT	3	4
1	4	Y.E.P. QA Manual, Section 15 "Audits"	1/2	0
2	8	Records of two schedules of internal audits for the periods of October, 1980 through September, 1981, and October, 1981 through September, 1982.	-	N.A.
3	8	Records of 19 Internal Audit Reports (checklists) of QA Manual areas for audits performed for the period of October, 1980 through April, 1982.	various	"
4	8	Following records relative to audit personnel: (1) "Qualification Requirements For York Electro - Panel Control Co., Inc. Auditors"	current	"
		(2) Y.E.P. records of certification and appointment for two auditors.	"	"

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Scop/Module Nonconformances and
Corrective Action

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1	2	TITLE/SUBJECT	3	4
1	4	Y.E.P. QA Manual Section II "Deficiencies During In-Process Manufacturing"	1/76	0
2	8	Following Deficiency Reports (Form DR-122) and the related Red Hold Tags: (1) No. DR-122-386 for Contract Y-3860 (2) No. DR-122-3919-1 for contract Y-3919 (3) No. DR-122-3919-2 for contract Y-3919	9/5/81 11/8/81 11/29/81	N.A. " "
3	8	Ten Receiving Inspection Disposition Reports (Form RID-109) and the related Yellow Hold Tags for purchased items	Various	"
4	8	Six Inspection-Test Bench Lists covering nonconformances found during in-process tests and inspections.	Various	"

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Scop/Module 10 CFR Part 21

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1	2	TITLE/SUBJECT	3	4
1	3	Y.E.P. Standard Operating Procedure No. 128, "Compliance with 10 CFR Part 21"	2/4/75	N.A.

- Document Types:
- 1. Drawing
 - 2. Specification
 - 3. Procedure
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