

ORGANIZATION: GENERAL ELECTRIC COMPANY
SAN JOSE MOTOR PLANT
SAN JOSE, CALIFORNIA

REPORT NO: 99900339/82-01	INSPECTION DATE(S) 6/28-7/2/82	INSPECTION ON-SITE HOURS: 26
CORRESPONDENCE ADDRESS: General Electric Company San Jose Motor Plant ATTN: Mr. R. W. Hagstrom Manager, Quality Assurance P. O. Box 6376, Mail Code 970 San Jose, CA 95150		
ORGANIZATION CONTACT: Mr. R. W. Hagstrom, Manager, QA TELEPHONE NUMBER: (408) 925-2832		
PRINCIPAL PRODUCT: AC Motors for Vertical Pumps		
NUCLEAR INDUSTRY ACTIVITY: Approximately 10%		
ASSIGNED INSPECTOR: <u>R. E. Oller</u>	R. E. Oller, Reactive & Components Program Section, (R&CPS)	<u>8-10-82</u> Date
OTHER INSPECTOR(S):		
APPROVED BY: <u>I. Barnes</u>	I. Barnes, Chief, R&CPS	<u>8-10-82</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> : Status of previous inspection findings, manufacturing process control, internal audits, nonconformances and corrective action, and 10 CFR Part 21.		
DESIGNATED ORIGINAL		
PLANT SITE APPLICABILITY:	Certified By <u>Rheanne Jouts</u>	
Salem, Docket No. 50-311; Enrico Fermi No. 2, Docket No. 50-341; A. W. Vogtle, Docket No. 50-427.		

ORGANIZATION: GENERAL ELECTRIC COMPANY
SAN JOSE MOTOR PLANT
SAN JOSE, CALIFORNIA

REPORT NO: 99900339/82-01	INSPECTION RESULTS:	PAGE 2 of 4
A. <u>VIOLATIONS:</u> None		
B. <u>NONCONFORMANCES:</u> None		
C. <u>UNRESOLVED ITEMS:</u> None		
D. <u>STATUS OF PREVIOUS INSPECTION FINDINGS:</u> 1. (Closed) Deviation A (79-01): Failure to recalibrate certain measuring devices and test instruments within the specified calibration schedule as required by Section XII of the QA Manual. The inspector verified that, in accordance with the vendor's response letter, dated July 2, 1979, all of the inspection and test devices in the plant were located, checked, and recalibrated; and the results recorded on the calibration record cards. Record entries showed that these devices were currently recalibrated within the specified schedule. 2. (Closed) Deviation B (79-01): Failure to include certain measuring devices and test instruments in the calibration recall card system. The inspector verified that in accordance with the vendor's response letter, dated July 2, 1979, a thorough investigation was made of all the inspection devices in the plant and those which were not identified in the recall system were added to the Gage Lab recall calibration card system. Record entries showed that these devices were entered on the recall cards.		
E. <u>OTHER FINDINGS OR COMMENTS:</u> 1. Manufacturing Process Control - The inspector reviewed 10 sections of the vendor's QA Manual, Revision 9, which were applicable to parts manufacture, inspection, tests, and assembly of AC electric motors for vertical pumps for nuclear service. Observations were made of inprocess fabrication and inspection of motor components in the areas of: shaft machining, rotor casting and machining, large wound stators, formed wound coil assemblies, formed coil and random stators-rotors "VIP Treatment," and final assembly.		

ORGANIZATION: GENERAL ELECTRIC COMPANY
SAN JOSE MOTOR PLANT
SAN JOSE, CALIFORNIA

REPORT NO: 99900339/82-01	INSPECTION RESULTS:	PAGE 3 of 4
<p>To verify that motor components and motors are fabricated, inspected, tested and assembled, and the results documented in accordance with requirements, a review was made of: seven quality control requirement (QCR) procedures; five different types of inspection records in the shaft inspection area; four different inspection records in the large wound stator area; three different inspection records in the formed wound coil assembly area; two different inspection records in the rotor area; a GE Requisition No. 30362115 and four related inspection records for components of motors for the Salem Nuclear Plant; a GE Requisition No. 320-69585 and nine inspection records for components and motors for the Enrico Fermi Plant No. 2; and six inspection records for components of motors for the A. W. Vogtle Nuclear Plant.</p> <p>Within this area, no nonconformances or unresolved items, with respect to NRC and the QA program requirements, were identified.</p> <p>2. Internal Audits - The inspector reviewed Section XVIII "Audits" of the vendor's QA manual to verify that: (a) planned periodic audits of all aspects of the QA program are performed in accordance with written procedures or checklists by qualified personnel; (b) the results are documented and reviewed by management; and (c) followup action is taken where indicated. A review was made of two QCR procedures, 18 checklist audit records of the QA program areas audited on November 5, 1981, and current training and certification records for 15 auditors.</p> <p>Within this area, no nonconformances or unresolved items, with respect to NRC and the QA program requirements, were identified.</p> <p>3. Nonconformances and Corrective Action - The inspector reviewed Section XV, "Non-Conforming Materials, Parts, and Components," and Section XVI, "Corrective Action," 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: two QCR procedures; four weekly product rejection data sheets; 20 inspector's reports on rejects; 20 corrective action request reports; a corrective action record summary, and corrective action record log sheets.</p> <p>Observations were made of facilities for segregation of nonconforming items in four departments.</p> <p>Within this area, no nonconformances or unresolved items, with respect to the NRC and QA program requirements, were identified.</p>		

ORGANIZATION: GENERAL ELECTRIC COMPANY
SAN JOSE MOTOR PLANT
SAN JOSE, CALIFORNIA

REPORT NO: 99900339/82-01	INSPECTION RESULTS:	PAGE 4 of 4
<p>4. 10 CFR Part 21 - The inspector reviewed the vendor's document No. SJMP-1G-54, "Complying with Regulation Reporting Of Defects And Non-Compliance," to verify that adequate documented measures are available to meet the reporting requirements of 10 CFR Part 21.</p> <p>A notice to employees, which meets the posting requirements of 10 CFR Part 21, was observed to be posted on the employee bulletin board.</p> <p>Within this area, no violations to 10 CFR Part 21, were identified.</p>		

Inspector R.E. Offer
 Scope/Module Status of Previous Inspection Findings

DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
1	4	GE-SJMP, QA Manual Section VII "Control of Measuring and Test Equipment"	8/81	9
2	8	Record of "Audit Training Session"	11-7-79	NA
3	8	Calibration Record Cards and Recall System Calibration Cards for measuring devices and test instruments.	Various	NA

Document Types:

- Drawing
- Specification
- Procedure
- QA Manual
- Purchase Order
- Internal Memo
- Letter
- Other (Specify-if necessary)

Columns:

- Sequential Item Number
- Type of Document
- Date of Document
- Revision (If applicable)

Inspector R. E. Oller
 Scope/Module Manufacturing
Process Control

DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
1	4	G.E.-SJMP, QA Manual sections I, II, V, VIII, IX, X, XI, XIV and Supplements A & B	8/81	9
2	3	Following Quality Control Requirements (QCRs) procedures: (1) QCR-IV, 9-5, "Quality System For Nuclear Class IE And Other Critical Motors" (2) QCR-IV, 9-8, "Nuclear Rotor Inspection" (3) QCR-IV, 4-3, "Inspection - Shaft Area" (4) QCR-IV, 4-10, "Large Wound Stator Inspection" (5) QCR-IV, 4-12, "Formed Wound Coil Assembly" (6) QCR-IV, 4-15, "Formed Coil & Random Stators - Rotors VPI Treatment" (7) QCR-IV, 4-16, "Rotor Inspection"	3/82 - 9/80 1/80 5/82 1/82 7/80	NA NA " " " " "
3	8	Following Inspection Records Located in the Shaft Areas: (1) Shaft Inspection Cards (2) Special Product Q.C. Inspection Reports for shafts tag nos. 4/14-20, 6/3-225 and 6/23-226 (3) Log Index of Inspector's Reports cent	current current "	" " " "

- Document Types:
1. Drawing
 2. Specification
 3. Procedure
 4. QA Manual

5. Purchase 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 R.E. Oller
 Scope/Module Manufacturing
Process Control

DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
3(cont.)	8(cont.)	(4) Inspector's Report No. 3525	—	N.A.
		(5) Work Order/Operator Sequence Lists	VARIOUS	"
4	8	Following records located in Large Wound Stator Area:		
		(1) Work Order/Operator Sequence Lists	VARIOUS	"
		(2) Large Wound Rotor Inspection sheets	"	"
		(3) Parts List Book	—	"
		(4) QCR procedures book	VARIOUS	"
5	8	Following records located in Formed Wound Coil Assembly area:		
		(1) Inspector's Report Log book	VARIOUS	"
		(2) QCR procedures book	"	"
		(3) Inspector's Reports	"	"
6	8	Following inspection records on completed electric motors for the Salem Plant:		
		(1) G.E. Requisition No. 30362115	—	"
		(2) Special Product Inspection Results record for Rotor Assembly, SN. 6/02-001	6-2-82	"
		(3) Special Product Inspection Results record for shaft with Standard Extension, SN 6/2-001	5-28-82	"

(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)

Columns:

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

DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
(cont.)	8 (cont.)	(4) Large Wound Rotor Inspection record	6-4-82	N.A.
		(5) Formed Wound Coil Inspection record	5-14-82	"
7	8	Following Inspection Records in the Rotor Inspection area:		
		(1) Work Order / Operator Sequence Lists	Various	"
		(2) Reject Log Index	"	"
8	8	Following Inspection Records for completed motors for Enrico Fermi Plant 2:		
		(1) GE Requisition 320-69585	—	"
		(2) Parts Lists	—	"
		(3) Special Products Q.C. Inspection Results record for shaft SN 4/21-3	4-3-82	"
		(4) Large Wound Rotor Stator Inspection record	4-29-82	"
		(5) Product Control Record, Vertical Pump Motor, record for SN 4/21-003	5-14-82	"
		(6) Report of Routine Test Induction Motor	5-17-82	"
		(7) Report of Tests, Induction Motor	5-10-82	"
		(8) Form Wound Coil Inspection record	3-31-82	"
		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)

Columns:

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

DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
8(cont.)	8(cont.)	(9) Inspector's Reports	Various	N.A.
		(10) Product Control Record, Vertical Pump Motor record	5-6-82	"
9	8	Following records for completed motors for A.V. Vogt/Lecht:		
		(1) Special Product QC Inspection Results record for Rotor Assemblies as follows:		
		(a) SN. 9/30-019	3-10-81	"
		(b) SN. 9/30-018	10-13-81	"
		(c) SN. 9/23-022	10-12-81	"
		(d) SN. 9/23-023	10-12-81	"
		(2) 26 Inspector's Reports	Various	"
		(3) Frame Bore Inspection, 20-42 Inch Bore Size SN 9/30-018	9-10-80	"
		(4) Special Product QC Inspection record for shaft with Standard Extension for the following shafts:		
		(a) SN 9/30-18	10-8-81	"
		(b) SN 9/30-19	10-8-81	"
		(c) SN 9/23-23	10-7-81	"
		(d) SN 9/23-22	10-7-81	"

cont.

Document Types:

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

Columns:

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

DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
1	4	GE-SJMA QA Manual Section XVIII "Audits"	8/81	9
2	3	Following quality control requirements (QCRs) procedures:		
		(1) QCR-II, 5-1, "Plant Quality System Audit"	9/80	N/A
		(2) QCR-III, 7-1, "Quality Assurance Audit of Purchasing Documents"	12/81	"
3	8	Eighteen Internal Audit Checklist Records of the Audit of the QA Program performed on November 6, 1981.	-	"
4	8	Records of Auditor Training and Certification for 15 Audit Personnel.	11/81	"

- Document Types:
- 1. Drawing
 - 2. Specification
 - 3. Procedure
 - 4. QA Manual
 - 5. Purchase 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 R. E. Oller
 Scope/Module Nonconformances
and Corrective Action

DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
1	4	GE-SJMP, QA Manual Section XV, "Non-Conforming Material, Parts And Components", and Section XVI, "Corrective Action"	8/81	9
2	3	Following Quality Control Requirements (QCR's) Procedures: (1) QCR-IX, 1-1, "Inspector's Report Record System" (2) QCR-IV, 11-1, "Correction of Conditions Adverse To Quality"	6/80	NA
3	8	Records consisting of four weekly "Product Rejection Data" sheets for the weeks ending 4/3/82, 4/9/82, 4/17/82, and 4/24/82.	-	"
4	8	Records consisting of 20 Inspector's Reports of ^{and other types of} in-process deficiencies common to Nuclear Class 1 Motors for the A.W. Vogtle Nuclear Station, for the period of 9/81 through 4/82.	-	"
5	8	Twenty Corrective Action Request records for nuclear work for the period of 1/80 through 1/81.	-	"
6	8	A corrective Action Record Summary	-	"
7	8	A corrective Action Record Log	Various	"

Document Types:

- 1. Drawing
- 2. Specification
- 3. Procedure
- 4. QA Manual
- 5. Purchase 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)

