REPORT INSPECTION INSPECTION DATE(S) 6/21-25/82 ON-SITE HOURS: 54 NO: 99900404/82-01 CORRESPONDENCE ADDRESS: Westinghouse Electric Corporation Nuclear Technology Division ATTN: R. J. Slember, General Manager P. O. Box 355 Pittsburgh, Pennsylvania 51230 P. T. McManus, Manager, Product Assurance ORGANIZATION CONTACT: (412) 273-7988 **TELEPHONE NUMBER:** PRINCIPAL PRODUCT: Nuclear Steam Supply Systems NUCLEAR INDUSTRY ACTIVITY: The Nuclear Technology Division of Westinghouse Electric Corporation (W) employs approximately 2,212 people, 100% of which are assigned to domestic nuclear power plant activities. ASSIGNED INSPECTOR: TR. H. Brichley 8/10/82 Date R. H. Brickley, Reactor Systems Section (RSS) OTHER INSPECTOR(S): P. H. Harrell, RSS APPROVED BY: Chief. INSPECTION BASES AND SCOPE: 10 CFR Part 50, Appendix B and Topical Report No. WCAP-8370. Α. BASES: Inspection made in response to the following: (1) a Preliminary Β. SCOPE: Notice from Pacific Gas & Electric Company (Diablo Canyon) concerning an apparent failure by W to forward to licensees revisions of a Pacific Pump Company instruction manual; (2) a request from NRC:RII concerning an apparent failure by W to perform audits of suppliers at least every 3 years; (3) a (cont. on next page.) Cortified by Theanne Fourts PLANT SITE APPLICABILITY: Docket Nos. 50-275, 50-323, 50-390, and 50-391.

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B. SCOPE: Cont.

construction deficiency report from NRC:RII concerning incorrect values in computer code UHISATAN provided by <u>W</u> to TVA for use in calculating peak clad temperatures following a potential accident at Watts Bar; and (4) a notification to the NRC Office of Inspection and Enforcement that under certain conditions stipulated by Babcock & Wilcox, <u>W</u> designs may provide inadequate core cooling. In addition, supplier performance and verification of supplier activities were inspected.

A. VIOLATIONS:

None

B. NONCONFORMANCES:

Contrary to commitments contained in Table 17-1 of WCAP-8370, Revision 9A, <u>W</u> had not performed a formal evaluation each year or conducted an audit of Anchor Darling every 3 years to maintain them as a qualified supplier nor had tney otherwise requalified them prior to Anchor Darling performing modifications to valves for Watts Bar. The last audit of Anchor Darling was in March 1975, and the last Supplier Performance Evaluation in November 1977.

C. UNRESOLVED ITEMS:

None

D. OTHER FINDINGS OR COMMENTS:

1. Control of Supplier Manual Revisions - An NRC Preliminary Notification dated October 18, 1981, (PNO-V-81-60) reported a failure of a safety injection pump at Diablo Canyon during surveillance testing. Inspection revealed the pump wear ring had seized the shaft. Reportedly, the pump manufacturer (Pacific Pump) had issued a change to their instruction manual for this pump about January 1981, which corrected this problem. This change was transmitted to Pacific Pump customers, W in this case, but W apparently did not forward the change to the licensee.

A review of the records maintained by W on this item disclosed: (1) Procurement Advisory Release (PAR) No. 38, issued by W to Pacific Pump on November 2, 1981, gave an approval status code of I indicating the subject change had been received for information; (2) the change to the Operations & Maintenence Instruction (Sections 6E-6 and 6E-9) recommended replacement of the impeller nut set screws with Locktite 242 the next time the pumps are disassembled for service or

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	repair; and (3) the November 1981, to al	subject change had been transmit 1 affected licensees; i.e., D. C on 1 and 2, Salem 1 and 2, Seque	C. Cook 1 and 2, Zion
	There were no noncon	formances or unresolved items ic	dentified.
2.	identified by the NR had contracted Ancho head injection isola QA procurement servi conducted triennial	riennial Audits of a Supplier - RC Region II Resident Inspector a pr Darling, through Westinghouse ation valves. During a Region II ces, the available records indic audits of Anchor Darling per the WCAP-8370, Revision 9A, Table 1	at Watts Bar. TVA , to modify upper I inspection of TVA's cated that <u>W</u> had not eir commitment in
	Procedures (PAP) Man qualified supplier 1 supplier audits. Th were reviewed: Anch	ewed the Water Reactor Division (nual and Product Assurance Proced list, supplier performance evalua nose records maintained on the fo nor Darling, Speedway, Southwest soll-Rand, Joseph Oat, and ITT-Ba	dures Manual, ations, and ollowing suppliers Fabricators,
	conducted on Februar evaluation on Novemb stated that all equi anticipated, and tha new orders or activi Anchor Darling was n The nonconformance, Annual supplier perf	Darling records disclosed that by 11-12, 1975, and the last support poer 16, 1977. The supplier perfor poment had been shipped, no new of at an audit was required prior to ties on equipment returned from not listed on the latest <u>W</u> quality identified in B above, is a resu formance evaluations and trienning ters had been performed as commit i.	olier performance ormance evaluation orders placed or o placement of sites. fied supplier list. ult of this review. al audits of the
3.	was notified by Babo provisions included owners on inadequate inadequate core cool Safety Features Actu low reactor coolant conditions (superhea errors, then the ope	ns - The NRC's Office of Inspecti cock & Wilcox (B&W) on January 12 in guidelines provided to B&W's core cooling that, if followed ling. If, during a small LOCA, to uation System is automatically ac system pressure, and inadequate at) are incorrectly indicated due erator, by following the guideling pumps to continue to run. But	2, 1982, that operating reactor , could result in the Engineered ctuated due to core cooling e to instrument nes, would allow

REPORT			INSPECTION	PAGE 4 of 5
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	satu the	rated conditions	, the reactor coolant syste , rather than superheated. r prior to the high pressu	Subsequent loss of
	pump coul	s were subsequen	r were misled by instrument tly lost, unacceptable core &W had notified their licent is situation.	e cooling conditions
	B&W resp stud appl conc prom cool	concern and, if ect to this conc y which conclude icable to the gu lusion was based pted by a set of ant thermodynami	s inspection was to determ so, had they reviewed their ern. The inspector reviewe d that the concerns express idelines prepared by <u>W</u> for on recommended operator as parameters which include, c state. For all criteria development of action leve	r guidelines with ed the results of a <u>W</u> sed by B&W are not their customers. This ctions which are but are not limited to, , instrument uncertainties
4.	Regi outp prod	on II via a CDR ut data from the	er Code UHISATAN - This iter from the licensee (TVA) and W computer code UHISATAN. culating peak clad tempera	d concerns erroneous This code is used to
	main	inspector review tained by the Sa review disclose	wed applicable procedures a afety Review Committee on t ed that:	nd the records his item (PI-81-145).
	a.	tected during r	as created by a hardware ma routine preventive maintena about March 21, 1979.	lfunction that was de- nce of the A-system
	b.	System users we 1979, and were	ere notified of this malfun advised to check the accur	ction on March 21, acy of their results.
	c.	Watts Bar run,	e responsible engineer revi compared the data with tho the results were correct.	ewed the results of the se of similar runs, and
	d.	time the code w icantly different the A-system (N	nange in code input data in was run on the B-system com ent results. Further inves MFA) and B-system (MFB) ver onfigurations code did not	puter and gave signif- tigation disclosed that sions of the most recent
			The second se	and the second

 When the absolute version of the code on MFA was produced (3/15/7 unreproducable computer hardware caused the computer (FTN4.1) to produce errors in the absolute file version of the code during conversion from Fortran to machine language. e. The rerun of the code for Watts Bar resulted in an increase in th highest peak clad temperature from 20950 to 21710 F. f. The W investigation of this problem involves some 250 analyses that were run on MFA from January 1978 to the present. At the time of this inspection, 200 of these had been checked with the only identified errors being those in UHISATAN. All ECCS codes that were run during the period in question have been checked. A review of the status of the W investigation of the effect of the computer malfunction on safety-related codes will be conducted during a future inspection. There were no nonconformances or unresolved items identified. Supplier Performance - Applicable procedures from the PAP Manual were reviewed to determine that procedures had been prepared and approved by W that prescribe a system for evaluation of supplier performance which is consistent with the comfutemation were reviewed to determine that procedures had been prepared and approved by W that prescribe a system for evaluation of supplier performance which is consistent with the comfutemation were reviewed to determine that procedures had been prepared and approved by U that prescribe a system for evaluation of supplier performance which is consistent with the commitments in Topical Report No. WCAP-8370. Ingersoll-Rand, Joseph Oat, and ITI-Barton) were reviewed to determine that procedures had been prepared and approved by W that prescribe a system for verification activities which is consistent with commitments in Topical Report No. WCAP-8370. The records maintained on six items procedures from the PAP Manual were reviewed to determine that procedures for verification activities which is consistent with commitments in Topical Report No. WCAP-8370	EPORT 0: 9990	00404/82-01	INSPECTION RESULTS:	PAGE 5 of 5
 highest peak clad temperature from 2095° to 2171° F. f. The W investigation of this problem involves some 250 analyses that were run on MFA from January 1978 to the present. At the time of this inspection, 200 of these had been checked with the only identified errors being those in UHISATAN. All ECCS codes that were run during the period in question have been checked. A review of the status of the W investigation of the effect of the computer malfunction on safety-related codes will be conducted during a future inspection. There were no nonconformances or unresolved items identified. Supplier Performance - Applicable procedures from the PAP Manual were reviewed to determine that procedures had been prepared and approved by W that prescribe a system for evaluation of supplier performance which is consistent with the commitments in Topical Report No. WCAP-83 The records maintained on six items procured for Comanche Peak from six suppliers (Speedway, Southwest Fabricators, Pacific Pump, Ingersoll-Rand, Joseph Oat, and ITT-Barton) were reviewed to determine that procedures had been prepared and been properly and effectively implemented. Verification Activities - Applicable procedures from the PAP Manual were reviewed to determine that procedures for the PAP Manual were reviewed to determine that procedures for the properly and effectively implemented. Verification Activities - Applicable procedures from the PAP Manual were reviewed to determine that procedures had been properly and effectively implemented. Verification Activities - Applicable procedures from the PAP Manual were reviewed to determine that procedures had been prepared and approved by W that prescribe a system for verification activities which is consistent with commitments in Topical Report No. WCAP-8370. The records maintained on six items procured for Comanche Peak from the six suppliers identified in paragraph 5 were reviewed to determine that procedures for verification activities whi		When the absolu unreproducable produce errors	computer hardware caused the in the absolute file version (computer (FTN4.1) to of the code during
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		There were no noncon	formances or unresolved items	identified.

PERSONS CONTACTED

Company Westinghouse

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Dates 6/21-25/82

Docket/Report No. 404/82-01

Inspector R. H. BRickley

Page_1_of_1___

NAME(Please Print)	TITLE(Please Print)	ORGANIZATION(Please Print)
BRIAN A. M'Tarme	ACTING MANAGER SAFEGUARD AN	1513 WESTLICHOUSE NULION SHEET
JOHN J. BESSPIATA	SENIOR ENG. B, SED	WESFINGHOUSE NUCLEAR SAFET
Philip T. Mc MANUS	MANAGER, DESIGN ASSURANCE SYSTEMS	
ROBERT A. WIESEMANN	MGR, REGULATORY & LEGISLATIVE ATTA	us W N.S.
Michael H. SHANNON	Serier QUALITY ENDE. NTO DASYSTERS	A DECEMBER OF THE OWNER OWNER OWNER OWNER OWNER OWNER OWNER OWNER OWNER OWNE
Robert E. Kelly	Manager, Pump and Manager, Valve Engineer	WTD/SEED
WR SPEZIALETT	MGR, PLANT LICENSING BESTER &	W NTO / NUC SAFETY
J.T. Grane	Engineer Plant Licensing	W NTD/ Nuc. Safety
EA TOMASIKO	MANAGER QA LANDERRIAG	
E.J. SAUPE	QA. ENG.	WNTO DIJOA
N.T. DROGEL	GA MAR, - MECHNICAL	WNTD PIÉDA

ATTENDANCE LIST

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OMPANY: WESTING +	buse DO	CKET NO. <u>99900404</u>
	Pre-Inspection Conference	177
ME (Please Print)	The second	ORGANE ATION Print)
PHARRELL	REACTOR ENGINEER	
R. H. TBRICKLEY	REACTOR ENGLNEER	NRC/RIV/VIT3
EATOMASKO	MANAGER, QA ENGG	NTO PIZDA
M. H. SHANNON	SENION QUALITY ENGINEER	WNTD PIJDA
Philip T. Mc MANUS	MGR, DESIGN Assurance Systems	WNTD PI+DA
Henry Beel	Myn. QA Electrical Surv.	WNTO PIDA
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Inspector T.H. Brickley

Scope/Module REVISION to S.I. PUMP INSTRUCTION MANUAL

DOCUMENTS EXAMINED

Docket No. 99900404 Report No. 92-01 Page 1 of 1

1	2	TITLE/SUBJECT	3	4
1	7	EP-SA-34987 (DIAble CANYON Site Safety Injection PUMp)	11/12/81	NA
2	8	PROCUREMENT Advisory Release (PAR) #38 (Operations & Maintenance Instructions 2348) to PACIFIC Pump	11/2/81	
3	8	Document Applicability Form	10/26/81	
4	3	WRD-OPR-H.O (PROCUREMEN! DocuMENT Control)	3/20/81	2
5	3	WRD-OPE-T.OLCONTROLOF PURCHASEd MATERIA EQUIPMENT, & SERVICES)	1/19/82	3
6	4	NTD/SOD DEGIGN CONTRO/ MANUAL		
7	3	NTD-DPP-2. 8(PROCUREMENT CONTROL)	7/24/8/	٥
8	3	NTD-DPP-ZD (DOCUMENT CONTRol)	7/24/31	. 1

Document Types:

- 1. Drawing 5. Purchas 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)

Inspector R.H. BRICKley

Scope/Module UHISATAN Computer Code ERROR

DOCUMENTS EXAMINED

Docket No. 99900404 Report No. 82-01 Page (of 1

6 6 6 4	SE-05A-305 (PARTIAL EVALUATION MEA SAFETY-Related Calculations) SED-APM-DIGLMEA SAFETY-Related Calculations) NS-AT-9725 (MFA SAFETY-Related Calculations) ECS-5301 (SATAN Result Differences) SAFEGUARDS ENGINEERING INSTRUCTION & GUIDANCE MANUAL (SEIGM)	1/27/82 5/7/82 1/8/82 12/14/81	NA NA NA
6 6 4	SED-APM-DIGLMEA SAFEty-Related Calculations) NS-AT-9725 (MFA SAFEty-Related Calculations) ECS-5301 (SATAN Result Differences)	1/8/82	NA
6 4	NS-AT-9725 (MFA SAFEty-Related Calculations) ECS-5301 (SATAN Result Differences)		
4	ECS-5301 (SATAN Regult Differences)	12/14/81	NA
	SAFEGUARDS ENGINEERING INSTRUCTION & GUIDANCE MANUAL (SEIGM)		
7			
3	NG-BE-IG-14 (NRC REQUIREMENTS)	-	0
3	NS-SE-IG-15 (REPORTING OF Potential SAFEty ISSUES)		0
н	WED Policy & PROCEDURES MANUAl (PEPM)		
3	WR.D-OPR-3.2 (VERIFICATION of COMPUTER PEOSRAMS USEd IN		
	ENGINEERING ANALYSIS, DESIGN OR Safety ANALYSIS)	3/20/81	1
3	WED-OPR-3.3 (Configuration Control of Computer PROGRAMS)	3/20/81	1
6	MEMA #205 (A-System Divide ERROR)	3/21/79	NH
	н З Э	 WED Policy & PROCEDURES MANUAL (P&PM) WED-OPR-3.2 (VERIFICATION OF COMPUTER PROSRAMS USED IN ENGINEERING ANALYSIS, DESIGN OR SAFETY ANALYSIS) WED-OPR-3.3 (Configuration Control of Computer PROGRAMS) 	H WRD Policy & PROCEDURES MANUAl (P&PM) 3 WRD-OPR-3.2 (VERIFICATION OF COMPUTER PROBRAMS USED IN ENGINEERING ANALYSIS, DESIGN OR SAFETY ANALYSIS) 3/20/8/ 3 WRD-OPR-3.3 (ConfiguRation Control of Computer PROGRAMS) 3/20/8/

Document Types:

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

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- 4. Revision (If applicable)

Inspector R. H. Brickley & P.H. HARREll

Scope/Module TRIENNIAL AUDIT of Anchur DARLING Supplier PERFORMANCE VERIFICATION Activities

DOCUMENTS EXAMINED

Docket No. 99900404 Report No. 82-01 Page / of 3

1	2	TITLE/SUBJECT	3	4
1	3	NTD-DPP- 2. 2 (PROCUREMENT CONTRO!)	7/24/81	0
z	3	NTD-DPP-20 (DocuMENT Contizo/)	7/24/81	(
3	3	WED-OPE-12.0 (CONTROL OF MEASURING & TEST Equipment)	3/20/81	1
4	3	WRD-OPR-10-0 (INSPECTION)	3/20/81	2
5	3	PRODUCT ASSURANCE PROCEDURE (PAP)-2.1 (QUALIFICATION REQUIREMENTS		
		for Audit PERGONNEl)	7/1/21	Z
6	3	PAP-Z.Z (QUALIFICATION OF SURVEILANCE PERSONNEL)	7/1/8/	3
7	3	PAP-2.3 (QUALIFICATION & TRAINING & CERTIFICATION OF	6/9/82	3
		PERGONNEL IN NDE)		
8	3	PAP-3.0 (SuppliER EVALUATION & AppROVAL)	6/9/80	4
9	3	PAP-3.1 (Supplier QA System REQUIREMENTS)	7/1/8/	Z
10	3	PAP- 3.2 (QUALity PROCUTEMENT Specification)	7/1/81	2
11	3	PAP-3.3 (Notification of Hold / Hotification Points)	7/1/8/	1
2	3	PAP- 3.4 (SuppliER SURVEILLANCE)	7/1/8/	z
13	3	PAP- 3.6 (Quality Releases)	7/1/81	2
14	3	PAP-3.7 (Supplier Quality Releases)	7/1/81	1
15	7	PAP-3.8 (SuppliER CORREctive Action Notice)	7/1/81	,

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 T.H. Brickley & P.H. HAREell

Scope/Module TRIENNIAL Audits of Anchor Darling Supplier Performance VERIFICATION Activities DOCUMENTS EXAMINED

Docket No. 99900404 Report No. 82-01 Page 2 of 3

1	2	TITLE/SUBJECT	3	4
16	3	PAP-3.9 (SURVEILLANCE & TRIP/CONTERENCE REPORTS)	7/1/81	1
17	3	PAP - 4.4 (CORRECTIVE Action Notice)	7/1/81	1
18	5	PO # 546-CPK-27112-BN (CROM SEISMIC Support Arry)	10/19/17	0
19	8	Records MAINTAINED ON P.O. 271102 CONSISTING of REQUISITION	VARIOUS	VARIOUS
		CHANGE Notices, CHANGE Notices, Supplier AcknoledomEntof		
		CHANGE Notice, PROCUREMENT Advisory Reports, Releases,		
		Field Difficiency Reparts, SURVEIllANCE Reports, Quality		
		RELEASES, Supplier PERFORMANCE EVALUATIONS, AND SupplieR		
		Audits by W.	+124/37	
20	7	W LTR to TVA (ANCHOR DARLING UHI VALVE ModiFICATIONS)	+/24/81	NA
21	8	QUALFIED SUPPLIER List	6/4/82	NA
22	8	Quality PROBRAM Audit Report (Anchor DARLING) # QE-75-122	3/12/75	NA
23	5	PO#546-CAV-236901-T3PE (CHARGING SI FUMPS)	6/27/75	0
24	8	Records MAINTAINED ON PO#236901. Sime contents to item 19	12/20/15	
25	5	PO#546-CAZ-241672-BN (REDIDUAL HEAT EXCHANGERS)	12/30/75	0
26	8	RECORDS MAINTAINED ON PO # 241677. Similar to contents of item 19	VARIOUS	VARIOUS
27	5	PO# 546-CLC-407101-F3N (CLASS I TRANSMITTER-LEVELA)	6/27/79	0

Document Types:

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

Scope/Module Travenial Auchity of Auchon Darahine Inspector 72.4. Daukley \$ P.H. HARDEll

DOCUMENTS EXAMINED

Supplier Performance Verification Hetivities

Sequential Item Number Type of Document VATUOUS VATENUS PARIOUS 0 0 4 51/1/2 VARIOUS VARIOU+ 12/16/76 VARIOUS Columns: 3 -Records MAINTAINED ON TO #407101. Sum Parte contents of item 19 Records reactained on PO# 253731. Singilar to contexts of item 19 Records Maintained on PO" 121972. Similar to contents of item 19 P6#546-CAL-181972-BN(R.H.R. TUMP) TITLE/SUBJECT 70 = 546 - - 253731 Purchas Order Document Types: 5 0 5 00 0 Drawing N 32 28 29 OF 3 1

Specification Procedure in't

QA Manual

5. 8.

Internal Memo

Letter

Other (Specify-if necessary)

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