

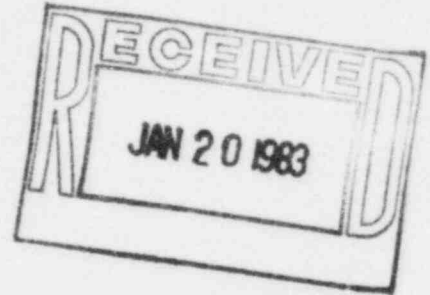


GULF STATES UTILITIES COMPANY

RIVER BEND STATION POST OFFICE BOX 220 ST. FRANCISVILLE, LOUISIANA 70775
AREA CODE 504 635-3237 387-4257

January 14, 1983
RBG-14,135
File Nos. G9.5, G15.4.1

Mr. John T. Collins, Regional Administrator
U. S. Nuclear Regulatory Commission
Region IV, Office of Inspection and Enforcement
611 Ryan Plaza Drive, Suite 1000
Arlington, Texas 76011



Dear Mr. Collins:

River Bend Station Unit 1
Refer To: RIV
Docket No. 50-458/Report No. 82-15

This letter is in response to the Notice of Violation contained in I&E Report No. 50-458/82-15. The inspection was conducted at the River Bend Station construction site by Mr. L. D. Gilbert and Mr. C. E. Johnson during the period of November 15-19, 1982, of activities authorized by the NRC Construction Permit No. CPPR-145 for River Bend Station Unit No. 1.

Gulf States Utilities Company's response to the Notice of Violation concerning a "Failure to Follow Procedure", is provided in the enclosed attachment. We will be glad to discuss any further comments that you may have regarding our response.

Sincerely,

W. J. Cahill, Jr.
Senior-Vice President
River Bend Nuclear Group

WJC/RJK/kt

Attachment

cc: Director of Inspection & Enforcement
U. S. Nuclear Regulatory Commission
Washington, D. C. 20555

R. L. Brown (SRI)

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PDR ADOCK 05000458
G PDR

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RBG- 14,135

ATTACHMENT

RESPONSE TO NOTICE OF VIOLATION

Reference

Notice of Violation - G. L. Madsen letter dated December 16, 1982, refer to: Docket 50-458/82-15.

Failure to Follow Procedure

Criterion V of Appendix B to 10 CFR Part 50 requires that activities affecting quality shall be prescribed by documented procedures of a type appropriate to the circumstances, and shall be accomplished in accordance with the procedures.

Stone & Webster Welding Procedure W-3 for welding carbon steel specifies in Weld Technique Sheet W3-03, Revision 3, that when welding the root pass using a current of 100 amps, the travel speed shall be 2.25 inches per minute minimum.

Contrary to the above:

On November 16, 1982, the NRC inspector observed the root welding of weld FW002, designated as a class 1 weld on Drawing 1-FWS-066A for the feedwater system, and determined that a travel speed of 1.7 inches per minute and a welding current of 100 amps were being used. This travel speed does not meet the 2.25 inches per minute minimum travel speed requirement of Weld Technique Sheet W3-03.

This is a Severity Level V violation. (Supplement II.E)
(458/8215-01)

Corrective Steps Which have Been Taken and The Results Achieved

A review of the Procedure Qualification Records has been performed for Weld Technique Sheet W3-03. The review revealed that a lower minimum travel speed than that specified was allowable. Weld Technique Sheet W3-03 has been revised to specify a travel speed of 1.4 inches per minute at a welding current of 100 amps and 14 volts. (E&DCR No. C-11,866 dated November 19, 1982, Page 4). Nonconformance and Disposition Report No. 3006 has been dispositioned to "accept-as-is" the nonconforming item.

Corrective Steps Taken To Avoid Further Violations

Training of welders and Weld Supervisors has been provided to assure a full understanding of travel speed and weld technique sheet requirements. These persons have been instructed on the necessity to adhere to procedure requirements. Weldments which warrant heat input control will be identified prior to welding. For these weldments,

FQC has added to the inspection plan an attribute to check weld travel speed. When welding requiring travel speed restrictions is being performed, each weld inspector will inspect for weld travel speed once per four day shift. The welding technique sheets for welds which warrant heat input control have been reviewed to determine if they fully utilize the allowable heat inputs for which the technique was qualified, and where applicable, revisions to the weld technique sheets have been implemented.

Date When Full Compliance Will Be Achieved

Full compliance has been achieved.

