

ORGANIZATION: WESTINGHOUSE ELECTRIC CORPORATION  
NUCLEAR FUEL DIVISION  
COLUMBIA, SOUTH CAROLINA

REPORT NO.:	99900005/82-01	INSPECTION DATE(S)	7/27-30/82	INSPECTION ON-SITE HOURS:	28
CORRESPONDENCE ADDRESS: Westinghouse Electric Corporation Nuclear Fuel Division ATTN: Mr. W. M. Jacobi, General Manager P. O. Box 355 Pittsburgh, PA 15230					
ORGANIZATIONAL CONTACT: Mr. R. R. Cost, Operations Product Assurance TELEPHONE NUMBER: (412) 373-5105					
PRINCIPAL PRODUCT: Nuclear Fuel Assemblies. NUCLEAR INDUSTRY ACTIVITY: Nuclear fuel supplier for Westinghouse-designed cores.					
ASSIGNED INSPECTOR: <u><i>[Signature]</i></u> <u>8-25-82</u> for W. M. McNeill, Reactive & Component Program Section Date (R&CPS)					
OTHER INSPECTOR(S):					
APPROVED BY: <u><i>[Signature]</i></u> <u>8-25-82</u> for I. Barnes, Chief, R&CPS Date					
INSPECTION BASES AND SCOPE: A. <u>BASES</u> : Westinghouse Topical Report WCAP 7800/5A. B. <u>SCOPE</u> : Control of component fabrication (nozzles); nonconformances and corrective actions; document control; and action on previous inspection findings.					
PLANT SITE APPLICABILITY: None identified.					
DESIGNATED ORIGINAL Certified By <u><i>Rheanne Jouts</i></u>					

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99900005 PDR

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A. <u>VIOLATIONS:</u>		
None		
B. <u>NONCONFORMANCES:</u>		
1. Contrary to Section 5 of the Topical Report and Quality Control Instruction (QCI)-000147, one of the eight Procedure Checklists sampled, namely a strap inspection procedure, QCI-933025 had not been retained, as required.		
2. Contrary to Section 5 of the Topical Report and Manufacturing Operating Procedure-14, a required Operating Procedure-715604, of the 14 procedures sampled, had not been added to the assigned book in work area 61 (Spider Rework Station).		
C. <u>UNRESOLVED ITEMS:</u>		
None		
D. <u>STATUS OF PREVIOUS INSPECTION FINDINGS:</u>		
1. (Closed) Nonconformance (81-02): A plating voltage was observed which was above the procedure limits. The procedure in question has been revised and the limits opened. An internal audit in January verified compliance to the revised procedure.		
2. (Closed) Nonconformance (81-02): Quality Control Instruction, QCI-93400 and Operating Procedure, OP-711001 did not have the appropriate acceptance criteria and applicable parametric limits as defined by the Process Specification 595221. The QCI, OP and Process Specification all have been revised to establish new acceptance criteria. An internal audit in January verified compliance to the revised procedures and specification. This revision of the Process Specification also made the parametric limits in question target values and not toleranced limits.		
3. (Closed) Nonconformance (81-02): There was insufficient documentation available to show that a currently used heat treat procedure had been qualified. Qualification data and reports have been issued for all special processes. Some special processes had been "grandfathered." One qualification memo QC-MJF-81-012, appears to conflict with the product specifications paragraph 5.4 for nozzles, grids, etc. This will be followed up during the next inspection.		

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<p>4. (Closed) Nonconformance (81-02): The Maintenance Calibration Card for a tour gage on the Unit B leak detector failed to record the calibration performed on October 22, 1980, and the last entry on the card was misdated. A review of Maintenance Calibration Cards and instruments found no further problem in this area.</p> <p>E. <u>OTHER FINDINGS OR COMMENTS:</u></p> <ol style="list-style-type: none"><li>1. Control of Component Fabrication (Nozzles) - The specifications and procedures on nozzle fabrications were reviewed. Nozzle inspection was observed. The inspection records and documentation were reviewed. All activities were found to follow the established procedures.</li><li>2. Nonconformances and Corrective Actions - The identification, segregation, disposition, and documentation of nonconformances were verified to follow the established procedures. Eight Deviation Notice Disposition Requests, Quality Control Deviation Notices, Defective Apparatus Tags, and Material Rejection Notices were sampled. It was observed that the status of material could be confused because of the practice of reusing cardboard boxes with DNDR and/or QC Release type tags on them. A number of nozzles were observed with tags of different serial numbers and status on the outside of the storage boxes than that of the hardware and associated routings inside the boxes. Loss of identification did not result because of this, in that routings did identify the materials. Westinghouse is, however, reviewing this practice.</li><li>3. Document Control - The review, approval, release, and distribution of procedures were verified to follow the established procedures with the exceptions noted. The controls of changes, revisions, markups, etc., were verified. A sample of eight Quality Control Instructions were reviewed and nonconformance B.1 was identified. It was noted by the NRC inspector, that due to a change in supervision in that area several years ago, the record in question may have been lost or misfiled. Some 11 other such records should have also been issued during that time frame to the area of strap inspection. A sample of 14 procedures, and seven drawings were reviewed. One nonconformance, B.2, was identified on the distribution of OP's. OP-715604 was the only repair type procedure in the sample, although many repair type procedures have been issued. It was reported that the review by the area supervisor did not address repair type procedures due to an oversight.</li></ol>		

PERSONS CONTACTED

Company Westinghouse

Dates 7/27/82

Docket/Report No. 99900005/82-01

Inspector McKidd

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NAME(Please Print)	TITLE(Please Print)	ORGANIZATION(Please Print)
* P. KAYS	PLANT OPERATIONS PROD. ASSURANCE	(W)
* K.R. COST	OPERATIONS PRODUCI ASSURANCE	
H.D. HINSON	QC RECORDS ENG.	
* S.S. PATRICK	QC DEV. ENG.	
M A SCHWARTZMAN	QC ENG MGR.	
R JAMES	INSPECTION FOREMAN	
J FREE	Mfg FOREMAN	
* B. WHITEHEAD		
* F. SCHAFFER		
J. BUSH		
* S		

Inspector Westinghouse  
 Scope/Module follow up

DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
OP 711001	3	PLATE STRAP	10/5/81	16
QC 934001	3	INNER & OUTER INCONEL GRID STRAPS - PLATING INSPECTION, ETC	6/2/81	12
NPS 59521	2	NICKEL PLATING OF MONEL-718 FOR BRAZING PURPOSES	MAY 13, '81	11
OPA 81-010	9	OPERATIONS PRODUCT ASSURANCE INTERNAL AUDIT	OCT 26 '81	-
82-010	9	QA QUALIFICATION FILE - CHEMICAL AREA QUALIFICATIONS	SEPT 24 '81	-
82-011	9	QUALIFICATION OF FINAL ASSEMBLY WELDS	SEPT 1 '81	-
QC-WJF 81-012	9	HEAT TREATING, BRAZING, SPECIFICATIONS - QUALIFICATION FILE	SEPT 1 '81	-
82-ADD 81-011	9	QUALIFICATION OF MACHINE SHOP WELD	SEPT 12 '81	-
QCOP-91	4	CONTROL OF SPECIAL PROCESSES	5-23-80	5
QC-0000	3	TOOL & GAGE CONTROL	2-12-82	11
86	3	TOOL & GAGE INSPECTION PROCEDURE	5-19-81	4
-	9	FOLLOW UP OF INTERNAL AUDIT 81-010	1-5-82	-
-	3	ROD ACCOUNTABILITY AND MONITORING SYSTEM MANUAL	-	-
QC-D-SSP 84-82	9	UT QUALIFICATION REPORT	2-5-82	-
QC-D-SSP 84-82	9	X-RAY FLUORESCENCE OF SEAL WELLS	APRIL 29, 82	-
QCOP 15.1	NCCA 4	NONCONFORMING MATERIALS, PARTS COMPONENTS ASSEMBLIES, AND PROCESSES	5-13-82	6

- Document Types:
1. Drawing
  2. Specification
  3. Procedure
  4. QA Manual
  5. Purchase Order
  6. Internal Memo
  7. Letter
  8. Other (Specify-If necessary)
  9. Report
- Columns:
1. Sequential Item Number
  2. Type of Document
  3. Date of Document
  4. Revision (If applicable)

Inspector Westinghouse  
 Scope/Module NRCA

DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
00016.1	2	CORRECTIVE ACTION	14-24-78	1
00017.3	4	QC HOLD TAGS	5-18-82	5
00014.5	3	"DA" TAG CONTROL PROGRAM	5-8-81	7
932916	3	CONTROL OF DEVIATIONS NOTED IN INSPECTION (MACHINE SHOP)	6-2-82	5
00019.8	3	SUPPLEMENTAL QCI INSTRUCTIONS & GENERAL INSTRUCTIONS	7/24/79	6
00011.2	3	QUALITY CONTROL DEVIATION NOTICE (QCDN)	JULY 6 '82	14
00012.6	3	RECEIVING INSPECTION OF PURCHASED CORE COMPONENTS & MATERIAL	5/2/82	10
00016.2	3	MATERIAL REJECTION NOTICE (MRN) FILE	4/9/80	8
00016.1	Doc. Control			3
00010.5	4	DOCUMENT CONTROL	7-26-82	6
00010.9	3	PREPARATION & REVISION OF QUALITY CONTROL INSTRUCTIONS	4/29/81	13
00011.0	3	ENGINEERING CHANGE NOTICE REVIEW, APPROVAL & DOCUMENT	JULY 21, 82	13
00011.7	3	CONTROL AND DISTRIBUTION OF QUALITY CONTROL OPERATING PROCEDURES	12/6/77	2
00012.5	3	JOB ORDER AND CDAR REVIEW, ACKNOWLEDGEMENT & IMPLEMENT	JULY 12 '82	6
00012.9	3	QC REVIEW OF PURCHASE ORDERS	2/19/82	9
00013.1	3	NEW SPECIFICATION REVIEW AND APPROVAL	5/28/81	5
		IMPLEMENTATION OF CONTRACT QUALITY ASSURANCE REQUIREMENTS	12/22/81	0

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Inspector McNeill  
 Scope/Module Dr. Control

DOCUMENTS EXAMINED

1	2	TITLE/SUBJECT	3	4
QCI 000147 DATE JUN 00010	2	CONTROL & DISTRIBUTION OF QCI	JUL 22 82	4
CAGE 103 CAMEGUP	3	OPERATING PROCEDURES - MACHINE SHOP PROCESS DRAWINGS	JUL 6 '81	16
	3	QC INSTRUCTION STATUS	7/21/82	10
	9	MECHANICAL OF SOI-PD STATUS	7/22/82	-
	9			-
	NOZZLES			
1101E77	1	TOP NOZZLE	-	30
NFP 31037	2	PRODUCT SPECIFICATION STAINLESS STEEL NOZZLE ASSY	APR 30 '82	17
NPS 80314 MOP-14	2	PROCESS SPECIFICATION FAB. OF TOP NOZZLES FOR NUCLEAR F.A.	SEPT 27 '79	4
QCI 931001	3	MAINTENANCE AND DISTRIBUTION OF OP-SOI-PD STATUS REPORT	12/17/80	1
93102 NFP 21039	3	BOX TOP NOZZLE FINAL INSPECTION	4/22/82	27
	3	ENGRAVED COMPONENTS FINAL INSPECTION AND NOZZLE S-HOLE	5/19/82	16
	2	NICKEL-ALLOY FUEL ASSEMBLY GRIDS		21

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