

U. S. NUCLEAR REGULATORY COMMISSION

REGION V

Report No. 50-206/82-25

Docket No. 50-206

License No. DPR-13

Licensee: Southern California Edison Company  
2244 Walnut Grove Avenue  
Rosemead, California 91770

Facility Name: San Onofre Unit 1

Inspection at: San Clemente, California

Inspection Conducted: August 30 - September 3, 1982

Inspectors:

W. J. Wagner  
W. J. Wagner, Reactor Inspector

9-17-82  
Date Signed

Approved by:

G. B. Zwetzig  
G. B. Zwetzig, Chief  
Engineering Programs Section

9/17/82  
Date Signed

Summary:

Inspection on August 30 - September 3, 1982 (Report No. 50-206/82-25)

Areas Inspected: Routine, unannounced inspection by regional based inspector of construction activities associated with the seismic upgrading of safety related structures and supports. The inspection involved 32 onsite inspection hours by one NRC inspector.

Results: No items of noncompliance or deviations were identified.

## DETAILS

### 1. Individuals Contacted

#### a. Southern California Edison Company (SCE)

- \*J. M. Curran, QA Manager
- \*J. D. Dunn, Project QA Supervisor
- \*M. J. Speer, Compliance Engineer
- \*P. A. Croy, Manager, Configuration Control & Compliance
- \*G. W. McDonald, QA/QC Supervisor
- \*H. A. Timmons, QA Engineer
- \*N. R. Dickinson, Construction Supervisor
- \*W. C. Moody, Deputy Station Manager
- R. F. Brown, QA Engineer
- T. M. Broughton, Civil Engineer

#### b. Bechtel Power Corporation (Bechtel)

- J. Sherman, Senior QA Engineer
- \*R. Nilius, Project Field QC Engineer
- \*G. R. Klein, Welding Engineer
- T. Blumfield, Lead Welding QC Engineer
- W. J. Quiris, Lead Field Welding Engineer

\*Denotes those attending exit interview on September 3, 1982.

### 2. On-Site Quality Assurance Activities

The inspector reviewed the quality assurance organizations' (SCE and Bechtel) involvement in the seismic upgrading activities relative to surveillance and audits of the construction effort. Bechtel, who is responsible for the design and installation of the seismic supports, is performing their quality activities in accordance with their "Project Quality Assurance Manual for SONGS Unit 1." This manual is implemented by Bechtel's Field Construction and Quality Control Manual. All jobsite functions listed in the quality control manual are audited once a year.

In addition to this program, Bechtel has increased their surveillance activities until all seismic modifications are completed. The inspector examined several nonconformance reports (NCR's) generated from the audits and surveillances performed for appropriate and timely corrective actions and evidence of management review.

SCE is performing audits and surveillances of Bechtel's construction activities for compliance to Bechtel quality assurance procedures. The following SCE inspection reports are indicative of the type of surveillance reports being performed; these reports are listed in SCE's Field Surveillance Report Log.

<u>Inspection No.</u>	<u>Activity</u>
. M-179-82	Welding Procedures and Welder Qualifications
. M-180-82	General Welding Requirements
. M-186-82	Calibration and Control of Measuring and Test Equipment
. M-188-82	Weld Filler Material Control
. M-197-82	General Welding Requirements
. M-206-82	S. W. Turbine Building El. 14' Pipe Shop
. M-213-82	General Welding Requirements

In regards to in-process welding activities, SCE quality assurance verifies proper compliance to procedures whereas Bechtel welding quality control engineers observe the actual welding process.

Review of the surveillance logs indicates that between Bechtel and SCE there are approximately 15 surveillances being performed each week with no major problems having been identified to date.

No items of noncompliance or deviations were identified.

### 3. Welding Activities

#### a. Weld Procedure Review

The following Bechtel Welding Procedure Specifications (WPS) and Procedure Qualification Records (PQR's) were examined for compliance with AWS D1.1 requirements:

- . P1-A-c-Lh, Revision 1 of 7/3/73, PQR's 5, 6 and 331
- . P1-A-Lh (Structural), Revision 2 of 5/3/77 - Prequalified Joint Details
- . P1-A-c-Lh, Revision 6 of 7/8/81, PQR's 5 and 6
- . P1-A-c-Lh, (Structural) Revision 1 of 5/3/77 - Prequalified Joint Details

The procedure qualification records supported the essential variables listed in the welding procedure specification.

No items of noncompliance or deviations were identified.

b. Visual Examination of Welds

The inspector visually examined ten completed pipe support welds in the containment and turbine building areas. Characteristics examined included weld location, size, profile, finish and freedom from surface defects exceeding requirements. While in containment, the inspector identified an improperly secured wide beam flange. The flange is serving as a support for a recently installed pipe support assembly. The licensee issued NCR No. S01-P-1155 and was in process of retrieving the technical and quality records associated with this item. These records will be reviewed during the next NRC inspection.

This is an unresolved item (50-206/82-25/01).

c. Welder Qualification

The inspector reviewed the performance qualification records for three of the welders involved in the pipe supports inspected. All were qualified, on the date the welds were made, in accordance with ASME Section IX for the weld procedure and positions used.

No items of noncompliance or deviations were identified.

d. Weld Filler Material Control

The control, issue, return and storage of weld filler material was examined for compliance with procedural requirements. All holding ovens were calibrated and operating within the required temperature range and contained only one electrode classification. All filler material located in holding ovens and in opened containers was correctly identified.

No items of noncompliance or deviations were identified.

4. Unresolved Items

Unresolved items are matters about which more information is required in order to ascertain whether they are acceptable items, items of noncompliance or deviations. One unresolved item was identified during this inspection and is discussed in paragraph 3(b).

5. Exit Interview

The inspector met with licensee representatives identified in paragraph 1 at the conclusion of the inspection on September 3, 1982. During the meeting the inspector summarized the scope and findings of the inspection identifying the unresolved item discussed in paragraph 3(b).