

U. S. NUCLEAR REGULATORY COMMISSION

REGION V

Report No. 50-344/82-21

Docket No. 50-344 License No. NPF-1 Safeguards Group _____

Licensee: Portland General Electric Company

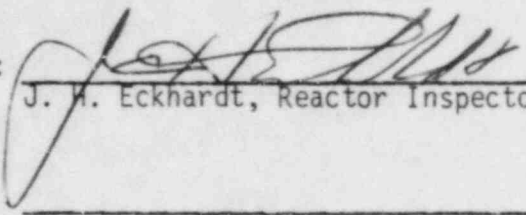
121 S. W. Salmon Street

Portland, Oregon 97204

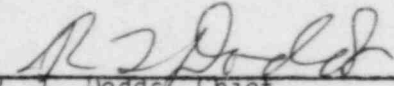
Facility Name: Trojan

Inspection at: Rainier, Oregon

Inspection conducted: July 12, 1982

Inspectors:  10/1/82
J. H. Eckhardt, Reactor Inspector Date Signed

_____ Date Signed

Approved by:  10/1/82
R. T. Dodds, Chief Date Signed
Reactor Projects Section No. 1

Summary: Inspection on July 12, 1982 (Report 50-344/82-21)

Areas Inspected: Routine inspection of program for welding of the pressurizer surge line. The inspection involved eight inspector-hours onsite by one NRC inspector.

Results: No items of noncompliance or deviations were identified.

DETAILS

1. Persons Contacted

- *C. P. Yundt, General Manager
- *D. Broehl, Assistant Vice President, Nuclear
- *J. K. Aldersebaes, Manager, Nuclear Maintenance and Construction
- *C. A. Olmstead, Manager, Operations and Construction
- *G. J. Stein, Mechanical Supervisor
- *T. O. Meek, Radiation Protection Supervisor
- *P. A. Morton, Quality Assurance Supervisor
- *D. Wheeler, Quality Control Coordinator
- *B. Northness, Quality Control/Assurance Specialist
- R. Nelson, Welding Supervisor

*Denotes those people attending exit meeting. The meeting was also attended by the NRC Senior Resident Inspector, M. H. Malmros.

2. Review of Welding Program Procedures

Selected Portland General Electric (PGE) procedures applicable to welding of the pressurizer surge line were reviewed to ascertain compliance with the ASME Code and NRC requirements. The following procedures were reviewed:

- a. Maintenance Procedure MP-3-6, Rev. 10, "Welding Material Control"
- b. Maintenance Procedure MP-3-7, Rev. 5, "Weld and Welder Records"
- c. Welding Standard WP-3-G, Rev. 3, "Gas Tungsten - Arc Welding of Stainless Steel"
- d. Quality Control Procedure QCP-4, Rev. 4, "Visual Weld Inspection"
- e. Quality Control Procedure QCP-5, Rev. 7, "Liquid Penetrant Inspection"
- f. Resident Engineer Work Plan No. G/C-919 Add. #1, Maintenance Request MR No. 82-2619, "Removal of Thermal Sleeve on 14" RC2501R-20-1 Pressurizer Surge Line"

These procedures appeared satisfactory. No deviations or items of noncompliance were identified.

3. Examination of Welding Activities

The inspector examined the weld material control and welder qualification programs to ascertain compliance with the applicable procedures listed in paragraph 2.

At Trojan, the weld material is issued from the main warehouse. This area was inspected regarding material identification, segregation, storage, and moisture control. In addition, Purchase Requisition QA-3919-0 which was a purchase order for ER308L weld machine wire was reviewed. The certification of test report for this material indicated that the material properties were within the ASME Code specifications.

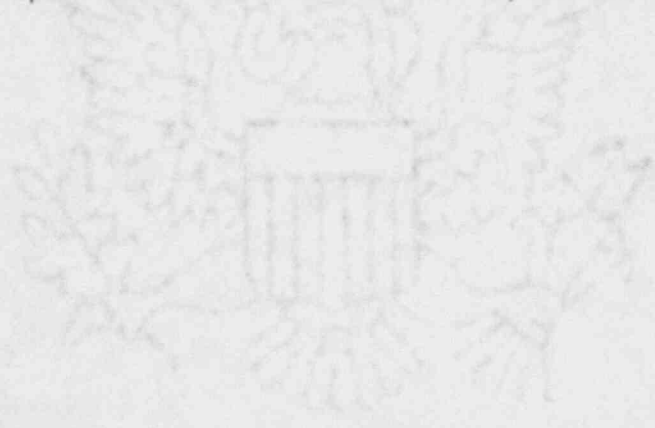
Welder training was in progress in preparation for qualifying welders for the pressurizer surge line weld. A mock-up had been built in the welder training/qualification area, and the welders were machine welding 14 inch pipe to qualify the machine welding procedure. The inspector suggested that the welders perform this effort in at least partial anti-contamination clothing to more closely simulate the working conditions they would encounter during the actual surge line welding. PGE management indicated that this would be done. The welding qualification program appeared to be progressing satisfactorily and receiving sufficient engineering and management attention.

Subsequent to this inspection, the NRC Senior Resident Inspector observed specific in-process welding activities and visually examined the completed weld.

No deviations or items of noncompliance were identified.

4. Exit Meeting

The inspector met with the PGE representative (denoted in paragraph 1) at the conclusion of the inspection. The scope and findings of the inspection as detailed in this report were discussed.



1980