

APPENDIX A

ALFAB, Incorporated  
Docket No. 99900787/82-01

NOTICE OF NONCONFORMANCE

Based on the results of an NRC inspection conducted on August 9-12, 1982, it appears that certain of your activities were not conducted in accordance with NRC requirements as indicated below:

Criterion V of Appendix B to 10 CFR Part 50 states: "Activities affecting quality shall be prescribed by documented instructions, procedures, or drawings, of a type appropriate to the circumstances and shall be accomplished in accordance with these instructions, procedures, or drawings. Instructions, procedures, or drawings shall include appropriate quantitative or qualitative acceptance criteria for determining that important activities have been satisfactorily accomplished."

Nonconformances with these requirements are as follows:

- A. The Carolina Power and Light Company (CP&L) Purchase Order No. H-36933, dated January 19, 1982, states in part, ". . . Welding controls and parameters in accordance within limitations of AWS D1.1 and welding procedures as defined by AWS D1.3 . . . ."

Paragraph 6.8.2.8 of AWS D1.3 states, "Separate welder qualifications shall be required for welding galvanized sheet steel or sheet steel with other coatings."

Contrary to the above, two welders, who were listed on the ALFAB, Inc. (AI) Inspection Report (Form No. 12) as having performed welding on galvanized coated conduit seismic support members, had not been qualified as required by paragraph 6.8.2.8 of AWS D1.3.

- B. Paragraph 9.1.6 of the Quality Assurance Policy Manual states, "All gages, instruments and other device used in controlling and testing of special processes shall be calibrated in accordance with the Code."

Paragraph 12.1.9.3 states, "Listed below are the type of special tools or equipment requiring calibration and the normal frequencies . . . . H. Weld Gages - 1 year . . . ."

Contrary to the above, weld gages on a Lincoln welding machine (Model R3S-600), which was located in the bay where nuclear work was in progress, had not been calibrated.

- C. Paragraph 5.1 of AI welding procedure specification W-001 states in part, ". . . The first two stud shear connectors or concrete anchors welded at the start of a new production period shall be bend tested after being

allowed to cool . . . Additionally, one out of every one hundred studs shall be bend tested . . . ."

Paragraph 4.26.2 of the AWS D1.1 Code states in part, "For studs other than shear connectors, at least one stud in every 100 shall be bent to an angle of 15 deg (sic) from its original axis by striking with a hammer."

Contrary to the above, required numbers of stud bend tests were not performed, as evidenced by:

1. Only 21 bend tests were performed on a January 15, 1982, shipment of 528 embedded strip plates, which contained 4476 studs;
  2. Only 20 bend tests were performed on a January 19, 1982, shipment of 506 embedded strip plates, which contained 3836 studs; and
  3. Only 19 bend tests were performed on a January 28, 1982, shipment of 475 embedded strip plates, which contained 2376 studs.
- D. The Carolina Power and Light Company Purchase Order No. H-36933, dated January 19, 1982, states in part, ". . . Welding controls and parameters in accordance within limitations of AWS D1.1 and welding procedures as defined by AWS D1.3 . . . ."

Paragraph 5.3.1 of the AWS D1.1 Code states in part, "All welders, welding operators, and tackers to be employed under this Code shall have been qualified by tests . . . ."

Contrary to the above, the NRC inspector observed an AI employee, who had not been qualified by test, tack welding on a fabrication per AI Drawing No. S101-84, Revision 1, for Job No. 321357.