

ORGANIZATION: ALLOY RODS, INCORPORATED
HANOVER, PENNSYLVANIA

REPORT NO.:	99900806/83-01	INSPECTION DATE(S)	1/24-28/83	INSPECTION ON-SITE HOURS:	33
CORRESPONDENCE ADDRESS: Alloy Rods, Incorporated ATTN: Mr. D. J. Jacoby Manager of QA & Process Engineering P. O. Box 517 - Wilson Avenue Hanover, PA 17331					
ORGANIZATIONAL CONTACT: Mr. D. J. Jacoby, Manager of QA & Process Engineering TELEPHONE NUMBER: (717) 637-8911					
PRINCIPAL PRODUCT: Welding filler metals.					
NUCLEAR INDUSTRY ACTIVITY: Approximately 12 percent of the 1982 production.					
ASSIGNED INSPECTOR:	<u>Wm M. Keill for</u> J. T. Conway, Reactive and Component Program Section (R&CPS)			<u>2/17/83</u> Date	
OTHER INSPECTOR(S):					
APPROVED BY:	<u>Wm M. Keill for</u> I. Barnes, Chief, R&CPS			<u>2/17/83</u> Date	
INSPECTION BASES AND SCOPE:					
A. <u>BASES</u> : 10 CFR Part 50, Appendix B and 10 CFR Part 21.					
B. <u>SCOPE</u> : This inspection was made as a result of the notification by Gulf States Utilities Company of the furnishing of mixed stainless steel electrodes (E308 and E309) in the same can to the River Bend nuclear site. In addition, the following programmatic areas were inspected: training, (Cont. on next page)					
PLANT SITE APPLICABILITY:					
Docket No. 50-548/549.					
Certified By <u>Rheanne Clark</u>					

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SCOPE: (Cont.) identification and control of items, manufacturing process control, inspection, NDE, material identification and control, calibration, document control, procurement control, audits (internal/external), and reporting of defects.

A. VIOLATIONS:

Contrary to Section 21.6 of 10 CFR Part 21:

1. A copy of 10 CFR Part 21 that was posted was not the current copy dated September 1, 1982.
2. A copy of Section 206 was not posted.

B. NONCONFORMANCES:

1. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and paragraph 2.1 and subparagraph 2.2.1 in Section QA-3 of the Quality System Manual (QSM), a review of the training and certification records for two quality technicians and six quality control inspectors revealed: (1) a lack of documentation on examinations for the two technicians, and (2) no evidence of training sessions on Code revisions being given to the technicians and inspectors.
2. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and paragraphs 5.2, 5.3, and 5.4 in Section QA-5 of the QSM, a review of processing procedures manuals revealed the following: (a) the record revision page for Revision 1 of the "Low Hydrogen Coated Electrodes Procedure Manual" was not signed off by the affected departments; (b) revisions to four pages of Section SA-2 of the "Spoolarc Processing Procedures" manual were not made to the manual copy assigned to the Manager, QA; (c) the "Spoolarc Processing Procedures" and the "Stainless Steel Processing Procedures" manuals noted on the cover page that both manuals were totally reviewed and revised on May 1, 1981, but two assigned copies of each of the two procedures manuals were identified to contain numerous pages that were dated as earlier revisions; and (d) the record revision page for Revision 5 of the "Spoolarc Processing Procedures" manual was not signed off by the Manager, QA.

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<p>3. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and Section 11.0 in Procedure QC-9000, a review of purchase orders for 1981 and 1982 to suppliers of calibration services revealed that purchase orders to Tinius Olsen Testing and Fairbanks Weighing Division did not specify any system requirements.</p> <p>4. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and paragraph 2.1 in Section QA-11 of the QSM, during observation of a production run of electrodes on line 5, it was noted that a Starrett dial gage used to check concentricity at the front-end inspector's station did not contain a serial number nor a sticker indicating its calibration status.</p> <p>5. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and Part 0 in Section SCE-I of processing procedures, during observation of a production run of electrodes on line 5, it was noted that the press operator was taking only one concentricity check on the examined electrodes.</p> <p>6. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and paragraphs 2.1, 2.2, and 4.1 in Section QA-13 of the QSM, a review of internal audit reports for 1981, 1982, and 1983 revealed the following: (1) the Order Analysis Section of the Quality System was not audited in 1982, and (2) the results of an audit conducted in January 1983 of the solid wire, coated electrode, and dual shield areas were not distributed to the Plant Manager nor any General Foreman.</p> <p>C. <u>UNRESOLVED ITEMS:</u></p> <p>None</p> <p>D. <u>OTHER FINDINGS OR COMMENTS:</u></p> <p>1. <u>Mixed stainless steel electrodes</u> _ Stone & Webster (S&W) notified (ref. Rineaman/Clifford letter dated August 23, 1982) Alloy Rods that two cans of 3/32" diameter E309 electrodes (Heat No. 36611C, Lot No. 051F703L) were found intermixed with E308 electrodes at the River Bend nuclear site. Alloy Rods' response (ref. Clifford/Jacoby letter dated September 13, 1982) indicated that the logic of the manufacturing process for producing 9" long stainless steel electrodes prevented a mixup of a few electrodes of one alloy with another alloy that was designated on the can.</p>		

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<p>Based upon the inspector's direct observation of a production run of stainless steel electrodes on line 5 and a review of the production records from June 1-6, 1977 (Lot No. 051F703L was run on line 5 on June 3, 1977), the NRC inspector was unable to determine how such a mixup could have occurred if the same manufacturing process controls in effect during this inspection were being utilized in June 1977. Following the issuance of Gulf States Utilities Company's final report on this matter, any required corrective action taken by Alloy Rods will be evaluated during the next NRC inspection.</p> <p>2. <u>QA Program</u> - A detailed review of documentation (e.g., QA manual, procedures, data packages, purchase orders, certifications, audit reports) led to the identification of six nonconformances (B above) and the following observations:</p> <ul style="list-style-type: none">(a) Indoctrination/training programs were not being kept current.(b) There was no requirement for management (above or outside the QA organization) to regularly assess the scope, status, and compliance of the QA program to 10 CFR Part 50, Appendix B.(c) The organizational positions with stop-work authority were not identified. <p>These observations were not considered as sufficiently severe deficiencies in the existing QA program or its implementation to be classified nonconformances, but were brought to the attention of appropriate Alloy Rods management personnel for their evaluation and follow up. These areas will be reexamined during a future inspection.</p>		

INSPECTOR JIM CONWAY
 SCOPE _____

DOCUMENTS EXAMINED

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ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
15	OTR	—	—	—	QA DATA PACKAGES FOR 6 NUCLEAR CONTRACTS IN-HOUSE
16	PO	—	—	—	PURCHASE ORDERS FOR: 5 CHEMICAL SUPPLIERS - 3 CALIBRATION SERVICES & 5 SUPPLIERS OF METAL PRODUCTS
17	REP	—	—	—	INTERNAL AUDIT REPORTS FOR '81 (11), '82 (8), & '83 (3)
18	REP	—	—	2/17/81	MANAGEMENT AUDIT REPORT FOR '81
19	OTH	—	—	—	CERTIFICATIONS FOR INDIVIDUALS (5) PERFORMING FRACTURE TOUGHNESS TESTING
20	OTH	—	—	—	CERTIFICATIONS FOR QC TECHNICIANS (2) & QC INSPECTORS (6)
21	OTH	—	—	—	CALIBRATION TEST RECORDS (10) FOR WEIGHING SCALES
22	OTH	—	—	—	CALIBRATION TEST RECORDS (10) FOR TEMPERATURE RECORDING INSTRUMENTS
23	PRO	—	—	6/25/82	PROCEDURE - "RADIOGRAPHY - WRITTEN PRACTICE"
24	PRO	—	—	7/17/79	PROCEDURE FOR THE RADIOGRAPHIC EXAMINATION OF WELD TEST PLATES
25	OTH	—	—	—	CERTIFICATIONS FOR 5 NDE PERSONNEL

TYPE OF DOC.:

DWG - DRAWING
 SPEC - SPECIFICATION
 PRO - PROCEDURE
 QAM - QA MANUAL
 QCD - QC DOCUMENT
 P.O. - PURCHASE ORDER
 INM - INTERNAL MEMO

LTR - LETTER
 OTR - OTHER
 REP - REPORT

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ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
3-cont	Pro	-	-	-	PROCESSING PROCEDURES:
	"	-	1	11/11/81	"LOW HYDROGEN COATED ELECTRODES"
	"	-	5	8/18/82	"DUAL SHIELD"
4	OTR	-	-	-	RECORD OF QA MANUAL DISTRIBUTION
5	OTR	-	-	12/3/82	APPROVED VENDOR LIST
6	REP	-	-	-	EXTERNAL AUDIT REPORTS FOR '81 & '82 (3-CALIBRATION SERVICES & 10-SUPPLIERS OF METAL PRODUCTS)
7	OTR	-	-	-	QA DATA PACKAGES FOR 8 NUCLEAR CONTRACTS IN '82
8	SPEC	-	-	-	PRODUCTION SPECIFICATIONS - FABRICATED WIRE
9	SPEC	-	-	-	PRODUCTION SPECIFICATIONS - COATED ELECTRODES
10	OTR	-	-	-	RAW MATERIAL SPECIFICATIONS & VENDOR APPROVALS (10 MATERIAL MFGs)
11	Pro	-	-	3/28/78	PROCEDURE FOR COMPLIANCE WITH PART 21
12	Pro	-	-	3/10/82	PROCEDURE FOR EDAX PV 9500/9100 MASS SPECTROMETER
13	LTR	-	-	8/23/82	RINEAMAN (ALLOY RODS) / CLIFFORD (S&W) LETTER - Re: MIXED ELECTRODES
14	LTR	-	-	9/13/82	CLIFFORD (S&W) / JACOBY (ALLOY RODS) LETTER - Re: MIXED ELECTRODES

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ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
1	QAM	-	1	3/1/82	QUALITY SYSTEM MANUAL
2	PRO	-		-	QUALITY CONTROL & INSPECTION PROCEDURES:
	"	QC-1000	0	5/15/81	"QC TECHNICIANS"
	"	QC-2000	0	5/15/81	"SOLID WIRE DEPARTMENT (STAINLESS STEEL & HIGH ALLOYS)"
	"	QC-3000	0	5/15/81	"SOLID WIRE (MILD STEEL)"
	"	QC-4	0	5/22/74	"COATING CHEMICALS"
	"	QC-5	0	5/22/74	"COATED ELECTRODES"
	"	QC-6	0	5/22/74	"FLUX CORED WIRE"
	"	QC-7	0	5/22/74	"FABRICATED WIRE (WEAR-O-MATIC)"
	"	QC-8	0	5/22/74	"SPOOLARC"
	"	QC-9000	0	5/15/81	"CALIBRATION OF MEASURING EQUIPMENT"
3	PRO	-		-	PROCESSING PROCEDURES:
	"	-	0	6/15/81	"STAINLESS STEEL ELECTRODES"
	"	-	5	4/22/82	"SPOOLARC"
	"	-	7	6/29/82	"STAINLESS STEEL"

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