

ORGANIZATION: UNIBRAZE CORPORATION
COVINGTON, OHIO

REPORT NO.:	99900793/83-01	INSPECTION DATE(S)	1/10-14/83	INSPECTION ON-SITE HOURS:	31
CORRESPONDENCE ADDRESS: Unibraze Corporation ATTN: Mr. M. B. MacBryde President 7502 W. State, Route 41 Covington, Ohio 45318					
ORGANIZATIONAL CONTACT: Mr. C. R. Miller, QA Manager TELEPHONE NUMBER: (513) 473-2001					
PRINCIPAL PRODUCT: Welding filler metals.					
NUCLEAR INDUSTRY ACTIVITY: Approximately 1 percent of the CY 1982 sales.					
ASSIGNED INSPECTOR:	<u>Wm McNeill for</u> J. T. Conway, Reactive and Component Program Section (R&CPS)			<u>2/17/85</u> Date	
OTHER INSPECTOR(S):					
APPROVED BY:	<u>Wm McNeill for</u> I. Barnes, Chief, R&CPS			<u>2/17/85</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 the Tennessee Valley Authority of the furnishing of mixed diameter electrodes (1/8" and 5/32" in the same canister) to the Hartsville nuclear site. In addition, the following programmatic areas were inspected: training, (Cont. on next page)					
PLANT SITE APPLICABILITY:			DESIGNATED ORIGINAL		
Docket No. 50-518			Certified By <u>Rheanne Clark</u>		

REPORT NO.: 99900793/83-01	INSPECTION RESULTS:	PAGE 2 of 4
<p><u>SCOPE:</u> (Cont.) material identification and control, nonconformance, calibration, inspection, QA records, audits (internal/external), handling/storage/shipping, and reporting of defects.</p> <p>A. <u>VIOLATIONS:</u></p> <p>Contrary to Section 21.6 and Section 21.21 of 10 CFR Part 21, a current copy of 10 CFR Part 21 was not posted in the area where Section 206 was posted and required procedures had not been adopted to provide for the evaluation of deviations or for notification of the licensee or purchaser.</p> <p>B. <u>NONCONFORMANCES:</u></p> <ol style="list-style-type: none">1. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and paragraph 5.3.2 and subparagraph 5.3.2.1 in Section 5.0 of the Identification and Verification Manual (IVM), a review of documentation and material for three inprocess nuclear contracts revealed that certain reels of wire were not identified with tags containing a control number, material descriptions, and weight for two of the contracts; i.e., three reels from Contract No. N-202 and three reels from Contract No. N-207 which were held, respectively, in the controlled material and nonconforming hold areas.2. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and paragraph 4.4.2 in Section 4.0 of the IVM, a review of the QA record files revealed that two vendors (Ohio Counting Scales and Eli Whitney Metrology Lab) performing testing services had been neither surveyed nor audited by Unibraze.3. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and paragraph 7.9 in Section 7.0 of the IVM, a review of the QA record files revealed that a purchase order had not been sent nor had the applicable calibration procedure or standard to be used been otherwise provided to Ohio Counting Scales who had performed calibrations of weighing scales since 1975.4. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and Section QCF-8 of procedure QCI-12-76-2, a review of material in the nonconforming material hold area revealed that a reject tag attached to a reel of material for nuclear Contract No. N-207 was not signed by the individual responsible for attaching the tag.5. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and paragraphs 12.1.3 and 12.1.4 in Section 12.0 of the IVM, a review of internal audit activities for 1981 and 1982 revealed that: (a) an		

REPORT

NO.: 99900793/83-01

INSPECTION

RESULTS:

PAGE 3 of 4

internal audit procedure did not exist, and (b) internal audit reports for 1981 and 1982 were not distributed to the applicable manager(s) of the areas being inspected.

C. UNRESOLVED ITEMS:

None

D. OTHER FINDINGS OR COMMENTS:

1. Mixed Diameter Electrodes -In March 1981, Tennessee Valley Authority (TVA) notified Unibraze that they had discovered 5/32" diameter electrodes intermixed with 1/8" diameter electrodes in 10 lb. canisters labeled 1/8" at the Hartsville nuclear site. All the material (approximately 9000 lbs. on Contract No. 76x72-523054-5) was returned to Unibraze for inspection. A 100 percent inspection revealed that approximately 10 percent of the 308L electrodes were intermixed in the canisters. Unibraze determined that the packaging error was due to similar lot numbers on the two different diameter electrodes. Unibraze modified procedures to prevent the packaging of like materials with similar control numbers. Chemical and mechanical tests were performed on the material, and the repackaged electrodes along with the certified material test reports were returned to TVA.
2. QA Program - A detailed review of documentation (e.g., QA manual, procedures, travelers, data packages, nonconformance reports, audit reports) led to the identification of five nonconformances (B above) and the following observations:
 - a. The QCF-16 form, "Specification and Contract Review Sheet," for nuclear Contract No. N-196 completed in 1982 was not signed and dated by a representative from the QA department.
 - b. The QCF-3 form, "Hold for Testing," for nuclear Contracts N-206 and N-207 was not filled in (e.g., invoice number plus date sample was taken) to indicate that the material was in a hold status awaiting test results.
 - c. The procedures manual did not have an index to indicate the revision and date of the applicable procedure in effect.
 - d. Procedures for quality affecting activities lacked sufficient detail for the activity being performed and were not posted at each work station.

ORGANIZATION: UNIBRAZE CORPORATION
COVINGTON, OHIO

REPORT NO.: 99900793/83-01	INSPECTION RESULTS:	PAGE 4 of 4
<p>e. Individuals performing dimensional and visual inspection were not required to satisfactorily pass an eye examination.</p> <p>f. The checklist used for internal audits was lacking in specificity to ensure that the QA program in a particular area was effective and properly implemented.</p> <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 Unibraze management personnel for their evaluation and follow up. These areas will be reexamined during a future inspection.</p>		

INSPECTOR JIM CONWAY

SCOPE _____

DOCUMENTS EXAMINED

DOCKET NO. 99900793
 REPORT NO. 83 - 01
 PAGE 1 OF 2

ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
1	QAM	-	2	2/26/82	IDENTIFICATION & VERIFICATION MANUAL
2	PRO	-	-	3/5/82	QA PROCEDURE MANUAL
3	LOG	QCF-35	-	-	CONTROLLED MATERIAL RETRIEVAL LOG
4	LOG	QCF-33	-	2/26/82	QA MANUAL LOG
5	LOG	-	-	-	QA MANUAL PROCEDURE LOG
6	LOG	-	-	-	QC INSTRUMENT TEST & MAINTENANCE RECORD
7	FIL	-	-	-	TRAINING FILE (7/80 to 1/83)
8	FIL	-	-	-	UNIBARE APPROVED AUDITORS FILE
9	REP	-	-	-	INTERNAL AUDIT REPORTS FOR 1981 and 1982
10	REP	-	-	-	MANAGEMENT AUDITS OF QA PROGRAM FOR 1981 (2) & 1982 (2)
11	PRO	-	-	-	AUDIT PROCEDURE FOR EXTERNAL AUDITS
12	OTH	-	-	-	QA DATA PACKAGES FOR THREE NUCLEAR CONTRACTS IN-HOUSE
13	OTH	-	-	-	QA DATA PACKAGES FOR SIX NUCLEAR CONTRACTS COMPLETED IN 1982
14	OTH	-	-	11/18/82	APPROVED VENDOR'S LIST
15	REP	-	-	-	EXTERNAL AUDIT REPORTS FOR 1982 FOR TEN VENDORS

TYPE OF DOC:

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

- LTR - LETTER
- LOG - LOG
- FIL - FILE
- REP - REPORT
- OTH - OTHER

INSPECTOR Jim Coulsey
 SCOPE _____

DOCUMENTS EXAMINED

DOCKET NO. 99900793
 REPORT NO. 83-01
 PAGE 2 OF 2

ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
16	LOG	-	-	-	NONCONFORMANCE REPORT ACCOUNTABILITY LOG FOR MATERIALS
17	REP	-	-	-	SIX NONCONFORMANCE REPORTS FOR NUCLEAR CONTRACTS
18	REP	-	-	-	TREND ANALYSIS REPORTS FOR SIX VENDORS
19	LOG	QCF-32	-	-	PROCEDURE CONTROL LOG
20	LOG	QCF-30	-	-	FORM CONTROL LOG
21	REP	-	-	-	EXTERNAL AUDIT REPORTS FOR 1981 FOR THREE VENDORS

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 FIL - FILE _____
 REP - REPORT _____
 STA - STATEMENT _____

