

WEST JERSEY MANUFACTURING CO.

P. O. Box W
Williamstown, N.J. 08094

(609) 629-4776



MANUFACTURERS
CARBON, ALLOY & STAINL
Steel Forgings
FORGED STEEL PIPE FLAN

March 22, 1983

Mr. Lee Ellershaw, P.E.
United States Nuclear Regulatory Commission
611 Ryan Plaza Drive
Arlington, Texas 76011

RE: Chicago Tube & Iron purchase order to West Jersey #N00566
West Jersey purchase order 1431

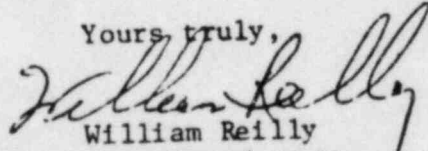
Dear Mr. Ellershaw,

Regarding the above purchase order, I did mail you a letter yesterday, March 21, 1983. However, this morning we received via Express Mail another copy of Chicago Tube's letter to us along with some additional paperwork.

I am forwarding this along to you to complete your files. If anything else comes along, I will in turn forward it to you upon receipt.

Thank you for your attention in this matter.

Yours truly,


William Reilly
Vice Pres/ QA Manager

8307210224 830714
PDR GA999 EMVWJMC
99900816 PDR

cc: File



Quality System Certificate Manufacturing Number



March 17, 1983

Mr. William Riley
West Jersey Mfg.
P.O. Box W
Williamstown, N.J. 08094

Re: Chicago Tube P.O. #N00566
West Jersey #1431

Dear Mr. Riley:

This letter is to confirm our conversation of today regarding 4 pcs. of a 10" 150# FS Blind Flange with heat #221814, supplied by your company against the above referenced purchase order.

Our customer, Northern States Power, has informed us, in writing, that they intend to use these parts in an ANSI B31.1 application. They further state that they are waiving the UT or RT requirements as long as weld repairs were not performed. A copy of their correspondence is attached.

I trust this letter will clear up any problems associated with this material.

Regards,

CHICAGO TUBE AND IRON COMPANY

A handwritten signature in black ink, appearing to read 'Tim Graham', written over a horizontal line.

Tim Graham
Manager Quality Assurance

TG/tm
Attachment

March 17, 1983

Tim Graham

Chicago Tube and Iron Company
2531 West 48th Street
Chicago, Illinois 60632

Dear Mr. Graham

Subject: Northern States Power Company Purchase
Order A80734MQ Change #002

The material supplied on NSP purchase order A80734MQ Change number 002 (ie 10"-150" flat face blind flange SA105) was intended to be used in accordance with ANSI B31.1 (1967) and the original plant Hiawatha 10L specification. Radiographic Testing or Ultrasonic Testing of the flanges is not required provided that repair welding is not performed. These flanges will not be returned even though the RT's were not performed since they meet the plant design specification.

Sincerely,

Robert S. Zraen

Robert S. Zraen
Asst. Mech. Engr

Don Fricke

Asst Q.E. Engineer

PURCHASE ORDER

TYPE MS

DATE 10/07/82 PURCHASE AB073

TO: PRAIRIE ISLAND NUCLEAR PLANT
ROUTE 2 WELCH MINN 55089
ATTN-BOB FRASER
CONTAINMENT INSERVICE
PURGE/DCB22692

MAIL INVOICE TO

Northern States Power
Invoice Accounting Dept
P.O. Box 9366
Minneapolis, MN 55440

CHICAGO TUBE & IRON COMPANY
2531 WEST 48TH STREET
CHICAGO IL 60632

Unless Otherwise Indicate
Mail All Acknowledgements
And Correspondence Promptly To
Northern States Power Company
PURCHASING DEPARTMENT
414 NICOLLET STREET
MINNEAPOLIS MN 55401
612 330-5674

ORIGIN	FACTORY	PAGE	:
FREIGHT PREPAID AND CHARGED BACK			
Date 10/07/82	Terms 2 % 10 DAYS	THIS PURCHASE ORDER AND LINE NO. MUST APPEAR ON ALL PAPERS AND P	
Plant Or W.O. Number 91.04.11.52-15	Requisition No. G717084	Requisitioner FRASER ROBERT G	Buyer D K HEBZYNSKI

Quantity

4 EA

OUTAGE

DATE 11/11/83

Material Or Services To Be Furnished

MEMORANDUM OF CHANGE #002
PLEASE ADD TO ORDER

10" - 150# FLAT FACE BLIND FLANGE SA105

ITEM #4 SHALL BE 100% LIQUID PENETRANT OR MAGNETIC PARTICLE TESTED BY PERSONNEL QUALIFIED IN ACCORDANCE WITH SNT-TC-1A (1975). ITEM #4 SHALL BE CHARPY IMPACT TESTED PER ASTM A370 WITH A TEST TEMPERATURE OF 0 DEG FAHRENHEIT. THE MINIMUM ABSORBED ENERGY SHALL BE 15 FT-LB WITH 15 MILS LATERAL EXPANSION.

ALL MATERIALS SHALL BE MANUFACTURED IN ACCORDANCE WITH ASME SECTION III CLASS NB (1980 SUMMER 1981 ADDENDA). THE ACCEPTANCE STANDARD FOR ALL NDE SHALL BE ASME SECTION V FOR CLASS NB COMPONENTS (1980 SUMMER 1981 ADDENDA).

ORIGINAL SPECIFICATIONS: XH106

DOCUMENTATION REQUIREMENTS: SUPPLY 1) CERTIFIED MILL TEST REPORTS DOCUMENTED TO THE P.O. # AND TRACEABLE TO THE MATERIAL 2) NDE REPORTS DOCUMENTED TO THE PO# AND TRACEABLE TO THE MATERIAL, SIGNED AND STATING THAT THEY ARE ACCEPTABLE AND 3) CHARPY IMPORTED TEST

Price

ADVISE PRIC

C.T.I. U.A. D

OCT 14 1983

See Reverse Side For Additional Terms And Conditions Applying To This Order.

TAXES
MATERIAL SUBJECT TO TAX OF STATE TO WHERE MATERIAL IS SHIPPED ACTUAL FREIGHT CHARGES ARE GENERALLY TAX EXEMPT AND MUST BE SHOWN SEPARATELY ON INVOICE.

PURCHASE ORDER

TYPE MS

DATE 10/07/82 PURCHASE NO. A8073

TO

NORTHERN STATES POWER COMPANY

FOR

PRAIRIE ISLAND NUCLEAR PLANT
ROUTE 2 WELCH MINN 55089
ATTN-BOB FRASER
CONTAINMENT INSERVICE
PURGE/DC822692

MAIL INVOICE TO

Northern States Power
Invoice Accounting Dep
P.O. Box 9366
Minneapolis, MN 55440

Unless Otherwise Indicate
Mail All Acknowledgem
And Correspondence
Promptly To

CHICAGO TUBE & IRON COMPANY
2531 WEST 48TH STREET
CHICAGO IL

60632

Northern States Power Co
PURCHASING DEPT
414 NICOLLET M
MINNEAPOLIS MN
612 330-5674

ORIGIN FACTORY PAGE 2
FREIGHT PREPAID AND CHARGED BACK

Date 10/07/82
Or W.O. Number 91, 04, 11, 52-15

Terms: 2 % 10 DAYS
Requisition No. G717084
Requisitioner: FRASER ROBERT G

THIS PURCHASE ORDER
AND LINE NO. MUST APPEAR
ON ALL PAPERS AND PA
Buyer D K HEBZYNSKI

Item No.	Quantity	Material Or Services To Be Furnished	Price
		REPORTS DOCUMENTED TO THE PO# AND TRACE- ABLE TO THE MATERIAL. SIGNED AND STATING THEY ARE ACCEPTABLE.	

See Reverse Side For Additional Terms And Conditions Applying To This Order

TAXES

MATERIAL SUBJECT TO TAX OF STATE TO WHERE
MATERIAL IS SHIPPED. ACTUAL FREIGHT CHARGES
ARE GENERALLY TAX EXEMPT AND MUST BE SHOWN
SEPARATELY ON INVOICE.

BY NORTHERN STATES POWER COMPANY
[Signature]
AUTHORIZED SIGNATURE



WEST JERSEY MANUFACTURING CO.

NUCLEAR QUALITY ASSURANCE
PROGRAM MANUAL

REVISION: 2

DATE: June 10, 1964

APPROVED: W.R. 6/10/64

QAI
NO. 8.0

RECEIVING INSPECTION AND MATERIAL CONTROL

Page 1
of 1

- 8.1 All incoming material is to be placed in the designated "Hold Area" until the proper documentation review is performed to determine if the material is Nuclear or Non-nuclear.
- 8.2 The QA Engineer and/or Inspector will bring the material test reports of the material received to the QA Department (Administration section) for review and approval. Note: It is possible that the material test reports may have been sent in prior to the material arrival.
- 8.2.1 The QA Department (Administration section) will review the material test reports against the applicable specification, i.e., ASME, ASTM, etc. If the MTR's meet the specification requirements the Administration Section of QA will fill out the top section of the Receiving Inspection Form then place the R&I form in the Travel Folder and issue the Travel Folder to the QA Engineer so the receiving inspection may be performed.
- NOTE: If the review of MTR's show that material does not meet the applicable material specification, the QA manager will be notified and NCR will be issued.
- 8.2.2 No material is to be inspected or worked until the R&I form is issued by the Administration section of QA.
- 8.2.3 No material is to be removed or used for the "Hold Area" until released by the Quality Assurance Department.
- 8.3 A Receiving Inspection Form must be properly completed by the Quality Assurance Department before any material may be released.
- 8.4 Any material found nonconforming for any reason, (no certification, lack of traceability, etc.) will be controlled in accordance with Section 15 of the (MQAM) Nuclear Quality Assurance Manual and Quality Assurance Instruction 15. A (NCR) Nonconformance Report must be issued and dispositioned before the material may be released for use.
- 8.5 Materials must be properly identified (permanent or temporary) using approved methods and marking materials before it leaves the "Hold Area".
- 8.6 The QA Administrator will assure that the Heat treat records from the manufacturer or subcontractor are in accordance with the Code and purchase order requirements.

WEST JERSEY MANUFACTURING CO.

P. O. Box W
Williamstown, N.J. 08094

(609) 629-4776



MANUFACTURERS
CARBON, ALLOY & STAINLESS
Steel Forgings
FORGED STEEL PIPE FLANGES

June 10, 1983

Magnaflux Quality Services
270 Andrews Avenue
Trevose, Pa. 19114

Attn: Mr. Walt Lanagan

Subj: NDE Reports

Gentlemen:

This is to advise you that we, West Jersey Mfg. Company have been cited by the NRC for accepting NDE reports that do not reflect the NDE Procedure number and revision.

We will not accept any further NDE reports without the proper information completed.

Thank you for your cooperation.

Yours truly,

William Reilly
William Reilly
Vice-Pres/QA Manager

CC: File



Quality System Certificate Manufacturing Number

WEST JERSEY MANUFACTURING CO.

P. O. Box W
Williamstown, N.J. 08094
(609) 629-4776



MANUFACTURERS
CARBON, ALLOY & STAINLESS
Steel Forgings
FORGED STEEL PIPE FLANGES

June 10, 1983

Magnaflux Quality Services
270 Andrews Avenue
Trevose, Pa. 19114

Attn: Mr. Walt Lanagan

Subj: NDE Reports

Gentlemen:

This is to advise you that we, West Jersey Mfg. Company have been cited by the NRC for accepting NDE reports that do not reflect the NDE Procedure number and revision.

We will not accept any further NDE reports without the proper information completed.

Thank you for your cooperation.

Yours truly,

William Reilly
William Reilly
Vice-Pres/QA Manager

CC: File



Quality System Certificate Manufacturing Number 385



WEST JERSEY MANUFACTURING CO.

NUCLEAR QUALITY ASSURANCE
PROGRAM MANUAL

REVISION: 3

DATE: June 10,

APPROVED: *WR.*

QAI
NO.

12.0

CONTROL OF MEASURING EQUIPMENT

Page
of

- 12.1 All measuring equipment is controlled and sent out for calibration on a scheduled basis. The calibration service is sub-contracted, with a re-call system included.
- 12.2 No personal tools are permitted at any time.
- 12.3 Measuring equipment that is out of calibration is not to be used. It is to be immediately given to the General Manager or Quality Assurance Engineer who will arrange for the tool to be sent out for calibration.
- 12.4 All calibrated measuring equipment must be signed out in the Calibrated Equipment sign-out log before it is used. Also, the tool must be returned at the end of each shift. The QAE or GM will verify that they have all been returned.
- 12.5 All tools are assigned numbers. The numbers are to be entered on the Inspection Sheet to document what tool was used.
- 12.6 A list of all measuring equipment and the calibration frequency is on file.
- 12.7 All material that was checked with a non-conforming tool will be placed on hold in accordance with Section 12 and 15 of the Nuclear Quality Assurance Manual.
- 12.8 The Quality Assurance Engineer or General Manager will send the manager of Quality Assurance a "Material Evaluation Form" which will indicate measuring equipment has been found out of calibration.
- 12.9 The QA Engineer will review all calibration records and initial them indicating their review to assure their compliance to the requirements and check for nonconformances prior to their (measuring equipment) being placed back into service.

WEST JERSEY MANUFACTURING CO.

P. O. Box W
Williamstown, N.J. 08094

(609) 629-4776



MANUFACTURERS
CARBON, ALLOY & STAINLESS
Steel Forgings
FORGED STEEL PIPE FLANGE

May 6, 1983

TO: William Reilly
Vice-President/QA Manager

RE: Gage Laboratories
Huntingdon Valley Pa.

Dear Bill,

On May 2, 1983 as a representative of West Jersey Manufacturing Company, I met with Sal Scicchitoni at the Gage Laboratory facility.

Their entire operation was witnessed i.e., receiving, control of orders, calibration, and packaging for shipment.

The certificate of calibration was reviewed and revised at this time. The certificate will now have three columns. The first column will record the measurement of the instrument as received. The second column will record the standard measurement for the instrument. The third column will record the measurement (corrected if necessary) as returned to West Jersey.

It was reiterated that any deviation observed between column one and column two is to be reported to West Jersey immediately.

George J. Meissler
George J. Meissler



Quality System Certificate Manufacturing Number 385

CONTROL NO.	DESCRIPTION	CUST. REF.
.650020	Outside Micrometer	-
LOT NO.	SIZE OR RANGE	C/F
9865	2 -3 Inch	12
C/N	PROCEDURE	DATE
M-3	Calibrate per MIL-STD 45662	05/23/83

NBS See below

NAME AND ADDRESS

SERVICE NO.

West Jersey Mfg. Co.
Main & Chesnut Streets
Williamstown, NJ 08094

0650

C R 31617 D
CERTIFIED

THAT THE DESCRIBED EQUIPMENT HAS BEEN PRESENTED FOR INSPECTION AND TEST AS SHOWN THAT THE INDICATED WORK HAS BEEN PERFORMED AND THAT THE STANDARDS USED IN OBTAINING DATA ARE CALIBRATED REGULARLY TRACEABLE TO THE

NATIONAL BUREAU OF STANDARDS



Gage Lab Corporation
Frederick

AUTHORIZED SIGNATURE

P.O. #4135

EQUIPMENT MITUTOYO

OBSERVED READINGS IN INCHES

STANDARD DIMENSION	AS RECEIVED	AFTER ADJUSTMENT
2.000	2.000	2.000
2.105	2.105	2.105
2.110	2.110	2.110
2.140	2.140	2.140
2.145	2.145	2.145
2.500	2.500	2.500
3.000	3.000	3.000
	LENGTH STANDARD	
CN 650020-S 2.0000	2.00000	2.00000

Calibrated at 20°C

Precal: Received as shown

TEST EQUIPMENT

CONTROL NUMBER

000170

000172

000512

PRIMARY STANDARDS

DESCRIPTION

Master Gage Blocks

CONTROL

NUMBER

000590

NBS TRACEABILITY

000512

000512

000590

738/228062

LAST CAL.

DATE

11/01/82

11/01/82

11/01/82

05/11/82

C/F

MOS.

12

12

12

24

Gage Lab



BOX 11575 • PHILA. PA. 19116 • (215) 355-5420

WEST JERSEY MANUFACTURING CO.

P. O. Box W
Williamstown, N.J. 08094
(609) 629-4776



MANUFACTURERS
CARBON, ALLOY & STAINLESS
Steel Forgings
FORGED STEEL PIPE FLANGES

TO: RECORD

SUBJ: Training Class for Office and Quality Assurance Employees

On June 10, 1983, a training class was held by Richard T. Griffith Sr. on the subject of Revision of the Quality Assurance Instructions Manual, QAI 8.0.

A Copy of the training material discussed is attached with the names of employees in attendance.

Richard T. Griffith Sr. PE
Quality Assurance Consultant
and Training Engineer.





WEST JERSEY MANUFACTURING CO.

NUCLEAR QUALITY ASSURANCE
PROGRAM MANUAL

REVISION: 2

DATE: June 10, 19

APPROVED: *WJ 6/8*

QAI
NO. 8.0

RECEIVING INSPECTION AND MATERIAL CONTROL

Page 1
of 1

- 8.1 All incoming material is to be placed in the designated "Hold Area" until the proper documentation review is performed to determine if the material is Nuclear or Non-nuclear.
- 8.2 The QA Engineer and/or Inspector will bring the material test reports of the material received to the QA Department (Administration section) for review and approval. Note: It is possible that the material test reports may have been sent in prior to the material arrival.
- 8.2.1 The QA Department (Administration section) will review the material test reports against the applicable specification, i.e., ASME, ASTM, etc. If the MTR's meet the specification requirements the Administration Section of QA will fill out the top section of the Receiving Inspection Form then place the R&I form in the Travel Folder and issue the Travel Folder to the QA Engineer so the receiving inspection may be performed.
- NOTE: If the review of MTR's show that material does not meet the applicable material specification, the QA manager will be notified and NCR will be issued.
- 8.2.2 No material is to be inspected or worked until the R&I form is issued by the Administration section of QA.
- 8.2.3 No material is to be removed or used for the "Hold Area" until released by the Quality Assurance Department.
- 8.3 A Receiving Inspection Form must be properly completed by the Quality Assurance Department before any material may be released.
- 8.4 Any material found nonconforming for any reason, (no certification, lack of traceability, etc.) will be controlled in accordance with Section 15 of the (MQAM) Nuclear Quality Assurance Manual and Quality Assurance Instruction 15. A (NCR) Nonconformance Report must be issued and dispositioned before the material may be released for use.
- 8.5 Materials must be properly identified (permanent or temporary) using approved methods and marking materials before it leaves the "Hold Area".
- 8.6 The QA Administrator will assure that the Heat treat records from the mill or subcontractor are in accordance with the Code and purchase order requirements.