

APPENDIX B

U. S. NUCLEAR REGULATORY COMMISSION
REGION IV

NRC Inspection Report: 50-498/84-04
50-499/84-04

Dockets: 50-498; 50-499

Construction Permits: CPPR-128
CPPR-129

Licensee: Houston Lighting & Power Company (HL&P)
P.O. Box 1700
Houston, Texas 77001

Facility Name: South Texas Project (STP), Units 1 and 2

Inspection At: South Texas Project, Matagorda County, Texas

Inspection Conducted: March 1 - April 30, 1984

Inspectors:

David Tomlinson
D. P. Tomlinson, Senior Resident Inspector

6-01-84
Date

for *J.R. Carpenter*
D. R. Carpenter, Resident Inspector

6/1/84
Date

Approved:

for *J. Jaldon*
J. Jaldon, Chief
Reactor Project Section A, Reactor Project Branch 1

6/1/84
Date

Inspection Summary

Inspection Conducted March 1 - April 30, 1984, (Report 50-498/84-04;
50-499/84-04)

Areas Inspected: Routine, announced inspection of allegations, site tours, weld filler material control, nonconformance report system, special nondestructive examination inspection, and cad welding. The inspection involved 313 inspection hours onsite by two NRC inspectors.

Results: Within the six areas inspected, one violation was identified in the area of the nonconformance report system (failure to have procedure for material control). No violations or deviations were identified in the other five areas.

Details1. Persons ContactedPrincipal Licensee Employees

- *J. Barker, Supervising Project Engineer
- *D. Bednarczyk, Project QA Supervisor-Civil/Structural
- J. Estella, Supervisor, Quality Systems
- J. Geiger, Corporate Manager, QA
- *J. Goldberg, Vice President, Nuclear Engineering and Construction
- S. Hubbard, Senior QA Specialist
- T. Jordan, Site QA Manager
- D. Keating, Project QA General Supervisor
- T. Logan, QC Supervisor
- *G. Oprea, Executive Vice President
- *J. Williams, Site Manager
- C. Wright, Project QA Supervisor-Mechanical/NDE

Other PersonnelBechtel Power Corporation (Bechtel)

- D. Bentley, QC Inspector
- *J. Downs, Deputy Manager of Construction
- *L. Hurst, Project QA Manager
- R. Miller, Project QA Engineer

Ebasco, Services, Inc. (Ebasco)

- *J. Crnich, Construction Manager
- R. Grippardi, QC Site Supervisor
- *C. Hawn, Quality Program Site Manager
- F. Miller, Welding Construction Superintendent
- J. Thompson, Site Manager

Westinghouse Electric Company (Westinghouse)

J. Baker, Site Representative

The NRC resident inspectors also interviewed additional licensee personnel, Bechtel personnel, and other contractor personnel during this inspection.

*Denotes those individuals attending one or more exit interviews during the inspection period.

2. Site Tours

During this reporting period, routine tours of the site were conducted by the NRC inspectors. In addition to the general housekeeping activities and cleanliness of the facilities, specific attention was given to areas where safety-related equipment is installed and where activities were

in progress involving safety-related equipment. These areas were inspected to ensure that:

- a. Work in progress was being accomplished in accordance with approved procedures.
- b. Special precautions for protection of equipment were being implemented, where required, and additional cleanliness requirements were adhered to, where required.

The areas inspected included:

Units 1 and 2

Reactor containment buildings, mechanical-electrical auxiliary buildings, fuel handling buildings, diesel generator buildings, and the springline area of Unit 2 reactor containment.

Site

Reservoir, essential cooling pond, warehouses, laydown areas, welder qualification area, Pittsburg Testing Laboratory area, and heavy equipment storage area.

With regard to the above areas, the NRC inspector confirmed the following:

- a. Safety-related and storage areas were free from accumulations of trash, refuse, and debris.
- b. Work areas were clean and orderly.
- c. Tools, equipment, and material were returned to their proper storage locations when no longer in use.

Some areas requiring additional attention relative to housekeeping and cleanliness were pointed out to the licensee. These areas were attended to within a reasonable time and the NRC inspectors had no further questions concerning site tours.

3. Allegations

Two separate allegations were received by the NRC dealing with the primary and secondary shield wall placements at about the 67' level of Unit 2. After discussions between the licensee's management and the region, the constructor placed a stop work order for all construction activities related to the primary and secondary shield walls in Unit 2. HL&P (licensee), Bechtel (architect-engineer), and Ebasco (constructor) investigated the allegations and the impact of these allegations on safety and construction. The NRC resident inspector monitored these investigations and commenced an independent inspection of the work on the shield walls. The results of the investigation and inspection will be documented in a future inspection report.

4. Weld Filler Material Control

The NRC inspector observed activities at two of five field weld issue stations. Weld material was properly stored as required by Procedure QCP-9.4, "Verification of Weld Filler Material Control," Rev. 0, dated July 16, 1982. No open cans of coated rod were found. All open boxes of welder material were properly identified (red paint on butt tip). All ovens were checked for properly identified material and proper oven temperature. The portable ovens were in proper working condition. Rod was issued in accordance with approved procedures. The rod issue rooms were clean, well organized and contained current issues of approved procedures. No deviations or violations were noted in this area.

5. Nonconformance Report System

The NRC inspector selected two nonconformance reports (NCR) at random, one closed (BP-00351), dealing with damaged weld rod, and one open (HM-00254), dealing with improperly identified weld filler material at the field weld issue stations.

NCR BP-00351 was properly completed and dispositioned. The NRC inspector reviewed the documentation dispositioning the damaged rod to the welder qualification building. The NRC inspector visited the welder qualification facility and found the weld rod by lot and heat number. It was clearly marked as not to be used in fabrication.

NCR HM-00254 was open for approximately three months and dealt with weld filler material that was mislabeled, and found as such by personnel in the field weld issue station. The five boxes (250 pounds) were identified at three separate stations, hold tags applied, and the five boxes returned to the warehouse by Procedure QCP 15.1, "Identification and Control of Discrepancies and Nonconforming Conditions," Rev. 4, dated November 28, 1983. The NCR system failed to identify documentation and reinspection requirements for material returned from the field. The NCR system failed to allow for this situation. Additionally, no provision was made to cease issuing filler material from the warehouse of the same lot and heat number as the bad rods until it could be re-inspected by receiving QC inspectors. The mislabeling identified was between 1/8" and 3/32" diameter material. The rod issued before reinspection at the warehouse of the remaining rod of the same heat and lot, presented no compromise of welding integrity, because 1/8" and 3/32" rods could be used interchangeably. This matter is an apparent violation (498/499-8404-01).

6. Special Nondestructive Inspection

NRC Inspection Report 50-498/84-01; 50-499/84-01 discussed a special announced inspection on nondestructive examination (NDE) activities by an NRC van. The results of this special inspection were presented in NRC Inspection Report 50-498/84-02; 50-499/84-02. This special inspection found that weld CS2007FW0001 was unsatisfactory, but had

been accepted by the licensee. The NRC inspector monitored licensee activities to followup on this apparent violation. Examination of the weld in question was made by radiographic, liquid penetrant, and visual means. The licensee used several Level III NDE examiners, including an independent consultant. As a result of this examination, the licensee concluded that weld CS2007FW0001 was, in fact, satisfactory as originally made. The NRC inspector reviewed the licensee's findings and concurred with their conclusion. Accordingly, the Notice of Violation, dated March 21, 1984, was withdrawn by separate correspondence.

7. Cad Welding

The NRC inspector observed the inspection by the constructor QC field inspector of safety-related cad welds in Unit 2 reactor containment building. The QC inspector went through a step-by-step inspection using Procedure QCP 10-1, "Cad Weld Inspection," Rev. 2, dated November 30, 1983, explaining what he was looking for and how he was evaluating the data. Data sheets, with qualification cards and weld identification to prints were reviewed. All data reviewed was complete and in accordance with the above procedures. The QC inspector's field log was reviewed for rejection of welds. The log was satisfactory. No deviations or violations were identified based on this inspection.

8. Exit Interviews

Exit interviews were held periodically with licensee management personnel during the course of this inspection. Those attending one or more of the meetings are denoted in paragraph 1. At these meetings, the scope and findings of the inspection were presented.