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orig 3

DOCUMENTATION TRANSMITTAL

To: Stone & Webster - CIO
PO Box 1963
Midland, MI 48640

Transmittal No: CIO-0044
Date: May 12, 1984

Attention: David Beauchamp

The documentation listed below is provided herewith, X was previously provided on 5-11-84 ; as requested by David Beauchamp .

Documentation Description: Nonconformance Report - C-02834-V

CIO has X has not been placed on routine transmittal for the described documentation.

Janne Kinne
Signature

8406050511 840512
PDR ADOCK 05000329
S PDR

- CC RJCook, NRC Site (w/a, unless voluminous)
- JJHarrison, NRC Region III (w/a, unless voluminous)
- DDJohnson, SMO (w/o)
- JGKeppler, NRC Region III (w/a, unless voluminous)
- BHPeck, SMO (w/o)
- NIRichel, SMO (w/o)
- RAWells, MPQAD (w/o)
- CMThompson - File 24.2 (w/a, unless voluminous)

IE01
MAY 30 1984

MIDLAND PROJECT
QUALITY ASSURANCE
DEPARTMENT

ORIGINAL

NONCONFORMANCE REPORT

16 NCR NO. C-02834-V
17 DATE ISSUED 4-16-84 18 REV 2
19 PAGE 1 OF 9 *mjlw 4/16/84*

1 ITEM LOCATION

Unit #2, Aux. Bldg., Rm 118, 596' El., 5:5"N/16:14:7"W 17.4 Mod 1200

2 ITEM DRAWING/PART NO.

Dwg L-855 rev. 22

3 ITEM PART NAME

Unit Code 2VM54A

4 ITEM SERIAL NO.

N/A

5 ITEM DESCRIPTION

Welded Connections of Structural Supports

6 ITEM STARTUP SYSTEM NO.

Mod. 1200

7 REFERENCE DOCUMENT ~~PCI L-2.10 rev. 13~~ ^{AW5 01.1}
~~PCI LW-1.00 rev. 6~~ Spec. C-304 rev. 14

8 ASME A.H.I. REQUIRED
 YES NO

9 INSPECTION RECORD NO.

U-LW-1.00-10

LOG NO.

U154

REV NO.

N/A

10 RESPONSIBLE ORGANIZATION

Construction

11 NONCONFORMANCE DISCOVERED DURING:

POST INSPECT TURNOVER POST TURNOVER DESIGN RECEIVING CONST RELEASE FOR INSPECT PRE-OP TEST FINAL TURNOVER OVERINSPECT

12 REQUIREMENT Dwg. L-855 rev. 22 Det. 2 Sec. B & Dwg. C862 rev. 22 Det. 6 Show Required Weld Sizes
~~PCI rev. 6 LW-1.00 para. 3.1.1 The minimum fillet weld shall be the size specified in the Dwg., and shall not under-run the size by more than 1/16" for more than 10% of weld length.
3.1.2 A Maximum overrun for either or both fillet weld legs shall not exceed +3/16" for welds up to and including 3/8" ...
3.1.9.4 Blemishes resulting from arc strikes are ground to a smooth contour ...
3.1.12 Thorough fusion shall exist ...
3.1.13 All craters are filled to the full cross section of the weld.~~ *mjlw 4/16/84 see 1. cont. Smt.*

- 13 NONCONFORMANCE ^{ITEM 1}
- 1. Fillet weld sizes are not in accordance with the design requirements.
 - Item 2. Arc strikes are not ground smooth.
 - Item 3. Thorough fusion does not exist between weld and base metal.
 - Item 4. Craters are not filled to the full cross section of the weld.
 - Item 5. Final configuration is not acceptable.
 - Item 6. Welder's Identifying Symbol Not Legible.
 - Item 7. Excessive leg size

14 NCR ORIGINATED BY (PERSON)
Mark L. Winkler 4/16/84
DATE

15 NCR ORIGINATED BY (DISCIPLINE)
MPQAD/Civil Struct.

See Attachments for Detail.

20 NUMBER OF HOLD TAGS (IF APPLIED)

1

21 LOCATION OF HOLD TAGS

596' El. 6:5"N/16:15:4"W 17.4

22 POTENTIAL 50.55(e)

YES NO

24 ACTION ITEM NO.

SO6664

25 ITEM PRIORITY CODE NO.

5

26 NCR REVIEWED BY:

William E. Jones 4/16/84

23 REPORTED TO MPQA MANAGER

DATE N/A

25 DISCIPLINE:

S

27 TREND CODE

CC-20016
CC-40019 40005
CC-38002

DATE:

4/16/84

29 CAUSE

30 PROCESS CORRECTIVE ACTION

YES NO QAR NO. _____

31 RECOMMENDED DISPOSITION

REMARK SCRAP/REJECT REPAIR USE AS IS

32 CONDITIONAL RELEASE

YES NO

31A ADDITIONAL INFORMATION

33 DISTRIBUTION FOR ACTION

34 DISPOSITION CONCURRENCE

_____	_____	_____	_____	_____	_____
PROJECT FIELD ENGINEER	DATE	MPQAD CONCURRENCE	DATE	PFQCE (ASME)	DATE
_____	_____	_____	_____	_____	_____
LEAD DESIGN ORG	DATE	CP Co SMD (for turned over systems)	DATE	PQAE (ASME)	DATE
_____	_____	_____	_____	_____	_____
				A.N.I. (ASME)	DATE

35 DISPOSITION ACTION TAKEN

36 METHOD OF DISPOSITION ACTION VERIFICATION

RESULT OF DISPOSITION ACTION VERIFICATION
 ACCEPTABLE UNACCEPTABLE

IF UNACCEPTABLE, REFERENCE SUPERCEDING NCR NUMBER _____

37 NCR CLOSED BY

_____	_____
MPQAD	DATE
_____	_____
A.N.I. (ASME)	DATE

ORIGINAL

NONCONFORMANCE REPORT CONTINUATION SHEET

NCR NO. C-02834-V

DATE ISSUED 4-16-84

REV 01

PAGE 23 OF 9

msw
4/16/84

msw
4/16/84

Block 13¹² Cont. PQCI C-210 rev.13 para. 3.2.4 Final configuration is acceptable.

PQCI CW-1.00 rev.6 para 3.1.15 Welder's Identifying symbol.

msw
4/16/84

msw
4/16/84

See below

Block 12 Change A

Item #1 Spec. C-304 para. 6.2.1A Minimum fillet weld size shall be the size specified on the Dwg. ... (Dwg C-855 rev.22 Oct. 2 Sec. B & Dwg. C-862 rev.22 Oct. 6)

Item #2 AWS D1.1 para 4.4 Blemishes resulting from arc strikes are ground to a smooth contour...

Item #3 Spec. C-304 para. 6.2.4 Thorough fusion shall exist...

Item #4 AWS D1.1 para. 8.15.1.3 All craters are filled to the full cross section of the weld.

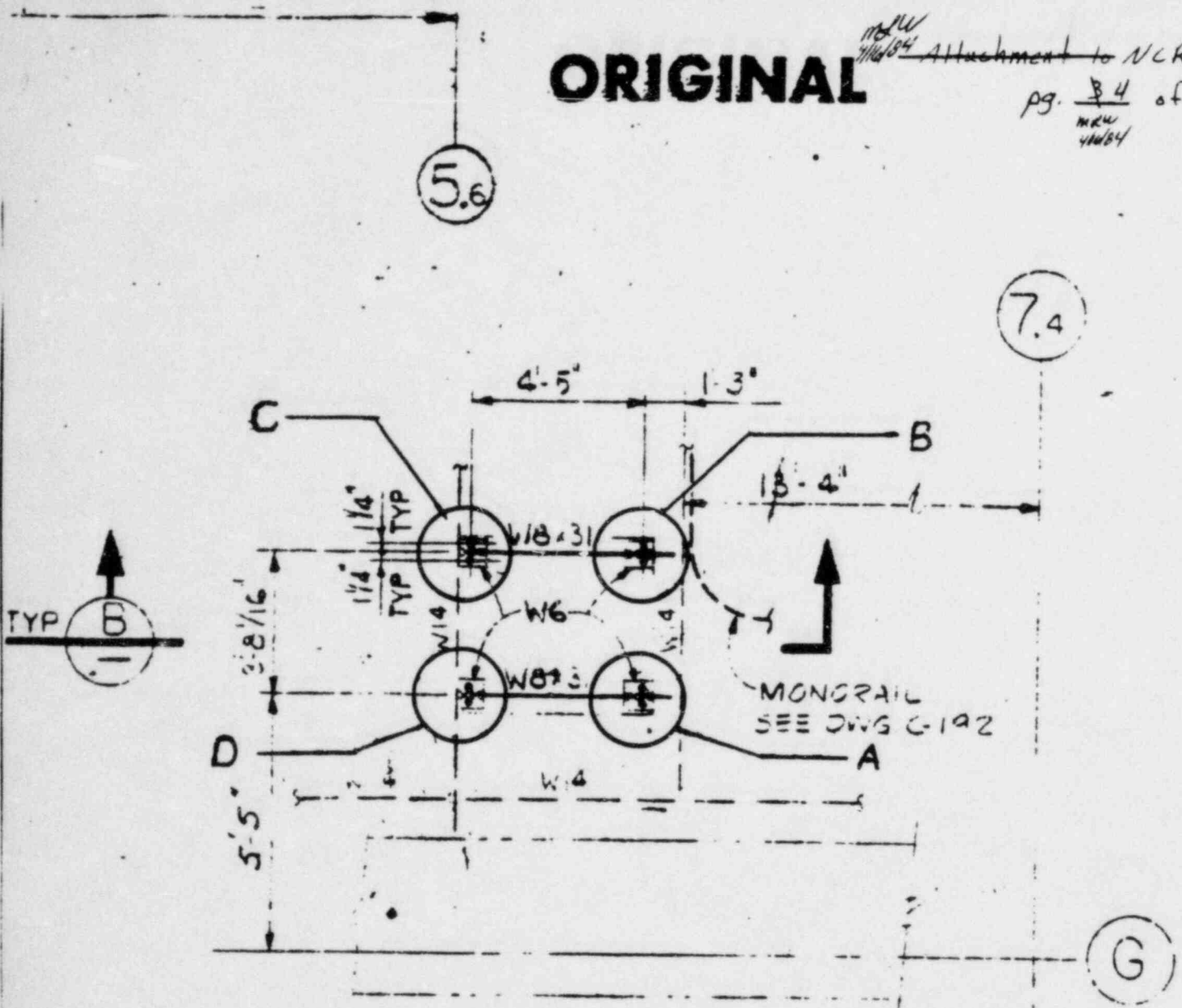
Item #5 Dwg. C-855 rev.22 Final Configuration

Item #6 PQCI CW-1.00 rev.6 para. 3.1.15 Welder's Identifying Symbol.

Item #7 Spec. C-304 6.2.1b Maximum overrun for either or both fillet weld legs shall not exceed $\pm 3/16$ "...

ORIGINAL

maw
4/12/64 Attachment to NCR # C-0785
pg. 84 of pg 9
maw
4/12/64



Plan Locations

DETAIL 2

Ref. Dwg C-855
QC Roll Out

EXIST. 1/2" R
TOP & BOT FLG

EXIST. W14

1/4" x 7/8" STIFF R EA SIDE

W8

T.O.S.
EL 596'-0 1/2"

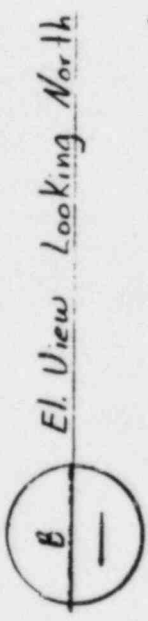
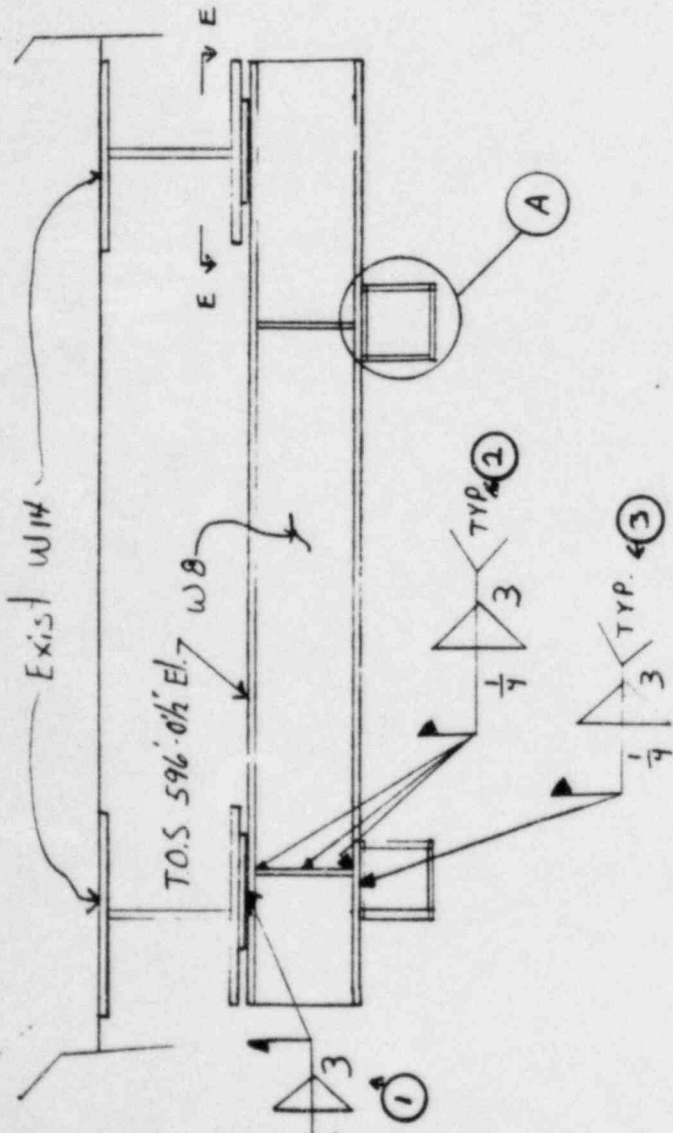
WG-23
5" LG.

2-3/4" - S BOLTS
A-325

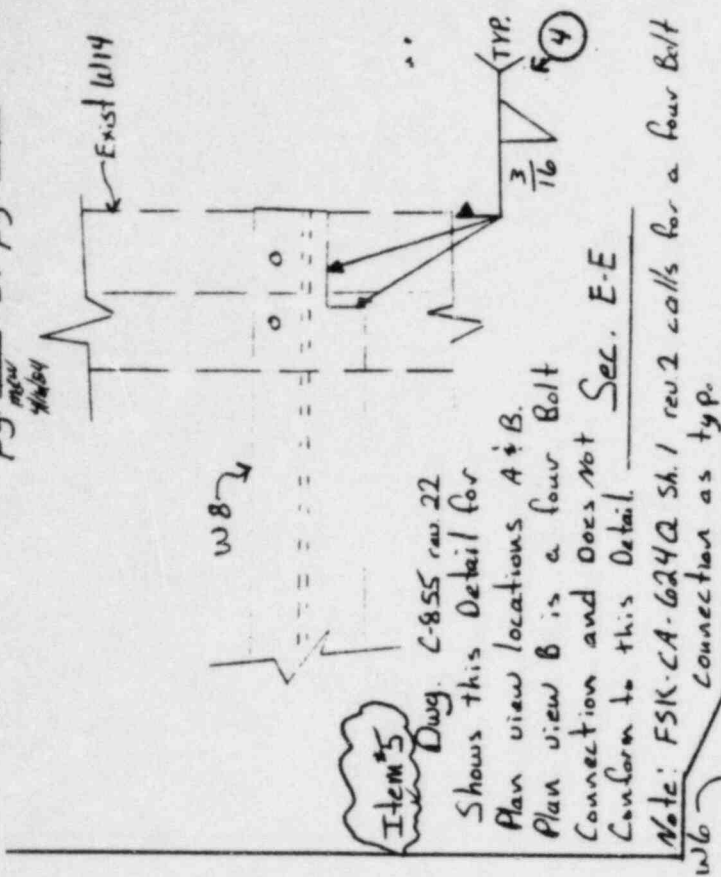
3" MAX RES
3" NOT MORE TH

maw
4/12/64
QC Roll Out Log
pg. 84 of 89
maw
4/12/64

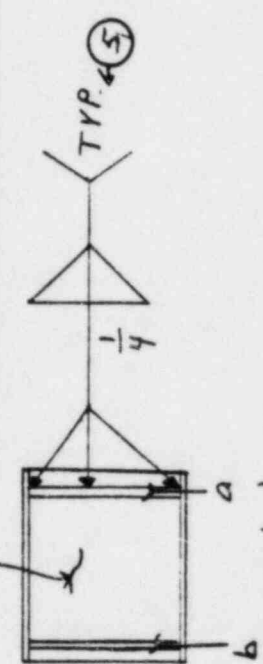
MSJ/WJ
4/10/04 Attachment to NCR # C-02932-V
Pg 25 of 29
REV 4/10/04



Note: Weld Identification
 A, B, C, D Plan Locations
 1, 2, 3, 4, 5 Individual Welds
 N.S. Near Side (Looking North)
 F.S. Far Side (Looking South)



Item 5
 Dwg. C-855 rev 22
 Shows this Detail for
 Plan view locations A & B.
 Plan view B is a four Bolt
 Connection and Does Not Sec. E-E
 Conform to this Detail.
 Note: FSK-CA-624Q Sh. 1 rev 2 calls for a four Bolt
 Connection as typ.



Detail A
 (Ref. Dwg. C862)

ORIGINAL

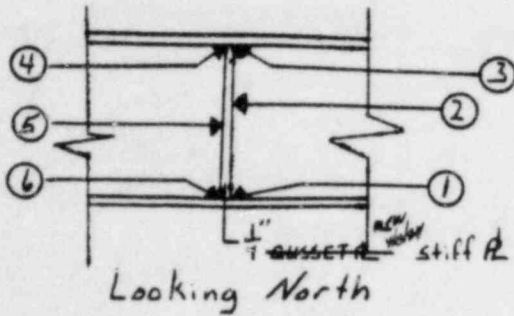
QC Roll out NO SCALE
 Structural Supports for Unit Cooler 2UM54A
 Ref. Dwg. C-855

ORIGINAL

2NS (TYP)

^{mjw}_{4/14/04} Attachment to NCR # C-02834-V

pg. ~~6~~ of pg. 9
{mjw}{4/14/04}



Notes: Undersize = 1 leg $\frac{3}{16}$ "
Insufficient Throat = $< \frac{1}{4} \geq \frac{3}{16}$ " *
* Fillet Gage Size
* Gouges in weld metal apparently caused by grinding.

Weld C2NS

2) $5 \frac{7}{8}$ " length

5) $5 \frac{3}{4}$ " length ^{mjw}_{4/14/04}

weld B2NS

1) Gouge in weld metal (G.W.M) *
 $2 \frac{1}{4}$ " length $\frac{3}{32}$ to $\frac{1}{8}$ " Deep

2) $5 \frac{7}{8}$ " length
G.W.M. $4 \frac{3}{8}$ " length $\frac{3}{32}$ " Deep

4) G.W.M. $2 \frac{3}{8}$ " length $\frac{3}{32}$ " Deep

5) $5 \frac{7}{8}$ " Length
G.W.M. 4" length $\frac{1}{8}$ " Deep

6) G.W.M. $2 \frac{3}{8}$ " length $\frac{5}{32}$ " Deep

Weld A2NS

1) Insufficient Throat $\frac{1}{2}$ " \approx

2) $5 \frac{7}{8}$ " length
Insufficient Throat & Undersize 100%

3) Insufficient Throat 50% \approx
Undersize 100%

4) Undersize 100%

5) Undersize & Insufficient Throat 100%

6) Undersize 100%
Insufficient Throat 50% \approx

Item #1

Item #1

Weld O2NS

1) Undersize 25% \approx Insufficient Throat 80% \approx

2) Undersize & Insufficient Throat 100%

3) Insufficient Throat 50% \approx

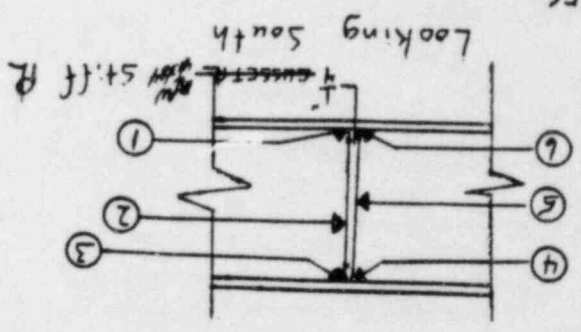
4) Undersize 100% Insufficient Throat 25% \approx

5) Undersize 100% Insufficient Throat 10% \approx

6) Undersize 100% Insufficient Throat 50% \approx

Item #1

Notes: Under size = 1 leg $\frac{1}{2}$
 Insufficient Throat = $\frac{1}{2} < \frac{1}{8}$
 * Fillet Gage & size



Weld A2FS

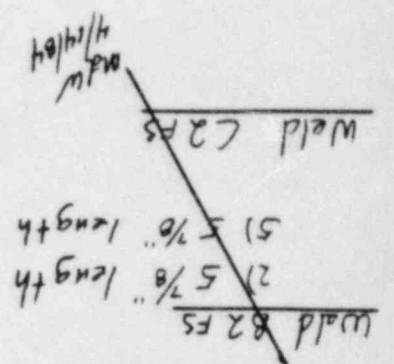
- 1) Under size & Insufficient Throat 90% \approx
- 2) 5/2" in length
- Under size 90% \approx Insufficient Throat 1" \approx
- 3) Under size 60% \approx Insufficient Throat 1" \approx
- 4) Under size 25% \approx Insufficient Throat $\frac{1}{2}$ " \approx
- 5) Under size 90% \approx Insufficient Throat 75% \approx
- Length 5/2"
- 6) Under size & Insufficient Throat 50% \approx

Item #1

Item #1 & 4

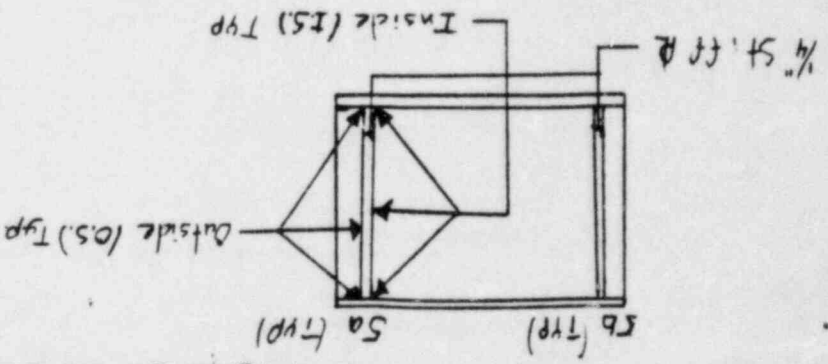
- 1) Under size & Insufficient Throat 100% \approx
- 2) 5/8" length, Under size 100% \approx
- 3) Crater Not filled to full cross section of weld
- 4) Length 5/8" Insufficient Throat & Under size 25% \approx
- 5) Insufficient Throat & Under size 90% \approx
- 6) Base metal seam runs up to the toe of each weld.

Weld D2FS



Weld C2FS

pg 28 of pg 9
 Item # 5
 Doug L-855 re 22 calls for these
 stiff fls to be on the South
 side of the W6 x 15.85
 The opposite exists in the field.



Weld A5a
 O.S. Undersize & Insufficient Throat 100%
 I.S. Undersize 80% = Insufficient Throat 25%
 Item # 1

Weld A5b
 O.S. Undersize & Insufficient Throat 100%
 I.S. Undersize 100% Insufficient Throat 10%
 Item # 1

Weld D5a
 O.S. Undersize 25% = Insufficient Throat 25%
 I.S. Undersize & Insufficient Throat 40%
 Lack of Fusion & Slag Included 1/2" length
 Bottom Corner not web & stiff fl
 Item # 1 & 3

Weld D5b
 O.S. Undersize 100% Insufficient Throat 95%
 I.S. Undersize + Insufficient Throat 50%
 Item # 1

Weld B5a
 O.S. Undersize 100% Insufficient Throat 90%
 I.S. Undersize 100% Insufficient Throat 50%
 Item # 1

Weld B5b
 O.S. Undersize & Insufficient Throat 100%
 I.S. Undersize 80%
 Item # 1

Weld C5a
 O.S. Undersize & Insufficient Throat 100%
 I.S. Undersize 100% Insufficient Throat 10%
 Item # 1

Weld C5b
 O.S. Undersize 90%
 I.S. Undersize & Insufficient Throat 80%
 Item # 1

ORIGINAL

Weld A3 Item #1

N.S. 5" length Excessive Convexity $\frac{1}{2}$ " *
F.S. $4\frac{7}{8}$ " length Insufficient Throat $\frac{1}{2}$ " $\frac{1}{2}$ " $\frac{1}{2}$ " 10% =

Weld B3 Item #1 ^{msw 4/14/04} #7

N.S. 5" length
1 leg $\frac{1}{2}$ " Excessive Convexity $\frac{7}{16}$ " - $\frac{1}{2}$ " *
* Fillet Gage Size
F.S. $4\frac{3}{4}$ " length

Weld C3 Item #1 #4

N.S. $4\frac{7}{8}$ " length
F.S. Crater not filled to full cross section of weld
Under size 25%
5" length

Weld D3 Item #2 #6

N.S. Arc strike not ground smooth

F.S. $4\frac{7}{8}$ " length
Arc Strike not ground smooth
Welder ID Not Legible

~~Weld O1~~

~~N.S. $5\frac{7}{8}$ " length

F.S. $5\frac{7}{8}$ " length~~

~~Weld E1~~ ^{msw 4/14/04}