

D-329  
50-330

DMB

PRINCIPAL STAFF		
RA	has	✓ orig 3
D/RA		DE
A/RA		DRMSP
RC		DRMA
PAO		SCS
SGA		ML
ENF		File has

DOCUMENTATION TRANSMITTAL

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

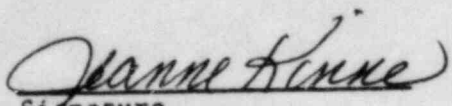
Transmittal No: CIO-0066  
Date: June 6, 1984

Attention: Ralph Butler

The documentation listed below \_\_\_ is provided herewith, X was previously provided on 6-6-84 ; as requested by Ralph Butler .

Documentation Description: Nonconformance Report - C-03736

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

  
Signature

- CC RJCook, NRC Site (w/a, unless voluminous)
- JJHarrison, NRC Region III (w/a, unless voluminous)
- DDJohnson, SMO (w/o)
- JGKepler, 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)

MI0384-0001A-QL06

B406150054 B40606  
PDR ADOCK 05000329  
S PDR

JUN 11 1984

LEO/

NONCONFORMANCE REPORT

**ORIGINAL**

16 NCR NO. C-03736 SU  
17 DATE ISSUED 5-12-84 18 REV 0  
19 PAGE 1 OF 6

1 ITEM LOCATION

UNIT # 2, AUX. Bldg, EL. 5B4, Rm 11B, 11'-6" T<sub>o</sub> 15'-6" W/7.4, 13'-6" N/G

2 ITEM DRAWING/PART NO.

7220-A17A-14/A

3 ITEM PART NAME

(Door #23, WATER TIGHT) WELDS

4 ITEM SERIAL NO.

N/A

5 ITEM DESCRIPTION

WELDS ON Door #23, See ATTACH. #1

6 ITEM STARTUP SYSTEM NO.

Module # 120D

7 REFERENCE DOCUMENT ACT. 3.1.7, 3.1.2, 2.1.22, 2.3  
PQCI CW-1.00 AWS D1.1, G-27 GWS - STR

8 ASME A.N.I. REQUIRED  
 YES  NO

9 INSPECTION RECORD NO.

CW-100-747

LOG NO.

216417

REV NO.

6

10 RESPONSIBLE ORGANIZATION

CONSTRUCTION

11 NONCONFORMANCE DISCOVERED DURING:

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

12 REQUIREMENT

- (1) AWS D1.1 Paragraph 3.2.1: Surfaces and edges to be welded smooth, uniform and free of defects.
- (2) GWS STR 5.1: Preheat temperature shall be in accordance with general preheating requirements.
- (3) AWS D1.1 Section 5: Joint fit up conforms to the prequalified joint detail.  
GWS STR 4.1.3.1: The parts to be joined by fillet welds shall be brought into close contact as possible, if gap is 1/16" or greater both legs of fillet weld will be increased by the amount of separation.  
GWS STR: Verify that tack welds that are to be incorporated into final weld meet requirements of final weld.

CONTINUED

13 NONCONFORMANCE

The above requirements are listed in PQCI CW-1.00 with hold points to be inspected. The welds on the above listed IR have been made previous to inspection and the condition is indeterminate, on the following:

- (1) Preparation of Base Metal
- (2) Preheat
- (3) Fitup

14 NCR ORIGINATED BY (PERSON)

Jim Hellett

5/12/84  
DATE

15 NCR ORIGINATED BY (DISCIPLINE)

GC CIVIL

20 NUMBER OF HOLD TAGS (IF APPLIED)

1

21 LOCATION OF HOLD TAGS

Door #23 FRAME

22 POTENTIAL 50.55(a)

YES  NO

24 ACTION ITEM NO.

507917

25 ITEM PRIORITY CODE NO.

2

26 NCR REVIEWED BY:

William E. Dampf

23 REPORTED TO MPOA MANAGER

DATE N/A

25 DISCIPLINE:

S

27 TRENCH CODE

GG-20001 GG10001  
GG-30004 GG50008

DATE:

5/12/84

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

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

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

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

Block 12 continued -

(4) Drawg. 7220-A17A-14-8 specifies A intermittent  $3/16"$  Fillet weld with 2" length AND 6" pitch.

AWS. A 2.4-79 SECTION 4.6.1 STATES THAT THE SYMBOL INDICATES THAT INCREMENTS SHALL BE LOCATED AT THE ENDS OF THE DIMENSIONED LENGTH.

(5) MAX. OVERRUN FOR FILLET WELD LEGS SHALL NOT EXCEED  $+3/16"$  FOR WELDS UP TO AND INCLUDING  $3/8"$ . FILLET WELDS LARGER THAN THIS REQUIRES FE. APPROVAL PRIOR TO FINAL ACCEPTANCE. SPEC. C-304 6.2.1

(6) ADDITIONAL WELDS NOT SHOWN ON DRAWING REQUIRE FIELD ENGINEERING APPROVAL PRIOR TO FINAL ACCEPTANCE. SPEC C-304 6.2.7

Block 13 continued:

(4) THE INTERMITTENT FILLET WELDS ( $3/16"$  - 2" LONG + 6" PITCH) CONNECTING DOOR FRAME TO EMBEDDED ANGLE DOES NOT HAVE INCREMENTS AT THE ENDS. SEE ATTACHMENT #1. THIS <sup>APPLIES</sup> ~~APPLIES~~ TO THE VERTICAL ENDS OF THE FRAME ONLY.

(5) THE WELDS IDENTIFIED WITH A \* SYMBOL ON ATTACHMENT 1 ARE THOSE WITH WELD SIZES IN EXCESS OF  $+3/16"$ . THE AVG. ACTUAL SIZE IS  $7/16"$  FOR ENTIRE WELD. WELDS #3 OVERSIZE AND #4. (SEE ATTACH 1)

(6) ADDITIONAL WELDS INDICATED ON ATTACHED SKETCH SECTION <sup>"ARE</sup> ~~"ARE NOT~~ SHOWN ON DRAWINGS.

NOTE  $1/4"$  GRIND OFF OF WELD #7 (LENGTH), THESE WELDS <sup>CONNECT</sup> ~~"ARE NOT~~ WALL EMBEDDED ANGLE FRAME TO EMBEDDED FLOOR ANGLE FRAME.

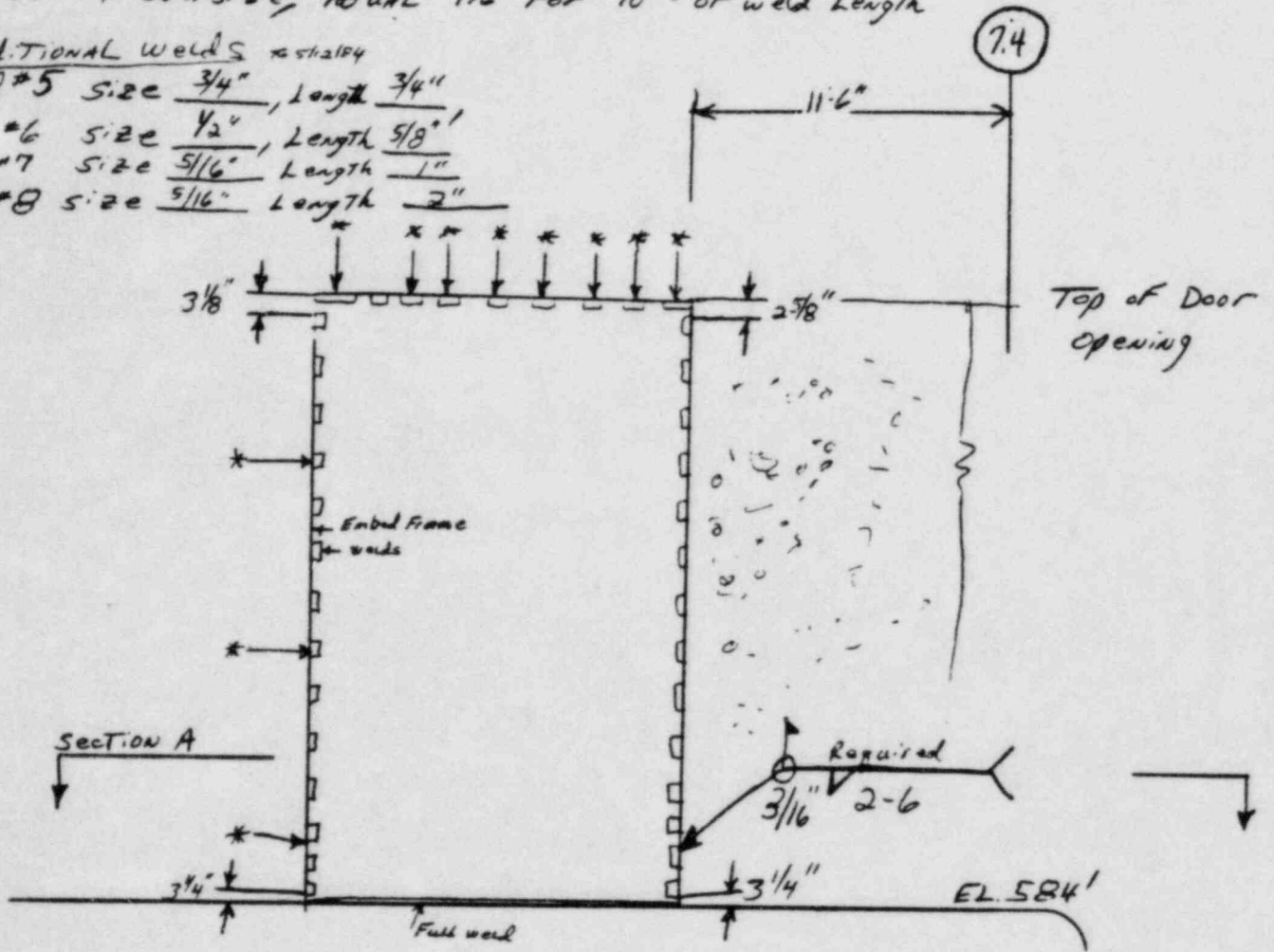
## ATTACHMENT #1

### NON-CONFORMANCES

- ① The symbol \* indicates (oversize welds, #1) to shaly
- ② Weld #3 oversize, ACTUAL  $7/16"$  For 10% of weld Length  
Weld #4 oversize, ACTUAL  $7/16"$  For 10% of weld Length

### Additional welds to shaly

- ③ Weld #5 size  $3/4"$ , Length  $3/4"$
- Weld #6 size  $1/2"$ , Length  $5/8"$
- Weld #7 size  $5/16"$ , Length  $1"$
- Weld #8 size  $5/16"$ , Length  $2"$

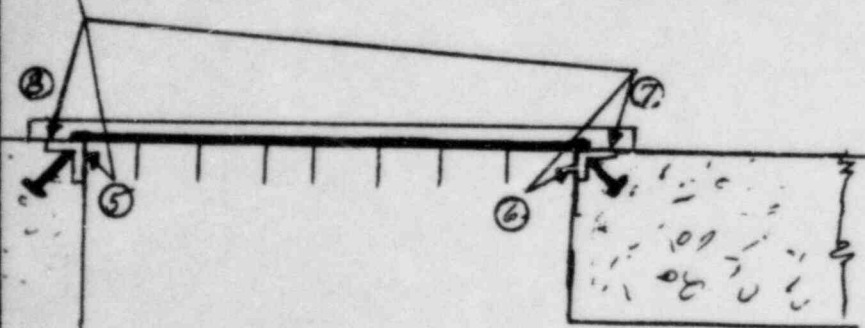


Elevation View (Looking North)

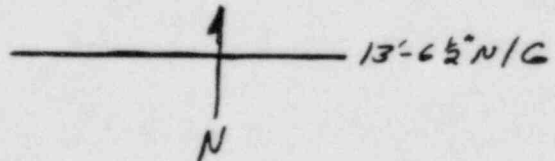
Watertight Door #23

13'-6" N/G, Aux. Bldg.

### Additional welds



SECTION A

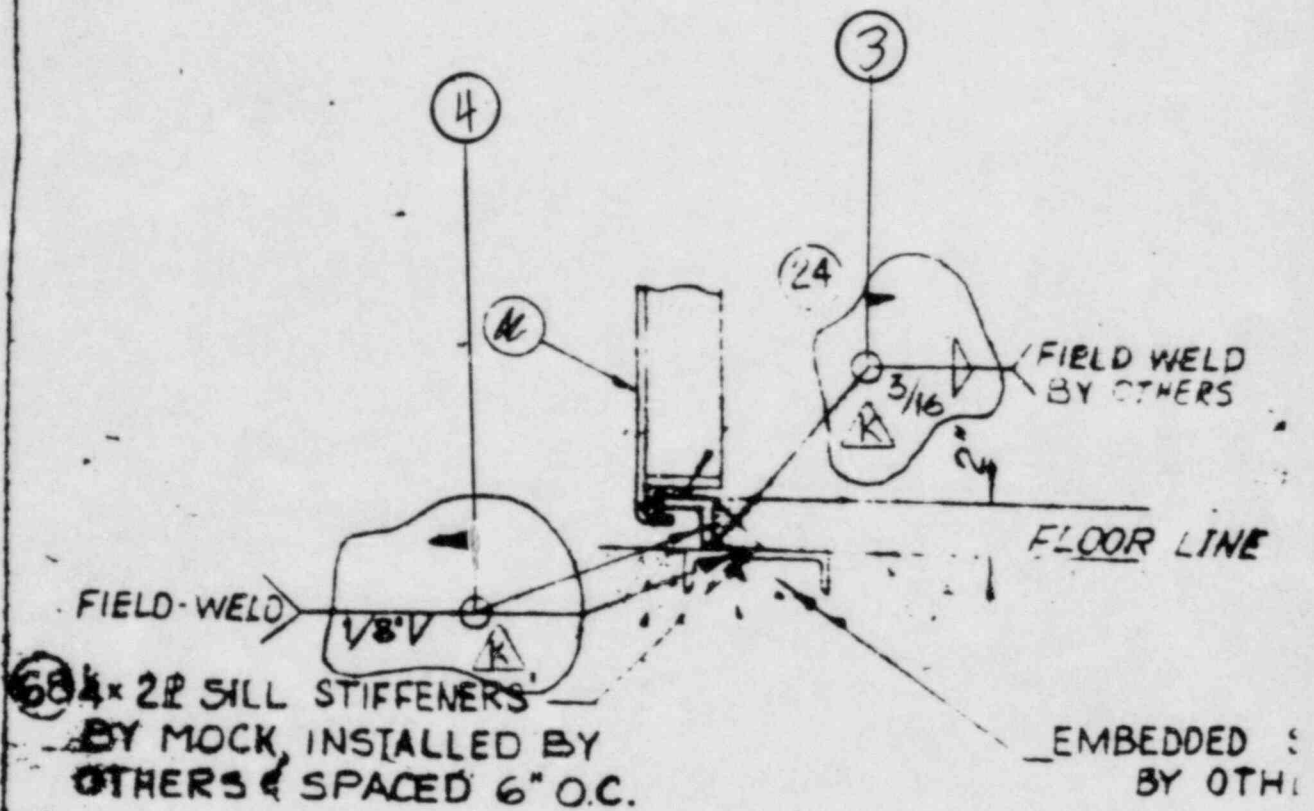


14 2 +2  
**ORIGINAL**

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GRAB HANDLE (65)  
USE FOR LIFTING LUG  
HALF SCALE



SECTION B-B'  
SCALE 1/2" = 1'-0"

(H)  
3 SIDES

(1)  
(5)

