

50-329
50-330

PRINCIPAL STAFF	
RA	las
D/RA	DE
A/RA	DRMSP
RC	DRMA
PAO	SCS
SGA	File
ENF	las

✓ page 3
JMB

DOCUMENTATION TRANSMITTAL

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

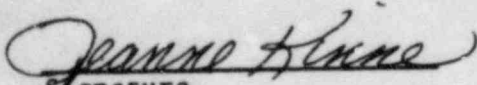
Transmittal No: CIO- 0063
Date: June 6, 1984

Attention: Neal Wetherell

The documentation listed below ___ is provided herewith, X was previously provided on 6-1-84 ; as requested by Neal Wetherell .

Documentation Description: Nonconformance Reports -
C-03732
C-03736
C-01006

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


Signature

B406150216 B40606
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)
- JGKepler, NRC Region III (w/a, unless voluminous)
- BHPeck, SMO (w/o)
- NIReichel, SMO (w/o)
- RAWells, MPQAD (w/o)
- CMThompson - File 24.2 (w/a, unless voluminous)

JUN 11 1984

JEO1

MIDLAND PROJECT
QUALITY ASSURANCE
DEPARTMENT

ORIGINAL

NONCONFORMANCE REPORT

16 NCR NO. C-03732-
17 DATE ISSUED 5-12-84 18 REV 0
19 PAGE 1 OF 2

1 ITEM LOCATION AUX. BLDG. EL. 584 ... 13'-6 1/2" N. OF "G" ... 11' E OF 6.9
MOD. 120D, 120E

2 ITEM DRAWING/PART NO. A17A-148
A17A-2186; 5/12/84 3 ITEM PART NAME "Julius Mock and Sons"
WATERTIGHT DOORS 4 ITEM SERIAL NO. N/A

5 ITEM DESCRIPTION INSTALLATION OF WATERTIGHT Door #23

6 ITEM STARTUP SYSTEM NO. MOD. 120D, 120E 7 REFERENCE DOCUMENT PQCI C-2.11.13 2.1.B; 2.1.D; 2.1.E 8 ASME A.N.I. REQUIRED YES NO

9 INSPECTION RECORD NO. C-2.11-6 LOG NO. 258041 REV NO. 0 10 RESPONSIBLE ORGANIZATION MPQAD-DC-CIVIL

11 NONCONFORMANCE DISCOVERED DURING: DESIGN RECEIVING CONST RELEASE FOR INSPECT
 POST INSPECT TURNOVER POST TURNOVER PRE-OP TEST FINAL TURNOVER OVERINSPECT

12 REQUIREMENT (A) SPEC. A17A-38-2 REV. 1 II #6; III #4 STATES ... GRINDING TO PRODUCE FAIR TRANSITIONS BETWEEN SHIMS AND FRAME HAS BEEN ACHIEVED.
(B) SPEC. A17A-38-2 REV. 1, II #6; III #4 STATES ... ALIGN AND CENTER DOOR ASSEMBLY. MAX. GAP BETWEEN SUBFRAME AND DOOR FRAME IS 1/16".
(C) SPEC. A17A-38-2 REV. 1; III #3, #12; II #3, #4 STATES ... BOTH EMBEDDED FRAME, DOOR FRAME, AND SILLS HAVE BEEN MECH. CLEANED FREE OF CONCRETE, LUBRICANT, DIRT, PAINT AND ANY FOREIGN MATTER FROM THE MOUNTING SURFACE OF THE PIECES.

13 NONCONFORMANCE (A) SHIMS ARE INDETERMINATE
(B) PROPER CONTACT IS INDETERMINATE
(C) CLEANLINESS IS INDETERMINATE

14 NCR ORIGINATED BY (PERSON) David G. Stinson 5/12/84
DAVID G. STINSON -6028 DATE
15 NCR ORIGINATED BY (DISCIPLINE) MPQAD-DC-CIVIL

20 NUMBER OF HOLD TAGS (IF APPLIED) 1 21 LOCATION OF HOLD TAGS ADJACENT TO DOOR

22 POTENTIAL 50.55(a) YES NO 24 ACTION ITEM NO. 507913 25 ITEM PRIORITY CODE NO. 2 26 NCR REVIEWED BY: William E. Gump

23 REPORTED TO MPQA MANAGER DATE NIA 25 DISCIPLINE: S 27 TREND CODE CC-50001 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

_____	_____	_____	_____	_____	_____
PROJECT FIELD ENGINEER	DATE	MPQAO CONCURRENCE	DATE	PFQCE (ASME)	DATE
_____	_____	_____	_____	_____	_____
LEAD DESIGN ORG	DATE	CP Co SMO (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

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

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, FL. 5B4, Rm 110, 11'-6" To 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, 3.1.22, 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 Schmitt 5/12/84
DATE

15 NCR ORIGINATED BY (DISCIPLINE)

QC Civil

20 NUMBER OF HOLD TAGS (IF APPLIED)

1

21 LOCATION OF HOLD TAGS

Door #23 FRAME

22 POTENTIAL 50.55(e)

YES NO

24 ACTION ITEM NO.

509917

26 ITEM PRIORITY CODE NO.

2

28 NCR REVIEWED BY:

William E. Gange

23 REPORTED TO MPCA MANAGER

DATE 5/12

25 DISCIPLINE:

S

27 TEND CODE

GG-20001 GG10001
GG-30004 GG50008

DATE:

5/12/84

CONTINUED ON REVERSE

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		HPQAB CONCURRENCE		PPQCE (ASME)	
_____	DATE	_____	DATE	_____	DATE
LEAD DESIGN ORG		CP Co SMO (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
HPQAB	
_____	DATE
A.N.I. (ASME)	

Block 12 continued -

(4) Drawg. 7220-A17A-14-8 specifies A intermittent $\frac{3}{16}$ " fillet weld with 2" length and 6" pitch.

A.W.S. 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 $+\frac{3}{16}$ " FOR WELDS UP TO AND INCLUDING $\frac{3}{8}$ ". FILLET WELDS LARGER THAN THIS REQUIRES F.E. 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 ($\frac{3}{16}$ " - 2" long + 6" pitch) connecting Door Frame to Embedded Angle does NOT have increments at the ends. See Attachment #1. This ^{APPL. 05} ~~APPL. 05~~ _{11/25/84} 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 $+\frac{3}{16}$ ". The avg. actual size is $\frac{7}{16}$ " for entire weld. Welds *3 oversize and *4. (see Attach 1)

(6) Additional welds indicated on attached sketch section "A" ^{ARE} ~~ARE NOT~~ _{11/25/84} shown on drawings.

Note: $\frac{1}{4}$ " ground off of weld *7 (length), these welds ^{CONNECT} ~~WALL~~ _{11/25/84} Embedded Angle Frame to Embedded Floor-Angle Frame.

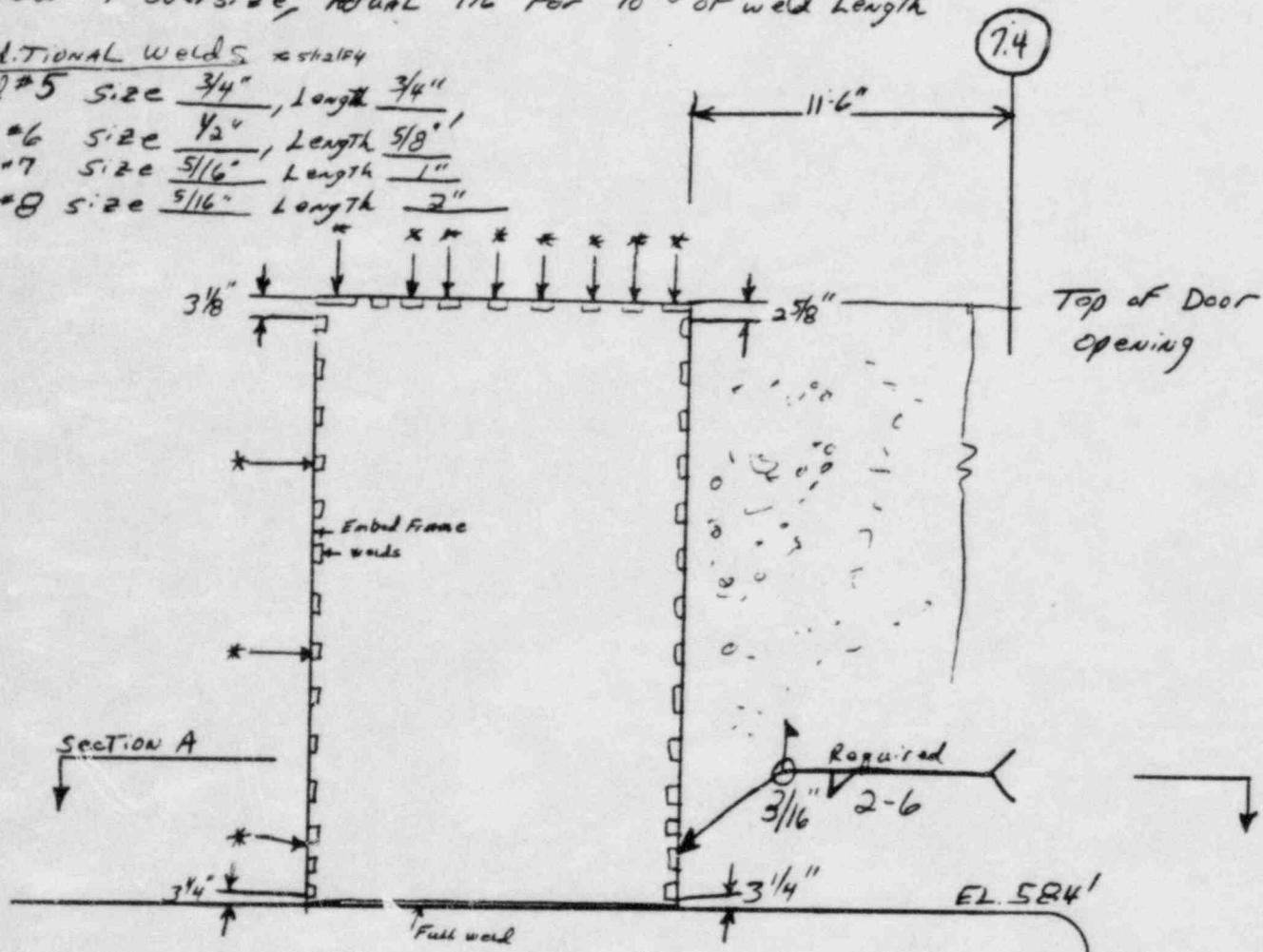
ATTACHMENT #1

NON-CONFORMANCES

- ① The symbol * indicates (oversize welds, #1) $\frac{1}{16}$ "
- ② Weld #3 oversize, actual $\frac{7}{16}$ " for 10% of weld length
- Weld #4 oversize, actual $\frac{7}{16}$ " for 10% of weld length

Additional welds *shaly

- ③ Weld #5 size $\frac{3}{4}$ ", length $\frac{3}{4}$ "
- Weld #6 size $\frac{1}{2}$ ", length $\frac{5}{8}$ "
- Weld #7 size $\frac{5}{16}$ ", length 1"
- Weld #8 size $\frac{5}{16}$ ", length 2"

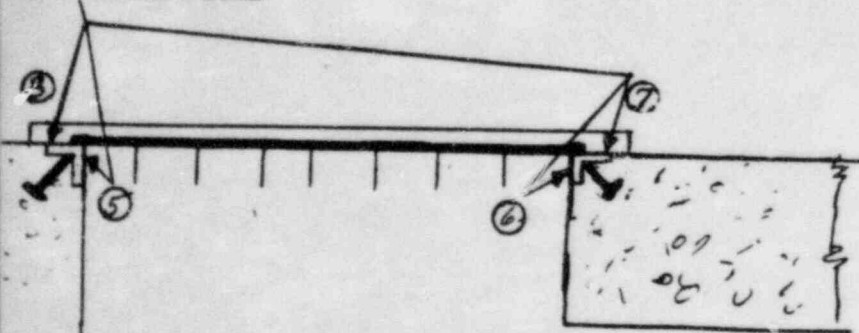


Elevation View (Looking North)

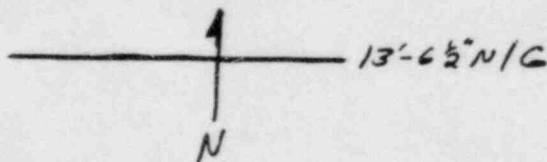
Watertight Door #23

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

Additional welds



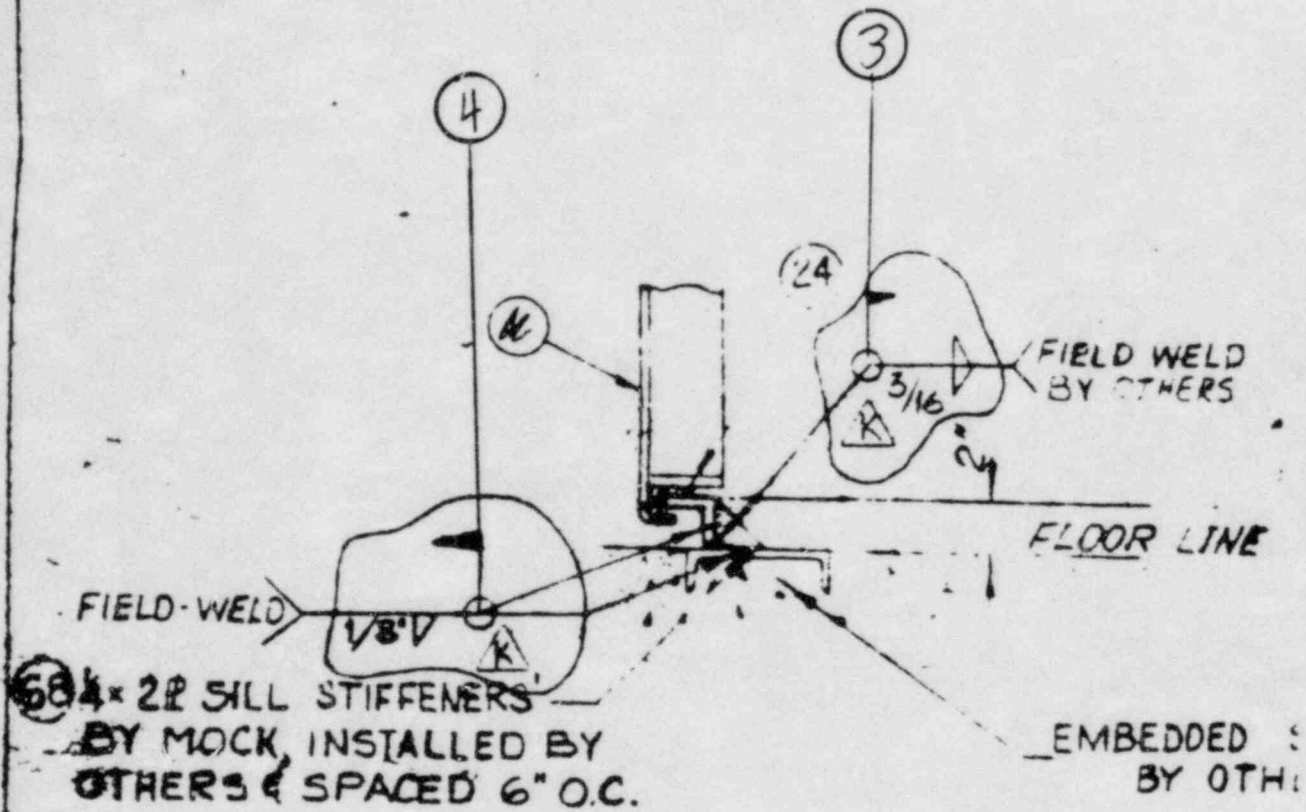
Section A



ORIGINAL

NCR # C-03736
Page 5 of 6

GRAB HANDLE (65)
USE FOR LIFTING LUG
HALF SCALE



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

1
5

3 SIDES

ORIGINAL

page 6 of 6
NCR # C-03736

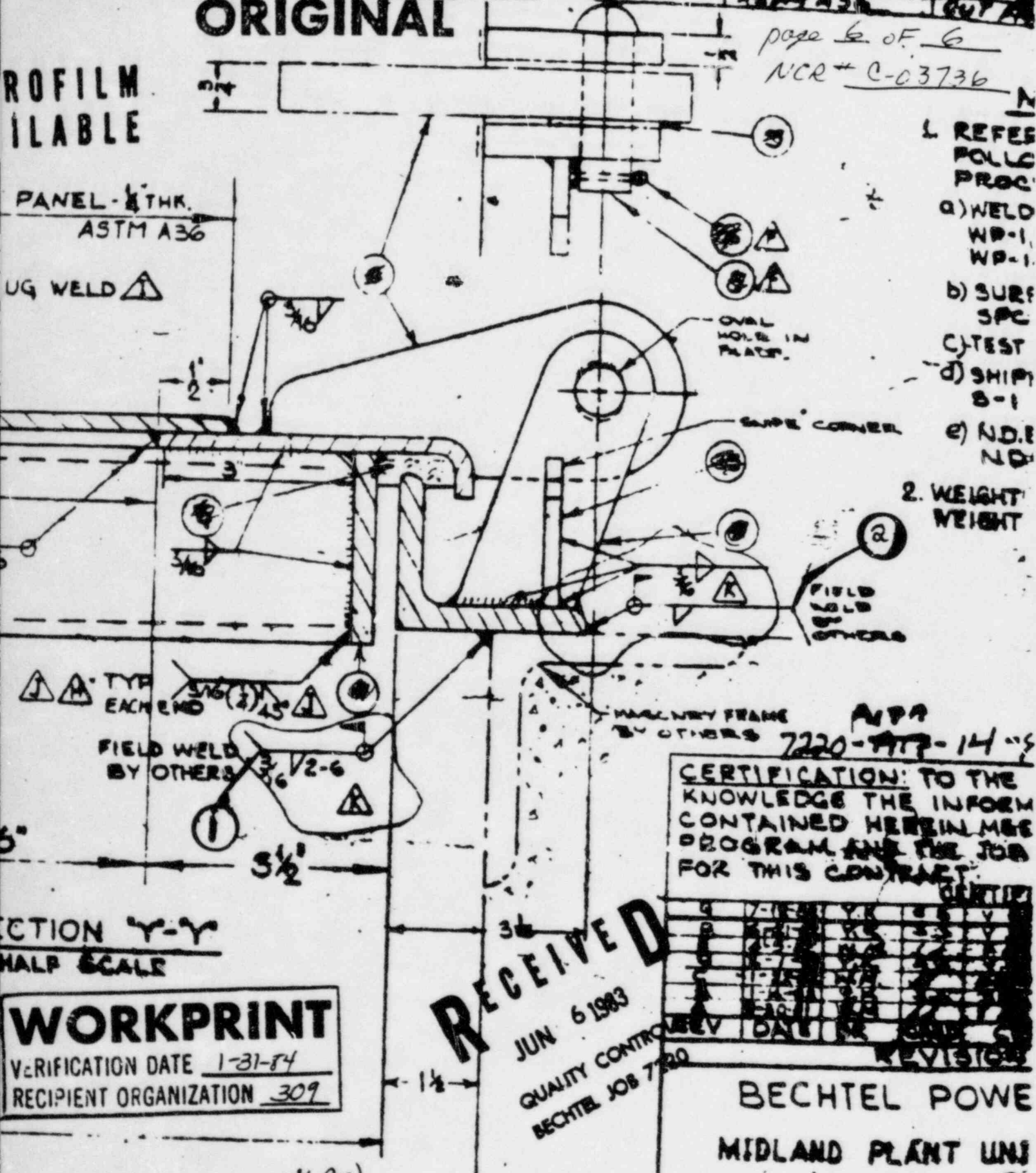
ROFILM
ILABLE

PANEL - 1/4 THK.
ASTM A36

UG WELD

- 1. REFER TO POLICIES PROC.
- a) WELD WP-1, WP-1
- b) SURF SPC
- c) TEST
- d) SHIP B-1
- e) N.D.E N.D.

2. WEIGHT WEIGHT



△ △ TYP EXHEND
 FIELD WELD BY OTHERS
 3/16 (2) 45°
 1/2-6
 3/8
 3/2

APR 7220-APP-14

CERTIFICATION: TO THE KNOWLEDGE THE INFORM CONTAINED HEREIN MEETS PROGRAM AND THE JOB FOR THIS CONTRACT.

RECEIVED
 JUN 6 1983
 QUALITY CONTROL
 BECHTEL JOB 7220

NO.	DATE	BY	REVISION
1			
2			
3			
4			
5			
6			
7			
8			
9			
10			

SECTION Y-Y
HALF SCALE

WORKPRINT
 VERIFICATION DATE 1-31-84
 RECIPIENT ORGANIZATION 309

BECHTEL POWER
 MIDLAND PLANT UNIT
 CONSUMER POWER CO

1-31-84 RW

CONFIDENTIAL

MIDLAND PROJECT
QUALITY ASSURANCE
DEPARTMENT

NONCONFORMANCE REPORT

ORIGINAL

16 NCR NO. C-01006

17 DATE ISSUED 1-20-84

18 REV 01 3/2/84

19 PAGE 1 OF 2 3638 JAN

1 ITEM LOCATION

Aux. Bldg. Elev. 568' through 634'. See attached sheet for locations

2 ITEM DRAWING/PART NO.

Vendor 0085-2 & 2A

3 ITEM PART NAME

Watertight doors & frames

4 ITEM SERIAL NO.

N/A

5 ITEM DESCRIPTION

Contract A17AQ Julius Mock & Sons, Inc.
Watertight doors & frames

6 ITEM STARTUP SYSTEM NO.

ORGC

7 REFERENCE DOCUMENT Vendor Procedure WP.1
C-304(Q) Rev. 13 (Specification) & AWS D1.1

8 ASME A.H.I. REQUIRED

YES NO

9 INSPECTION RECORD NO.

N/A

LOG NO.

N/A

REV NO.

N/A

10 RESPONSIBLE ORGANIZATION

Vendor

11 NONCONFORMANCE DISCOVERED DURING:

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

12 REQUIREMENT

~~Spec C-304(Q) Rev. 13, Sec. 6.2 states that all structural steel and misc. steel to conform to visual acceptance of AWS D1.1, Sec. 9.25. The following exceptions and clarifications are to be applied; fillet weld sizes shall be shown in drawings and measured to the nearest 1/16", undercut shall not exceed 1/32" or 25% of base metal thickness (whichever is less), and piping porosity shall be acceptable provided total sum of diameters does not exceed 3/8" in any linear inch and not exceed 3/4" in any 12 linear inches. Additionally, isolated undercut of 1/16" for base metal thicknesses of 1/4" and over may be tolerated for an accumulated length of 2" in any 12 inches of weld.~~

13 NONCONFORMANCE

Welding on doors and frames 5,6,7,8,210,205,14,15,18,23,24,25,26,109,29,31,32,33,34,35,40,43,44,45,46,53,65,77,84,88,108 contain non-conforming conditions (Eg. 'undercut', slag, porosity and undersized welds).

Welding on the above mentioned doors and frames is not in compliance with project approved vendor drawings and project approved welding procedure specifications.

See attached 31 drawings for results of a partial weld inspection completed by field welding engineers on 2-10-84

14 NCR ORIGINATED BY (PERSON)

Randall Womack RANDALL WOMACK 1-19-84 DATE

15 NCR ORIGINATED BY (DISCIPLINE)

Welding Engineer

20 NUMBER OF HOLD TAGS (IF APPLIED)

62

21 LOCATION OF HOLD TAGS

SEE Pg 2 of 2 3

22 POTENTIAL SO. 55(e)

YES

NO 3/2/84

24 ACTION ITEM NO.

S04345

26 ITEM PRIORITY CODE NO.

3

28 NCR REVIEWED BY

3/3/84

23 REPORTED TO MPOA MANAGER

DATE 3/2/84

25 DISCIPLINE:

A/C

27 TREND CODE

M-7

DATE:

1/24/84

CONTINUED ON REVERSE

F-2M/LA (Rev 1)

29 CAUSE VENDOR WORKMANSHIP

30 PROCESS CORRECTIVE ACTION

YES NO QAR NO. _____

31 RECOMMENDED DISPOSITION

REWORK SCRAP/REJECT REPAIR USE AS IS

32 CONDITIONAL RELEASE

YES NO

31A ADDITIONAL INFORMATION

PROJECT TO EVALUATE *L. Hawley 7/12/84*
SEE sh's 37 + 38 OF 38 FOR PROJECT ENGINEERING'S DISPOSITION

33 DISTRIBUTION FOR ACTION PROJECT

34 DISPOSITION CONCURRENCE

Handwritten signature *for EB Posrv* *4/27/84*

PROJECT FIELD ENGINEER DATE
LEAD DESIGN ORG *AVP* *5-2-84*

Handwritten signature *5/2/84*

LEAD DESIGN ORG DATE
PROJECT FIELD ENGINEER *AVP* *5-2-84*

MPOAD CONCURRENCE DATE

CP Co SMO (for turned over systems) DATE

PFQCE (ASME) DATE

PQAE (ASME) DATE

A.N.I. (ASME) DATE

35 DISPOSITION ACTION TAKEN

RECEIVED
MAR 13 1984
Midland Project
A

36 METHOD OF DISPOSITION ACTION VERIFICATION

RESULT OF DISPOSITION ACTION VERIFICATION

ACCEPTABLE UNACCEPTABLE

IF UNACCEPTABLE, REFERENCE SUPERCEDING NCR NUMBER _____

37 NCR CLOSED BY

MPOAD DATE

A.N.I. (ASME) DATE

MIDLAND PROJECT
QUALITY ASSURANCE
DEPARTMENT

NONCONFORMANCE REPORT
CONTINUATION SHEET

NCR NO. C-61006

DATE ISSUED
3/2/84

REV
1

PAGE 2 OF 3639
pv

Page 1 continued;

Blk. 12 Requirement: Vendor, project approved welding procedure WP-1: Welding shall be performed in accordance with AWS D1.1 and in accordance with approved shop dwgs.

See attached copy of WP.1

ORIGINAL

**NONCONFORMANCE REPORT
CONTINUATION SHEET**

NCR NO. C-01006

DATE ISSUED
1-20-84

REV 01/05
3/21/84

PAGE 3 OF 26 38
122

DOOR AND FRAME LOCATION

FRAME	EL	AREA	ROOM	DOOR	WAREHOUSE 3
5					X
6					X
7					X
8					X
210	575	340A	40	SAME	
205	"	540A	1	SAME	
14	584	120K	126	WHSE 3	
15	"	103A	130	" "	
18	"	102A	131	" "	
23	"	120D	118	" "	
24	"	120C	117	" "	
25	"	120A	111	" "	
26	"	120B	113	" "	
29	"	102A	116	" "	
31	"	120F	121	" "	
32	"	120G	122	" "	
33	"	120H	124	" "	
34	"	120J	125	" "	
35	599	130H	216	" "	
40	"	130J	217	" "	
43	"	130F	214	" "	
44	"	130G	215	" "	
45	"	130D	212	" "	
46	"	130E	213	" "	
53	614	103B	328	" "	
65	"	102B	329	" "	
77	"	210B	358	" "	
84	"	210E	361	" "	
88	"	210C	359	" "	
108	634	150C	420	" "	
109	"	150R	421	" "	

WELDING PROCEDURE NO. WP-10.

TO BE USED WITH JOINT DETAILS SHOWN ON WELD PROCEDURES WP-11, 12, 13 & 14

GENERAL

Welding shall be performed in accordance with AWS D1.1 and in accordance with approved shop drawing. Welding shall be performed by qualified welders only inside the shop. All joints are to be AWS prequalified. Process— The welding process shall be shielded metal arc., base material A36.

POSITION

The welding shall be done in the 1G, 1F & 2F position

PREHEAT

No preheating shall be used.

HEAT TREATMENT

No post weld heat treatment required.

BACKING STRIP

The welded joints shall not utilize a backing strip. Gouge root to sound metal before welding second side.

PREPARATION

Surfaces and edges to be welded shall be wire brushed and ground clean and smooth and shall be free of all loose mill scale.

ASSEMBLY

All parts to be joined shall be brought in to as close contact as possible. Gaps shall not exceed 1/8" and the joints shall be properly aligned and held in position by clamps, wedges or other suitable devices utilizing jigs and fixtures wherever possible. Assemblies shall be tack welded with single pass welds which are to be remelted and incorporated in to the continuous welds.

UNCONTROLLED
NOT TO BE USED
FOR CONSTRUCTION

The weld sequence shall skip around the entire welding periphery and both sides of the joining surfaces to minimize distortion and shrinkage. Upon completion of welding, welds shall cool to ambient temperatures. Weld surfaces shall be peened and brushed clean of all slag and other impurities. Assemblies shall be straightened as required by hydraulic press or manual means. Welded joints shall not be painted until all welding has been completed and the assembly approved and tested.

Manufacturer: JULIUS MOCK & SONS, INC.

Authorized By: *Edward F. Orde* Q.A. Mgr.

Date 6-15-79 Issue 1 Sheet 1 of 2

Date Issue

WELDING PROCEDURE NO. WP-1 (Cont'd.)

CLEANING

All slag and flux and any defects that appear on a bead of welding shall be removed by chipping, or grinding before the next pass is started. Welds need not be removed unless cracked or defective, but they must be completely fused in the root bead.

INSPECTION

Visually inspect welds for quality of workmanship.

The following are defect criteria:

- a. Cracks - not allowed.
- b. Craters - not allowed.
- c. Undercuts - Shall not be more than 0.01" deep when its direction is transverse to primary tensile stress in part that is undercut, nor more than 1/32" for all other situations.
- d. Overlap/Concavities - not allowed.
- e. Convexity - MAX. 1/8"
- f. Porosity - The sum of diameters of piping porosity shall not exceed 3/8 in. in any line of weld and shall not exceed 3/4 in. length of weld.

Δ
2

UNCONTROLLED
NOT TO BE USED
FOR CONSTRUCTION

TECHNIQUE

For type and size of joint, see applicable drawings.

For welding technique see table below.

MATERIAL	TYPE OF WELD	ELECTRODE		WELD'G CURRENT	
		TYPE	SIZE	AMPS	VOLTS
Mild Steel ASTM.A.36	Fillet & Groove	E 7018	5/32"	180	

UNCONTROLLED
NOT TO BE USED
FOR CONSTRUCTION

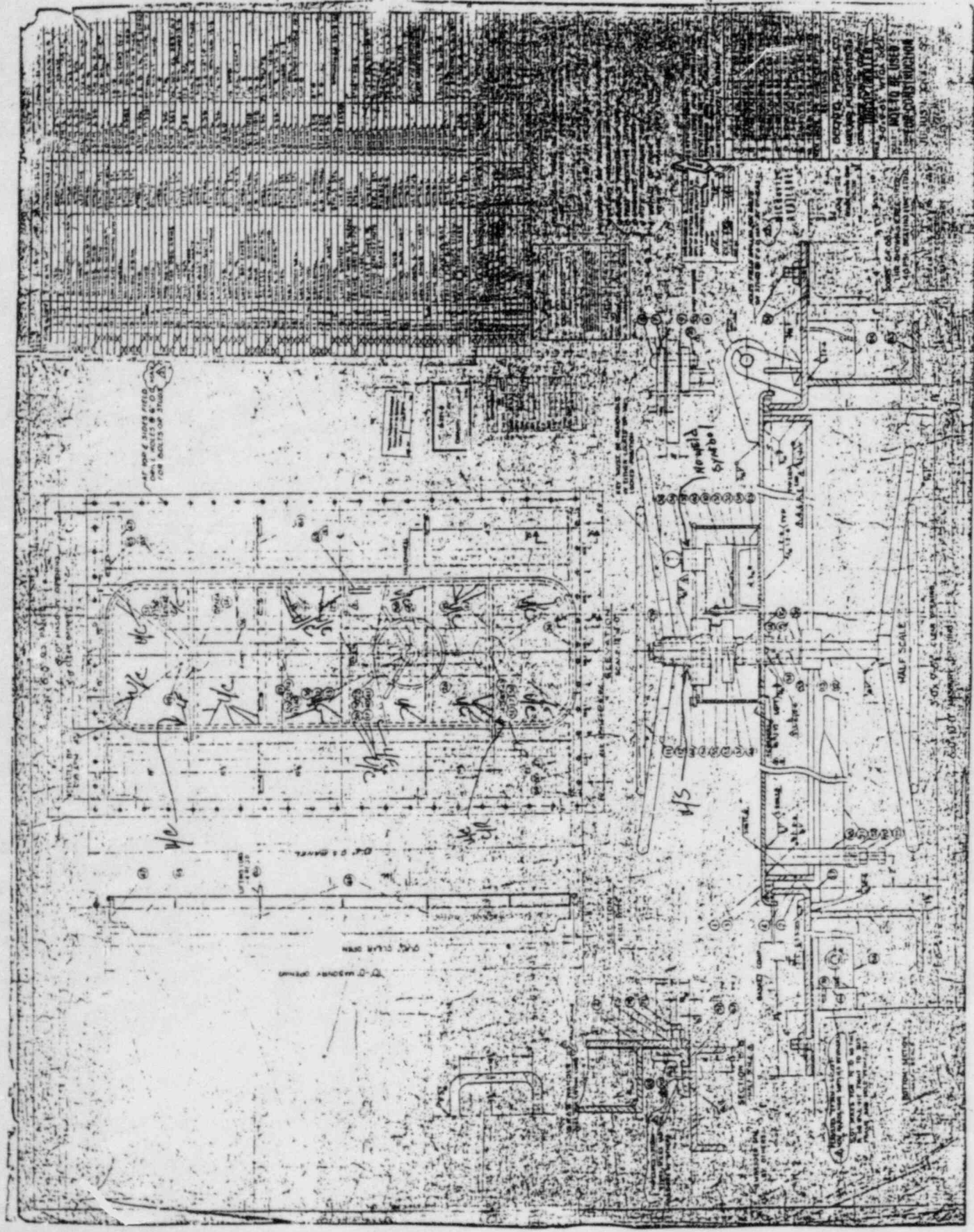
Weld Current - DC
Polarity - Reverse

Manufacturer: JULIUS MOCK & SONS, INC.
 Authorized By: *Edward T. ...* Q.A. Mgr.
 Date 6/15/79 Issue 1 Sheet 2 of 2
 Date _____ Issue _____
 Date _____ Issue _____

UIC C-01006 Page 6 of 38
as RVI
3/21/54

Door # 88 (C)

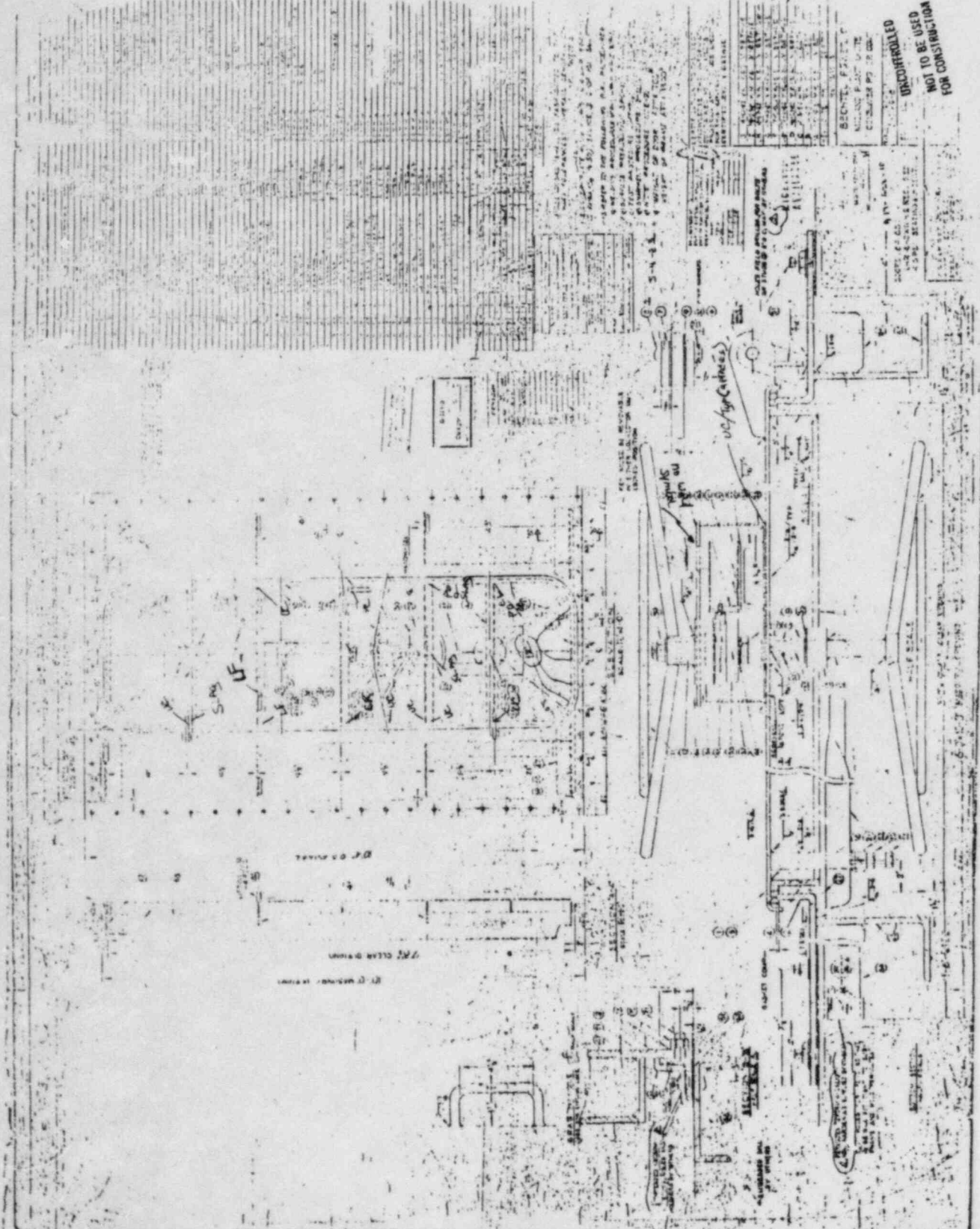
Pages 6 thru 38
are just
reference copies.
The big prints
are in QC Vault.



4/12 = under cut
4/13 = under size
4/14 = cold roll 1/16"

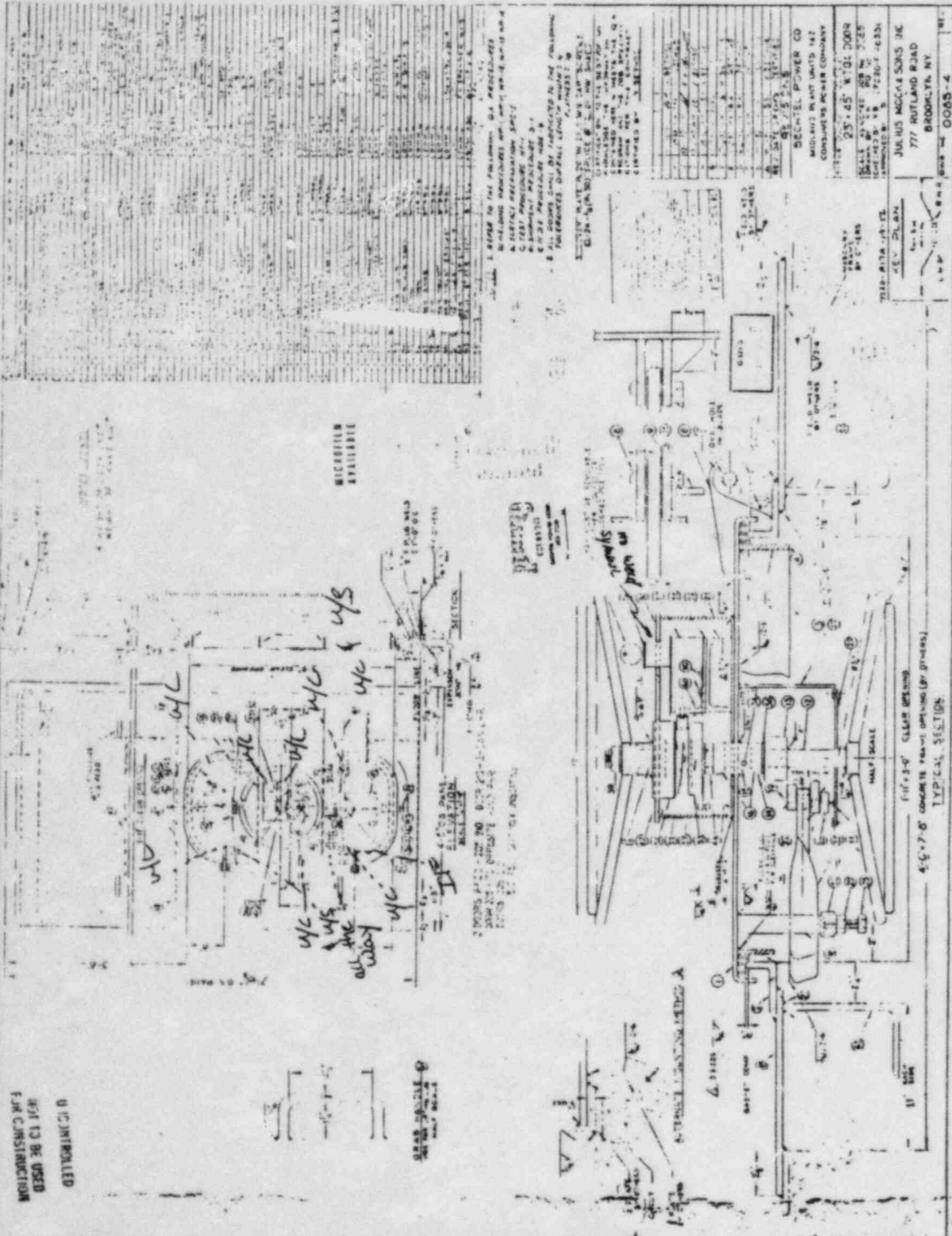
Plan # 84C

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FOR CONSTRUCTION



LF = Lack of fusion
 u/c = undercut
 P.O. = porosity
 c.l. = cold lap

Door # 210



UNCONTROLLED
 NOT TO BE USED
 FOR CONSTRUCTION

NCR C-01006 PAGE B OF 38
 Rev 1
 05 3/2/84
 JAN

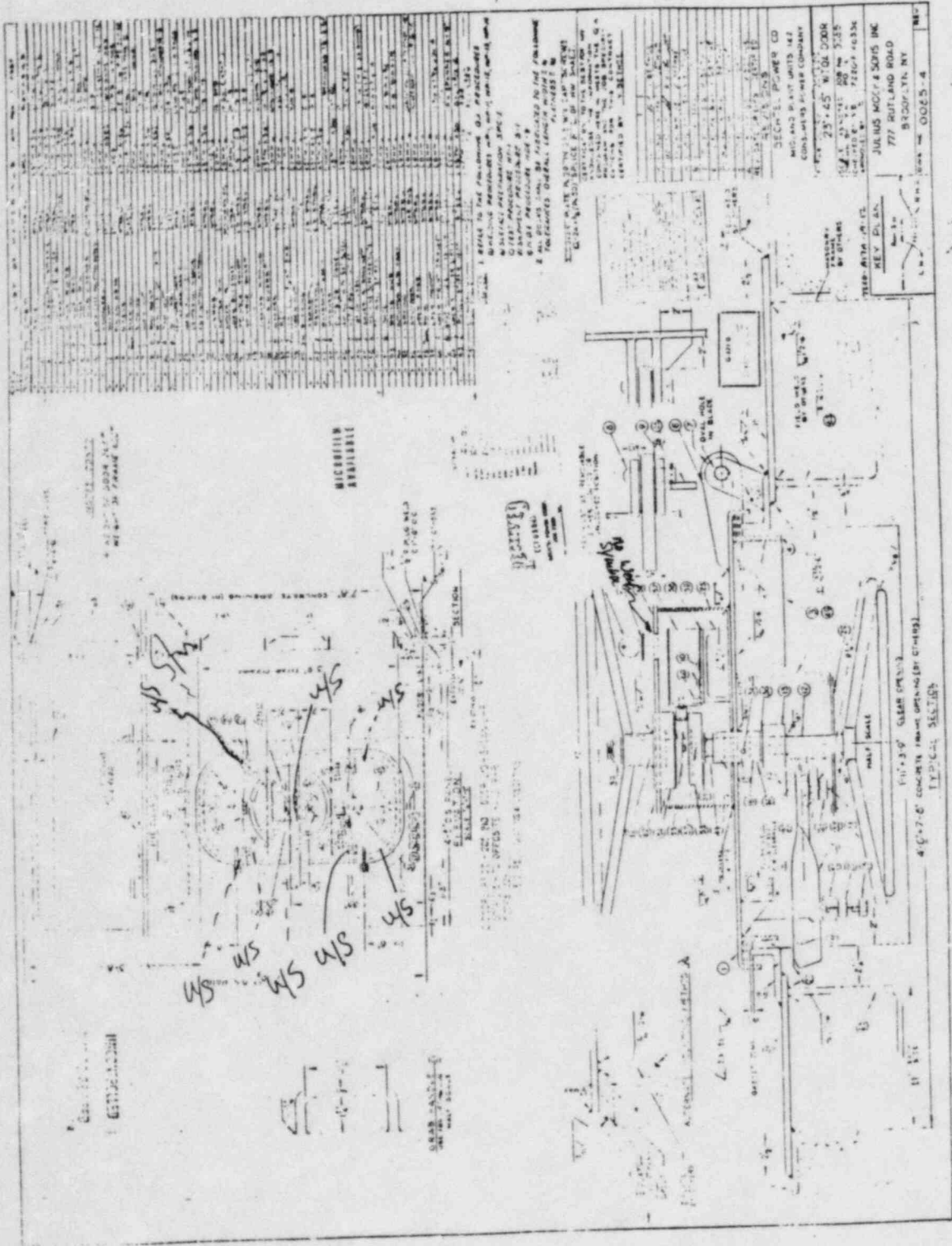
u/c = undercut
 u/s = under size
 IF = incomplete finish

SECOTEL POWER CO
 MIDLAND PLANT UNITS 142
 CONSUMERS POWER COMPANY
 25-45 W 70th STREET
 BROOKLYN 10
 JULIUS NICKEL & SONS INC
 777 RUTLAND ROAD
 BROOKLYN, NY
 SPEC NO. 0005-4

1. REFER TO THE FOLLOWING FOR SPECIFICATIONS:
 A. PARTS SPECIFICATION SHEET
 B. PARTS DRAWING
 C. PARTS LIST
 D. PARTS IDENTIFICATION SHEET
 E. ALL DIMENSIONS SHALL BE INDICATED IN THE FOLLOWING UNLESS OTHERWISE SPECIFIED:
 F. DIMENSIONS SHALL BE IN INCHES UNLESS OTHERWISE SPECIFIED
 G. DIMENSIONS SHALL BE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED
 H. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 I. DIMENSIONS SHALL BE IN FEET UNLESS OTHERWISE SPECIFIED
 J. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 K. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 L. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 M. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 N. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 O. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 P. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 Q. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 R. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 S. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 T. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 U. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 V. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 W. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 X. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 Y. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED
 Z. DIMENSIONS SHALL BE IN METERS UNLESS OTHERWISE SPECIFIED

Roll
05 3/2/84

Jan



SOT # Door

S
W
4/5
4/5

4/5 = undersize
4/2 = undercut

NO.	DESCRIPTION	QTY	UNIT	PRICE	TOTAL
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SECTION 28-0100-01
 JULIUS ROY & SONS INC
 777 RUTLAND ROAD
 BRIDGEVILLE, PA 15005

SECTION 28-0100-02
 JULIUS ROY & SONS INC
 777 RUTLAND ROAD
 BRIDGEVILLE, PA 15005

SECTION 28-0100-03
 JULIUS ROY & SONS INC
 777 RUTLAND ROAD
 BRIDGEVILLE, PA 15005

SECTION 28-0100-04
 JULIUS ROY & SONS INC
 777 RUTLAND ROAD
 BRIDGEVILLE, PA 15005

SECTION 28-0100-05
 JULIUS ROY & SONS INC
 777 RUTLAND ROAD
 BRIDGEVILLE, PA 15005

SECTION 28-0100-06
 JULIUS ROY & SONS INC
 777 RUTLAND ROAD
 BRIDGEVILLE, PA 15005

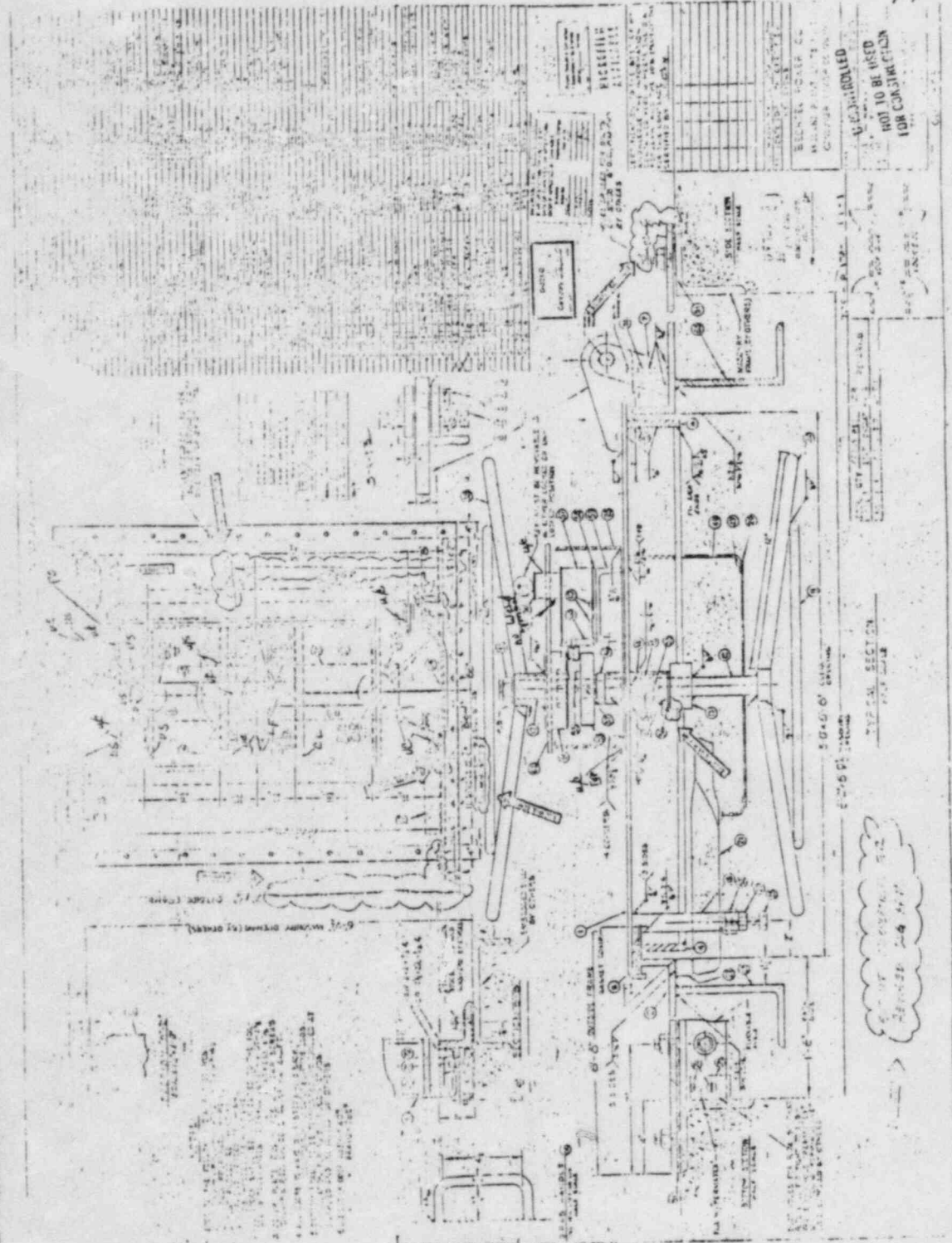
SECTION 28-0100-07
 JULIUS ROY & SONS INC
 777 RUTLAND ROAD
 BRIDGEVILLE, PA 15005

SECTION 28-0100-08
 JULIUS ROY & SONS INC
 777 RUTLAND ROAD
 BRIDGEVILLE, PA 15005

SECTION 28-0100-09
 JULIUS ROY & SONS INC
 777 RUTLAND ROAD
 BRIDGEVILLE, PA 15005

SECTION 28-0100-10
 JULIUS ROY & SONS INC
 777 RUTLAND ROAD
 BRIDGEVILLE, PA 15005

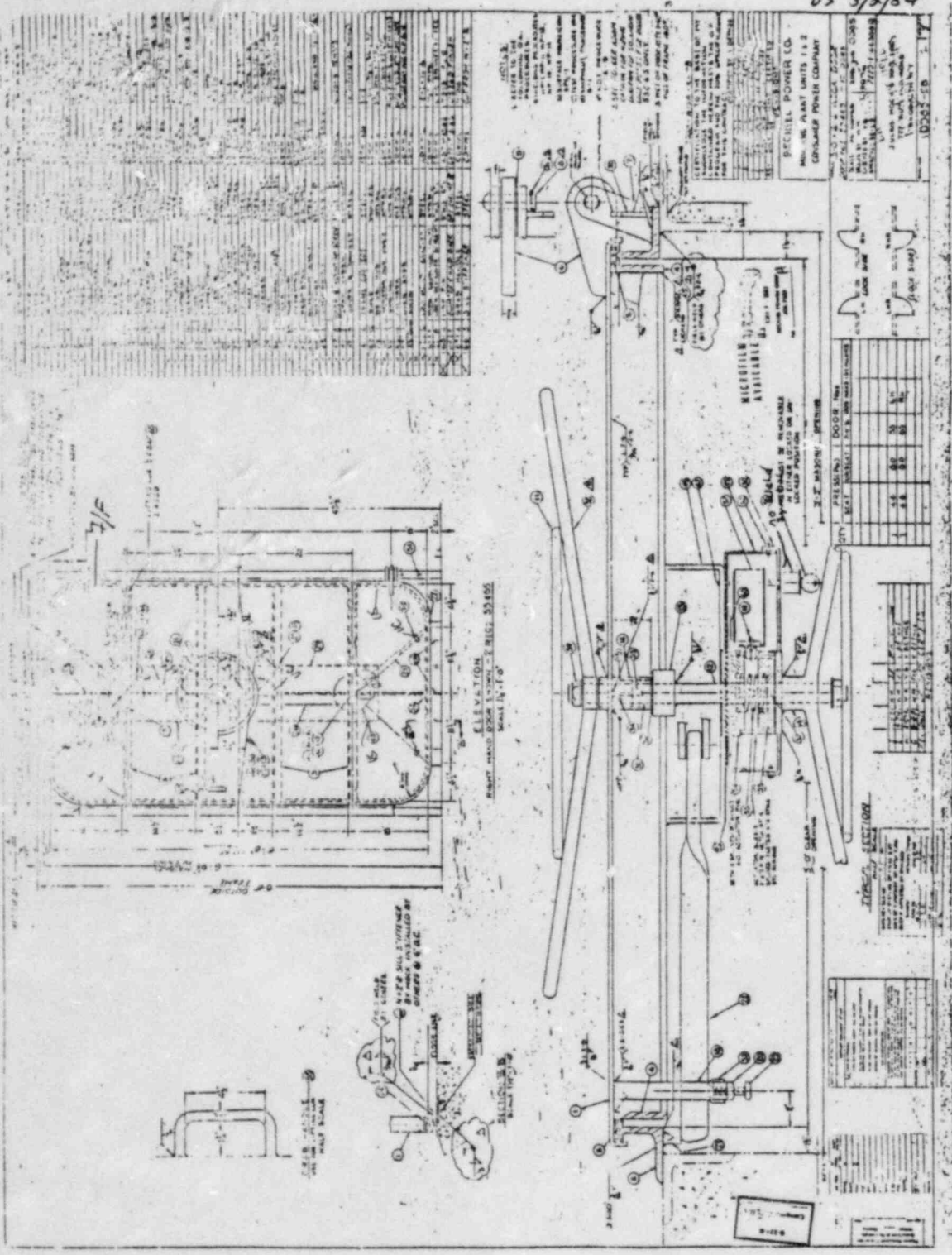
Draw # 14 (C)



REGISTERED
 NOT TO BE USED
 FOR CONSTRUCTION

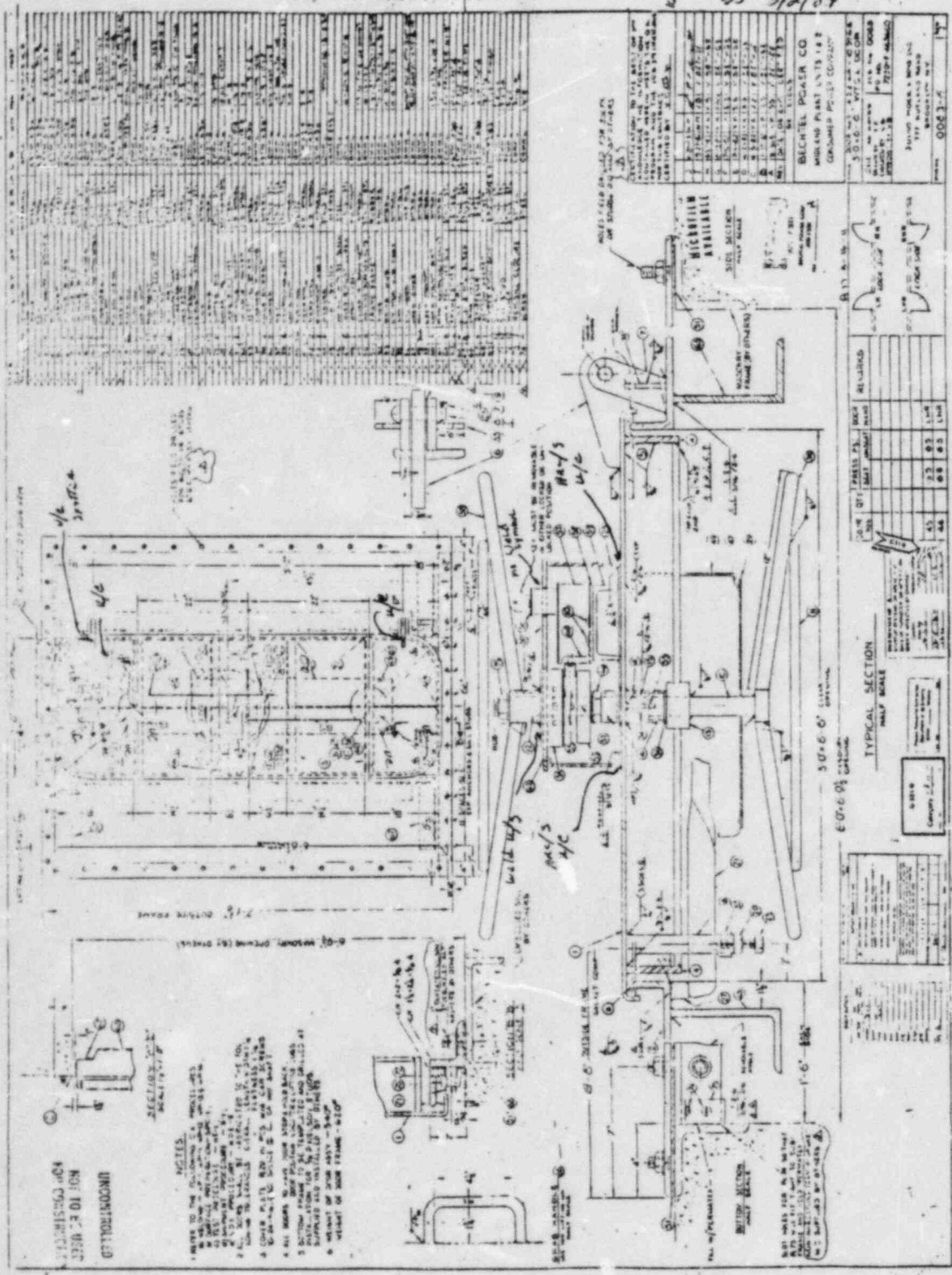
u/l = undercut
 L/P = Lack of finish
 P/O = Porosity

Rev # 65(c)



L.F. = Lack of Fusion
 U/S = under size
 U/C = undercut
 I/F = incomplete fusion
 C/L = cold lap/roll

Door #43 ©



UNCONTROLLED
 NOT TO BE USED
 FOR CONSTRUCTION

- NOTES:
1. REFER TO THE FOLLOWING C.A. REVISIONS:
 2. ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.
 3. ALL DIMENSIONS ARE TO FACE UNLESS OTHERWISE SPECIFIED.
 4. ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED.
 5. ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED.
 6. ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED.
 7. ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED.
 8. ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED.
 9. ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED.
 10. ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED.

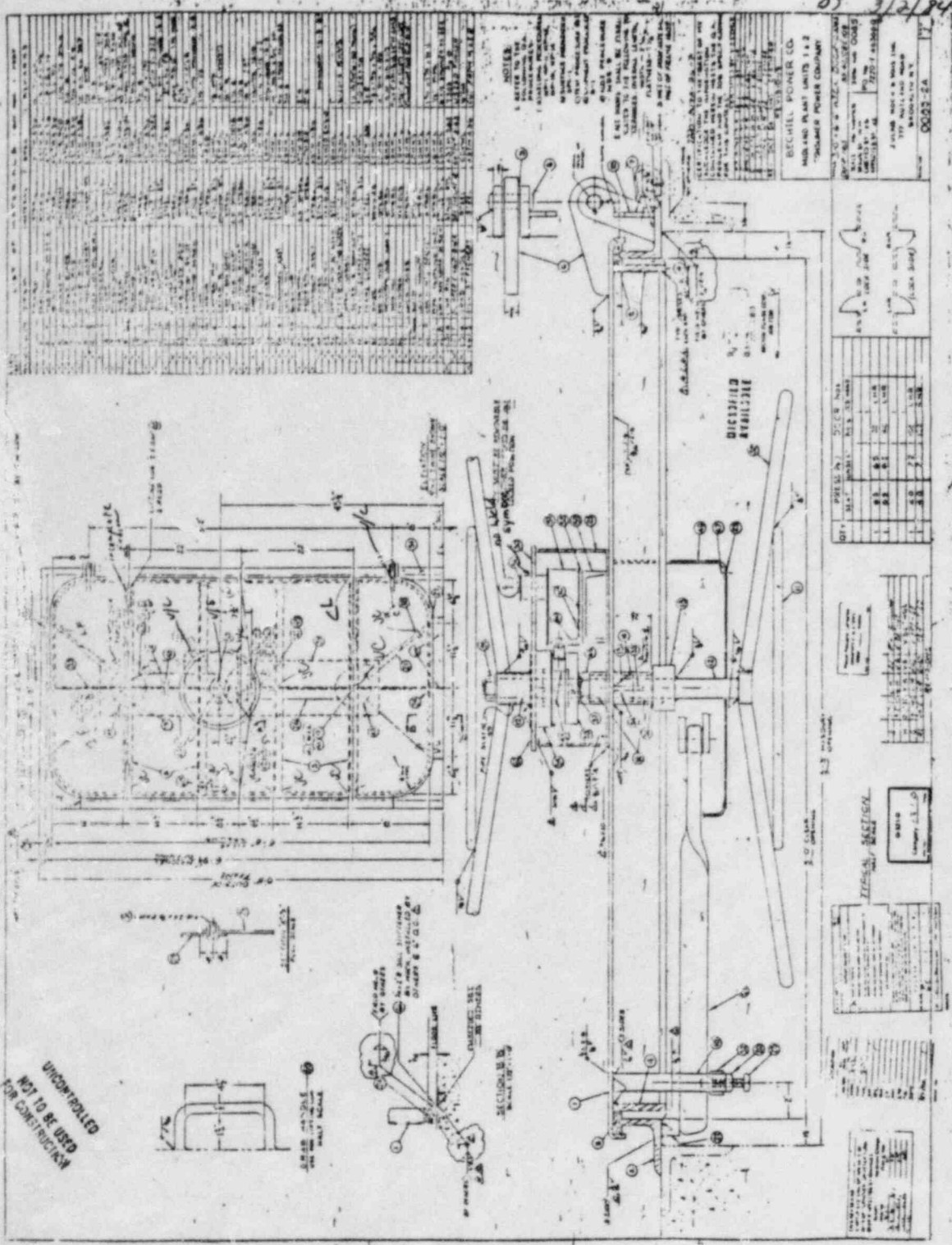
ITEM NO.	DESCRIPTION	QTY	UNIT	PRICE	TOTAL
1	DOOR #43	1	EA	100.00	100.00
2	DOOR #43	1	EA	100.00	100.00
3	DOOR #43	1	EA	100.00	100.00
4	DOOR #43	1	EA	100.00	100.00
5	DOOR #43	1	EA	100.00	100.00
6	DOOR #43	1	EA	100.00	100.00
7	DOOR #43	1	EA	100.00	100.00
8	DOOR #43	1	EA	100.00	100.00
9	DOOR #43	1	EA	100.00	100.00
10	DOOR #43	1	EA	100.00	100.00

ITEM NO.	DESCRIPTION	QTY	UNIT	PRICE	TOTAL
1	DOOR #43	1	EA	100.00	100.00
2	DOOR #43	1	EA	100.00	100.00
3	DOOR #43	1	EA	100.00	100.00
4	DOOR #43	1	EA	100.00	100.00
5	DOOR #43	1	EA	100.00	100.00
6	DOOR #43	1	EA	100.00	100.00
7	DOOR #43	1	EA	100.00	100.00
8	DOOR #43	1	EA	100.00	100.00
9	DOOR #43	1	EA	100.00	100.00
10	DOOR #43	1	EA	100.00	100.00

4/c = undercut
 4/s = under-size
 4/f = are smokes
 4/g = lack of finish

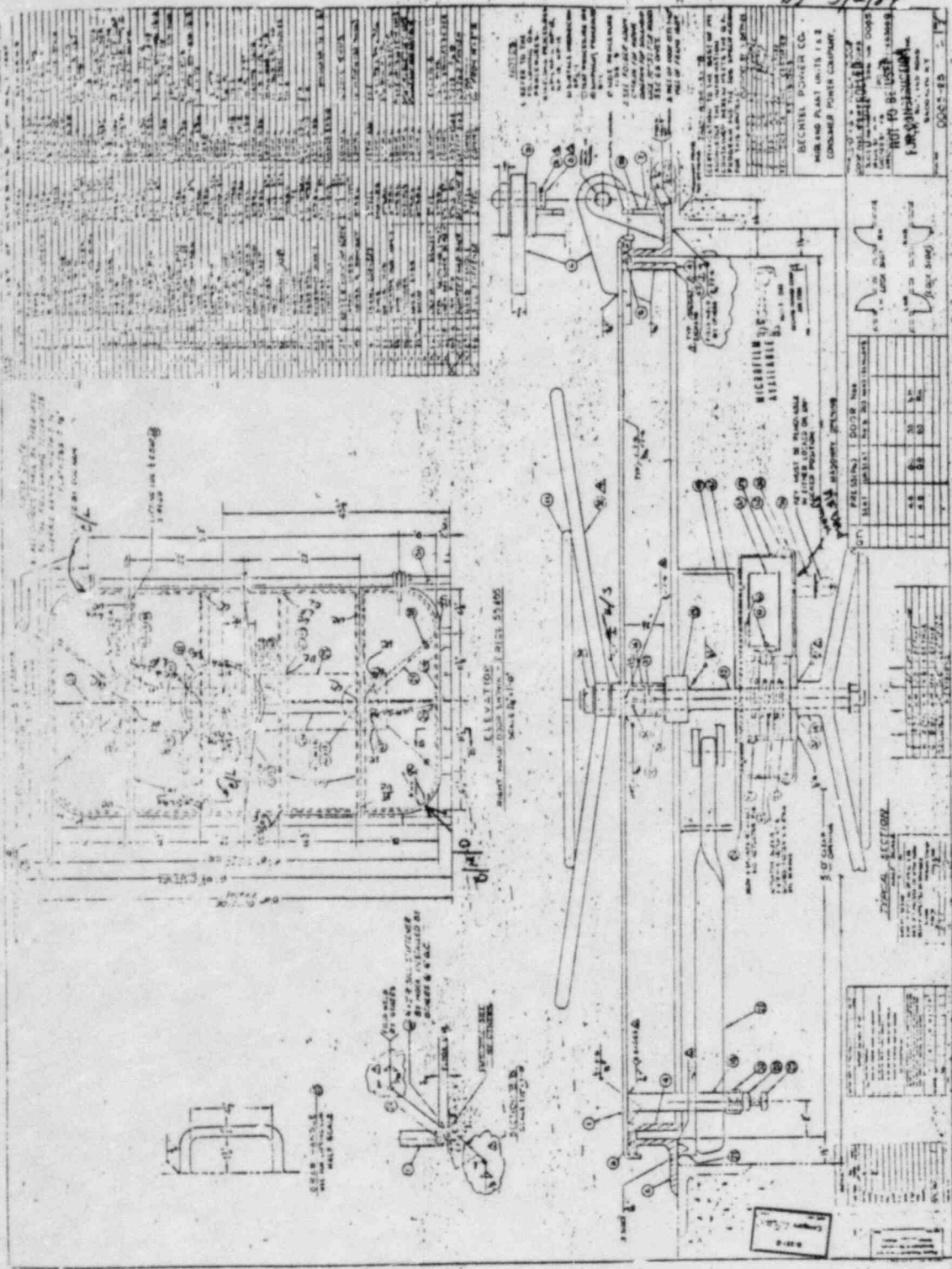
3-5-15

Draw # 109 (C)



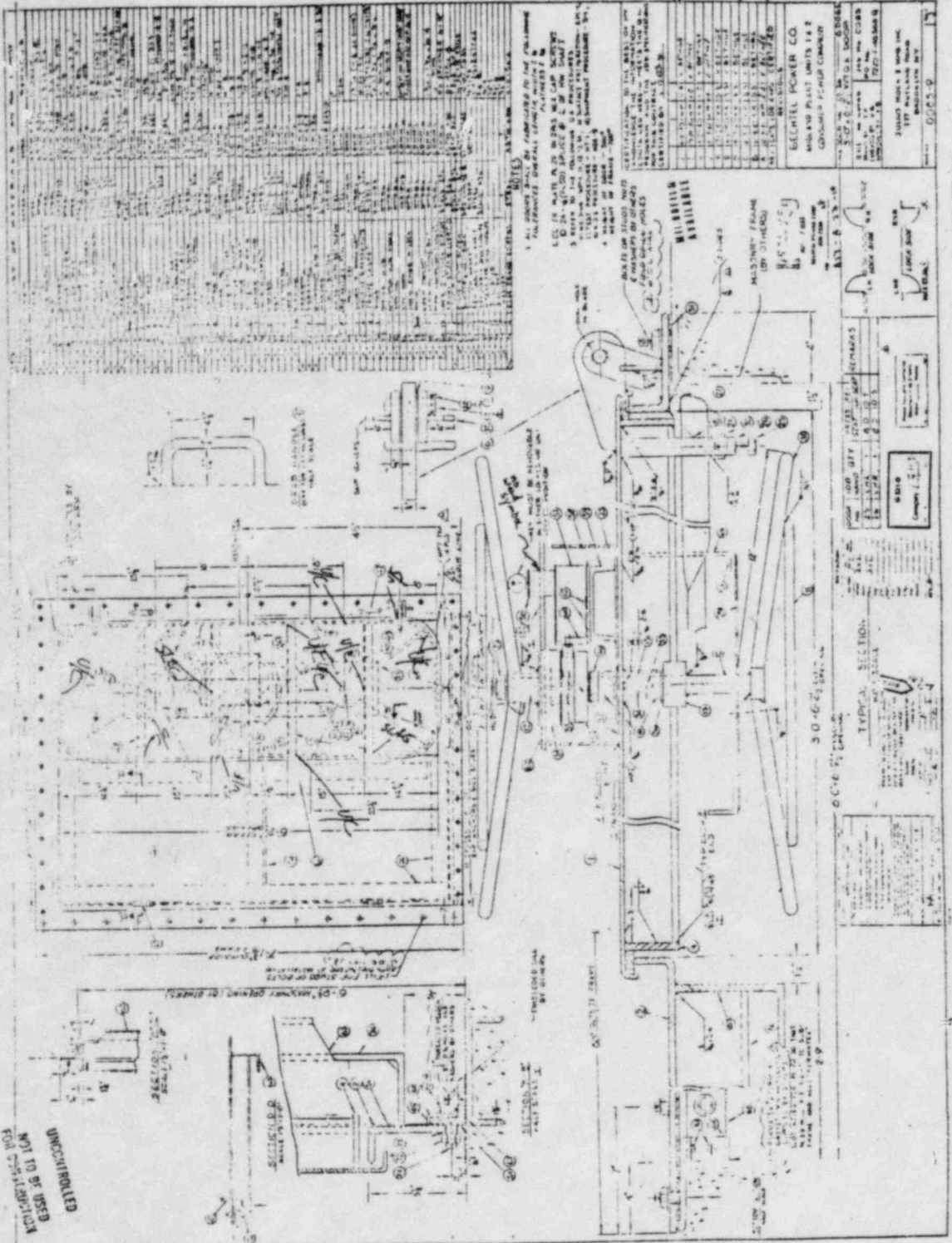
F.F. = incomplete Finish
 C.L. = Cold Lap
 SLAG = slag
 4/8 = undercut
 4/5 = under size

Draw # 53 (C)



C.L. = Cold Lap
 P.O. = Porosity
 L.F. = Lack of Fusion
 4/2 = Undercut
 4/5 = Under Size
 4/7 = Under Fill

①
 Plan # 25



UNCONTROLLED
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 FOR CONSTRUCTION

4/F = under full
 4/C = under cut
 4/S = under size

5-9-83

NOTES

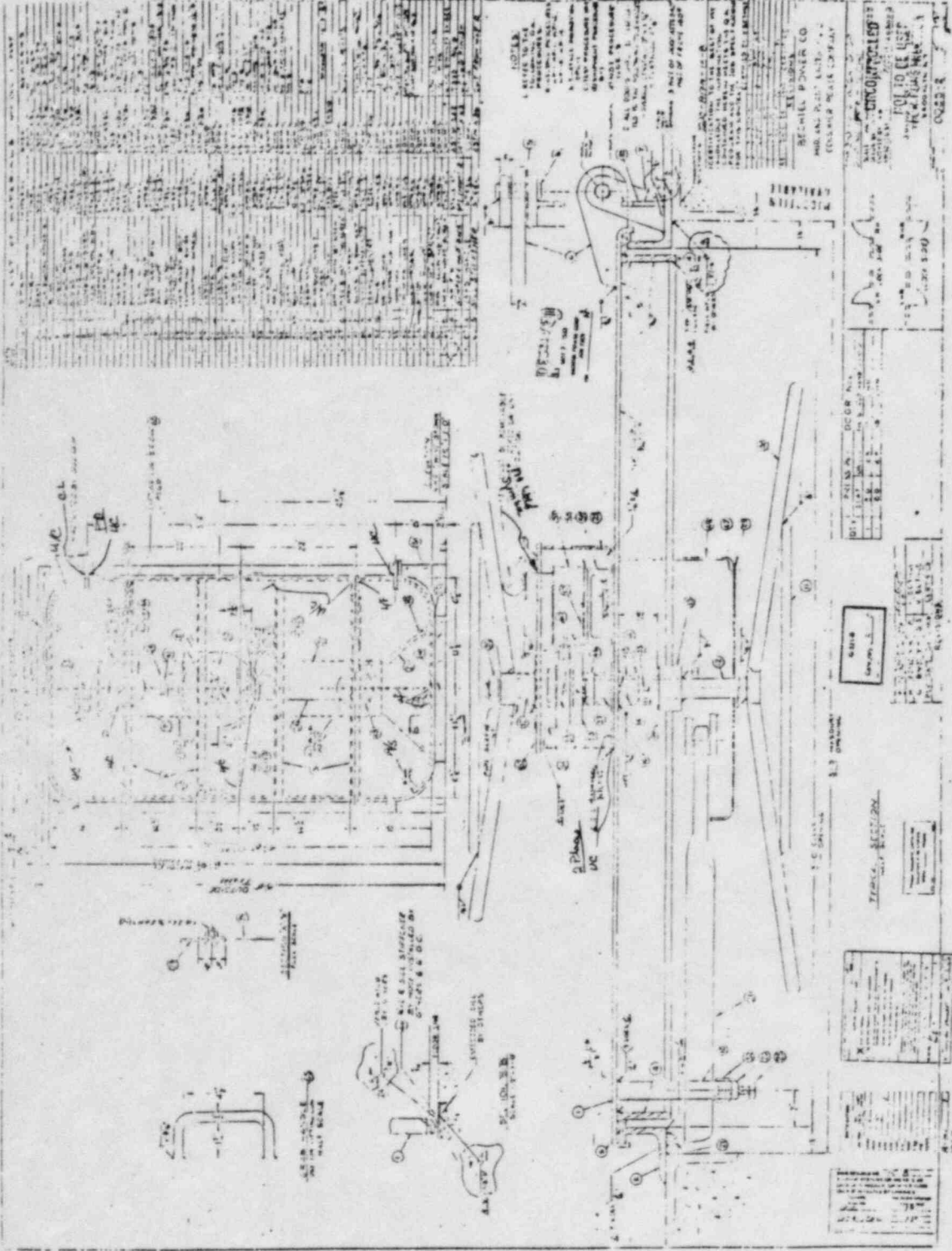
1. ALL ROOMS SHALL BE FINISHED TO THE FOLLOWING STANDARDS:
 - 1.1 FLOORING: POLISHED CONCRETE
 - 1.2 WALLS: PLASTER AND PAINT
 - 1.3 CEILING: PLASTER AND PAINT
 - 1.4 LIGHTING: AS SHOWN ON DRAWINGS
 - 1.5 MECHANICAL: AS SHOWN ON DRAWINGS
 - 1.6 ELECTRICAL: AS SHOWN ON DRAWINGS
 - 1.7 FINISHES: AS SHOWN ON DRAWINGS
2. ALL ROOMS SHALL BE FINISHED TO THE FOLLOWING STANDARDS:
 - 2.1 FLOORING: POLISHED CONCRETE
 - 2.2 WALLS: PLASTER AND PAINT
 - 2.3 CEILING: PLASTER AND PAINT
 - 2.4 LIGHTING: AS SHOWN ON DRAWINGS
 - 2.5 MECHANICAL: AS SHOWN ON DRAWINGS
 - 2.6 ELECTRICAL: AS SHOWN ON DRAWINGS
 - 2.7 FINISHES: AS SHOWN ON DRAWINGS

SECRETTEL POWER CO.
 1000 WEST 142ND STREET
 CHICAGO, ILLINOIS 60643

REV 05/31/84

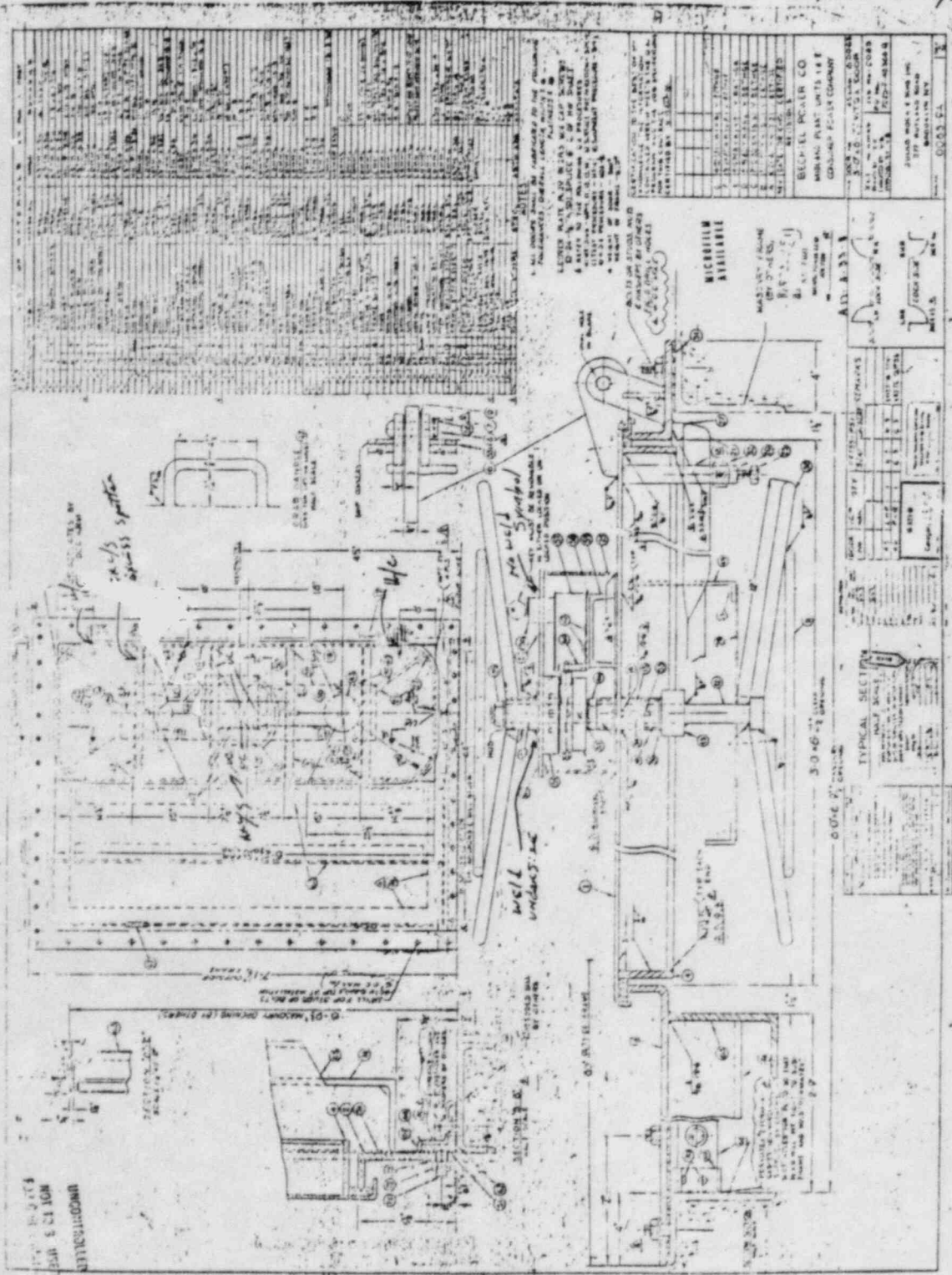
JAM

Draw # 15 (C)



WC = undercut
 L/F = Lack of Fusion
 C.L. = Cold Lap
 A/S = arc strikes
 U/S = under size

Q 402 # 45 ©



NOTES

1. ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.
2. DIMENSIONS IN PARENTHESES ARE FOR INFORMATION ONLY.
3. DIMENSIONS IN SQUARE BRACKETS ARE FOR INFORMATION ONLY.
4. DIMENSIONS IN BRACKETS ARE FOR INFORMATION ONLY.
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10. DIMENSIONS IN BRACKETS ARE FOR INFORMATION ONLY.

MATERIAL AVAILABLE

ALUMINUM 6061-T6
 304 STAINLESS STEEL
 4140 STEEL

REVISIONS

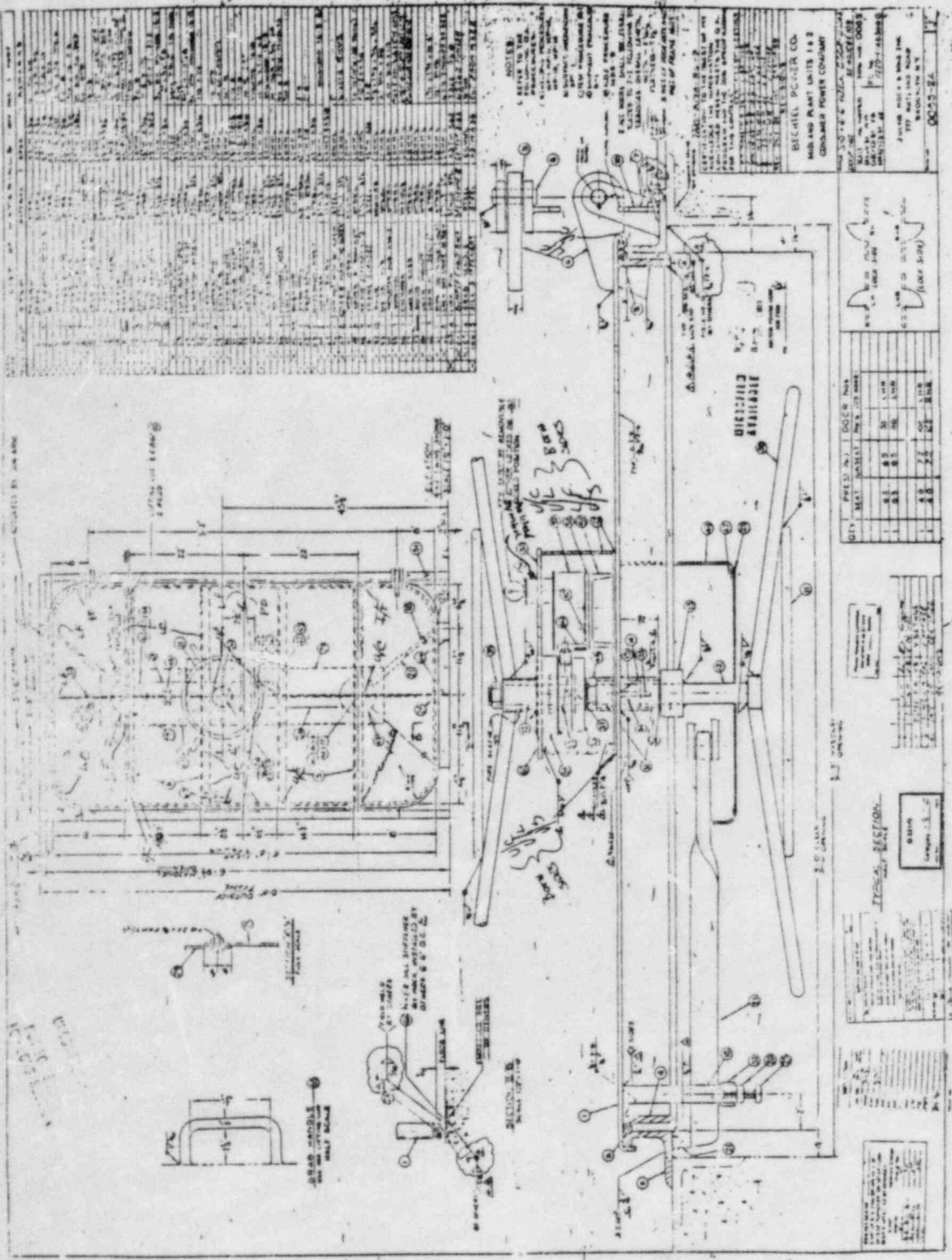
NO.	DATE	DESCRIPTION
1	10/1/83	ISSUED FOR FABRICATION
2	11/1/83	REVISED DIMENSIONS
3	12/1/83	REVISED DIMENSIONS
4	1/1/84	REVISED DIMENSIONS
5	2/1/84	REVISED DIMENSIONS

4/c = undercut
 arc = arc strikes
 w/s = welds
 P.O. = Porosity

5-5-83

MR C-01006 PAIR 22 OF 28 39
 Rev 1 AS 3/1/84 JAW

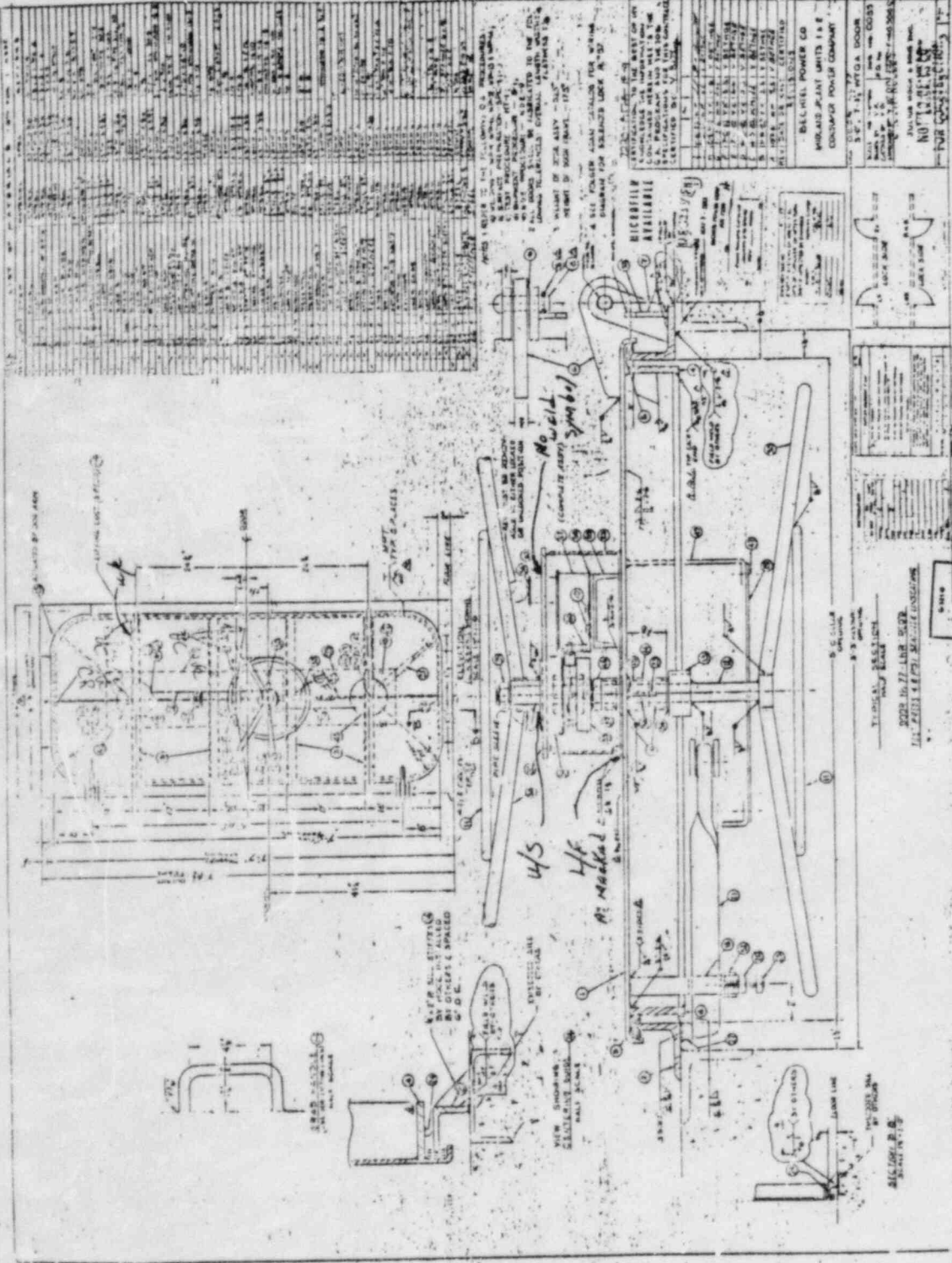
Rev # 108



4/c = undercut
 4/s = under size
 4/l = under length

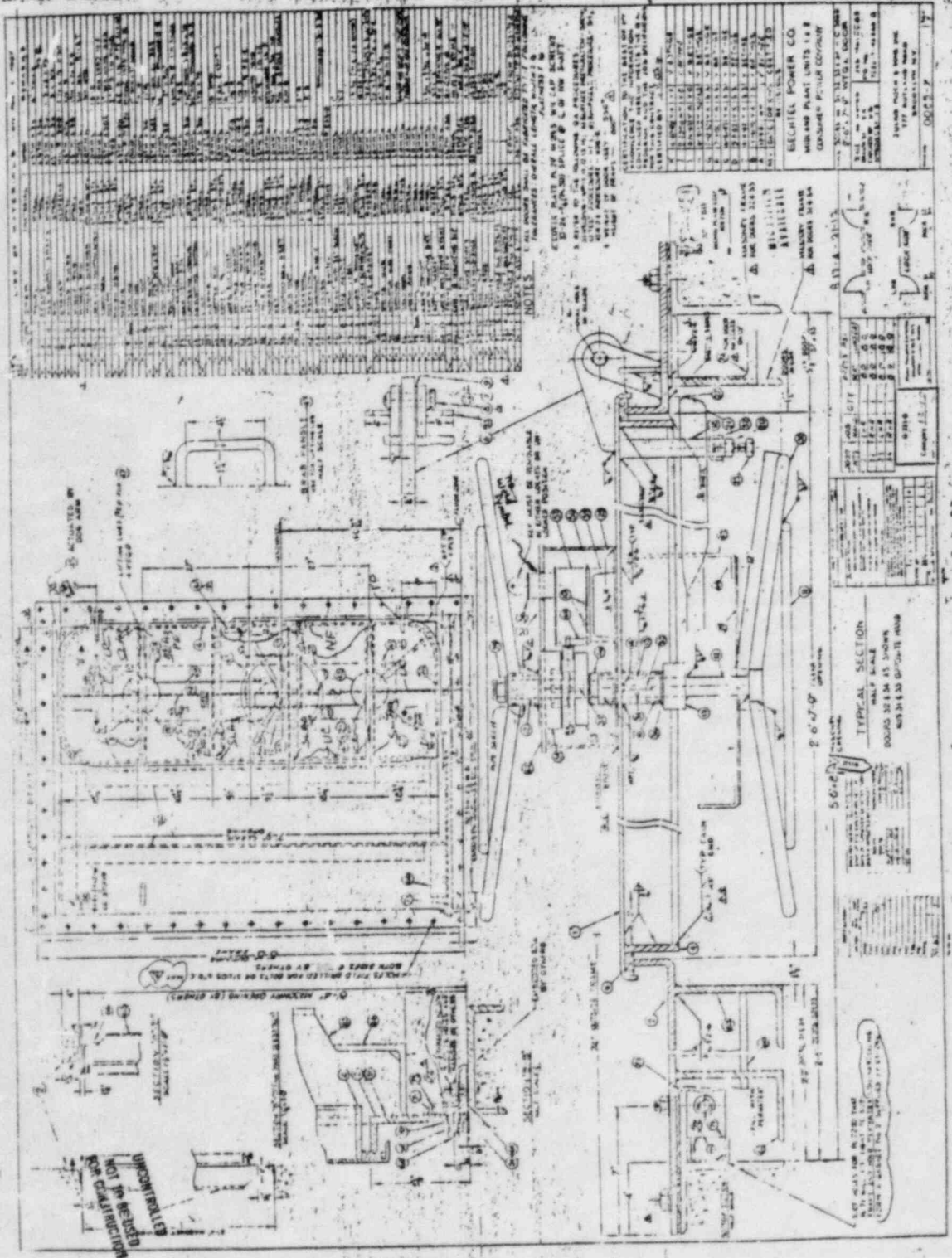
4/c UNDER CUT
 4/s UNDER SIZE
 4/l UNDER LENGTH

Door #77C

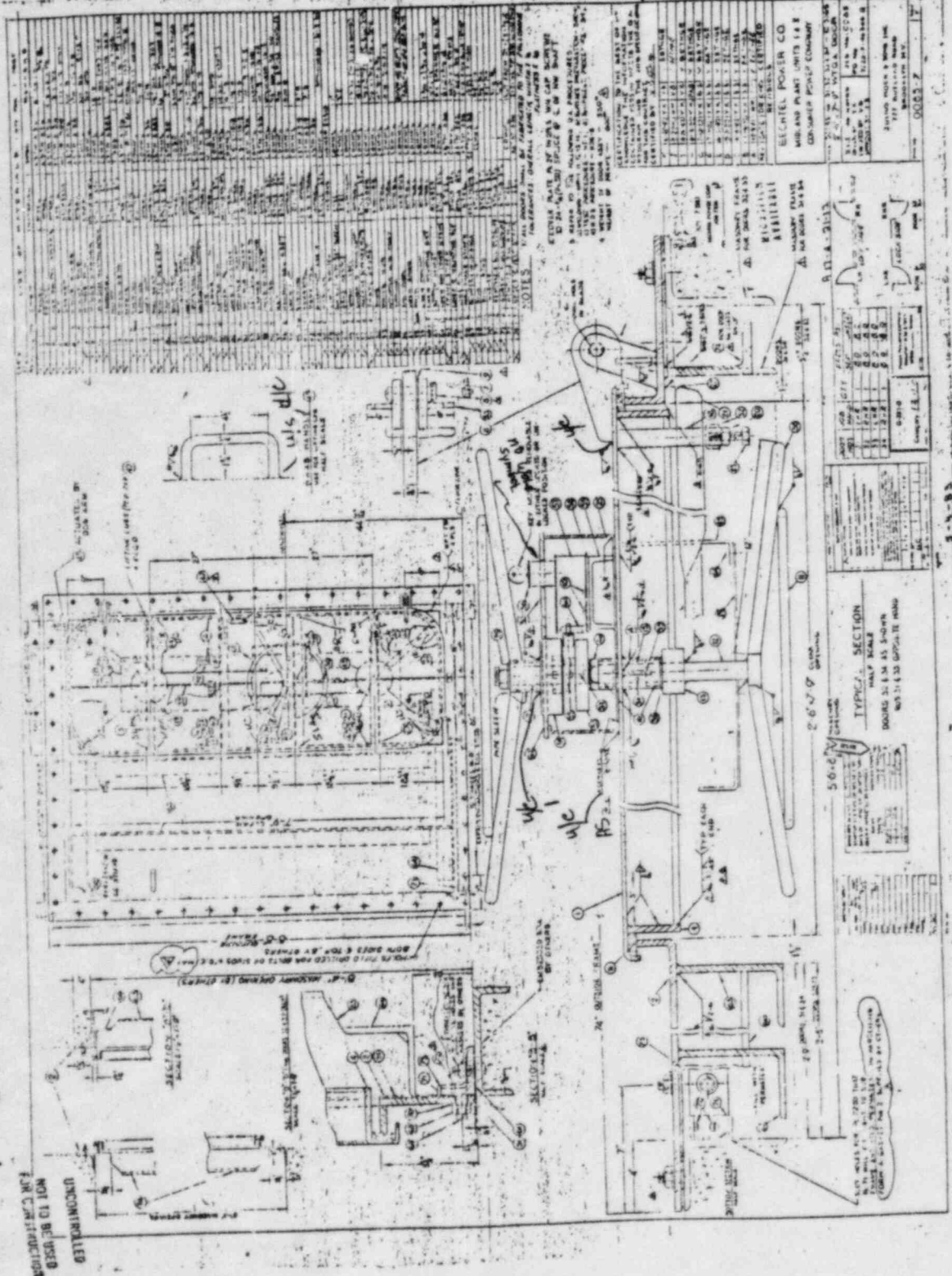


C.R. = cold roll
 L/F = lack of fusion
 C/C = undercut
 4/5 = under size

Door #31 ©

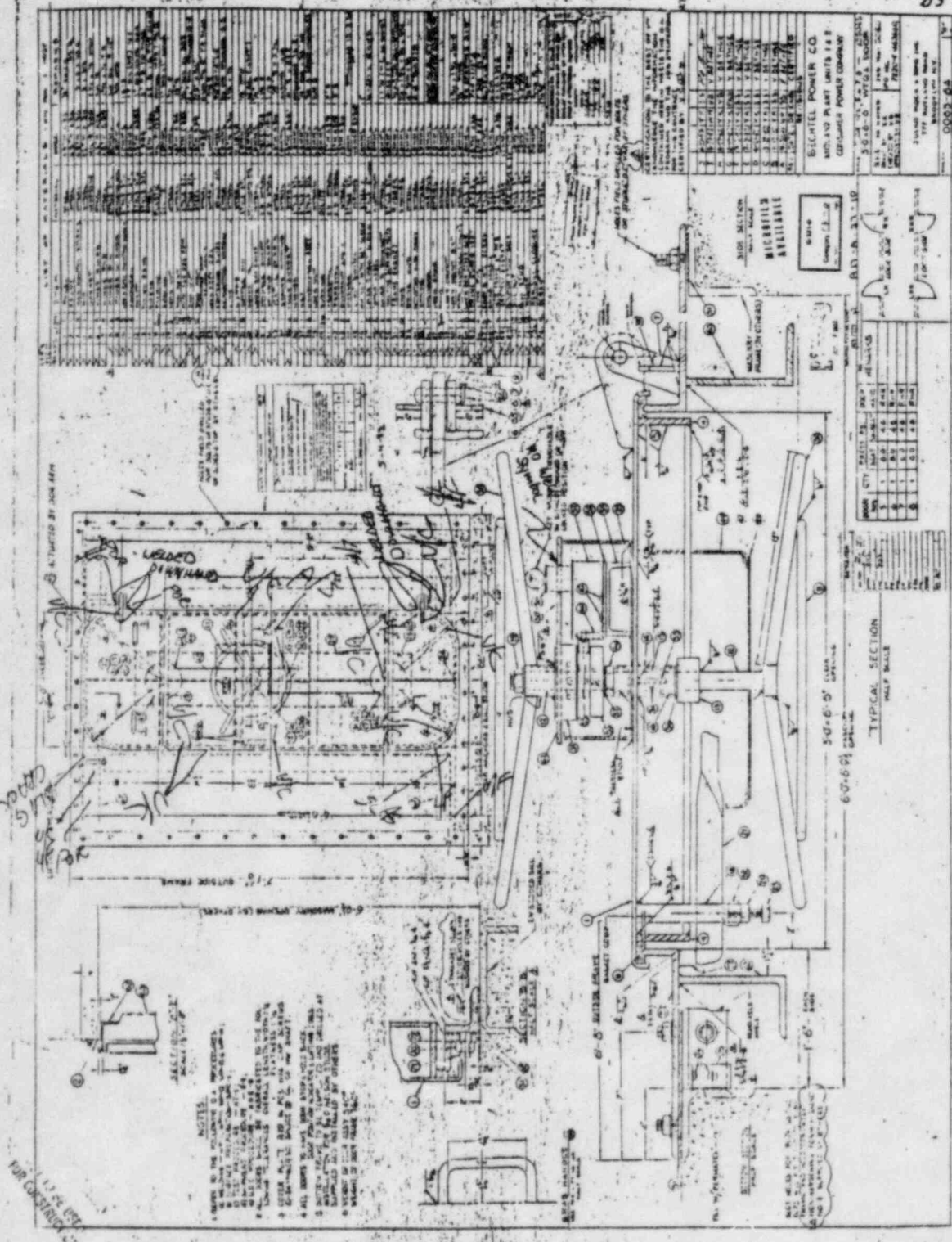


Door # 32 C



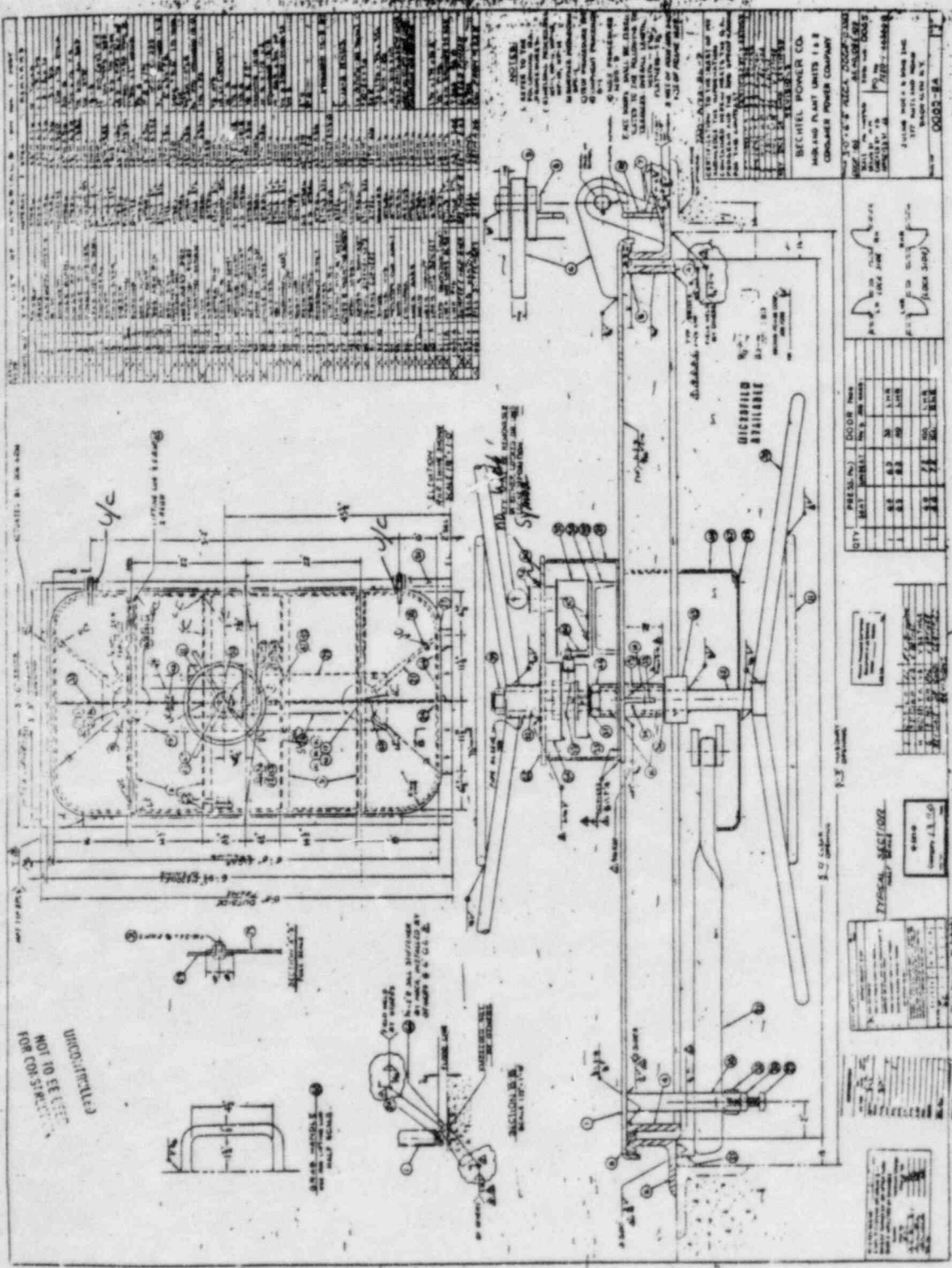
WPC - UNDERWAY
 A/S - ARE STARTED
 WS - UNDER SIZE

Door # 5



4/c = undercut
 u/s = under size
 c/l = cold lap
 por = porosity
 u/f = underfill

Door # 40 @

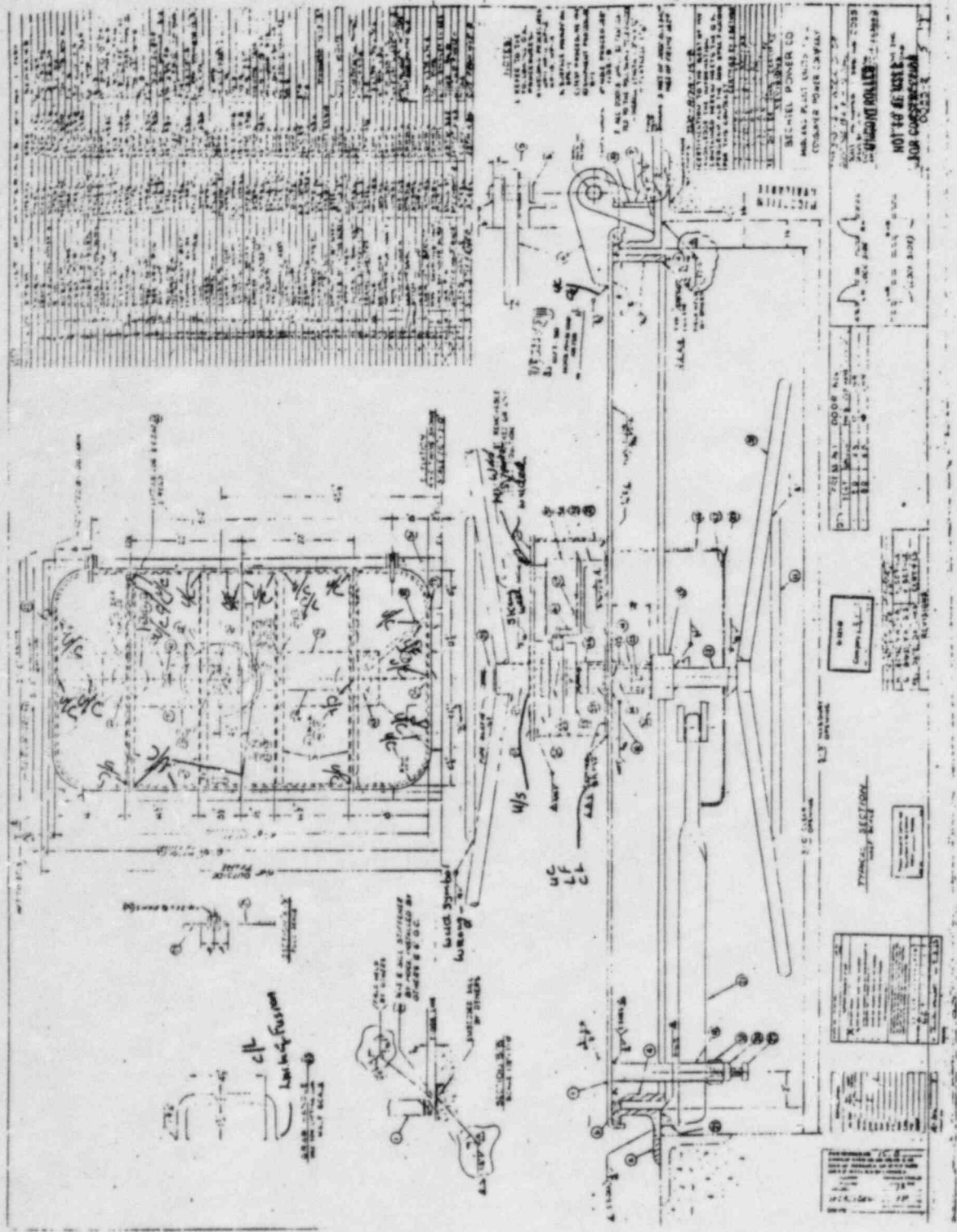


UNCOMPLETED
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 FOR CONSTRUCTION

4/c = undercut
 4/s = undercut
 L = list of fusion

Rev 1
3/2/84

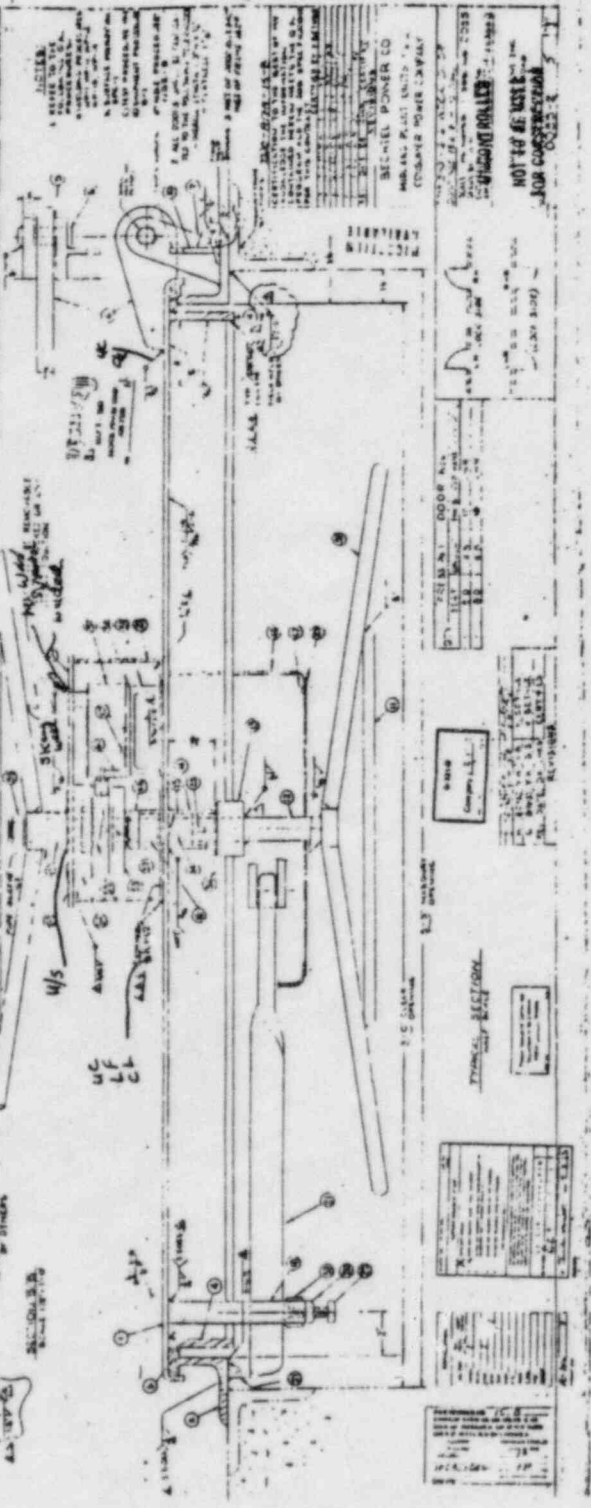
Door # 18 (C)



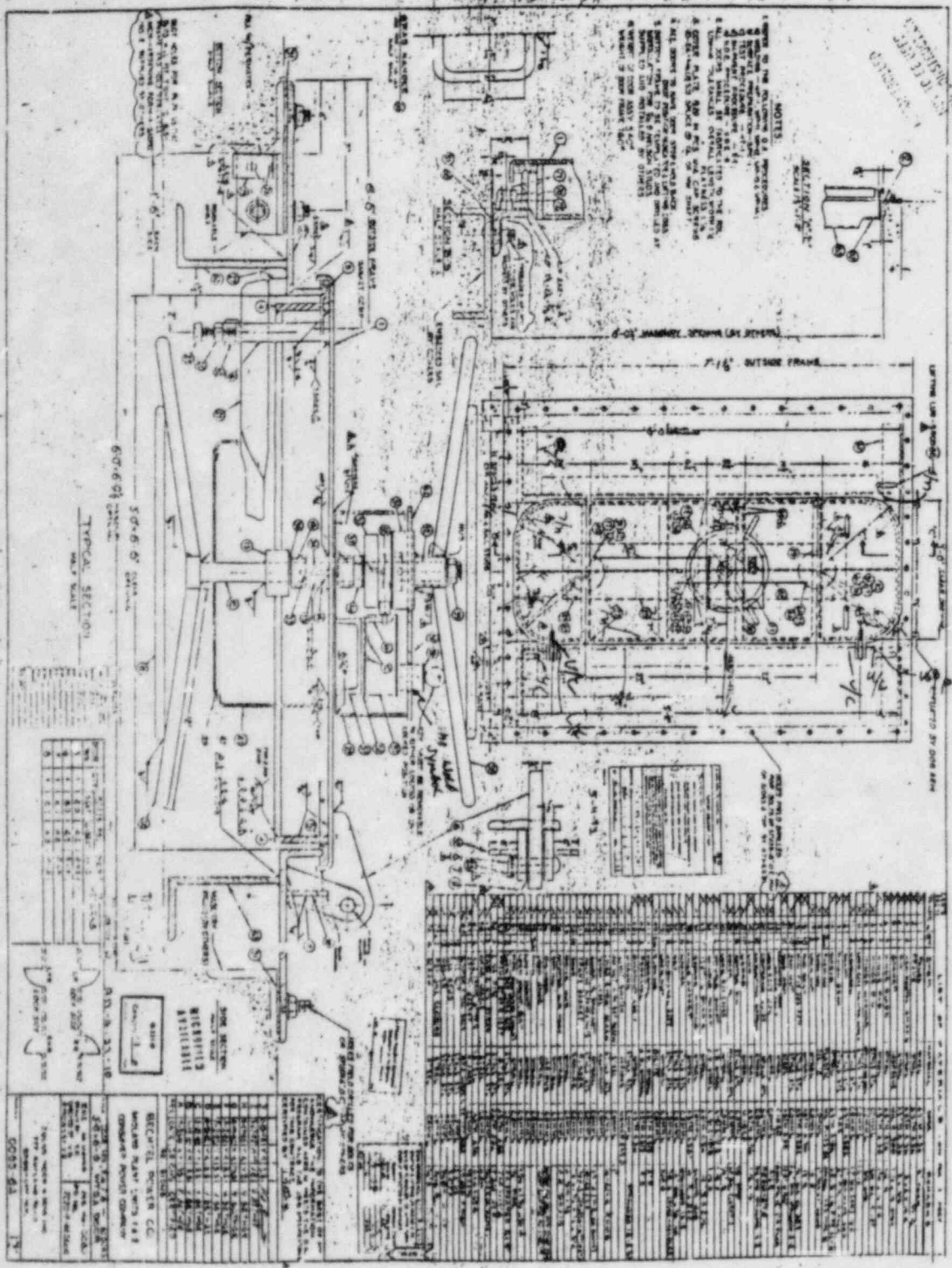
W/C = undercut
L/F = lock of fusion
C/L = cold lap/roll

Door 18

NO.	DESCRIPTION	DATE	BY
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Door # 6



u/c = Undercut
 L/F = Lead Flange

OVERSTRESS.

ALSO, BY REVIEWING THE VENDOR DESIGN CALCULATIONS,
THE SEISMIC LOAD WAS FOUND TO BE INSIGNIFICANT COMPARED
TO THE HYDROSTATIC PRESSURE.

~~THE~~ PROJECT ENGINEERING CONCLUDES THAT
THE EXISTENCE OF THESE DEFICIENT WELDS WILL NOT
AFFECT THE SAFETY OF THE DOORS AND THIS RECOMMENDS
TO "USE AS IS"

JAN 4/27/84 P. Chen 4/27/84
R. Chen for P. Rogala
4/27/84

BLOCK 31a CON'D.

PROJECT ENGINEERING DISPOSITION:

PROJECT ENGINEERING HAS EVALUATED THE NONCONFORMANCE CONCERNING DEFECTIVE WELDS ON THE REFERENCED WATERTIGHT DOORS AND FRAMES.

THE PRELIMINARY RESPONSE TO GAR RD-00027 CONCERNING THE DEFICIENCIES IN WATERTIGHT DOORS AND FRAMES, HAS BEEN REVIEWED BY PROJECT ENGINEERING. THE ATTACHED TRIP REPORT TO THIS GAR SHOWS THE RESULTS OF A DETAILED INSPECTION FOR TWO REPRESENTATIVE DOORS; DOOR AND FRAME NO. 5 AND FRAME NO. 34. THE WORST CONDITIONS DETECTED WERE UNDERCUTS OF $1/16$ " x $1/4$ " LONG. THE TOTAL LENGTHS OF WELD DEFICIENCIES FOUND FOR THE TWO DOORS WERE .3" OUT OF 722" OF WELDS INSPECTED.

~~A REVIEW OF CALCULATIONS~~ A REVIEW OF CALCULATIONS 7220-A17A-12-7 FROM JULIUS MOCK & SONS, INC. SHOWS THAT THE MAJORITY OF THE CALCULATED WELD STRESSES ARE WELL BELOW THE ALLOWABLE STRESSES, WHICH WERE NOT INCREASED FOR ACCIDENT CONDITIONS. DRAWING 7220-G-60 SH. 2 ALLOWS A 50% INCREASE IN ALLOWABLE STRESSES FOR ACCIDENT LOADS WHICH WOULD GIVE A MINIMUM MARGIN OF SAFETY OF 33%. THE WELD DEFICIENCIES ARE WELL BELOW THIS MARGIN OF SAFETY AND THIS WILL NOT HAVE ANY IMPACT ON THE OPERATIONAL SAFETY ~~OF~~ OF THE DOORS.

FURTHERMORE, ALL THE DOOR AND FRAME ASSEMBLIES HAVE BEEN TESTED TO THE MAXIMUM REQUIRED DESIGN PRESSURE BASED ON ACCIDENT CONDITIONS. ALL THE ASSEMBLIES MET THE REQUIREMENTS WITH NO EVIDENCE OF STRUCTURAL

MILANO PROJECT
QUALITY ASSURANCE
DEPARTMENT

NONCONFORMANCE REPORT
CONTINUATION SHEET

NCR NO. (C-0-1006)

DATE ISSUED

REV

PAGE 2 OF 2

DOOR AND FRAME LOCATION

FRAME	EL	AREA	ROOM	DOOR	WAREHOUSE 3
5					X
6					X
7					X
8					X
210	575	340A	40	SAME	
205	"	540A	1	SAME	
14	584	120K	126	WHSE 3	
15	"	103A	130	" "	
18	"	102A	131	" "	
23	"	120D	118	" "	
24	"	120C	117	" "	
25	"	120A	111	" "	
26	"	120B	113	" "	
29	"	102A	116	" "	
31	"	120F	121	" "	
32	"	120G	122	" "	
33	"	120H	124	" "	
34	"	120J	125	" "	
35	599	130H	216	" "	
40	"	130J	217	" "	
43	"	130F	214	" "	
44	"	130G	215	" "	
45	"	130D	212	" "	
46	"	130E	213	" "	
53	614	103B	328	" "	
65	"	102B	329	" "	
77	"	210B	358	" "	
84	"	210E	361	" "	
88	"	210C	359	" "	
108	634	150L	420	" "	
109	"	150R	421	" "	

