

U. S. NUCLEAR REGULATORY COMMISSION

REGION III

Report No. 50-461/84-15(DE)

Docket No. 50-461

License No. CPPR-137

Licensee: Illinois Power Company  
500 South 27th Street  
Decatur, Illinois 62525

Facility Name: Clinton Nuclear Power Station, Unit 1

Inspection At: Clinton Site, Clinton, Illinois

Inspection Conducted: May 24 - 25, 1984

Inspector: *R. D. Walker for*  
R. D. Schulz

6/12/84  
Date

*F. C. Hawkins*  
Approved By: F. C. Hawkins, Chief  
Management Programs Section

6/12/84  
Date

Inspection Summary

Inspection on May 24 - 25, 1984 (Report No. 50-461/84-15(DPRP))

Areas Inspected: Routine safety inspection of quality assurance/quality control activities relative to component supports and follow-up on previously identified items in NRC Inspection Reports 83-15 and 84-02. The inspection consisted of 13 inspector-hours by one NRC inspector during regular hours and zero inspector-hours during off-shift.

Results: One item of noncompliance was identified in the area of component supports (failure to impact test lugs attached to Class 1, NB, Section III, pipe, paragraph 3).

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## DETAILS

### 1. Persons Contacted

#### Illinois Power Company

- \*W. C. Gerstner, Executive Vice President
- \*D. P. Hall, Vice President
- \*W. Connell, Manager, Quality Assurance
- \*R. E. Campbell, Director, Quality Systems and Audits
- \*J. E. Loomis, Construction Manager
- \*J. Greene, Assistant Power Plant Manager
- \*J. G. Cook, Assistant Plant Manager
- \*D. I. Herborn, Director Licensing
- \*J. R. Sprague, Station Quality Assurance Specialist
- M. Desai, Station Quality Assurance Specialist

#### Baldwin Associates

- \*A. E. King, Jr., Project Manager
- \*L. W. Osborne, Manager, Quality and Technical Services
- R. Neeb, Senior Piping Mechanical Engineer
- D. Shumway, Staff Engineer
- J. Eaton, Quality Control Reviewer
- E. Campbell, Quality Control Reviewer
- D. Kozlowsky, Quality Assurance Engineer

\*Denotes those personnel attending the exit interview.

### 2. Licensee Action on Previously Identified Items

(Closed) Noncompliance (50-461/83-15-05): Procedure QCI-302 was not in accordance with the ASME Boiler and Pressure Vessel Code, Section III, NB, NC, or ND-4000 for cold bending. QCI-302 was revised January 3, 1984, by Quality Procedure Change Request (QPCR) 83-232 to require the inspector to record the actual measurement for pipe bend ovality. Training sessions were conducted on August 30 and December 2, 1983. A decision was made by the licensee to reinspect and record dimensions for all 2" and under pipe bends. Controls have been instituted to assure that all pipe bends are reinspected and measured to the 8% ovality tolerance. Of the 142 bends reinspected and measured as of May 24, 1984, four bends exceeded the 8% ovality tolerance and were documented on nonconformance reports.

(Closed) Open Item (50-461/84-02-01): Procedures BQA-184 and BAP 2.1.1 appeared to require further clarification and revision. Baldwin Associates Procedure 2.1.1 was revised February 13, 1984, stipulating in Section 6.2.1, the method in which the applicable disciplines review exception list items, including the document distribution order. Baldwin Associates Procedure BQA-184 is in the process of being revised, deleting the portion of the job description for Level II and III's regarding the interpretation and evaluation of results.

(Closed) Open Item (50-461/84-02-03): The generic Resolution Group Supervisor was previously in the process of documenting the 10 CFR 50.55(e) review for all generic resolutions. During the inspection the inspector determined that the generic Resolution Group Supervisor has reviewed all generic resolutions for 10 CFR 50.55(e) applicability. This review has been documented. The inspector reviewed generic resolutions 1, 5, 10, 15, 20, 24 and 39.

### 3. Component Supports

The inspector reviewed the weld data package for four lugs attached to 12" Residual Heat Removal Pipe Line 1RH04B-12". The lugs were attached by weld numbers 15E, 15F, 15G, and 15H, and were therefore integral attachments. The carbon steel line was classified as ASME Section III, Class 1, NB pipe and with a wall thickness of .844 inches, required impact testing.

The four lugs, 1 1/4" x 1/2" x 2", heat number 411C1371, SA-516GR.60, were furnished by Interstate Steel Supply Company and the test report indicated the lug material was not impact tested as required by ASME Section III, NF-2311 and Sargent and Lundy Specification K-2884, Component Supports. Failure to impact test the lugs, which transmit the load of the pipe is an item of noncompliance with the requirements of 10 CFR 50, Appendix B, Criterion IX (461/84-15-01).

The inspector reviewed various component support inspection checklists, weld data packages, and component support drawings. ASME Section III NF welds were controlled with a Weld Data Traveler and each weld was assigned a unique number. The drawings categorized supports as "plate and shell" or "linear" for material requirements according to ASME, NF-2130; and "primary or secondary," and "plate and shell", "linear", or "component standard supports" for nondestructive examination requirements according to ASME, NF-5200. Weld data packages included quality control check points for preheat, interpass temperature, and completed weld. Inspection checklists included such attributes as:

- Filler metal correct
- Welder properly certified
- Fit-up correct
- Correct size of variable spring
- Travel stops installed
- Nuts/bolts tight
- Cold and hot load indicators/settings
- Spacers installed

- Clamp perpendicular to the transverse axis of pipe
- Name plate present
- No interferences
- Tolerances
- Material traceability
- Orientation of material

Traveler packages were reviewed by engineering, technical services, and quality control prior to issuance and after component support installation.

4. Exit Interview

The inspector met with licensee representatives denoted in Paragraph 1 on May 15, 1984, and discussed the purpose and scope of the inspection and the findings.