

ILLINOIS POWER COMPANY
QUALITY ASSURANCE INSTRUCTIONS

QAI - 710.08

Revision 3

TITLE: OVERINSPECTION SAMPLE PLAN

Scope of Revision:

Revision 3: Major rewrite - rewritten because the number of items/attributes to be overinspected are not known prior to the actual inspection. Sample size by traveler/item listings have been chosen using a minimum sample dictated by MIL-STD-105D. Accept/Reject criteria now in QAI 710.09

QAI 710.08A01 Revised. QAI 710.08A02 Deleted.

QAI 710.08F01, 710.08F02, 710.08F03 superceded by QAI 710.08F04.

INFORMATION ONE
DRAFT

SIGNATURES

	Rev. 3	Rev. 4	Rev. 5
Prepared by:	<i>[Signature]</i>		
Supervisor of Welding, NDE and Testing.	<i>[Signature]</i>		
Supervisor of Quality Engineering.	<i>[Signature]</i>		
Manager - QA Approval:			
Approval Date:			

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1.0 PURPOSE/SCOPE

1.1 Purpose

This instruction provides the sample plans and methods to be used in the Illinois Power (IP) Company Overinspection Program.

1.2 Scope

This instruction applies to all installed safety related, augmented Class D, fire protection, and seismic HVAC systems, items, or components.

2.0 DISCUSSION/DEFINITIONS

2.1 Discussion

2.1.1 The sample plans contained in this instruction are derived from MIL-STD-105D, "Sampling Procedures and Tables for Inspection by Attributes" (Reference 6.1).

2.1.2 The results obtained using these sample plans will be evaluated in accordance with Reference 6.7.

2.2 Definitions

2.2.1 Lot: Collection of items from which a sample is drawn. For the Overinspection program, the lot may be developed from travellers in a Turnover Package, items in a specified area or system, groups of like items such as large bore pipe hangers, or small bore pipe, conduit, etc.

2.2.2 Master Lot Number: A number assigned by IP Overinspection to a lot made up of one or more Baldwin Associates' (BA) lot(s) to assure traceability between IP and BA lots.

2.2.3 Nonconformance: Deficiency in characteristic which renders the quality of an item unacceptable or indeterminate.

2.2.4 Overinspection: Program to provide additional inspection of previously verified items.

2.2.5 Random: Objective process in which all items being considered have an equal chance of selection. In the

overinspection program, randomness will be achieved by the use of random numbers.

- 2.2.6 Sample Plan: The required sample size for a given lot (Appendix 7.1).
- 2.2.7 Traveler: Document listing work activities to be performed, their sequence, scope, requirements, etc.
- 2.2.8 Turnover Package: Appropriate documentation provided for a system, sub-system, area, etc. designated for turnover as a unit.

3.0 RESPONSIBILITIES

- 3.1 The Supervisor - Welding, NDE and Testing is responsible for the implementation of the Overinspection Program.
- 3.2 The Area Overinspection Supervisor (AOIS) reports to the Supervisor - Welding, NDE and Testing and is responsible for:
 - a. training of personnel implementing this QAI
 - b. verification of Overinspection Sample Plans
- 3.3 The Discipline Overinspection Supervisor (DOIS) reports to the AOIS and is responsible for:
 - a. preparation of Overinspection Sample Plans
 - b. determining the applicable Checklist(s)
 - c. assignment of inspection personnel
 - d. review and approval of completed inspection reports and checklists.

4.0 INSTRUCTIONS

- 4.1 Baldwin Associates (BA) shall transmit a report of the results of their field verification inspections of each lot submitted to Illinois Power Supervisor-Welding, NDE and Testing for Overinspection. The report shall define the following:

- ° Identification of the lot inspected.
 - ° Traveler numbers
 - ° Component numbers
 - ° Inaccessible items
 - ° NCRs initiated.
- 4.2 The Supervisor - Welding, NDE and Testing shall then forward the Field Verification Report to the AOIS for action by the appropriate DOIS, who will initiate the Overinspection Sample Plan Form, Appendix 7.2. The DOIS shall obtain a Master Lot number from the Overinspection QA Analyst in accordance with Reference 6.3.

NOTE 1 Identification of lots and the population of the lot may be provided by BA prior to completion of BA inspections in order to allow IP to determine sample size and develop inspection packages.

NOTE 2 Lots submitted by BA that are comprised of items in the same discipline (electrical, HVAC, etc.) may be combined as approved by the Supervisor - Welding, NDE and Testing.

- 4.3 The DOIS shall determine which drawing(s) (design/supplier detailed drawings) are required, initiate and transmit a Request for Documents, Form JV-319(BA), to the BA Document Control Center for the required drawing(s).

All drawings utilized in the Overinspection process shall be marked with the Overinspection Report number and Master Lot number.

- 4.4 If sampling is to be performed, the DOIS will identify the travelers or items that constitute the lot population. Travelers or items to be inspected will be selected using random numbers generated by a computer. The number of selections will be determined by utilizing the Overinspection Sample Plan Table, Appendix 7.1. The selected samples shall be identified by circling the item on the lot identification document. A number of alternates, designated by the letter 'A' shall be identified in case some of the circled samples are found to be inaccessible or unavailable

for inspection due to additional work being performed on the item.

NOTE: The Supervisor - Welding, NDE and Testing may optionally determine to perform 100% overinspection of a lot.

- 4.5 The DOIS will obtain the applicable Checklist Instructions and Checklist for each category and type inspection required, and record these on the Sample Plan.
- 4.6 The DOIS will forward the completed Overinspection Sample Plan to the AOIS for verification. If the Master Lot is made up of more than one BAFV lot, the AOIS shall obtain the signature of the Supervisor - Welding, NDE and Testing.
- 4.7 If the system structure or component has been turned over to Illinois Power, interface with Plant Staff in accordance with Reference 6.4.
- 4.8 Physically locate items requiring inspection. If required, request craft support for scaffolding, cleaning, paint removal, etc. in accordance with Reference 6.5.
- 4.9 Perform inspection of selected items in accordance with the appropriate checklist instructions. Document results on the Overinspection Report, Checklists, and drawings as required in accordance with Reference 6.2.
- 4.10 Document all Nonconformances in accordance with Reference 6.6.
- 4.11 Initiate the evaluation process for each Lot Overinspection Report in accordance with Reference 6.7.
- 4.12 Transmit the Lot Overinspection Report and associated documents generated in accordance with this QAI to the CPS Central File in accordance with Reference 6.8.
- 5.0 RECORDS
- 5.1 Records generated as a result of overinspection activities shall be processed in accordance with Reference 6.8.
- 5.2 Overinspection documents are designated Record Type 4126.6-L.

6.0 REFERENCES:

- 6.1 MIL-STD-105 D, Change Notice 2, 20 March 1964, Titled:
SAMPLING PROCEDURE AND TABLES FOR INSPECTION BY ATTRIBUTES
- 6.2 QAI-710.01 OVERINSPECTION PROGRAM
- 6.3 QAI-710.02 OVERINSPECTION DOCUMENTATION IDENTIFICATION,
ISSUING AND TRACKING
- 6.4 QAI-710.03 IP PLANT STAFF INTERFACE
- 6.5 QAI-710.04 OVERINSPECTION CRAFT SUPPORT REQUEST
- 6.6 QAI-710.06 OVERINSPECTION NONCONFORMANCE INSTRUCTION
- 6.7 QAI-710.09 OVERINSPECTION EVALUATION PROGRAM
- 6.8 QAP-117.01 RECORDS CONTROL

7.0 APPENDICES/DOCUMENTS:

- 7.1 QAI-710.08A01 Overinspection Sample Plan Table
- 7.2 QAI-710.08F04 Overinspection Sample Plan (Combined)

OVERINSPECTION SAMPLE PLAN TABLE

QAI- 710.05A01
 Revision 2
 Date _____

Population Size <u>N</u>	Sample Size <u>n</u>
2-50	ALL
51-500	50
501-1200	80
1201-3200	125
3201-10,000	200
10,001-35,000	315

ILLINOIS POWER COMPANY
QUALITY ASSURANCE DEPARTMENT
OVERINSPECTION SAMPLE PLAN

QAI- 710.08F04

Revision 0

Date

Mechanical HVAC

Structural

Master Lot Number

Electrical

Other

Baldwin Associates Field Verification
Defined Lot Numbers

Category

- Mechanical: Large and small bore piping Piping supports/hangers
 Mechanical equipment HVAC
 Instrumentation Other _____
Structural: Structural steel Other _____
Electrical: Electrical hangers/conduit raceway Cable termination
 Electrical equipment Instrumentation (Electrical/mechanical)
Other: Cable Routing/Termination Other _____

Number of travellers in lot _____ Required sample size _____

Applicable Checklist Procedure(s), Checklist(s) and Revision Number

- QAI-710- _____ QAI-710- _____
QAI-710- _____ QAI-710- _____
QAI-710- _____ QAI-710- _____
QAI-710- _____ QAI-710- _____

Remarks: _____

Sample Plan Prepared by _____ Date _____
Verified by _____ DOIS Signature _____ Date _____
Approved by _____ AOIS Signature _____ Date _____
Supervisor-Welding, NDE &
Testing (as required by para. 4.6)