

Inspection

77-02-01: Failure to Adhere to Specification Requirements, are Accomplished Relative to Minimum Size of Fillet Welds on Carbon Steel Stiffener Attachments to the Stainless Steel Liner Plate of the Spent Fuel Pool.

The inspector viewed the spent fuel pool liner structure being erected on a concrete pad south of the reactor building. On each of four sides of the liner structure, segments of the fillet welds on various vertical stiffeners appeared marginal when viewed from a distance. The inspector obtained a fillet weld gage from the licensee quality assurance representative and measured the weld size at several locations (e.g. #48 A15) which appeared suspect. At least one location on each side of the liner assembly did not meet the 3/16-inch criteria shown on the design drawing C-236. This is contrary to the visual inspection criteria of part 5.6 of PDM procedure CVT-01 which requires "Fillet welds shall be of the specified size with full throat and legs of uniform size."

The existence of the above condition required that the responsible welder did not adhere to the specified weld size requirement in performing the work, and the quality inspector did not adhere to specified inspection requirements. This is contrary to criteria V, relative to implementation of criteria IX and X of Appendix B of 10 CFR 50, which require accomplishment and inspection of welding to assure adherence to specifications and procedures.

The inspector examined the following documents relative to the above:

Bechtel Drawing #C-236, Rev. 0
PDM Welding Specification WS-17
PDM Procedure CVT-01, Rev. 0

77-02-02: Failure to Prevent Damage and Deterioration of the Spent Fuel Pool Liner

The inspector observed that the stainless steel exterior surfaces of the spent fuel pool liner assembly had been exposed to the molten slag/iron material resulting from a carbon steel thermal cutting process. This was evidenced by the spray patterns of