



c. Component Support Structures

The inspector visually inspected four component structures for pipe supports. These included box restraints, suspended compression variable spring support, and cradle support structure. The units were checked for location (approximate), weld defects, bolt material and tightness, lubricants, and material certification where applicable. The units were also checked for conformance to the installation drawings. The following supports were inspected:

<u>Support</u>	<u>Load-Pounds</u>
HBC-143-H3(2)	1,502
G88-111-H1(0)	2,638
HBC-143-H5(4)	676
HBC-143-H4(3)	1,372

The inspector witnessed random checks on weld sizes. Clearances for pipe to support were in excess of the 1/16 inch requirement for HBC-143-H3, H4, and H5. These have been addressed on Bechtel's In-Process Rework Notice No. P-176. The final inspection of these units remains to be performed. The corrective action taken is within the licensee's program and appears to be satisfactory. The inspector reviewed typical findings by the licensee QC personnel and noted that similar findings were being documented.

No items of noncompliance were identified.

11. Safety Related Piping - Observation of Work Activities

a. Nondestructive Examination of Pipe and Pipe Welds

The inspector observed the in-process liquid penetrant examination of the weld end preparations for pipe spools G88-107-1-3 and G88-107-1-4. He verified that the test was performed in accordance with the Nondestructive Examination Standard Procedure PT-SR-1, 2, Revision 1, Amendment 15.

The inspector observed that indications in excess of 1/16" length were evident in the developing powder remaining on pipe weld HBC-183-1-FW-2 after a previous liquid penetrant examination. This weld is a circumferential groove weld in a 20" diameter pipe in the residual heat removal service water systems. Review of the weld card, form WR-5, and Peabody's certified report of nondestructive examination number PST-PT-796, indicated that the examination was performed on April 2, 1978, and that the weld was acceptable. In response to the inspector's questions concerning these indications, the licensee's representative suggested that the weld be re-examined to ascertain if these indications were false and the result of excessive bleed time.

The inspector observed the performance of the re-examination using the liquid penetrant technique. This examination was performed by a qualified examiner and witnessed by both the NRC inspector and the licensee's representative. Additional precleaning of the weld was performed at the inspector's request to assure removal of any materials which might cause false indications. The inspector observed that the liquid penetrant examination was performed in accordance with procedural requirements. Results of the re-examination also produced indications in excess of 1/16" in length. Although these indications were considered by the licensee's representative to be nonrelevant indications resulting from weld surface conditions, the inspector stated that proper examination practices require verification that such indications are not actual defects.

Additionally, the inspector noted that the original examination report, PST-PT-796, indicated that the weld had been tested in accordance with Peabody Test Procedure IPPT-340-39-02, Amendment 1 and 2, Revision G, and successfully passed that test. However, Paragraph 8.1.2 of this procedure requires that, "Any indication in excess of the acceptance standards (1/16") which is believed to be nonrelevant shall be regarded as a defect and shall be re-examined to verify whether or not actual defects are present." The failure to "verify" the absence of actual defects is considered to be an item of noncompliance. (35278-03-03)