

U.S. NUCLEAR REGULATORY COMMISSION  
REGION I

Report No. 50-423/84-18

Docket No. 50-423

License No. CPPR-113

Priority -

Category B

Licensee: Northeast Nuclear Energy Company  
P.O. Box 270  
Hartford, Connecticut 06101

Facility Name: Millstone Nuclear Power Station, Unit No. 3

Inspection At: Millstone Point, Waterford, Connecticut

Inspection Conducted: September 17-21, 1984

Inspectors: Lewis Narrow  
L. Narrow, Lead Reactor Engineer

10/25/84  
date

Approved by: J.P. Durr  
J. P. Durr, Chief, Materials and  
Processes Section

10/30/84  
date

Inspection Summary:

Millstone Unit 3 Inspection on September 17-21, 1984 (Report No. 50-423/84-18)

Areas Inspected: Routine, unannounced inspection by one region-based inspector of licensee action on previous inspection findings; observation and evaluation of work performance; and review of QC records related to installation of pipe supports. The inspection involved 32 hours of direct inspection time on site.

Results: No violations were identified.

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## Details

### 1.0 Persons Contacted

#### Northeast Utilities Service Company (NUSCO)

- \*K. W. Gray, Jr., Staff Assistant, Construction QA
- T. Kulterman, Unit 3 Coordinating Engineer
- \*R. E. Lefebvre, Project Staff Engineer
- P. Nurnberger, Construction QA Engineer
- \*P. J. Quinlan, Engineer, MP-3 Project
- V. Papadopoli, Supervisor, Construction QA

#### Stone and Webster Engineering Corporation (SWECO)

- S. Allen, QC Inspector
- R. Avery, QC Inspector
- J. A. Capozzoli, Jr., Supervisor, Construction Services
- \*A. A. Dasenbrock, Resident Manger
- \*R. P. Hagerman, Chief, Inspection Supervisor
- B. Hammer, Senior QC Inspector
- S. L. Hunt, Engineering Assurance Manager
- G. W. Marsh, Assistant Superintendent, FQC
- G. Milley, Lead Engineer, EMD
- \*R. S. Scannell, QA Program Administrator
- \*C. B. Sprouse, Superintendent of Construction
- W. Taylor, Inspection Supervisor
- \*G. G. Turner, Superintendent, FQC
- \*W. H. Vos, Senior Engineer, FQC

\*attendees at exit meeting.

### 2.0 Facility Tour

The inspector observed activities in progress, completed work and the status of pipe support installation during a tour of several areas of the plant. Work items were examined for obvious defects or noncompliance with NRC requirements. Particular note was taken of indications of QC activities, control and protection of materials and equipment and general housekeeping conditions.

No violations were identified.

### 3.0 Licensee Action on Previous Inspection Findings

(Open) Unresolved Item (423/84-03-08): Lack of control of core drilling bits and drilling records.

Following identification of this item, the licensee

- Conducted a search of the job site for missing drill bits and identified all existing bits on site with positive markings and established a program for improved control and return of issued drill bits to the warehouse within seven days of issue
- Reviewed records of core cut cards and performed engineering evaluation of identified cases where rebar may have been cut without FQC verification
- Revised Filed Construction Procedure FLP-268 and issued E&DCR F-S-34061 for changes to specifications 999 to provide for improved control of drill bits and core cut cards

The inspector reviewed SWECO Type C Inspections Reports No. MON 40283, 40297A&B, 40298A&B, and 40328; NUSCO Surveillance Reports C-2628, 2629 and 2630; FCP-268, Rev. 2; and ECDCR F-S-34061

This item remains unresolved pending close-out of Inspection report MON 40328, additional surveillance by NUSCO as required by Disposition of Surveillance reports C-2628 and 2629, and review by the NRC of the effectiveness of the licensee's corrective action.

#### 4.0 Bulletin Status

Bulletin 83-07: Apparently fraudulent products sold by Ray Miller, Inc.

The inspector reviewed documentation from SWECO and vendors which confirmed that no Ray Miller, Inc., material had been supplied to this plant.

This item is closed.

#### 5.0 Pipe Supports

The inspector reviewed applicable drawings, specification requirements, Field Construction Procedures (FCP's), and QA/QC procedures; observed the status of selected pipe supports; and reviewed SWECO QC Inspection and Surveillance Reports and NUSCO QA Surveillance and Audit Reports. The QA/QC organization and activities were discussed with NUSCO and SWECO personnel and qualifications of selected personnel were reviewed. Control of changes to previously accepted supports was discussed.

No violations were identified.

#### 5.1 Construction QA/QC Activities

NUSCO Construction QA (CQA) performs audits, surveillance and in-process verification (IPV) of construction activities. The same personnel perform all of these activities although they must be qualified for the

activity in question. In all cases, logs are maintained, the results are reported and nonconforming conditions are followed for corrective action.

SWECO QC performs inspections, surveillance and monitoring of construction activities. Inspections are performed at "Hold Points" or after notification of construction completion. Surveillance is performed by the same QC personnel to the same attributes but for work in progress. Monitoring is performed for an overview of construction and inspection activities by a separate Monitoring Group. Unsatisfactory conditions, if programmatic, are reported on a Type "C" inspection report. If not programmatic, it is referred to the discipline QC group which will initiate on unsatisfactory inspection report (UNSATIR)

No violations were identified.

## 5.2 Construction QA/QC Reports

The inspector reviewed the following documents:

- NUSCO Audit Report No. A-40847, "Hanger installations, supports and Temporary Supports." The audit was performed to a prepared checklist, findings were reported and sent to the audited group promptly, the response and corrective action was timely and followed by the auditor.
- NUSCO surveillance reports of hangers and supports for the period of February 1984 through August, 1984
- Qualification and experience records of NUSCO personnel performing the above surveillance
- SWECO QC inspection reports of selected pipe supports which had previously been examined in the field (see p 5.3)
- Selected SWECO Surveillance Reports
- Selected SWECO monitoring Type "C" reports.

All of the above documents conformed to the applicable requirements of:

- NUSCO NQA 1.14 "Audits"
- NUSCO NQA 2.10 "Surveillance"
- SWECO QAD - 10.43, "Hanger and Anchor Bolt Installation Inspections"
- SWECO QCI - FM3-D10.43-010, "Inspection of Pipe Supports"

No violations were identified

### 5.3 Installed Pipe Supports

The inspector examined the pipe supports listed below for conformance to the requirements of the applicable FCP's, BZ drawings, and specifications.

- 3-SWP-2-PSA071 Dwg. No. BZ-19B-48-7
- 3-SWP-2-PSSP407 Dwg. No. BZ-19B-55-6
- 3-SWP-2-PSST058 Dwg. No. BZ-19B-35-2
- 3-CHS-2-PSSH078 Dwg. No. BZ-74B-193-2
- 3-CHS-2-PSST031 Dwg. No. BZ-74B-189-1
- 3-CHS-2-PSR021 Dwg. No. BZ-74B-19-5

The inspector also observed the SWECO QC inspection of pipe support No. 3-GWS-2-PSA043. The inspector was aware of the inspection requirements and had available a "hand book" which provided details of the inspection attributes.

No violations were identified

### 6.0 Engineering Changes

Engineering and Design change request (E&DCR) F-J6855, which supersedes E&DCR's P-J-6724 and P-J-6815, revises dimension clearance requirements for pipe support restraints. This E&DCR was approved August 10, 1984. The inspector asked if these changes would be backfitted to supports which had been inspected and accepted by QC prior to that date. The licensee stated that it was their intention to reinspect these supports but this had never been documented. This item was discussed at the exit meeting and the licensee committed to perform this re-inspection. At the exit meeting the inspector also questioned the requirement that only a single lug be in contact with the support structure for a riser type dead weight support. The licensee stated that stress reconciliation calculations are based on this assumption.

The inspector had no further questions concerning this item.

### 7.0 Exit Interview

An exit interview was held on September 21, 1984 with members of the licensee staff and contractors as denoted in Paragraph 1. The Senior Resident Inspector, Mr. T. Rebelowski was also present. The inspector discussed the scope and findings of the inspection. At no time during this inspection was written material provided to the licensee by the inspector.