

U.S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT

REGION III

Report No. 50-440/78-17; 50-441/78-16

Docket No. 50-440; 50-441

License No. CPPR-148; CPPR-149

Licensee: Cleveland Electric Illuminating
Company
P. O. Box 5000
Cleveland, OH 44101

Facility Name: Perry Nuclear Power Plants, Units 1 & 2

Inspection At: Lake County, OH

Inspection Conducted: December 18-20, 1978

Inspector: C. M. Erb

C.M. Erb

1/22/79

Approved By: D. H. Danielson, Chief
Engineering Support Section 2

D.H. Danielson

1/22/79

Inspection Summary

Inspection on December 18-20, 1978 (Reports No. 50-440/78-17; 50-441/78-16).

Areas Inspected: Reactor pressure vessel moving procedures, Unit 2; quality records and hardware inspection for Class 1 and 2 valves, Unit 1; installation of reactor pressure vessel internals, Unit 2. The inspection involved 18 inspector-hours onsite by one NRC inspector.

Results: No items of noncompliance or deviations were identified.

7903090057

DETAILS

Persons Contacted

Licensee Employees

*J. M. Lastovka, Supervising Engineer - CEI-CQS
*M. Edelman, Manager Quality Assurance
*W. J. Kacer, CQS-QC Supervisor
*P. L. Gibson, CQS-QA Supervisor
*J. W. Mehaffey CQS-QE
*P.A. Fitzpatrick Manager - Site Organization
*J. M. Pipp, CQS
*G. J. Presby, CQE/Quality Engineer
T. Mehaffey, Lead Mechanical Quality Engineer

Kaiser Corporation (KEI)

*E. V. Knox, KEI-QA Manager

Newport News Industrial Corporation (NNIC)

N. Meek, QA Supervisor

General Electric Company (GE)

G. Dempster, Lead Mechanical - NSS.

*denotes attendance at exit interview.

Licensee Action on Previously Identified Items

(Closed) Noncompliance (440/78-09-03) - Welding procedure specifications were not available in the welding area. The inspector verified that the licensee and Newport News Industrial Corporation have implemented controls to assure that welding procedure specifications are available where ASME nuclear welding is underway.

(Closed) Noncompliance (440/77-06-01; 441/77-06-01) - Document control at weld rod issuance stations. The inspector examined the controls and practices in an electrode issuing area onsite and found them to be adequate.

Functional or Program Areas Inspected

1. General

- a. Entrance to the Unit No. 2 reactor pressure vessel made after setting. The cleanliness and conditions of the installed internals appeared to be satisfactory.

- b. Reactor Pressure Vessel for Unit 2 was lifted and set on its pedestal on December 16, 1978. Alignment was completed by December 18, 1978.
- c. Reactor Pressure Vessel heads for Units 1 and 2 will be shipped to the site in the spring of 1979.
- d. Presently, there are approximately 2,130 people working at the site.
- e. N2 nozzles, recirculation inlets, will be reworked although details have not been finalized.
- f. Core Spray headers for Unit 1 will be replaced with solution annealed material. Core Spray headers for Unit 2 were solution annealed at the fabrication shop. Core Spray nozzles will be field installed and orifices changed for both Units 1 and 2.
- g. Feed water safe ends and thermal sleeves (6) were reworked at CBI before delivery.
- h. Usage of Diametrics Automatic Pipe Welding Equipment will require extensive qualification tests which have not been made to date.
- i. Safety Relief Valves (SRV) downcomers to the suppression pool will be fitted with quenching devices of German design.

No items of noncompliance or deviations were found in this area.

2. Reactor Vessel Procedures for Lifting and Moving - Unit 2

The following Reliance Truck procedures were examined and determined to be acceptable.

- | | |
|------------------|--|
| 204A, Revision 1 | Offloading RPV and Setting on Transporters. |
| 205A, Revision 1 | Transporting RPV from Barge Slip to Position Beneath Containment Building Gantry Crane. |
| 206, Revision 2 | Erection Procedure for Gantry Crane at Containment Building. |
| 207, Revision 4 | Procedure 1017/1096 ton Load Test on Gantry Crane at Containment Building. |
| 208A, Revision 0 | Procedure for Upending and Setting the RPV, Final Position in Containment Building. |
| 209, Revision 2 | Procedure - Offload Head from Barge, Transporter to Containment Building and Setting in Storage. |

210, Revision 0 RPV Rinse Procedure, External Surface.
 212, Revision 1 Procedure for Rotating RPV Skirt End Trans-
 porter Bolster to a Vertical Position.

When upending the vessel from the horizontal to vertical position, some wooden blocking splintered and the bolster settled making it necessary to lift the bottom of the vessel with two cranes so that steel blocking could be inserted. No damage to the vessel was reported due to this incident.

GE Specification 22A4645 covered the receipt inspection, cleaning and preparation for installation. Licensee Specification No. SP-700-4549-00 included the requirements for procedures, NDT results, welding qualification, corrective action and records.

No items of noncompliance or deviations were found in this area.

3. Quality Records, Main Steam Valves Unit 1 and 2

The warehouse for the large NSS valves was clean and heated. Valves in this area were stored under acceptable conditions. A 26" Main Steam isolation valve to Specification No. 301 was examined. This valve MPL 2B4-F028C had been built by Atwood and Morrill and supplied by General Electric to Specification 22A-3796. It was covered and in addition contained desiccant VPI260 in the trim area.

Records for three valves SN14-560, 15-560, and 12-560 MPL No. B21-F022 were examined. These were received on a GE PQC and included material and NDT certifications from the various suppliers of parts as shown below:

| <u>Part</u> | <u>Specification</u> | <u>Supplier</u> |
|-------------|----------------------|-----------------|
| Body | SA216 Gr WCB | Quaker Alloy |
| Poppet | SA350 Gr LF-2 | Cann & Saul |
| Cover | SA-105 | Cann & Saul |
| Studs | SA540 Gr B23 | - |

Nonconformances and corrective action were listed. The certificate of shop inspection had been signed by the Hartford Steam Boiler and Insurance Authorized Inspector. Code Case No. 1622 was applicable to these valves.

No items of noncompliance were identified in the above area.

Exit Interview

The inspector met with site representatives (denoted in Persons Contacted Paragraph) at the conclusion of the inspection on December 20, 1978. The inspector summarized the scope and findings of the inspection which were acknowledged by the licensee. .