Contract W3-NY-5 WATERFORD'S EAR ELECTRIC STATION - UNIT NOV 3

PROCEDURE NUMBER: PR 10.0 FROCEDURE TITLE: TRAVELER SYSTEM PAGE OF ISSUE SUMMARY -ISSUE/DATE FREPARED APPROVED REMARKS 9/11-11-81 W. R. Laporte R. M. Ronquilla Added Section 6.1.4.1 and 6.1.4.1.1 Q. A. Manager Q. A. Engineer Attachment # 7.6 R.M. Ronquillo 10/8-26-82 (Revised Attachment #7.6 Q. A. Engineer Q.A. Manager R. M. Ronquillo 11/10-11-82 W. R. Laporte Revised Paragraph 6.1.3.1(e) Q. A. Manager Q. A. Engineer W. P. Zarette 1.M.1. W. R. Laporte R. M. Ronquillo (Revised Paragraph 6.1.3.1(e) 12/10-27-82 Q. A. Engineer Q. A. Manager EBASCO SERVICES INCORPORATED QUALITY ASSURANCE ENGINEERING This Document is: Previewed Without Comments Reviewed With Comments as Noted: Incorporate Comments, and Resubmit; Proceed With Orger. Rejected; Revise and Resubmit NOTE: Review of this document, with or FOIA-84-426 449 without comments, is for general conformance with the applicable specifications only and in no way relieves the manufacturer or contractor from full responsibility for delivery of all materials, equipment, services and documentation in strict accordance with the Purchase Ord Cy: dd 8506150191 850301 PDR FOIA Date: _ PDR

Contract W3-NY-5 WATERFORD STEAM ELECTRIC STATION - UNIT NO. 3

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		ISSUE SUMMARY	
ISSUE/DATE	PREPARED	APPROWED /	REMARKS
1/8-16-78	R. M. Ronquill	R. M. Ronquill QA Manager	This procedure cancels and super- sedes Procedure No. PR 12.0, Issue 9 dated 1/25/78, Same Title.
2/4-16-79	W. J. Rodrigue QA Engineer	R. M. Ronquill QA Manager	6.1.2.6, 6.2.3, 6.2.4, 6.2.11 and added paragraphs 4.12, 6.4, 6.4.1,
3/5-29-79	W. J. Rodrigue QA Engineer	R. M. Ronquill QA Manager	6.4.1.1, 6.4.1.2, 7.5. Revised para. 5.3, 5.4, 6.3.1, 6.3.5, 6.3.5.1, 6.3.6, 6.3.6.1, and 6.4.1.2. Added para. 6.1.1.5.
4/9-10-79	W.J. Rodrigue QA Engineer	R. M. Ronquille QA Manager	Deleted para. 6.3.1.1. Revised Paragraphs 4.4, 4.6, 5.1,5. 5.3, 6.2, 6.2.3, 6.2.8, 6.3.1, 6.2.7, 6.3.4 and 6.3.7.
5/8-4-80	R. Constable QA Engineer	R.M. Ronquino OA Manager	Added Para. 6.3.7.1 and 6.3.8.
6/1-21-81	R. B. Constable Q. A. Engineer	R. M. Ronquillo Q. A. Manager	Revised Paragraphs 4.4, 5.2, 5.5 6.2.3, 6.2.5.1, 6.3.4, 6.3.6, 6.3.6.1, 6.3.7 and Deleted Para. 6.2.7.1.2
7/8-28-81		R.M. Ronquillo Q. A. Manager	Revised Paragraph 6.2.2, 6.2.4 and 6.2.5
8/11-6-81	W. R. Laporte W. R. Laporte Q. A. Engineer	R.M. Ronquillo C Q.A. Manager	Added Paragraph 6.3.4.1

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1.0 PUR POSE

1.1 The purpose of this procedure is to establish a Traveler system that will be used to plan and record all operations, inspection and Hold Points, documentation, and other pertinent information and/or data required to handle, assemble, clean, install and test equipment and/or systems at the Nuclear Power Plant, Waterford Steam Electric Station - Unit No. 3. The Traveler will also serve as a record of in-process operating status and a record of all events in the installation sequence including the installation and securing of locking devices.

2.0 SCOPE

- 2.1 This procedure applies to the handling, assembly, and installation of all equipment including locking devices contracted by Gulf Engineering Company, Inc. that will become a permanent part of the Nuclear Power Plant, Waterford Steam Electric Station Unit No. 3.
- 2.2 This procedure will not apply to the construction of special tools, scaffolding or other items which do not become a permanent part of the facility.

3.0 REFERENCES

- Nuclear Quality Assurance Manual of Gulf Engineering Company,
 Inc.
- 3.2 Quality Assurance Criteria for Nuclear Power Plants and Fuel Processing Plants - 10CFR 50, Appendix B.
- Quality Assurance Program Requirements for Nuclear Power Plants - ANSI N45. 2-1971.
- 3.4 Ebasco Procedures for Inspections, Test and Operating Status, Procedure No. ASP-III-15.
- 3.5 Gulf Engineering Company Procedure No. PR 12.0 Examination, Test & Inspection.

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3.0 REFERENCES (CONTINUED)

- 3.6 Ebasco General Specification covering Installation of Mechanical Equipment, Specification MC-1.
- 3.7 Gulf Engineering Co., Inc. Procedure No. PR 14.0 Examination or Process Status

4.0 DEFINITIONS

- Authorized Nuclear Inspector (ANI) An inspector employed by an Authorized Inspection Agency who has been qualified by written examination under the rules of any state of the United States or Province of Canada that has adopted the ASME Section III, Division 1 Code and who meets the qualification requirements of ANSI N626.0.
- Authorized Quality Control Stamp A rubber stamp which carries an identifying number for a particular Quality Control personnel. This stamp is used as a symbol of approval and can only be used by the person it is assigned to. Use by other than the person a stamp is assigned to is grounds for dismissal. See reference in Paragraph 3.5 for details of stamps.
- 4.3 Code American Society of Mechanical Engineers Boiler & Pressure Vessel Code, Section III Division 1 and applicable addenda hereafter referred to as Code.
- 4.4 <u>Discrepancy</u> A deviation from specified requirements (Including Procedures) that can be readily corrected in accordance with approved operating procedures or specifications. A few examples of discrepancies are:
 - a) Incomplete operations which can be completed with approved operating procedures.
 - b) Replacing missing components.
- 4.5 Examination An element of inspection consisting of investigation of materials, components, supplies or services to determine conformance to specified requirements and description of accompanying documents.

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4.0 DEFINITIONS (CONTINUED)

- 4.6 Hold Points Points designated on the Traveler at which witnessing an activity and acceptance are required by Quality Control, the Owner, or the Authorized Nuclear Inspector. Work shall not proceed beyond Hold Points without consent of the Quality Assurance Engineer, the Owner, or the Authorized Nuclear Inspector, respectively.
- 4.7 <u>Inspection</u> A phase of quality control which by means of examination, observation, or measurement determines the conformance of materials, supplies, components, parts, appurtenances, systems, processes or structures to predetermined quality requirements.
- 4.8 Nonconformance A deficiency in characteristic, documentation, or procedure which renders the quality of an item unacceptable or indeterminate. Examples of nonconformances include: physical defects, test failures, incorrect or inadequate documentation, or deviation from prescribed processing, inspection or test procedures.
- 4.9 Owner Louisiana Power & Light Company or its properly authorized representative, successors, or assigns.
- 4.10 Testing The determination or verification of the capability of an item to meet specified requirements by subjecting the item to a set of physical, chemical, environmental or operating conditions. As defined here, tests refer only to those required by specifications or Code to satisfy the conditions of the specific application.
- 4.11 Traveler A system used to define and record proper sequence for the applicable job functions for handling, assembly, cleaning, installation and test of equipment and/or system(s), showing inspection and Hold Points and provides sign off by responsible parties.
- 4.12 Partial Traveler A Traveler processed to accomplish a portion of the installation of equipment and/or system(s).

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5.0 RESPONSIBILITIES

- 5.1 The Production Engineer, or other personnel assigned by the Project Manager, is responsible for preparing the Traveler.
- 5.2 The Construction Superintendent will approve the Traveler and have the Craft Foremen perform and sign-off all Craft operations assigned to them on the Traveler. He is also responsible for maintaining the Traveler during construction until conditional turnover of equipment to the Owner.
- The QA Engineer shall provide inspection planning inputs to the originator and is responsible for reviewing all Travelers for proper documentation, correctness, completeness and the necessary inspection and Hold Points. When an Authorized Nuclear Inspector is required, the QA Engineer will also obtain the necessary Hold Points from the Authorized Nuclear Inspector and designate on the Traveler. He will submit the Traveler to the Owner for reiew and approval of inspection, Hold Points and revisions. Once approved, the QA Engineer will issue the Work Copy of the Traveler to construction. In addition, he will maintain a records file index for Travelers.
- 5.4 The Quality Control Supervisor will be responsible for performing inspections, approving changes and witnessing tests as specified on the Traveler in the absence of the Quality Control Inspector. He may also submit the Traveler to the Owner for review and approval of Revisions.
- 5.5 The Quality Control Inspector, Engineer or Welding Engineer is responsible for performing all inspections, approving changes and witnessing tests specified on the Traveler and recording all data required to be recorded on the Traveler and/or data sheets. He will also notify the Owner and the Authorized Nuclear Inspector of any inspections or Hold Points requiring their approval. The Owner will be notified within the time specified in the Contract

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6.0 PROCEDURE

- 6.1 The Traveler system consists of four (4) basic forms: the Traveler First Sheet, Form No. PR 10.0-1; Traveler Supplement Sheet, Form No. PR 10.0-2; Parts List Page, Form No. PR 10.0-3 and Data Sheet, Form No. PR 10.0-4. (Copy of all attached)
 - 6.1.1 The Traveler First Sheet, Form No. PR 10.0-1, will be used for the following:
 - 6.1.1.1 To identify the item to be handled, assembled, cleaned, tested or installed, the storage level and safety class.
 - 6.1.1.2 To record the latest drawings, specifications, procedures, special processes and any revisions required for handling, assembling, cleaning, testing or installing.
 - 6.1.1.2.1 Quality Assurance will verify on form opposite the drawings, speciications, procedures or special processes that the latest revision has been recorded by stamping with an Authorized Q. A. Stamp.
 - 6.1.1.3 To log any unplanned events, such as discrepancies or nonconformances as they may occur.
 - 6.1.1.3.1 Quality Control will log and later verify when discrepancies or nonconformances are satisfied by stamping with an Authorized Q. C. Stamp.
 - 6.1.1.4 To document the originator of the Traveler,
 Construction approval, Quality Assurance
 approval, the Owner's approval and the ANI:s
 approval for Code items.

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- 6.1.1.4.1 Quality Assurance will sign and stamp with an authorized stamp in the approval block.
- 6.1.1.5 To provide, in the case of partial Travelers, a statement of the scope of work intended and to reference numbers of associated partial Travelers.
- 6.1.2 The Traveler Supplement Sheet, Form No. PR 10.0-2, will be used for the following:
 - 6.1.2.1 As many Supplement Sheets as required will be used to list in the sequence they are to be performed, a description of all operations required to handle, clean, test, assemble or install equipment defined on the First Sheet of the Traveler. It will also include operations for the proper securing and installation of locking devices.
 - 6.1.2.1.1 Operations within Hold Points may be performed out of sequence, if circumstances are warranted.
 - 6.1.2.2 The Supplement Sheets will have inspection and Hold Points in the proper sequence of operations.
 - 6.1.2.2.1 Inspection operations which are designated as Hold Points will be identified by writing the words "Hold Point" adjacent to the Operation number on the Traveler.
 - 6.1.2.3 The organization responsible for performing a given operation will be identified for each operation. An organization could be Craftsmen, Quality Control, Owner or Subcontractor.
 - 6.1.2.4 All operations will be dated and initialled or dated and stamped by the person responsible for performing that operation upon completion of that operation. Quality Control will stamp

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- 6.1.2.4 (Continued)

 and date with an Authorized Q. C. Stamp
 signifying approval of inspection operations.
 - 6.1.2.4.1 The last Q.C. operation on the Traveler which will be Q.C. acceptance of the item as being complete, will also be signed in addition to being stamped and dated.
- 6.1.2.5 Inspection and/or Hold Points for the Owner or the ANI will be signed by them signifying their approval.
- 6.1.2.6 The identification number of all measuring and test equipment, special tools, and special handling equipment used in the process will be recorded on Inspection Use Record Cards in accordance with Procedure PR 13.0.
- 6.1.3 The Parts List Page (Form No. PR 10.0-3) will be used to list all items, equipment or material specified on drawings, specifications and procedures that will be used. This only includes those items, equipment or material that will become a permanent part of the Nuclear Power Plant.
 - 6.1.3.1 The Parts List Page will have the following:
 - a) Part number or other identifying number of each item, equipment or material used.
 - b) Quantity of each item.
 - c) Brief description of each item.
 - d) P.O. Number, Serial No., or Heat No. as applicable.
 - e) Date and Authorized QC Stamp of the QC Inspector who receive-inspected the parts in accordance with Procedure PR 8.0. This verification will be done at the time the material is received from storage.

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6.1.3.1 (Continued)

- f) Any pertinent remark regarding an item that should be recorded.
- 6.1.4 The Data Sheet (Form No. PR 10.0-4) will be used if and as required to record any additional information or data, such as; coupling, readings, results of examinations or tests, pictorials of handling techniques, etc.
 - 6.1.4.1 A special Data Sheet (Form No. PR 10.0-6) will be used for Field Inspection of Pipe Hangers and Supports, All Travelers for Safety and Seismic Pipe Hangers, restraints, supports, snubbers, variable spring hangers and supports, anchors, and guides will require this Data Sheet. All Travelers for Non-Safety and Non-Seismic snubbers, spring hangers and supports for both large and small bore pipe will also require this Data Sheet.
 - 6.1.4.1.1 After struts have been accepted b QC Lock-Tite will be applied to identify acceptance.
- 6.2 The Traveler will be prepared by the Production Engineer, or other personnel assigned by the Project Manager. Travelers will be prepared and approved by all approving authorities required prior to start of work. Following preparation, the Traveler will be processed as follows:
 - 6.2.1 The originator will sign and date the Traveler, and present the original to the Construction Superintendent, or his designee, for his signature denoting approval.
 - 6.2.2 The originator will then submit the Traveler to the Quality Assurance Engineer who will review for the proper documentation, correctness, completeness, necessary inspection and Hold Points, and will sign, stamp, and date the document denoting same. In addition, the Quality Assurance Engineer will maintain a QA Records File Index for Travelers, Form No. PR 10.0-5, for the purpose of logging Travelers assigning each a

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	6.2.2	(Continued)				
		unique sequential identif	ication nu	mber	, a bri	ef
		description of the work,				
		forwarded to the Constr	uction Sup	erint	endent.	
	6.2.3	If inspection by the Auth	orized Nu	clear	Inspe	ctor is
		designated, the Quality				
		the required Hold Points				
		on the Traveler at the a				
		inclusion, the Travelers be presented to the Auth				
		review and acceptance of				
		Date.			,	
	6.2.4	Once the Traveler is ap	proved an	d nec	essary	interface
		has been conducted with				
		Quality Assurance Engir				
		safety-related Traveler approval via a letter of			or rev	lew and
		approvar via a retter or				
	6.2.5	Upon approval and retur				
		will furrish the "Work (
		Construction Superinten Quality Assurance Reco		ne m	e origi	nai in the
		6.2.5.1 The copy furn	ished to t	he Co	nstruc	tion Super-
		intendent will			Vork C	opy" in red
		on all sheets.		with		
	6.2.6	The "Work Copy" will b	e maintair	ned a	nd prot	ected from
		abuse or deterioration,	by the Co	nstru	ction S	uperintendent
		or his designee.				
		6.2.6.1 The !'Work Co	opy" will	be the	perm	anent record

copy on which all operations are initialed or stamped by the persons responsible for performing that operation. This includes operations requesting the Owner or Authorized

Nuclear Inspector's approval.

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- 6.2.7 The Construction Superintendent will assign operations on the Traveler to various craftsmen in the same sequence as specified on the Traveler. As an operation is completed, it will be initialed and dated by the foreman responsible for that operation. This will afford an up-to-date status of work performed and inspections thereof.
 - 6.2.7.1 If during the processing of the Traveler, an unplanned event (Such as a discrepancy or nonconformance) occurs, the event will be recorded by the Quality Control Inspector on the Traveler opposite the operation that the event occurred. It will also be recorded on the First Sheet of the Traveler.
 - 6.2.7.1.1 After the discrepancy or nonconformance has been corrected, the Quality Control Inspector will stamp and date the First Sheet of the Traveler with his Authorized Q.C. Stamp opposite the unplanned event.
- 6.2.8 The Construction Superintendent shall notify the QC
 Supervisor when a Hold Point is reached in the sequence
 of operations. The QC Supervisor, in turn will notify
 the Owner and the Authorized Nuclear Inspector of all
 Hold Points requiring their acceptance.
- 6.2.9 After successful completion of all operations on the Traveler, the Construction Superintendent will transmit the "Work Copy" to the Quality Control Supervisor.
- 6.2.10 The Quality Control Supervisor will file the "Work Copy" of the Traveler and keep on file in the Quality Assurance Records safe as a Permanent Record. The "original" may no longer be maintained once the "Work Copy" has been completed and filed.

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- 6.2.11 The Quality Assurance Engineer will review, stamp and date completed Travelers to verify that all applicable drawings, specifications, procedures and any revisions thereof have been utilized. He will also note the completion date on the QA Records File Index for Travelers.
- 6.2.12 Further handling of the Traveler as a permanent record will be covered in Procedure No. PR 17.0 Quality Assurance Records.

6.3 Revisions to Travelers

- 6.3.1 Revisions to Travelers can only be made by the Production Engineer or by other personnel assigned by the Project Manager. All Revisions will be initialled and dated by the person making the revision and the person(s) reviewing and approving the revision.
- 6.3.2 The originator will review all drawing, specification and procedure revisions and incorporate the applicable requirements in the Traveler.
- 6.3.3 Revisions cannot be made to operations previously accepted and stamped by Quality Control.
- 6.3.4 All revisions must be approved by Quality Control or Quality Assurance Personnel prior to implementing.

 Quality Control or Quality Assurance will signify approval by stamping with an authorized Quality Control or Quality Assurance Stamp and dating.
 - 6.3.4.1 Construction is allowed to make Traveler changes only to non-safety related items without immediate QA/QC approval. Approval will be obtained within 24 hours or on the next regular scheduled work day.
- 6.3.5 All revisions affecting safety class items which alter the form fit or function of the end product shall be approved by the Owner prior to implementing.

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- 6.3.5.1 The Quality Assurance Engineer or the Quality Control Supervisor are responsible for obtaining the approval of the Owner and such approval will be denoted by the Owner's initialling and dating the change on the Traveler.
- 6.3.6 Revisions affecting Owner or Quality Control Hold Points will be approved by the Owner or Quality Assurance Engineer, respectively.
 - 6.3.6.1 The Quality Assurance Engineer is responsible obtaining the approval of the Owner. Their approval will be signified by initialling and dating the change on the Traveler.
- 6.3.7 All changes affecting ASME Code work shall be reviewed by the ANI prior to implementing. Changes in the sequence of operation between ANI Hold Points may be made without review by the ANI.
 - 6.3.7.1 The Quality Assurance Engineer is responsible for obtaining the approval of the ANI. His approval will be signified by initialling and dating the change on the Traveler.
- 6.3.8 Travelers requiring extensive changes will be closed out at the last completed operation with reference to the revised Traveler. The revised Traveler will include a reference to completed operations on the original Traveler. The revised Traveler will be issued with the original Traveler(s) and submitted for approval and designation of Hold Points the same as the original.

6.4 Partial Travelers

6.4.1 Partial Travelers may be used when it is necessary to perform partial installations or incomplete work pending additional instruction.

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- 6.4.1.1 Partial Travelers will be prepared, issued, processed and closed out in identical fashion to other Travelers. The First Sheet of the partial Traveler will provide a brief summary of the scope of work intended.
- 6.4.1.2 Partial Travelers which are issued to continue and/or complete the work begun by an earlier partial Traveler will reference the Traveler number of the earlier work in the scope of work statement. Also, the Traveler number of the subsequent partial Traveler will be entered on the First Sheet of the earlier partial Traveler. Moreover, Q.C. will verify that the Traveler covering the earlier work is complete.

7.0 ATTACHMENTS

- 7.1 Form No. PR 10-0-1 Traveler First Sheet
- 7.2 Form No. PR 10.0-2 Traveler Supplement Sheet
- 7.3 Form No. PR 10.0-3 Parts List Page
- 7.4 Form No. PR 10.0-4 Data Sheet
- 7.5 Form No. PR 10.0-5 QA Records File Index for Travelers
- 7.6 Form No. PR 10.0-6 Field Inspection Data Sheet for Pipe Hangers and Supports

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Next Assy.	Originator		Date	Storage Level	vel	Safety Class	lass
Construction		Quality Assurance		Customer		A. N. 1.	
Drawings, Specifications,	ons, Procedur	Procedures, Nonconformance Reports	e Reports				
Number & Revision		, Description	ption		va	, ac	Date
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Part No.	Nomenclature	lature					-

Oper.

Part No.

		 -	-	 		 	 		Attac	hille	nt No	7.3
	Remarks											Sheet
ENGINEERING COMPANY, INC. PARTS LIST PAGE	fy Date											
	Veri Q. C											
	Serial . Number											
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Form No. PR 10. 0-3(5/78)

DATA SHEET	
	Nomenclature
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GULF ENGINEERING CO., INC. Attachment No. 7.5

WATERFORD STEAM ELECTRIC STATION - Unit 3

QA RECORDS FILE INDEX FOR TRAVELERS

Traveler No.	Item No. / Description	Date Released	Date Completed
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			a plant
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FIELD INSPECTION DATA SHEET FOR

PIPE HANGERS AND SUPPORTS.

	ISO NO.
HANGER MARK NO/ REV. NO.	REV. NO.
INSPECTION ACCEPTANCE ITEMS:	
A. Pipe Clamp	D. Variable Spring Hangers
l. Correct Size2. Spacers (Size & Location)(If Applicable)3. Fasteners,(Size, Location, Tightened)	1. Cold Setting + 1/8" 2. ID Tag Reflects Mark No. 3. Proper Type & Size of Spring Car 4. Fasteners (Size, Location, Tightened)
B. Mechanical Sway Strut	E. Rod Type Hangers
1. Proper Size or Type 2. Lock Nut Tight 3. Proper Orientation of Structure Attach Point 4. Compound Angle Correct + 2 Deg. 5. Inst'l. per FCR-MP-1730 C. Mechanical Snubber	1. Compound Angle Correct + 2 Deg. 2. Rods Straight With No Bends, Curves, Etc. 3. Adjustment Lock Nuts Tight F. All Hangers and Supports
	1. Proper Location Along Pipe Axis +2" 2. Material Traceability Recorded, 3. Material Correct or "As-Built" 4. Pipe Clearances (If Applicable per ESSE Sketch M-694
INSPECTION COMPLETE: Q.C. Inspector	DATE:

POTENTIAL VIOLATIONS		
ACTIONS REQUIRED		
ACTIONS REQUIRED		
REFERENCES		

NAME

DATE

PREPARED BY

REVIEW OF SITE PROCEDURE ENASCO SERVICES INCORPORATED NATERFORD STEAM ELECTRIC STATION - UNIT NO. 3

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Tot	Project SuperIntendent	Construction !	Superintemlant,	Benlor	Resident	Englacor,
	ester upolicy eronome	Williat I and/o	t Othern			

Pleane review the attached copy of Procedure No. PRIO.O Issue 12, and record your comments on this form: If there are no comments, this abduld be so noted. Comments are regulated by 11-3-82.

From Project Superintendent, Construction Buparintendent, Benler-Reoldent Engineer, Site Quality Program Ilunager, Senior Construction Accountant, or Other Melanie Gueffier - Mech-x48C

		Reviewers W. Fills Dates 4/3/82	Prep	ntert	Datel	nevleu-	iri
Page	far.	Comments		Reject	Renson	Accept	Nejec
		NONE					
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