

PLACE: Area H-1, SC

DATE/TIME: Dec 14, 1983

I, Robert Dean Bentley, do hereby make the following voluntary statement to James J. Vorse who has identified himself to me as an Investigator with the United States Nuclear Regulatory Commission. I do hereby make this voluntary statement without any threats having been made against me or any promises extended to me.

I am currently a senior inspector for Duke Power Company at the Catawba Nuclear Project in Cherokee SC. I have been inspecting for approximately 5 1/2 years. Before that I inspected welds for approximately 1 1/2 years, 1976-1977. Before then I worked for Daniels Construction Company. Many of the QC welding inspectors concerns were brought to light in the summer of 1981 when our wages were cut. The then corporate QC manager, Mr. Mills, informed me, during a discussion, that I was too qualified to be an inspector, that they did not need people like me in that position. This was after I explained to him the depth of knowledge required to know all of the procedures we worked with daily. From our discussion, I got the impression Duke would rather just hire people off the street and train them ^{RDB} procedures but would have no in-depth knowledge. Therefore, these people could be programmed to do exactly what they ^{(DUKE) RDB} wanted them to do, in my opinion. The inspectors wrote letters to Bill Lee ^{RDB} protesting the wage cuts expressing their concerns about QC inspection deterioration. This was after we were informed that we had recourse if we could not get satisfaction from our immediate supervisor. Bo Ross who was then my immediate supervisor (foreman) encouraged us to do this. After the letters were sent, a task force was formed. In my ^{RDB} opinion, the task force provided no service because nothing changed. Some of the problems which I addressed in my letter were a lack of communications, lack of support from management on our decision making in the field, insufficient visual inspection background of Bo Ross's supervisor, Charles Baldwin who was proficient in and had a ^{RDB} ~~working knowledge~~ ^{of} ~~formal~~ ^{RDB} NDE inspections. Baldwin also seemed to be influenced by production scheduling and lacked an understanding of visual inspections and the accompanying procedures. Regarding some procedures violations, Duke's position has been that QA officer the code and QC procedures are more

D-72

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PDR FOIA
BELL84-722

Dean Bentley

in depth, providing a greater margin of safety. However, if a QC violation is identified the QA manual is used to override the QC procedure because the code applies. The QC inspector then loses credibility with the craft because he is made out to look like he does not know what he is doing. The only time I have felt harassed was when Larry Davisson ^{RDB} told us that we were not to go to the NRC without going through the Duke Channel of command first. I got the impression I would be fired for going directly to the NRC. I have never received any threats from the craft with the exception of one time in 1979 or 1980 when I rejected a weld in the welder said words to the effect "you don't want me to have to jump on you". I told him to let his conscience be his guide and he walked off. I have had no other instances. I have never been threatened to accept a weld that I had rejected.

RDB

I have read the foregoing statement consisting of 2 handwritten/typed ^{p's} pages. I have made and initialed any necessary corrections and have signed my name in ink in the margin of each page. I swear that the foregoing statement is true and correct. Signed on 12-14-83 at 9:00 PM.

SIGNATURE:

Dean Bentley
NAME

Subscribed and sworn to before me this 14th December day of December, 1983 at Rick Hill SC.

INVESTIGATOR:

Jan Y. Van

WITNESS:

NAME/TITLE

MEMORANDUM TO CASE FILE

TYPE ACTION () RECORD OF CONVERSATION () CASE REVIEW / STATUS () OTHER	PARTICIPANTS	FILE NO.
		DATE
		TIME
	CONFIDENTIALITY REQUESTED YES NO	

SUMMARY

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MEMORANDUM TO CASE FILE

SUMMARY

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MEMORANDUM TO CASE FILE

SUMMARY

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MEMORANDUM TO CASE FILE

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THE BIGGEST CONCERN THAT I HAVE AS FAR AS NOT BEING SUPPORTED IN IMPLEMENTING THE QA PROGRAM IS THE FACT THAT AT TIMES RESOLUTIONS AND GENERAL GRAY AREAS HAVE BEEN WATERED DOWN IN ORDER FOR CRAFT TO MEET SCHEDULING DEAD LINES. A LOT OF THESE OCCASIONS HAVE BEEN EXACTLY OPPOSITE OF PROCEDURE REQUIREMENTS, YET THE PROBLEMS BEING BROUGHT UP WERE TO BE IGNORED, BECAUSE AT THIS POINT QUALITY DIDN'T MATTER ONLY DEAD LINES.

SOME EXAMPLES OF THESE PROBLEMS EXIST ON THE ENTIRE FW SYSTEM IN THE AUXILIARY BUILDING ON THE NUMBER ONE SIDE.

A NUMBER OF THESE WELDS HAD TO BE RE-INSPECTED BECAUSE OF AN NCI CONCERNING VIEWING PORTS. UP UNTIL THIS TIME WE (Q.C. INSPECTORS IN THIS AREA) ~~RE~~ DID NOT HAVE ANY MAJOR PROBLEM ASSURING THAT THE WELDING PROCEDURES AND GUIDELINES OF THE F.W.D.S.'S WERE FOLLOWED.

ON ONE PARTICULAR WELD REPAIR THE MISMATCH WAS $> \frac{1}{8}$ ". ON PREVIOUS OCCASIONS WHERE THE JOINT MISALIGNMENT WAS NOT IN ACCORDANCE WITH THE F.W.D.S. THE WELDERS AND/OR FITTERS WOULD WORK WITH THE PROBLEM UNTIL IT MET THE REQUIREMENTS OF THE F.W.D.S. BUT ON THIS OCCASSION, BECAUSE THE WELDING CRAFT WAS ISSUED A SHUTDOWN TO DO THIS AND THEY WEREN'T GOING TO MEET THE DEADLINE, WE WERE TOLD THAT MISALIGNMENT



WAS OF NO CONCERN IN WELD REPAIRS.
ANYONE KNOWS THAT THE ALIGNMENT OF
THE JOINT IS ESSENTIAL TO MAKING A
QUALITY WELD.

ALSO ON ALL OF THESE WELD REPAIRS
ON THIS FW SYSTEM M-24 (INTERNAL
CLEANLINESS) REQUIREMENTS WERE WAIVED
WITH AN F-9B. THIS BLUNDER MADE IT
ALMOST IMPOSSIBLE TO MAKE THESE REPAIRS
BECAUSE THE SYSTEM STILL CONTAINED
WATER (WHICH PREVENTED A COMPLETE PURGE
ON THIS S.S. SYSTEM), ALSO THE GRINDING
DUST & TRASH WAS STILL PRESENT.

IN EFFECT WHEN WE CHECKED THESE
REPAIR FOR WELDING ALL WE WERE LOOKING
FOR WAS TO SEE IF THEY HAD GROUND A HOLE
IN THE LINE TO WELD - UP.

WE ARE NEVER SUPPORTED IN OUR
DAILY ROUTINE INSPECTIONS. WHEN WE
MAKE MISTAKES WE ARE READILY BLAMED
AND CORRECTED. YET WHEN PROCEDURES AND
SPECS. ARE VIOLATED THE RULES ARE
BENT TO MATCH.

John R. McLoey



Dev./Station

Subject

Sheet No.

Field No.

attached in comparison of ASME S'72
VS ASME W'81 with regard to surface
Flaws. S'72 does not mention repair
of plate (just forgings) (NE-2500). Section
on localized thin areas did apply
to shells and heads. Now applies
only to shells.

JMM

NE-2121.5 Minimum Thickness of Materials.

(a) Mill Undertolerance. Plate material shall be ordered not thinner than the design thickness. Vessels made of plate furnished with an undertolerance of not more than the smaller value of 0.01 in. or 6 percent of the ordered thickness may be used at the full design pressure for the thickness ordered. If the specification to which the plate is ordered allows a greater undertolerance, the ordered thickness of the material shall be sufficiently greater than the design thickness so that the thickness of the material furnished is not more than the smaller of 0.01 in. or 6 percent under the design thickness.

(b) Pipe Undertolerance. If pipe or tube is ordered by its nominal wall thickness, the manufacturing undertolerance on wall thickness shall be taken into account. The next heavier commercial wall thickness may then be used. The manufacturing undertolerances are given in the several pipe and tube specifications listed in the applicable tables in Appendix I. After the minimum wall thickness is determined, it shall be increased by an amount sufficient to provide the manufacturing undertolerance allowed in the pipe or tube specification.

NE-2124 Size Ranges

Materials outside the limits of size or thickness given in any specification in Section II of this Code may be used if the material is in compliance with the other requirements of the specification and no size limitation is given in this Subsection. In those specifications in which chemical composition, and/or mechanical properties are indicated to vary with size or thickness, any material outside the specification range shall be required to conform to the composition and mechanical properties shown for the nearest specified range.

NE-2124 Material Size Ranges and Tolerances

(a) Material outside the limits of size or thickness given in any specification in Section II may be used if the material is in compliance with the other requirements of the specification and no size limitation is given in this Subsection. In those specifications in which chemical composition or mechanical properties are indicated to vary with size or thickness, any material outside the specification range shall be required to conform to the composition and mechanical properties shown for the nearest specified range [NCA-3866.6(a)(1)].

(b) Plate material shall be ordered not thinner than the design thickness. Vessels, except for piping, made of plate furnished with an undertolerance of not more than the lesser value of 0.01 in. (0.25 mm) or 6% of the ordered thickness may be used at the full design pressure for the thickness ordered. If the specification to which the plate is ordered allows a greater undertolerance, the ordered thickness of the material shall be sufficiently greater than the design thickness so that the thickness of the material furnished is not more than the lesser of 0.01 in. (0.25 mm) or 6% under the design thickness.

(c) If pipe or tube is ordered by its nominal wall thickness, the manufacturing undertolerance on wall thickness shall be taken into account. The manufacturing undertolerances are given in the several pipe and tube specifications listed in the applicable Tables in Appendix I. After the minimum wall thickness is determined, it shall be increased by an amount sufficient to provide for the manufacturing undertolerance allowed in the pipe or tube specification.

Virtually identical

S'72

ASME

W'81

ASME

D-76

Dev./Subj.

Subject

Sheet No.

5 '72

Date

W '81

No.

Date

No.

NE-2500 MATERIALS REPAIRS

NE-2510 GENERAL REQUIREMENTS

Defects in material may be repaired provided approval of the Inspector is first obtained for the method and extent of repairs (see NE-4621.1). Defective material that cannot be satisfactorily repaired shall be rejected.

NE-2540 REPAIR OF DEFECTS IN FORGINGS

NE-2548 Elimination of Defects

(a) Surface imperfections such as chip marks, blemishes or other irregularities shall be removed by grinding or machining and the surface exposed shall be blended smoothly into the adjacent area where sufficient wall thickness permits thin areas in compliance with the requirements of NE-4223. (thin areas)

(b) Thinning to remove defects beyond those permitted in NE-4223 may be repaired by welding, only after approval by the Inspector.

NE-2549 Repair by Welding

NE-2500 EXAMINATION AND REPAIR OF PRESSURE RETAINING MATERIAL

NE-2510 PRESSURE RETAINING MATERIAL

Pressure retaining material shall be examined and repaired in accordance with the material specification and as otherwise required by this Subarticle.

NE-2530 EXAMINATION AND REPAIR OF PLATE

NE-2531 Required Examination

Plates shall be examined in accordance with the requirements of the material specification.

NE-2537 Time of Examination

Acceptance examinations shall be performed at the time of manufacture as required in (a), (b), and (c) below.

(a) Examinations required by the material specification shall be performed at the time of manufacture as specified in the material specification.

(b) Radiographic examination of repair welds, when required, may be performed prior to any required postweld heat treatment.

(c) Magnetic particle or liquid penetrant examination of repair welds shall be performed after any required postweld heat treatment, except for P-No. 1 material which may be examined before or after any required postweld heat treatment.

NE-2538 Elimination of Surface Defects

(a) Unacceptable surface defects may be removed by grinding or machining provided the requirements of (1) and (2) below are met:

(1) the remaining thickness of the section is not reduced below the minimum required by the design;

(2) the depression, after defect elimination, is blended uniformly into the surrounding surface.

(b) When the elimination of the defect reduces the thickness of the section below the minimum required by NE-3000, the material shall be repaired in accordance with NE-2539.

note for FORGINGS (NE-2540)
W'81 refers back to NE2538

Dev / Stat

Subject

S'72

Sheet No.

Unit

File No

W'81

Date

Test By

Date

NE-4130 ELIMINATION AND REPAIR OF DEFECTS

NE-4131 Rules Governing Elimination and Repair

Defects in materials which were accepted on delivery or which are discovered during the process of fabrication or installation may be eliminated or repaired by welding, provided the defects are removed, repaired and examined in accordance with the requirements of NE-2500 for the applicable product form, except that the limitation on the depth of repair does not apply.

NE-4130 REPAIR OF MATERIAL

W81

NE-4131 Elimination and Repair of Defects

W81

Material originally accepted on delivery in which defects exceeding the limits of NE-2500 are known or discovered during the process of fabrication or installation is unacceptable. The material may be used

37 provided the condition is corrected in accordance with the requirements of NE-2500 for the applicable product form, except: (1) the limitation on the depth of the weld repair does not apply; and (2) the time of examination of the weld repairs to weld edge preparations shall be in accordance with NE-5130.

W'81
more emphatic

Dev./St.

Subject

Sheet

S'72

NE-4220 FORMING TOLERANCES

NE-4221 Tolerance for Vessel Shells

NE-4221.1 Maximum Difference in Cross-Sectional Diameters.

NE-4221.2 Maximum Deviation from True Theoretical Form

NE-4221.3 Deviations from Tolerances.

NE-4221.4 Tolerance Deviations for Vessel Parts Fabricated from Pipe.

NE-4222 Tolerances for Formed Vessel Heads

The tolerance for formed vessel heads shall be as set forth in the following subparagraphs.

NE-4222.1 Deviation for Specified Shape.

(a) The inner surface of a head shall not deviate from the specified shape by more than 1 1/4 percent of the inside diameter of the head skirt. Such deviations shall not be abrupt changes, shall be outside of the design shape and shall be measured perpendicular to the specified shape.

(b) The skirts of heads shall be sufficiently true to round so that the difference between the maximum and minimum diameters shall not exceed 1 percent of the nominal diameter (see Fig. NE-4221.1-1).

NE-4222.2 Tolerance on Forged Heads. Forged heads shall be as true as is practicable to make them to the shape shown on the design drawings. Any deviations therefrom shall merge smoothly into the general shape of the head and shall not evidence a decrease of strength for the sections as required by the formulas for design.

NE-4223 Localized Thin Areas

Localized thin areas are permitted if the adjacent areas surrounding each has sufficient thickness to provide the necessary reinforcement according to the rules for reinforcement in NE-3330.

applies to both

Dev./St.

W'81

NE-4220 FORMING TOLERANCES

NE-4221 Tolerance for Vessel Shells

NE-4221.1 Maximum Difference in Cross-Sectional Diameters.

NE-4221.2 Maximum Deviation From True Theoretical Form for External Pressure.

NE-4221.3 Deviations From Tolerances.

NE-4221.4 Tolerance Deviations for Vessel Parts Fabricated From Pipe.

NE-4221.5 Localized Thin Areas. Localized thin areas are permitted if the adjacent areas surrounding each has sufficient thickness to provide the necessary reinforcement according to the rules for reinforcement in NE-3330.

Applies to shells

NE-4222 Tolerances for Formed Vessel Heads

The tolerance for formed vessel heads shall be as set forth in the following subparagraphs.

NE-4222.1 Maximum Difference in Cross-Sectional Diameters. The skirt or cylindrical end of a formed head shall be circular to the extent that the difference in inches between the maximum and minimum diameters does not exceed the lesser of $(D + 50)/200$ or $(D + 10)/100$, where D is the nominal inside diameter in inches and shall match the cylindrical edge of the adjoining part within the alignment tolerance specified in NE-4232.

NE-4222.2 Deviation From Specified Shape

no mention of thin areas in formed heads

W'81

April 23, 1982

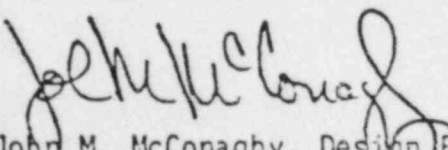
Memo To File

Re: Catawba Nuclear Station, Units 1 & 2
Steel Containment Vessel Dome Pitting, Unit 2
NCI 9092
File No: CN-1144.13

On April 23, 1982, I received a call from Mr. Jim West, Quality Assurance Manager at Newport News Industrial Corporation. NNI's technical staff has reviewed photographs of the surface conditions observed on the dome plate, and Mr. West wanted to advise us of what they believe is the source of these conditions.

Mr. Jerry Cobb, a metallurgist for NNI stated that they have experienced similar surface conditions as a result of exposure of plate to the environment. Near the Chesapeake Bay, where the atmosphere is considerably more brackish than this area, up to 25 mils of corrosion pitting can be experienced in one year. These conditions are aggravated by standing water on the plate. Localized effects are generated by dirt spots on the surface allowing the formation of oxygen pockets which accelerate the effect. NNI does not believe that this would be caused by inclusions, since these would be more elongated and indicative of rolling directions. Mill scale would probably not be the source of these problems, but the presence of scale could accelerate formation of localized oxygen pockets. In summary, NNI does not believe the conditions existed when the plate left NNI, since an inspector would have to be totally negligent to miss the conditions.

Mr. Cobb stated that if the plate were sandblasted to white metal prior to coating, the condition would be stable.


John M. McConaghy, Design Engineer I
Civil/Environmental Division

JMM/ks

xc: I. W. Pearce
D. E. DeMart

MEMORANDUM

DATE 4-29-82

FILE 10

ADDRESS _____

FROM JMM McCONAGHY

SUBJECT Reportability - NCI 9092

Ref: 10CFR 50.55 (e)

Conditions, if uncorrected, must have been capable of adversely affecting safety of operation at any time in the plant lifetime and represent:

- a) breakdown in QA Program - Does not apply - Based upon findings of metallurgists at NNI, conditions were probably brought about by exposure to environment and did not exist when received at site. Conditions were discovered during subsequent regularly scheduled inspection in preparation for erection. Therefore, no breakdown in QA present.
- b) deficiency in design: N/A
- c) significant deficiency in construction or significant damage to structure, system or component which requires extensive evaluation, redesign or repair to meet criteria and bases of SAR -
Thickness of plate is required for external pressure to preclude buckling of dome. No available evidence suggests that very small localized thin areas would adversely affect buckling strength of SCV. Repairs of plate are being made to insure that localized thin areas are properly reinforced as required by the arbitrary ASME code requirements.

CONCLUSION: Not Reportable

JMM 4-29-82

Amid recently discovered NRC documents showing Duke Power Company quality assurance employee complaints of harassment, orders to falsify records and a "Duke whitewash", Palmetto Alliance and Carolina Environmental Study Group have gained the assistance of the Government Accountability Project in their challenge to the Catawba Nuclear Station operating license.

GAP is a Washington, D. C. based organization which monitors government and industry practice through the use of whistle blowers - workers who expose fraud, waste and improper practices. GAP has helped expose widespread quality control problems at the Zimmer nuclear plant in Ohio, where the NRC has halted construction. Mr. Billie Garde, GAP staff investigator, will be present at the April 21 press conference. GAP agreed to assist in investigation and monitoring of the QA-QC programs at Catawba based on evidence of serious, systematic and widespread problems at the plant and indications that NRC efforts in correcting the problem have been ineffective.

In the NRC licensing case, ... based on information provided by two former Catawba workers - including a Q/C inspector - Palmetto Alliance charged that company pressure on inspectors to approve faulty workmanship and subvert the NRC required Q/A program produced systematic deficiencies in plant construction...

~~Riskening preparation~~

During prehearing preparation, Palmetto Alliance found Q/A-Q/C problems had caused Duke Power Company to conduct its own investigation from December, 1981 to March, 1982.

Recently released documents show that Q/C inspectors had complained as early as February 1, 1982, to the NRC that Duke Power Company would attempt to "whitewash" investigation that the QC personnel had been "harassed on the job" and that they had been "told to falsify records".

D-77

A15

*Added to RC by J. Brown, Charlotte Observer
3:00 p.m. (EST) 4/22*

Group Alleges Duke Records 'Falsified' At Nuclear Plant

By JACK HURAN

Observer and writer

An S.C. group fighting the Catawba nuclear plant will charge today that federal records show Duke Power Co. told workers to falsify records during an internal investigation of welding inspection at the plant.

Further, the Palmetto Alliance said in a press release made public Wednesday that the documents show Duke quality control inspec-

tors were "harassed on the job" and Duke "would attempt to whitewash" the investigation. The group said the charges by Duke employees date to February 1983.

Catawba is under construction 18 miles southwest of Charlotte in York County, S.C. About 3,000 people work at the site.

A Duke spokeswoman rejected the charges, contending the company's internal investigation of

welding inspection complaints at Catawba in 1981-82 found no faulty workmanship but did recommend changes in procedures. The investigation was triggered by employee complaints.

"Absolutely not," said spokeswoman Mary Cartwright when asked if Duke told workers to falsify records. She added, "There's been absolutely no recourse against the employees involved."

But The Observer learned

Wednesday a Nuclear Regulatory Commission (NRC) inquiry into the charges disclosed Duke supervisors did require some welding inspectors to approve welds they didn't think should pass inspection.

"However, they did so at the direction of a supervisor who had made an honest judgment that the item was acceptable," wrote NRC Inspector P.K. Van Dorn in a memo Feb. 15. "Duke Power Co.

has now implemented policy preventing someone signing for an item which he/she does not agree is acceptable."

Van Dorn, who is stationed at Catawba, interviewed nine supervisors and 18 welding inspectors and concluded "harassment is not a legitimate concern at Catawba.... My recommendation we consider the case closed."

Ken Clark of the NRC's Atlanta See GROUP Page 7A

Group To Accuse Duke In Nuclear Plant Records

Continued From Page 1A

ance director, said the NRC "didn't do much if anything about the worker complaints of harassment and harassment."

The groups plan to hold an 11 a.m. press conference in Charlotte to reveal NRC documents they say will support their charges. They will also announce that an organization that aids government and industry while blowing the whistle has joined their fight.

The eight-year-old, Washington-based accountability project forced the NRC to reopen its inquiry into construction problems at the Zimmer nuclear plant in Ohio. Last November, the NRC ordered work on the plant halted pending a federal safety review.

Regional office said the Catawba case is closed and NRC policy is not to reveal the names of people who complain against a utility.

"We have thoroughly reviewed Duke's investigation of these allegations and we conclude it was a sound investigation and we do not believe there are any major quality assurance or quality control problems at Catawba. We do not believe there was a whitewash."

The Palmetto Alliance and the Charlotte-based Carolina Environmental Study Group contend there are "serious systematic and widespread problems at the plant" and "NRC efforts in correcting the problems have been ineffective."

Michael Lowe, Palmetto Alliance

REGIONAL ADMINISTRATOR
DEPUTY ADMINISTRATOR
ASS'T TO ADMINISTRATOR
DIRECTOR, PRP
DIRECTOR, EOP
DIRECTOR, EPMSP
DIRECTOR, RMA

Observer
A.P. 21
Ken Clark - original
NRC

INDEX OF DOCUMENTS
CATAWBA NUCLEAR POWER PLANT
CASE NO. 2-83-039

I. Main Case File

A. Inside Front Cover

1. Region II, NRC letter dated October 21, 1983 requesting OI:RII investigative assistance regarding Catawba Nuclear Power Plant - 1 page
2. Completed Allegation Data Form, NRC Form 307 - 1 page
3. NRC Investigation Status Record, NRC Form 306 for Case No. 2-83-039 - 2 pages
4. Region II, NRC letter dated November 1, 1983 requesting OI:RII investigative assistance regarding Catawba Nuclear Power Plant - 1 page
5. Event Chronology Sheet for 2-83-039 (partially completed - one entry) - 1 page

B. Front Facing Divider

1. Region II, NRC letter dated October 31, 1983 providing additional information of interview conducted on 10/25/83 - 2 pages
2. Original draft Results of Interview provided by Region II undated - 10 pages
3. Corrected draft Results of Interview provided by Region II undated - 11 pages
4. Signed sworn statement provided by interviewee dated January 19, 1984 - 2 pages

C. Facing Back Divider

1. Copy of signed sworn statement provided by interviewee dated November 29, 1983 - 5 pages
2. Copy of signed sworn statement provided by interviewee dated November 30, 1983 - 6 pages
3. Copy of signed sworn statement provided by interviewee dated December 7, 1983 - 5 pages
4. Copy of signed sworn statement provided by interviewee dated December 7, 1983 - 5 pages

5. Copy of signed sworn statement provided by interviewee dated December 8, 1983 - 4 pages
6. Copy of signed sworn statement provided by interviewee dated December 13, 1983 - 5 pages
7. Copy of signed sworn statement provided by interviewee dated December 14, 1983 - 4 pages
8. Copy of signed sworn statement provided by interviewee dated December 14, 1983 - 2 pages
9. Draft copy of Results of Interview with information source dated December 15, 1983 - 7 pages
10. Copy of signed sworn statement provided by interviewee dated January 4, 1984 - 4 pages
11. Copy of signed sworn statement provided by interviewee dated January 5, 1984 - 7 pages
12. Copy of signed sworn statement provided by interviewee dated January 18, 1984 - 5 pages
13. Copy of signed sworn statement provided by interviewee dated January 19, 1984 - 5 pages
14. Draft Results of Interview with information source dated January 19, 1984 - 7 pages
15. Copy of sworn statement written for interviewee, undated and unsigned - 4 pages
16. Copy of signed sworn statement provided by interviewee dated January 26, 1984 - 4 pages

D. Inside Back Cover

Interview Notes in Draft or Rough Form

1. Rough interview notes of an information source dated November 28 and 29, 1983 - 5 pages
2. Rough interview notes of an information source dated November 30, 1983 - 6 pages
3. Rough interview notes of an information source dated December 1, 1983 - 6 pages
4. Rough interview notes of an information source dated December 6, 1983 - 6 pages
5. Rough interview notes of an information source dated December 7, 1983 - 4 pages

6. Rough interview notes of an information source dated December 9, 1983 - 6 pages
7. Rough interview notes of an information source dated December 14, 1983 - 4 pages
8. Rough interview notes of an information source dated December 14, 1983 - 3 pages
9. Rough interview notes of an information source dated December 15, 1983 - 8 pages
10. Rough interview notes of an information source dated January 3, 1984 - 4 pages
11. Rough interview notes of an information source dated January 4, 1984 - 8 pages
12. Rough interview notes of an information source dated January 17, 1984 - 4 pages
13. Rough interview notes of an information source dated January 18, 1984 - 6 pages
14. Rough interview notes of an information source dated January 19, 1984 - 8 pages
15. Rough interview notes of an information source dated January 24, 1984 - 6 pages
16. Rough interview notes of an information source dated January 25, 1984 - 5 pages
17. Rough interview notes of an information source dated January 26, 1984 - 7 pages

E. Auxiliary Folder #1

1. Memorandum from R.C. DeYoung to B. Hayes dated December 19, 1983 (1 page) with GAP letter to R.C. DeYoung dated December 2, 1983 (4 pages) with affidavits attached from three information sources (12 pages, 16 pages and 46 pages, respectively).
2. Memorandum from J. Lieberman to B. Hayes and G. H. Messenger dated January 13, 1984 (1 page) with letter to R. C. DeYoung from W. H. Owen, dated January 5, 1984 (2 pages) with attached DPC to GAP undated (53 pages).

INVESTIGATION STATUS RECORD

INSTRUCTIONS: This form is to be completed whenever significant activity has occurred relative to a case or at least every 30 days. If no change has occurred during the 30 day reporting period, indicate "No Change" in the status block. Keep the original with the case file and send one copy to Headquarters, Office of Investigations.

CASE NUMBER 2-83-038	CATEGORY		OFFICE OI Atlanta Field Office
	☐ D - OPERATING REACTOR	☐ I - INDIVIDUAL LICENSEE	
	☒ C - REACTOR UNDER CONSTRUCTION	☐ M - MATERIALS/FUEL	
	☐ V - VENDOR	☐ X - OTHER	
ASSIGNED TO E. L. Williamson		SUBJECT Possible Violation of Board Order; Lack of QA/QC Independence & Harassment/Intimidation of QC Inspectors	
STATUS (Specify date, and provide a brief description)			
10/31/83: General information was provided by an alleged regarding possible violation of a Board Order, Lack of QA/QC Independence and harassment/intimidation of QC welding inspectors at the Duke Power Company's Catawba Nuclear Power Plant. Field work will commence with interviews of some inspectors. This investigation is initiated by OI:HQ. EDC 01/15/84.			
11/7/83: Field work in progress.			
12/05/83 No Change			
01/03/84 No Change			
2/6/84 No Change			
3/3/84 No Change			
4/2/84 No Change			
4/28/84 Field work complete. Draft report in write-up.			
6/2/84 Final report in HQs for review.			
6/29/84 No Change			
7/28/84 Final report issued. Case closed			

D.80
E. I. A. S

ALLEGATION DATA FORM Instructions on reverse side

U.S. NUCLEAR REGULATORY COMMISSION

RECEIVING OFFICE

Docket Number (if applicable)

1. Facility(ies) Involved:

(If more than 3, or if generic, write GENERIC)

(Name)

Cummins

1	2	3	4	5	6	7	8	9	0

2. Functional Area(s) Involved:

(Check appropriate box(es))

☐
☒
☐
☐
☐

operations
construction
safeguards
other (Specify) _____

☐
☐
☐

onsite health and safety
offsite health and safety
emergency preparedness

3. Description:

(Limit to 100 characters)

S	S	1	S	1	+	1	U	S											

4. Source of Allegation:

(Check appropriate box)

☐
☐
☐
☐
☒

contractor employee
licensee employee
NRC employee
organization (Specify) _____
other (Specify) GHP

☐
☐
☐

security guard
news media
private citizen

5. Date Allegation Received:

MM	DD	YY
1	0	3
7	8	3

6. Name of Individual Receiving Allegation:

(First two initials and last name)

J. Y. Vorse

7. Office:

O	I	C	2
---	---	---	---

ACTION OFFICE

8. Action Office Contact:

(First two initials and last name)

9. FTS Telephone Number:

				-					
--	--	--	--	---	--	--	--	--	--

10. Status:

(Check one)

☐
☐

Open, if followup actions are pending or in progress
Closed, if followup actions are completed

11. Date Closed:

MM	DD	YY

12. Remarks:

(Limit to 50 characters)

13. Allegation Number:

Office	Year	-	A-	Number

D-81
IFC1

INVESTIGATION STATUS RECORD

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CASE NUMBER 2-83-038	CATEGORY				OFFICE OI Atlanta Field Office
	☐	O - OPERATING REACTOR	☐	I - INDIVIDUAL LICENSEE	
	☒	C - REACTOR UNDER CONSTRUCTION	☐	M - MATERIALS/FUEL	
	☐	V - VENDOR	☐	X - OTHER	
ASSIGNED TO E. L. Williamson					SUBJECT Possible Violation of Board Order; Lack of QA/QC Independence & Harassment/Intimidation of QC Inspectors
STATUS (Specify date, and provide a brief description)					
10/31/83: General information was provided by an alleged regarding possible violation of a Board Order, Lack of QA/QC Independence and harassment/intimidation of QC welding inspectors at the Duke Power Company's Catawba Nuclear Power Plant. Field work will commence with interviews of some inspectors. This investigation is initiated by OI:HQ. EDC 01/15/84.					
11/7/83: Field work in progress.					
12/05/83 No Change					
01/03/84 No Change					
2/6/84 No Change					
3/3/84 No Change					
4/2/84 No Change					
4/28/84 Field work complete. Draft report in write-up.					
6/2/84 Final report in HQs for review.					

D-82
1046
TFC 4

INVESTIGATION STATUS RECORD

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12/05/83 No Change					
01/03/84 No Change					
2/6/84 No Change					
3/3/84 No Change					
4/2/84 No Change					
4/28/84 Field work complete. Draft report in write-up.					
2 of 6					

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3016

INVESTIGATION STATUS RECORD

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CASE NUMBER 2-83-039	CATEGORY				OFFICE 01 Atlanta Field Office
	☐	D - OPERATING REACTOR	☐	I - INDIVIDUAL LICENSEE	
	☒	C - REACTOR UNDER CONSTRUCTION	☐	M - MATERIALS/FUEL	
	☐	V - VENDOR	☐	X - OTHER	
ASSIGNED TO E. L. Williamson					SUBJECT Alleged Cheating of QC Welding Inspectors Duke Power Company, Catawba Nuclear Plant

STATUS (Specify date, and provide a brief description)

10/28/83: Regional Administrator requested an investigation into allegations that an entire class of welding QC inspectors were provided copies and answers to examinations in 1977. EDC 03/15/84.

02/03/84: Interviews are being conducted in conjunction with Case No. 2-83-038.

2/6/84 No Change

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5016

INVESTIGATION STATUS RECORD

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CASE NUMBER 2-83-038	CATEGORY				OFFICE OI Atlanta Field Office
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ASSIGNED TO E. L. Williamson		SUBJECT Possible Violation of Board Order; Lack of QA/QC Independence & Harassment/Intimidation of QC Inspectors			

STATUS (Specify date, and provide a brief description)

10/31/83: General information was provided by an allegor regarding possible violation of a Board Order, Lack of QA/QC Independence and harassment/intimidation of QC welding inspectors at the Duke Power Company's Catawba Nuclear Power Plant. Field work will commence with interviews of some inspectors. This investigation is initiated by OI:HQA. EDC 01/15/84.

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CASE CHRONOLOGY

FILE NUMBER	DATE OPENED	OPENED BY
7-83-038		
DATE	ACTIVITY	
4-6-84	TC: Carr to Vorse	
4-9-84	TC: Williamson to Ross	
4-10-84	MTG: Williamson, Vorse + Ross	
4-11-84	TC: Williamson to Carr	
4-12-84	MTG: Williamson, Vorse, Carr, McGahey, Davison, Baldwin	
4-13-84	MTG: Williamson, Vorse, Carr, Hallen	
4-23-84	LHM: Transcripts of Baldwin/Davison received.	
4-24-84	LHM: TO URGC from Williamson	
4-25-84	TC: Williamson to Carr	
4-25-84	TC: Carr to Williamson	
4-26-84	LHM: Transcripts sent to DPL	
5-17-84	TC: Williamson to Vorse & Noeris	
5-24-84	LHM: Vorse to URGC -	

ACTIVITY CODES

L/M : LETTER OR MEMO

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REP : REPORT ISSUED

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D-83

1044
IFC 3

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CASE CHRONOLOGY

FILE NUMBER

2-83-038

DATE OPENED

10-28-83

OPENED BY

Vorse

DATE

ACTIVITY

1-16-84	MTG: Williamson & Urye
1-16-84	TC: Vorse to Fitzgerald
1-17-84	TC: Williamson to Crisp
1-18-84	TC: Williamson to E. Freeman
2-1-84	TC: B. Garde to Williamson
2-1-84	TC: Williamson to Vorse & John Sinclair (advise contact with GAP)
2-3-84	MEMO: Tom Urye to Hecht - re allegation
2-2-84	TC: Williamson to Phil Edwards
2-3-84	TC: Phil Edwards to Williamson
2-7-84	MTG: Williamson, Edward, Vorse
2-8-84	MTG: Williamson, Vorse, Eddie Wallace
2-9-84	MTG: Williamson, Vorse, Larry Jackson
2-9-84	MTG: Williamson, Vorse, Richard Jones
2-9-84	TC: Vorse to Ken Karamitak
2-15-84	MTG: Williamson & Jones
2-15-84	MTG: Williamson & Kirkland
2-21-84	MTG: Williamson, Vorse, Eddie Wallace
2-21-84	MTG: Williamson, Vorse & Ken Karamitak
2-22-84	MTG: Williamson, Vorse & Tom Bergardner
2-23-84	MTG: Williamson, Vorse & Ron Kirby (Oconee)
3-15-84	TC: Williamson to Gantt, Godfrey & Bergardner
3-20-84	MTG: Williamson, Vorse, Godfrey
3-21-84	MTG: Williamson, Vorse Gantt
3-21-84	MTG: Williamson, Vorse Bergardner
3-27-84	TC: Williamson & Gantt - (R2A #1's)
3-29-84	TC: Williamson to Ross & Godfrey
3-29-84	U/M: Vorse to Urye
3-30-84	TC: Vorse, Williamson to DeYoung
3-30-84	TC: DeYoung to Vorse
4-3-84	MTG: Williamson, Vorse & Ross
4-4-84	MTG: Williamson, Vorse & Al Carr
4-4-84	MTG: Williamson, Vorse & Ross

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204

CASE CHRONOLOGY

FILE NUMBER

2-83-038

DATE OPENED

Continued

OPENED BY

Continued

DATE	ACTIVITY
11-22-83	TC: Williamson to Allegre
11-23-83	TC: Williamson to Sinclair
11-23-83	MAIL: Garde to Williamson
11-28-83	MTG: Williamson, Vorse Allegre #1 1715-2215 Bryant
11-29-83	MTG: Williamson Vorse Allegre #1 1700-1900 Bryant
11-29-83	TC: Williamson to Allegre #2 Rockholt
11-30-83	MTG: Williamson, Vorse Allegre #2 Rockholt
12-1-83	MTG: Williamson, Vorse Allegre #2 Rockholt
12-1-83	MTG: Williamson, Vorse Allegre #3 Cranter
12-6-83	MTG: Williamson, Vorse Allegre #4 Brown Reep
12-7-83	MTG: Williamson Vorse Allegre #3 Cranter
12-7-83	MTG: Williamson, Vorse Allegre #5 Squire
12-8-83	MTG: Williamson Vorse Allegre #4 Brown Reep
12-8-83	MTG: Williamson Vorse Allegre #5 Squire
12-9-83	MTG: Williamson, Vorse Allegre #6 Buer
12-13-83	MTG: Williamson, Vorse Allegre #6 Buer
12-12-83	TC: Chagnoff , Williamson
12-12-83	TC: Williamson to Allegre #7 Eubanks
12-13-83	TC: Williamson to Allegre #8 Foster
12-14-83	TC: Allegre #9 to Williamson Bently
12-14-83	MTG: Williamson, Vorse, Allegre #7 & 9 Eubanks, Bently
12-15-83	MTG: Williamson, Vorse Allegre #8 Foster
12-28-83	TC: Williamson to Interviewee #10 Harris
12-29-83	TC: Williamson to Interviewee #11 Icky
1-3-84	MTG: Williamson Vorse and Interviewee #10 Harris
1-4-84	MTG: Williamson Vorse & Icky
1-5-84	MTG: Williamson, Vorse, Harris Icky
1-8-84	Limited Appearance Stmt- Billie D. Garde to ASLB
1-12-84	TC: Williamson to K. Davis
1-12-84	TC: Williamson to Ron Rickland

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CASE CHRONOLOGY

FILE NUMBER		DATE OPENED	OPENED BY
2-83-038		10-28-83	VORSE
DATE	ACTIVITY		
10-28-83	TC: Williamson & Vorse - Briefing		
10-31-83	TC: Williamson & Ward.		
10-31-83	TC: Williamson & Fortuna		
10-31-83	TC: Williamson & Ward		
10-31-83	TC: Garde + Williamson		
11-1-83	TC: Williamson to Sinclair		
11-1-83	TC: GARDE to Williamson		
11-1-83	TC: Williamson to Sinclair		
11-1-83	TC: Williamson to Ward.		
11-1-83	TC: Greenville Times to Williamson (ANN SIX)		
11-1-83	TC: Williamson to Ward.		
11-2-83	TC: Williamson to Garde		
11-2-83	TC: Williamson to Garde		
11-2-83	TC: Williamson to Garde		
11-3-83	MTG: Williamson, Garde, Sinclair, Ansell, Emily-		
11-4-83	MTG: Williamson, Garde, Sinclair - Sybil stat		
11-4-83	MTG: Williamson, Sinclair, Hayes, Fortuna, Ward.		
11-8-83	TC: Williamson to J. Sinclair		
11-8-83	TC: Williamson from Garde		
11-8-83	TC: Ron Gibson (DPC) to Williamson		
11-15-83	TC: Williamson, Vorse, Sinclair		
11-15-83	TC: Williamson to J. Bryant		
11-15-83	TC: Williamson to G. Ross		
11-15-83	TC: Williamson to Boueye		
11-15-83	TC: Williamson to B. Garde		
11-16-83	TC: Williamson to G. Ross		
11-16-83	TC: G. Charnoff to Vorse		
11-16-83	TC: Vorse to Fortuna		
11-18-83	TC: Charnoff to Vorse		
11-22-83	TC: Charnoff to Williamson		

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4014

Dear Mr. Morgan,

I am very satisfied with my job as a welding inspector at Duke Power's Catawba Nuclear station because of the job security, pleasant working companions, and good benefits, however I feel I have been slighted in the area of experience and pay. I would like to inquire how Duke's policy on starting pay is related to experience came about and is carried out.

The American Welding Society is a national and professional organization which is dedicated to the technical and quality aspects of all facets of welding. This organization recognizes a college degree and credits gained in the area of nondestructive testing as a substitute of years experience because they feel knowledge learned in these areas give an individual added insight and reasoning power into

the areas of welding inspection. Duke
Powers does not consider an education
or experience in other areas of welding
inspection towards experience as does
this professional organization of which
I am certified does.

I don't feel I should
be on top scale since I am not
fully oriented into Duke's Quality
Assurance program, but I do feel
my education and experience in all
areas of welding inspection warrant
a higher rating. I realize I agreed
to my present pay scale when I
was hired, but at that time
I felt there was nothing I could
do.

I may not know
the entire philosophy and intent of
this new program, and therefore
could be unjustly concerned, however
at this time I feel I have been
unadequately evaluated. Your investigation
into the matter and discussion with myself
would be deeply appreciated. Thanks,

erry Sanduck

Don
Tosh

My concern is
 being told by super
 management that the
 Q.A. Program would not
 change, then there's getting
 our instruction from
 Charlie that we have told that
 negative statement. To go back
 to Genl, could it say
 so direct. This is a false
 statement. Also we were told
 that our boy would not
 be cut, that we would
 get our money just like
 everyone else. This is not
 true. When boy-ety came
 at Charlie, we were told
 anyone getting boy-ety or taking
 a lay-off would lose nothing
 except the time he spent
 away from the company.

But at retire we
had to take less than
the 5% raise that the
other inspector received.

Thank You
Ransom Sims

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10/28/83: Regional Administrator requested an investigation into allegations that an entire class of welding QC inspectors were provided copies and answers to examinations in 1977. EDC 03/15/84.

02/03/84: Interviews are being conducted in conjunction with Case No. 2-83-038.

2/6/84 No Change

3/3/84 No Change

4/2/84 No Change

4/28/84 Field work complete. Draft report in write-up.

6/2/84 Draft report in write-up.

D-86

MEMORANDUM TO CASE FILE CONTINUATION SHEET

THE INFORMATION CONTAINED HEREIN
WAS PROVIDED AS PER FOIA 846 - 48

FILE NO.

DATE

TIME

PAGE OF

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D-87

Company No

Name

Last

First

Middle

SS NO

Date of Employment

Date of Birth

College

Degree

Date _____

Wife's Name

SALARY

[illegible]

D. 88

S.F.3

The department has really changed in the past year... We as inspectors don't have the support that we need.

In the five years that I've been in OC the program has really changed... when I first came to work for Data Resources in August 1975... This department was tops (OC) inspectors were treated with respect... I'm not asking to be put on a pedestal but given some respect!! We have a job to do but there's always things to prevent us from doing our job.

Since I've been an inspector, I've been in some real tight squeeze each Oct...

But they always have to upper hand on us. If we find a problem, it's a problem until it's resolved. Craft always puts us at the pinch. Why?

Our upper management tells us in our meetings, need to tighten up in some areas (integration time) example. We as inspectors do what we are told and we do it, if we can't go. And last comes tighten up... why?

We have guide lines on the job that we must go by. If we go by them it better, we some kind of job... why is this? I believe if a person does something that's not in guide lines and we as inspectors should have the support behind us to help us in every situation; if Craft violates a CI, it's a violation,



and it's not a problem, but I'm not sure. I've
told them to put up the inspection in the
morning, saying this has not been a problem in
the past... We talking about the present
not the past...

I've been treated on the job, because
I was doing my job... I was cursed on
the job for doing my job... I feel like
if you want me to do my job, I need
actual support from my upper management
when a situation like this happens... We
always need a witness, to make
a situation clear... I feel like if a
department can't trust its employees, we
get problems...

Example #1. Observed welding for an
welding on a class I weld... waited till
called for inspection of this weld.
Said "Quote" ask welder, where did you
foreman weld, are welded, right here... I
checked rod issue station to see if
foreman had checked any welding re-
out, did not, also checked pipe for
structural (welder). Did not put on pipe.
I wrote CP 49A. Resolution came
last, foreman was instructing welder
on how to make weld, he was holding
the hand! was not!

I was made to look like what
I said was false!

Why?

Larry D. Johnson

7. no concern with NCI

- verbal instructions were to follow criteria of CP-64 which does not apply in full to this problem
- const. tech. supp. welding (David Ladd) told that if Duke Power representative in New York Va. accepted the plates they were OK as far as he was concerned.

* Attachment 1. to NCI judged surface defects not to be significant — to my knowledge no one has ever visually inspected the plates besides Rick Lause (1-12-82 representative from Charlotte office)

Attachment 2. relates to engineering judgment based on prior experience and Duke Power QA surveillance of vendor supply. Minor or extremely small irregularities can go unnoticed and shipping damages & normal oxidation are factors to consider.

* Everyone writes something in response to NCI 9092 but does not address the specific problem.

- make decisions to correct the defects not may be questionable.
- all defect removal to sound metal & well fused conditions may be detrimental to plate as far as required thickness.
- procedure 1955 SP55 was issued only after NC1 was sent back for further evaluation.
- present surface conditions of some plates exceed the acceptable criterion shown in photographs in SP55.

Questions of Support

why did this issue have to be forced?

Why an over extended time frame (16 mos) with a questionable resolution 7-31-80 — 12-2-81 ?

Why so much correspondence & explanation & no one addresses the problem?

Why did the proper initiative in research & solution not be put forth at the introduction of NC1 9092

★ Why or how were all decisions made without some one in authority physically making an examination of the plate in question. (2)

... of water ...
still on the ground?

Knowing these questions cannot be answered but what
I want to point out is the

pass it around
write something about it
and say it is ok

attitude

This needs to be checked

In when it may concern.

My main concern with problems at Catemba are mostly covered in NCI's from Q16 I have written. Some of these problems have been properly evaluated by procedures used by Duke Power Company. Also some resolutions of these NCI's are written with Craft Personnel saying that they followed the correct steps, although it is the Welding Inspector that is checking and signing the materials and paperwork are followed correctly by procedure. If procedures and process controls are used correctly the Welding Inspector would not write NCI's.

As my job requires me to follow procedures and instructions from my supervisor, I have been threatened for following ^(then) my supervisor.

This was brought to the attention of my supervisor and also his supervisor. It was the third time before Craft supervision heard of the instances. On the second time I had a problem, my supervisor told me to handle this situation and try to work the problems out and if any more instances came up there would be immediate action taken. Another problem arose but no action was taken. Support is needed in the QH Department at Catemba if procedures are going to be followed without being Construction violated.

On inspection of that stick frame on 10-12, problems were brought to the attention of supervision on numerous occasions & the frame was checked by at least 4 Welding Inspectors. The welds were not uniform and had many defects. A few welds were checked over 20 times but when craft began being rushed to complete by supervision, we began getting pressured to sign the work off.

X V ② M & I inspections are being made with uncontrolled copies of schematic drawings. If these drawings are uncontrolled, how can the M & I be valid?

V ③ On inspection of 8 separate M-18's, there were about 15 welds not completed on 1 M-18. I had re-inspected all of these areas, although 1 M-18 was not complete because of the 15 or so welds. During the time of checking these M-18's, there was a rush to complete these areas. I was told by my supervisor to check to see if the welds had been completed to different times. Every time I went to check, the craft had not completed the work. At the meantime I was out sick with the flu for 5 days. When I returned to work I had a note in my box to check with Civil and sign the M-18's off. This note gave me the impression the work was completed while I was out sick. When I went to check with Civil, I found that the Civil Inspector was out sick with the flu. The inspector that was taking over for him gave me the M-18's and I signed them complete. I later went to the area of the

M-18's and the craft were working in the same area of the M-18A's signed off. I brought this to the attention of my supervisor that they were welding in the area where the M-18's were signed off. He told me they were probably working on something new. The next week the welding craft began work on the welds that were not complete. The inspector in the area knew I had completed the M-18A's and it was brought to the attention of our supervisor. I was given an A violation for signing the work off that was not complete. (falsifying documents) ||
My supervisor tried to explain the problem but he did not get any support from his supervisor. This kind of support has been long needed from our supervisor to give the welding inspectors complete confidence. There is not a welding inspector on the Columbia Project that is not willingly and ready to explain any problem or problems he or she or the QA Department has. The welding inspectors are confident and truthful in every job we hold.

Thanks for your time,
Lindsey Henry Harris Jr.
Welding Inspector QA

To Whom it may concern:

M-1
During A Routine inspection
ON A Hanger, A clear cut violation
was found. The welder involved did
NOT clean the surface FREE OF paint
As Required By the process specification.
The paint was within $\frac{1}{8}$ " of the joint.
Procedure L-300, paragraph 5.2.2. specif-
ically states; that, All surfaces up
to $\frac{1}{2}$ " on each side of the joint
shall be free from paint marking,
clayon or ink, alkaline cleaner, residue,
etc. This particular incident was non-
conforming and brought to the attention
of Charles Baldwin. At this time I
was questioned as to the importance
of this non conforming item. I was
then instructed to disregard the
Q-1A and instruct craft to clean
the paint back from the joint as
required by the process specification.

This particular case not only
involves me but the entire group
of welding inspectors. What we
have is a lack of support from

upper management. What happens
when this violation occurs again?
Do we initiate another QIA? Do
we instruct CRAFT to clean the
material per process specification
EVEN IF IT HAS ALREADY BEEN VIOLATED?
OR" Do we just look over the
situation because upper management
felt as if it was insignificant.

We all strive to do the
best job that we possible can.
But it becomes very difficult when
you have no support, excluding
Brian Ross

Thank You
Richard Allen Jones

Would never eventually cut out -
felt that I need technical concern because
of the pay issue. gdr

I AM concerned about support the Q.C.
department has at Catawba Nuclear station.
How come Q.A. department does not
recognize what QA. procedures say about
NCI's. It says that NCI's will be
written, then it will receive a serial number
if valid. If not valid it will be
Kept on file. If they won't let us
write certain NCI's on violates of Q.A.
procedures, who will know whether it is valid or
not. I have had problem getting NCI's
signed by upper management because they
say it is not a problem. Our technical
support group should determine whether
it is a problem or not. [One particular
case was when I was called for a final
visual inspection on miscellaneous steel
that was safety related. The weld was
O.K. but there was no traceability on the
steel. I was told by management not to
NCI it because craft said it was the
correct material. This is a direct violation
of Q.A. procedures. I also would like
to know why in some situations we have to
have witness to get something proved

to upper management or construction, We should not have to have witness — to get something proved. If the company does not have any faith in what we say, they should get rid of all of us. Why does our Foreman and general Foreman tell us to tighten up on certain inspection. Then a week later come back and say slack of boys you are finding too much wrong. Or they tell us one week to write Q.I.A's on certain items and then a week later tell us to stop writing Q.I.A's because it is looking bad on construction. If ~~these~~ ^{these} people are not going to go by Q.A. procedures they should get rid of them. I think the management in Q.A. department is affected a great ^{deal} by construction department. Because if construction has a dead line on something they will get it on line one way or the other. I think the Q.A. department has a bad outlook because the upper management in Q.A. won't let the inspectors do their job right. They let us do just what they want us to do. They say our job is not as important today as it was yesterday. Yet — we get more procedures put on us every day. We have a lot more Construction procedures today than I had a year ago.

Noted

I Feel there is A lack of interest or support From the QA Tech. group on NCI's. The EVALUATION, JUSTIFICATION, ACTION AND IMPROVEMENT requirements do NOT follow the problem as stated in some NCI's but these NCI's get QA approval. My concern is IT my responsibility To Give in these resolutions or To Accept them with a regard To the Answer.

As To support From Supervision it is there, I can make decisions on problems. I may NOT Fully understand the decision but Accept it As his experience is much greater than mine. AND I do have the chance To express myself if I disagree.

I do Feel like the major issue is communication on all levels of QA and QC. A lot of problems are NOT properly Addressed or Answered. I feel like more STAFF meetings on all levels would greatly reduce the problem.

B. Danton

This report is designed to point-out and, hopefully, to stop and correct discrepancies against the Quality Control Inspectors and the Duke Power Quality Assurance Program. This report is divided into two categories; the first is my general concerns of instances that have occurred that affect the integrity of all welding inspectors and the effectiveness of the QA program; the second category is comprised of specific occurrences that factually back-up my general statements.

As a concerned Duke Power employee, I feel that now is the time to point-out and prevent the recurrence of these problems which are deteriorating the QA/QC program and to correct those occurrences that are questionable or does not follow the QA procedures before they become an embarrassment and/or a set-back to the Duke Power Company.

Generals :

Upper management does not seem to want welding inspectors with our skilled qualifications, based on the statement made by Mr. Wells and Mrs. Gaddis to a few of my fellow inspectors, which is that the present inspectors are over-qualified and that people off the street could be hired to do our jobs.

In a meeting with L.R.D., on 1-7-82, he insinuated, that if I did not trust him, that I should find another job, after being unable

or unwilling to justify or correct decisions he made that are not in coherence with the QA procedures or design drawing requirements.

QC welding has been instructed by L.R.D. & C.R.B., that the directions given on a Q-IA resolution are of no concern to them. (It has been noted, by QC that many Q-IA resolutions do not address the stated problem or resolve the problem within the intent of our QA program.

L.R.D. & C.R.B. have stated that it is part of their jobs to make decisions and judgements, although their decisions may be questionable in accordance with QA procedures. When they do give verbal directions they do not always want to accept the responsibility for them.

example:

L.R.D. notified the QC welding inspectors, at one time, that they were over-inspecting misc. steel welds because they were holding the craft to close to design and QA procedures. If the welds were close to the requirements, they should be accepted. But, when the NRC came and found discrepancies, such as, weld lengths too short (approx. $\frac{1}{4}$ ") and weld sizes slightly under (approx. $\frac{1}{32}$ "), L.R.D. tried to place the full responsibility upon the inspectors and issue "A" violations to them.

Threats made to welding inspectors, by craft, while performing their assigned duties have not been properly handled by upper management to protect their people from future incidents. Action taken by our upper-

and words spoken by our upper management led the welding inspectors to believe that their upper management supports the craft and questions their own integrity. I believe this attitude stems from construction influence on our upper management.

examples:

(1) Welder, Howard Beard, threatened to push me off a scaffold after rejecting his weld in accordance with QA procedure L80. When this occurrence was reported to L.R.D., his reply was that encounters with angered craftsmen are a part of my job, and that I should handle the situation in a professional manner. He also reminded me that craft has come to him on many occasions, complaining about me. I have found that nearly all of craft's complaints about myself, stem from me having them to adhere closely to the QA program, and they come to L.R.D. in hope that he will have me be more liberal in my job.

(2) Craft foreman, Mike Brazell, cursed me for turning an ASME fit-up down in accordance with QA procedures M-4 + H-4 (^{wrong} BR # recorded). This occurrence was reported to L.R.D., but no knowledgeable action was taken by him.

(3) A general foreman told me, if it was the last thing he done, he would see to it that I would be removed from the Aux bldg.

In initiating Q-IAs, welding inspectors have been directed, that they must allow C.R.B. to review Q-IAs prior to securing a serial number for them.

I do not feel that this direction is in accordance with the intent of QA procedure - Q-1, pg. 2, rev. B, para. 5-B. Procedure Q-1 requires that all Q-IAs, initiated, to receive a serial number, although they still may be voided. L.R.D. and C.R.B. have not been following these QA requirements, for after reviewing a Q-IA, and they do not feel it should have been initiated, they discard the Q-IA without a serial number. Q-1, pg. 3, rev. 8, para. 5.1.4

The welding inspectors have been instructed not to give directions to craft, period. However, the directions that have been given to craft, are not those directions that would commit an inspector to accept something that is not correct, but directions that improve craft/QC communications, increase productivity, and saves Duke Power countless thousands of dollars each day - that goes unmentioned or recognized. It takes the caliber of inspector that you have now to be able to do this and I feel that are a few people in upper-management who recognize this, but does not want to give the inspectors recognition because the inspector has accomplished something good for the company, that they were unable to do or take credit for.

Additional responsibilities continue to be placed on the welding inspectors, such as 201-Bs. _____ ?

So far, Jim Wells, Larry Davison, Bob Morgan, or Charles Baldwin, have been unable to give justification for their decisions that were made outside the QA program guidelines and those for decisions that show no support for their welding inspectors.

and for the LK program

12
2

Also, Jim Wells has asked me, "to put aside my specific discrepancy issues, to wipe the slate clean, and to start anew." 1-8-82

Specifics:

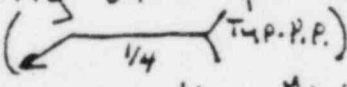
Item - NCI 6918:

Plan
Text
Harry Dawson, before reluctantly signing the Q-1A, suggested that I was over-inspecting the cracks in the welds by using a 5x magnifying lens and that cracks that could not be seen with the eye alone, were, in his opinion, insignificant. (Construction influence - L80 requirement)

Item - Q-1A discarded without a serial number:

D-3
A Q-1A was presented to L.R.D. for review and processing, involving welding with paint and foreign contaminants in the weld zone and the visual appearance of the root pass. Q-1A was not serialized or processed. L.R.D.'s explanation was that only a partial pene. weld is required and since a full penetration has been acquired, there is no problem.

Item - NCI 7514

D-4
L.R.D. would not accept NCI concerning the validity and clarity of a partial penetration welding symbol () although I was able to show him in the AWS Code Book, pg. 39 para. 9.2.3 that this was not an acceptable symbol for use. After Beau Riss approached him on this issue he rewrote the Q-1A and had me to sign it.

Specifics :

Item - Q-1A discarded - violation of H-5/CP23 ^(Revised bldg 1986)
L.R.D. was approached with a Q-1A, concerning a final visual on misc steel I made where the material was not identified in accordance with H-5/CP23. LRD discarded ~~the~~ the Q-1A and instructed me that craft may put the traceability on the material at this time.

Item - questionable NCI resolution (NCI#?)

A Q-1A was initiated for arc strikes present on Vent Stacks left by the fabricators. The Q-1A resolution stated that only those arc strikes in our immediate weld areas would have to be removed, the others are still present on the vent stacks. (Viol. all process specs)

Item - No welders stencils

At final visual on welds 1WL912-25+26, I found that welder stencils H37 & H48 were listed on the M-49 As, but their marks were not ON the materials. Before a Q-1A was initiated, CLB was contacted, who then contacted QA tech support, and as a result it was decided that the craft foreman may either strike the welders' stencils from the process control or have the welders stencil the work. (Viol. I-1)

Item - NCI 9258 - questionable resolution

NCI was written due to defective welds and no welder stencils. The Q-1A addressed only the weld defects, but not the question on the welder's stencil.

Specifics:

Items - NCI 9264 & 9266 - lack of interpass cleaning & ^{weaving} too wide
 L.R.D., in the presence of craft and craft supervision
 questioned my ability of making a meaningful
 inspection, by commenting that the small deposits
 of slag, trapped along the edges, of the multi-pass
 layers were insignificant and that I should
 have allowed the craft to grind the excessive
 weave widths back to within tolerable limits

Item - NCI 9291

After NCI 9291 had been initiated, Design
 comes-up with a V.N. to declare that the
 areas of the non-confirming welds are not
 nuclear safety-related, when at the time of
 the NCI, they were.

Item - Questionable NCI resolution - NCI 9293

M-4A not marked to indicate an accompanying
 F-9B and the F-9B had no AI signature. This
 resolution does not clearly show intent of QA program.

Item - Q-1A discarded with no serial # - questionable directions
~~discarded~~ No welders' stencils present at visual of
 removal area of DM 38-2 (M-4J). C.R.B., directed
 that welders' stencils are not mandatory on temp.
 attachment areas.

Item - NCI-10,013 - questionable resolution

Heavy rust & grit acceptable as is (Viol. M-24)

Specifies:

Item: Violation of NCI resolution

D-14 NCI 13,540 & ~~3,155~~ state that M-4As being issued in the future, where fillet welds are involved, that the leg size will be given on the M-4A. There has been several M-4As issued since this resolution that does not have the leg size shown. One example is ~~1~~ NV35-21

Item - accuracy of Q-1A resolution statements

D-15 NCI 13,053 was written for a crack in the root pass and in this base metal. The resolution called them slight gouges. This is a false statement.

Item - questionable instructions (VN 14967)

D-16 VN requires a $3/16$ " fillet at the ends of knee braces, however due to joint configuration (skewed joints), I was unable to verify the fillet sizes, but C.R.B. directed me to sign them off if they were flush.

Item - questionable NCI resolution

D-17 NCI ~~11,054~~^{11,304} - pitting that is believed have reduced the piping wall thickness below min wall is acceptable as is.

Item - Q-1A discarded (4-2-81)

D-18 M-4As for welds 2NC16-5, 10, +15 (C.B.) required a .205 fillet weld, but at final visual, QC found that only a .171 could be obtained due to valve config. C.R.B. discarded my Q-1A and directed me to allow welding tech. to correct this discrepancy.

Specifies:

Item - questionable NCI resolution

D-19 NCI 11,534, bought-off welding on inside of root-pass, while the design-drawing required welding from the root-out.

Item - questionable violation of QA - C.P. 22

D-20 Welding across flanges of beams has been permitted by Welding tech. support using a CP22A #6.
(dug.-cn-1915-11 rev. 2 - VN-14052 section AA.

Item - questionable decision

D-21 On weld 1CA67-11 (C.B.), QC found that the 90° all has 2 SA specs. on it. C.R.B. directed to put a note on the M-HA and to accept it. (H-4?)

* Item - minor incomplete fusion found visually in weld 1-37 (M-10), 6-11

D-22 CRB instructed me to accept the weld per NDE 30 J. (L80?)

Item - Weld 43-2 (M-10) was found to be welded down-hill; C.R.B. would not allow a Q-1A to be initiated, but allowed the craft weld over-top the previous welds. 6-18-81

Item - Pinhole on root of half-coupling, accepted per directions from C.R.B., because of no guidelines in L80.
D-24 (1A diesel gen.) 7-10-81

Item - Q-1A voided by CRB on hanger 1-R-SM-1541, where excessive undercut, trapped slag, base metal encroachments, and arc strikes existed on the 4th final inspection and craft foreman told me to go ahead and write it-up.
D-25 7-17-81

Specific:

Item: Q-1A resolution (12213) stated that fuds L353
D. 26 is acceptable where process control required
fuds L253 to be used for the root, 7-17-81

Item: Q-1A 12,239 resolution allows defects rejectable by
D. 27 QA procedure L80 to be acceptable, because of ET
criteria.

Item: Transparent black stain inside a class B pipe (ss)
D. 28 (ENV373-3) accepted by Joe Shropshire. viol. of M-24

Item: Q-1A 12,782 stated that welding outside ampere range
D. 29 is acceptable. (viol. - fuds. M-4. F-9. process specs.)

* D. 30
Falsified
weld -
created
Item: On weld INI162-27 a repair was made on the
root side which is approx. 7' from the open end of
the pipe. I did feel that I could make a meaningful
inspection due to accessibility. C. R. B. instructed
me to sign-off the weld.

D. 31
Satisfactory
resolution
Item: Q-1A 13,028 voided by CRB, who said he had no
problem with the root pass, where I, Ben, &
Harold detected lap-over, excess pent., and abrupt
weld profile.

Item: All QA process specs. have been revised to state
that attachment material may be welded on
stainless pipe of any thickness. I feel that
this statement has been made without Nuclear
Safety or the employee's interests in mind, because
if the water is under high pressure and the welder
is not qualified, he could receive bodily harm

Specifics:

from steam and molten metal. Also, the material itself can become embrittled.

Lack of Support from E.A.

(1)

I feel that the Larry Jackson charge's filed against Ed McKenzie was handled with poor support from our DA Dept. I have worked in Ed's area and have heard him make remarks that his men are too fast and slick ~~for~~ for welding shop. to catch them.

I was checking a fit-up for one of Ed's fitters, and I noticed they used a piece of pipe not listed in Release piping material log. I told the fitter, I had to N.C.I. this fit. I left the reactor & went to DA Office to fill out a Q1-A & get N.C.I. number. After getting back to the reactor with Q1-B Tag, I discovered that I had nothing to non-conform. Mr. McKenzie had instructed the fitter to cut out the pipe and re-make the fit. I wanted to N.C.I. Mr. McKenzie for doing away with my bad fit. I was told to get a note put on my N.C.I. stating that the fit was cut-out prior to placing Q1-B. I don't recall how this N.C.I. was handled, the following instances may let some-one know how Ed McKenzie gets his work done.

I caught his lead man in a mistake and after we corrected it, the following day, Ed McKenzie called me a liar. I asked the lead man to tell him what happened, so Ed would know his

(2)

What this problem was about.

One of Ed's fitters was caught making socket welds without the $\frac{1}{8}$ inch gap. I was told by him, his lead-man instructed him to do this. [I also caught one of his fitters making a 4 inch fit, on Stainless Steel without a purge. I asked the above fitters to cut-out & re-make these fits. I feel like they would have cut them out before I got back with an N.C.I. anyway.

I wonder how many fits his crew has made by violating construction procedures. I've tried to be as slick & fast as I could but we were told to slack-up on writing N.C.I.'s at one time.

I am still a welding inspector but I am on m 4-I inspections most of the time. It has been brought to my attention, that I may be over-inspecting, look for construction damage only. While I am inspecting these piping systems, I feel like I should, note all damage I find. I will continue to note on m 4-I form, anything, that I find damaging to a piping system until proven otherwise.

Lack of support on un-controlled filler weld man. We have been questioned on the distance a welder was from his filler material. I have picked up a welder's rods, strapped on his pouch, using his safety belt & waited till he was ready to tack a

him his rods back and warned him. He should have been N.C.I. ed. I found enough loose or lost filler material in the #1 Pipe Chase on different degrees, that I felt like the pipe Chase should have been N.C.I. ed. This filler material was turned over to Q.A., with a QI-B, which has no N.C.I. number. We have been instructed to turn loose rods into QA, without an NCI number. I believe if an inspector can get a welder's rods that have been laid around and the welder doesn't miss them until he needs them, there should be no question about the distance he is from his welder material. Weld filler material placed in tool boxes with no lock should be N.C.I. ed also.

Boyer Cautten
QA Weld. Insp.

I-1 | F-58-

On 8.28.81 while I was checking clean up for weld INV309-2 I saw what appeared to be excessive pitting and oxidation on internal surface of weld INV309-1. This was seen at a distance of about 8 feet through the 3" pipe. I notified my foreman & senior man who looked at the joint and agreed that it appeared to be oxidation & severe pitting.

Later in the day I was notified by my foreman that he had informed Charles Galatrin of this and Charles had told him that this joint was not accessible as defined by M-4 and not to worry about it.

This is typical of the support we receive from upper management. Every adverse situation seems to be settled in favor of craft even if this means violating procedures.

A. S. Dentt