

ORGANIZATION: DRESSER INDUSTRIES, INC.
ALEXANDRIA, LOUISIANA

REPORT NO.: 99900054/85-01	INSPECTION DATE(S): 09/30/85-10/04/85	INSPECTION ON-SITE HOURS: 50
CORRESPONDENCE ADDRESS: Dresser Industries, Inc. ATTN: R. G. Bronson, QA Manager Post Office Box 1430 Alexandria, Louisiana 71301		
ORGANIZATIONAL CONTACT: Mr. B. G. Bronson, QA Manager TELEPHONE NUMBER: (318) 640-2250		
PRINCIPAL PRODUCT: Nuclear Safety and Safety Relief Valves NUCLEAR INDUSTRY ACTIVITY: Less than 5% of Dresser Industries (Alexandria) business is supplying valves for nuclear facilities.		
ASSIGNED INSPECTOR: <u>J. C. Harper</u> <u>12-6-85</u> J. C. Harper, Reactive Inspection Section (RIS) Date		
OTHER INSPECTOR(S): L. D. Vaughan, Program Coordination Section (PCS)		
APPROVED BY: <u>E. W. Merschoff</u> <u>12-13-85</u> E. W. Merschoff, Chief, RIS Date		
INSPECTION BASES AND SCOPE: A. BASES: 10 CFR Part 21 and 10 CFR Part 50 Appendix B. B. SCOPE: To ensure that valves, model 7150 and 7250, Class 1 and 2 are being supplied to Fort Calhoun in accordance with established commitments. In addition, to ensure that valves and valve spare parts are supplied by Dresser to the nuclear industry in accordance with established QA procedures, applicable codes (ASME Section III) and standards (Appendix B to 10 CFR Part 50.)		
PLANT SITE APPLICABILITY: Fort Calhoun, 50-285; Perry Nuclear, 50-440, 50-441; Davis-Besse, 50-346; Diablo Canyon, 50-275, 50-323.		

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A. Inspection Issues

The inspection was conducted to determine whether models 7150 and 7250 Class 1 and 2 valves are being fabricated and supplied to Fort Calhoun in accordance with the established Dresser QA and QC commitments. Dresser is supplying these valves as part of the Fort Calhoun outage work package. During the inspection, observations were made on the fabrication of other valves and valve spare parts that are to be supplied to the nuclear industry. The survey consisted of ensuring that there is proper implementation of Dresser QA procedures, applicable codes (ASME Section III) and standards (Appendix B to 10 CFR Part 50.)

B. Inspection Findings

1. Violations

Contrary to section 21.21 of 10 CFR Part 21, evaluations of defects are not being performed adequately to determine if they merit reporting in accordance with 10 CFR 21. A review of Dresser's Part 21 procedure (#003.00 dated March 28, 1984) and Part 21 evaluation files for 1984 and 1985 concluded that as a result of an inadequate evaluation on file no. 84-01, Dresser failed to notify the NRC or its customers of a reportable Part 21 item (85-01-01).

2. Nonconformances

- a. Contrary to Criterion VII of Appendix B to 10 CFR Part 50, and Dresser Industries QAM, Section 6 paragraph 6.1 and 6.2, Dresser procured services from two sources that were not on an approved vendors list (85-01-02).
- b. Contrary to Criterion VII of Appendix B to 10 CFR Part 50, and Dresser Industries procedure QTI-13, paragraph 3.6, Dresser failed to perform receiving inspection on 4 containers of type 7018 nuclear welding rods (85-01-03).
- c. Contrary to Criterion XII of Appendix B to 10 CFR Part 50, and Dresser Industries procedure QIT-33, paragraph 9.0b, calibration of the Charpy V-Notch Impact Testing Machine has not been performed during the last five years (85-01-04).

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- d. Contrary to Criterion XII of Appendix B to 10 CFR Part 50, and Dresser Industries procedure QTI-76, paragraph 2.1, the calibration certifications (#1343, #6141) for torque devices had no documentation of a standard serial number. Therefore, the calibration load cell and readout devices used as the standard for calibration cannot be traced as required (85-01-05).
- e. Contrary to Criterion XII of Appendix B to 10 CFR Part 50, and Dresser Industries QAM, Section 12, paragraph 5.1, calibration of the WR-12 Carbon Determinator (used for analysis of carbon and sulfur content) was not traceable to national standards or equipment manufacturer's recommended standards (85-01-06).
- f. Contrary to Criterion XII of Appendix B to 10 CFR Part 50, and Dresser Industries procedure QTI-13, paragraph 3.1, Dresser quality control failed to certify calibration completed on June 6, 1984 for the nuclear welding rod oven bi-metal thermometers TG-2, TG-4, TG-6, TG-8, TG-11, TG-20, TG-21 (85-01-07).
- g. Contrary to 10 CFR 21, paragraph 21.21, and Dresser's Part 21 procedure, #003.00, paragraph 3.2, Dresser did not identify/list the pertinent data to substantiate an investigation for Part 21 file no. 85-01 (85-01-08).

C. Unresolved Items

None.

D. Other Findings and Comments

The NRC inspector reviewed the parts and travelers for Class 1 and 2 Dresser/Hancock 7150 and 7250 model valves to verify that heat number stamping, nondestructive testing, correct calibration of gages, subcontractor agreements were met, and appropriate sign offs were completed according to Dresser commitments.

The nonconformances found during the inspection did not involve the fabrication of valve models 7150 and 7250.

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1. 10 CFR Part 21 Requirement

- a. A review of Dresser's Part 21 files for 1984 and 1985 noted that Part 21 file no. 84-01 was not adequately evaluated in accordance with 10 CFR Part 21 Section 21.21. File no. 84-01 identified a problem with the failure of the disc collar on model 3707RA safety valves. The file stated this problem was not reportable since "The failure is an isolated case. Since 1971, Dresser QA system has improved to preclude this failure mode." However, a letter dated July 2, 1984 in the same file states this failure has happened twice since 1971 once in August 1981 at Toledo Edison/Davis-Besse and again at Diablo Canyon in May 1984.

Information in file no. 84-01 indicates that in May 1984, during blowdown testing by Wyle Laboratories, Huntsville, Alabama, on the main steam safety valves from Pacific Gas & Electric/Diablo Canyon 2 (Dresser valve type 3707RA), valve S/N BN 1741 lifted with simultaneous shearing of the disc collar/spindle threads and cotter pin. This occurred during the first actuation, at approximately 1065 psig. The disc and spindle deflected sidewise upon closing and the disc became wedged between the nozzle seat area and the bottom of the disc holder. The valve became mechanically jammed and could not open. It also leaked severely because the disc was not seated properly.

Dresser was asked about the blow-down problems that they are presently experiencing on the 3700 series safety relief valves undergoing testing at Wyle Labs in Huntsville, Alabama for Toledo Edison/Davis Besse. Specifically, Dresser was asked whether an investigation/evaluation was done or is planned to compare the problem experienced with the 3700 series safety relief valves to the problems documented in file no. 84-01. Dresser's response was "no evaluation has been performed." During a subsequent conference call on October 10, 1985, Dresser (Mr. J. Watz and Mr. R. Brunson) stated that "Dresser has performed an evaluation/comparison of file no. 84-01 and the valves being tested by Wyle Labs and determined the failure modes were similar. File no. 84-01 will remain closed, however, a new file, no. 85-04, will be initiated. This file (85-04) will reference file no. 84-01 and will be reported as a Part 21".

Violation 85-01-01 was identified during this part of the inspection.

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- b. A review was made of Dresser's Part 21 evaluation and reporting procedure "Evaluating and Reporting of Deviations and/or Noncompliances Affecting Safety Related to NRC Regulation 10 CFR Part 21" dated March 28, 1984 and Part 21 evaluation files for 1984 and 1985. This review noted that Dresser did not identify/list the pertinent data called for in their procedure to substantiate the investigation for Part 21 file no. 85-01.

This Part 21 file identified a problem with Dresser's model 3050 diaphragm valves sticking partially open or closed. The problem was reported to the NRC by the Cleveland Electric Illuminating Co., Perry Nuclear Power Plant. According to Dresser file no. 85-01, the problem was not reportable per 10 CFR 21 since Dresser had "no knowledge in power plant system design." However, Dresser's customers were notified. File 85-01 did not identify/list the information called for in paragraph 3.2 of procedure no. 003.001 to substantiate an investigation.

In addition, a review of the purchase order and specifications for valves ordered by the Perry Nuclear Power Plant was performed by the NRC inspector. This review identified documents which listed valves as "active" and "non-active", "safety related" and "non-safety related" and "ASME Class 1, Class 2 or Class 3" valves. With this information Dresser should have been able to determine the safety significance of the deviation.

Nonconformance 85-01-08 was identified during this part of the inspection.

2. Purchase Requirements

An examination was made of 20 purchase orders (P.O.) from Dresser for outside calibration services for gages, testing and measuring devices. Dresser was found to have purchased calibration and certification services for thermocouples TG-2, TG-4, TG-6, TG-8, TG-11, TG-20, TG-21, from two vendors that were not on Dresser's approved vendors list. Calibration of the thermocouples was performed by Honeywell-Houston on August 13, 1980 - Dresser order #26229-6; on October 19, 1982 - Dresser order #48879-6; and, on December 4, 1984 - Dresser order #47671-6. Likewise, Honeywell - Ft. Washington, PA performed calibration and certification of the thermocouples on February 25, 1982 - Dresser order #41201-6. These thermocouples were used to monitor the temperature of the heat treating furnaces.

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Nonconformance 85-01-02 was identified during this part of the inspection.

3. Control of Special Processes

Heat treating and weld rod ovens were inspected and were found to be adequately calibrated and functioning according to Dresser procedures. The nuclear welding rod storage area was inspected. Weld rod containers were stored in either locked cabinets or locked weld rod ovens. The Section III weld rod ovens were marked "Nuclear." All rods were stored in the metal containers received and were marked with rod specification, lot and/or heat number to maintain traceability. However, four cases were found where containers of Type 7018, nuclear welding rods, lot 3c504Y0Z, heat #76175, were not stamped (verified) by the receiving inspection personnel. Receiving Inspection is essential in verifying that cans are properly sealed, and that identification numbers, material type, and quantity ordered are correct.

Nonconformance 85-01-03 was identified during this part of the inspection.

4. Manufacturing Process Control

The NRC Inspector reviewed the parts, travelers, and drawings for four shop orders and verified that specified requirements such as: (a) heat number stamping, (b) nondestructive testing, (c) authorized nuclear inspector sign off, (d) final inspection, (e) calibration of gages, (f) serial number assignment, and (g) heat treatment had been completed and correctly documented. No nonconformances were noted in this area.

5. Calibration

The NRC inspector found that torque devices calibration certifications #1343 and #6141 had no documentation of a calibration standard serial number. Therefore, there is no objective evidence that the torque devices were checked using a traceable load cell and readout device as the standard for measurement.

Nonconformance 85-01-05 was identified during this part of the inspection.

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The NRC inspector found that calibrations of nuclear welding rod oven bi-metal thermometers (TG-2, TG-4, TG-6, TG-8, TG-11, TG-20, and TG-21) completed on June 7, 1984 were not certified by quality control. Accurate continuous monitoring of the nuclear weld rod ovens (between 250° and 300° F) is essential for low hydrogen electrodes. The temperature range of 250° to 300° F has to be maintained in order to reduce moisture or hydrogen absorption of the weld rods.

Nonconformance 85-01-07 was identified during this part of the inspection.

The NRC inspector reviewed the calibration and procedure requirements involved in the operation of the WR-12 Carbon Determinator. Dresser was not able to show that the calibration standards used for calibrating the carbon determinator are traceable to national standards or the equipment manufacturer's recommended standards. The WR-12 Carbon Determinator is used to determine material carbon and sulfur content. For applications where high levels of carbon and sulfur are detrimental to impact strength and low levels of carbon are desirable (i.e., some corrosive environments), accurate analysis of carbon and sulfur level is essential.

Nonconformance 85-01-06 was identified during this part of the inspection.

10 Plant Tour

A tour of Dresser's facility was performed by the inspectors. The activities observed were receiving, nuclear material storage area, nuclear welding rod storage area, heat treating furnaces, stock rooms, valve assembly clean room, calibration records area, and the metallurgical laboratory. The storage, laboratory and work areas were neat, clean and free of extraneous materials. Operations observed appeared to be well planned and progressing in an orderly fashion.

PERSONS CONTACTED

Company DRESSER INDUSTRIES

Docket/Report No. 99900054/95-01

Dates Sept 30 1955

Inspector HARDER / VAUGHAN

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ENTRANCE

NAME (Please Print)

TITLE (Please Print)

ORGANIZATION (Please Print)

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PERSONS CONTACTED

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Dates September 30 - Oct - 4 1935

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Inspector JC HARPER/LO

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EXIT —

NAME(Please Print)

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INSPECTOR J.C. HARRER / L.D. VAUGHAN

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DOCUMENTS EXAMINED

DOCKET NO. 99400054-8
REPORT NO. 85 - 01
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ITEM NO.	TITLE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
1	QAM	M 367	15	7/3/83	QA Manual - ASME (Section III) For Nuclear Vessels
2	QAM	35	-	5/24/83	QAM Procedures
3	SPEC.	MR-FC-84-51	0	11/21/81	1 SPEC FOR QUOTATION ON REPLACEMENT STEM DISC ASSEMBLIES FOR DRESSER HANCOCK VALVES "
4	SPEC.	MR-FC-84-51	0	7/1/85	" "
5	SPEC.	MR-FC-84-51	0	6/10/85	" "
6	EI	OS407	8	8/14/85	FT. CALHOUN "SPARE PARTS PROCESSING INSTR. FOR HANCOCK NUCLEAR SPARE P.A. FT. CALHOUN
7	EI	OS H-32	16	10/9/83	ORIGINAL ENGINEERING INSTRUCTION FOR DRESSER HANCOCK VALVES
8	EI	QAOPS-1	17	3/14/83	CONTROL & CALIBRATION OF MEASURING EQUIPMENT "
9	EI	QAOPS-2	"	"	" "
10	EI	GTI-14	5	3/14/83	CONTROL OF FURNACE TEMPERATURES
11	EI	GTI-23	4	1/30/84	CALIBRATION & CERTIFICATION OF MASTER INSPECTION EQUIP.
12	EI	GTI-25	1	1/30/85	CONDITIONAL MATERIAL RELEASE
13	EI	GTI-33	1	12/14/77	Requirements & Procedures for Change When In-process Testing of Nuclear Materials
14	EI	GTI-34	0	6/17/75	Quality Assurance Program Requirement For Engineering Lab
15	EI	GTI-40	4	12/17/84	Dresser Material Coding of Parts & Rod

TYPE OF DOC:

DWG - DRAWING
SPEC - SPECIFICATION
PRO - PROCEDURE
QAM - QA MANUAL
QCD - QC DOCUMENT
P.O. - PURCHASE ORDER
INT - INTERNAL MEMO

LTR - LETTER
EI - ENGINEERING INSTRUCTIONS
RDC - REJECTION DISPOSITION ORDERS
QAC - QUALITY ASSURANCE CERTIFICATION
AQ - QUALITY ASSURANCE
IAR - INSPECTION AUDIT REPORT
FOR - VENDOR QUALITY REPORT

INSPECTOR LC HARPER / LD VARGAS
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ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
16	FI	QTI-51	0	6/1/75	VISUAL EXAMINATION OF NUCLEAR BOLTING
17	EI	QTI-76	1	5/20/84	CALIBRATION & CERTIFICATION OF TORQUE DEVICES
18	EI	QTI-69	1	11/2/77	CALIBRATION & CERTIFICATION OF MAGNETIC PARTICLE Insp. Equip.
19	EN			7/19/84	CERTIFICATE OF COMPLIANCE - TIG-33981 SAFETY
					RELIEF VALVE
20	PO	55-79271-0	-	6/13/85	PRESSURE ORDER FOR FT. CALHOUN'S PO # 07853
21	PO	55-80753-0	-	8/22/85	" " " " " # 08116
22	PO	55-80252-0	-	7/11/85	" " " " " # 07496
23	PO	07853	-	5/24/80	FT. CALHOUN'S PO FOR HARDWARE VALUES SPARE PARTS
24	PO	08116	-	7/14/85	" " " " " "
25	PO	07496	-	6/27/85	" " " " " "
26	PER	603.0	-	3/28/84	EVALUATING AND REPORTING OF DEVIATIONS AND/OR NONCOMPLIANCES AFFECTING SAFETY RELATED TO NRC REGULATION 10 CFR 21"

TYPE OF DOC:

- DWG - DRAWING
- SPEC - SPECIFICATION
- PRO - PROCEDURE
- QA - QA MANUAL
- QC - QC DOCUMENT
- PO - PURCHASE ORDER

- LTR - LETTER
- EI - Engineering
- QO - Regulatory
- QA - Quality Assurance
- QC - Quality Control
- DR - DRAWING

- INST - INSTRUCTIONS
- DISP - DISPOSAL ORDERS
- QU - QUANTITY ASSURANCE
- QA - QUALIFICATION
- INT - INTERNAL A.D. - DOCUMENT

J.C. HARPER

INSPECTOR LARRY D. VAUGHAN

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ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
27	21	85-01	-	-	"3050 DIAPHRAGM VALVE"
28	21	85-02	-	-	"1525VX-2 RELIEF VALVE UP-GRADING TO 1525VX-3"
29	21	84-01	-	-	"DISC NUT AND COTTER PIN SHEARING"
30	21	83-02	-	-	"3700 SERIES VALVES 5% BLOWDOWN PROBLEMS"
31	LOG	-	-	-	"NUCLEAR DEVIATION & NONCOMPLIANCE LOG FOR PART 21"
32	SPEC	SP-531-01 4549-00	X	6/19/84	CCI'S "DESIGN SPEC. FOR SAFETY RELATED VALVES" - GATE, GLOBE AND CHECK VALVES 2" AND SMALLER
33	PRO	QTI-81	G	10/17/84	"SPECIAL REQUIREMENTS, CODING & DOCUMENTATION DISTRIBUTION
34	EPA	P-1628-E	-	8/8/80	AMENDMENT # 7 (4) (LIST OF NON-SAFETY RELATED VALVES)
35	EPA	P-1690-E	-	3/20/79	LIST OF ACTIVE & NON-ACTIVE SAFETY RELATED VALVES
36	SPEC	DSP-531-01 4549-00	-	10/1/79	SAME AS # ABOVE
37	OLD	INC-037	B	3/30/79	LIST OF BILL OF MAT'L'S IDENTIFYING CLASS I VALVES
38	AVL	-	-	-	APPROVED VENDOR'S LISTS ISSUED QUARTERLY (1981 thru 9/85-12/85)
39	VAR	-	-	6/84 6/85	VENDOR AUDIT REPORTS FOR CADMET CORP. DETROIT, MICH.
40	VAR	-	-	9/84 9/85	" " " " CRUCIBLE SPECIALTY METAL SYRACUSE, N.Y.
41	VAR	-	-	6/85	" " " " ARNOLD GREEN LAB., NATICK, MA.

TYPE OF DOC:

DWG - DRAWING
SPEC - SPECIFICATION
PRO - PROCEDURE
QAH - QA MANUAL
QCD - QC DOCUMENT

VAR - VENDOR AUDIT REPORT

LTR - LETTER
21 - PART 21 EVALUATION FILE #
LOG - LOG BOOK
EPA - EQUIPMENT PURCHASE AGREEMENT
QCD - ORDER CONTROL DWG

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42	VAR	—	—	9/84	VENDOR AUDIT REPORTS FOR (UNIVERSAL CYCLOPS) CYTEMP SPECIALTY, TITUSVILLE PA. QUAKER ALLOY, MYERSTOWN, PA. LARSON & SONS, CHICAGO, ILL. TEXAS BOLT CO, HOUSTON, TX. SUHAN SPRING, HOUSTON, TX.
43	VAR	—	—	9/85	
44	VAR	—	—	6/84	
45	VAR	—	—	6/85	
46	VAR	—	—	11/83, 1/84	
47	VAR	—	—	2/84, 1/85	ANNUAL INTERNAL AUDIT REPORT
48	VAR	—	—	2/85	
49	VAR	—	—	8/84	
50	VAR	—	—	8/85	
51	VAR	—	—	8/85	
47	IAR	—	—	2/5-7/85	ANNUAL INTERNAL AUDIT REPORT
48	IAR	—	—	2/6-9/84	ANNUAL INTERNAL AUDIT REPORT
49	IAR	—	—	SCHEDULE 1985	MONTHLY INTERNAL AUDIT REPORT FOR CHECKLIST # 4 & 7; # 16, # 9 & 16 pg. 4; # 14, 16 & 15 pg. 5; # 1, # 2, & 16 pg. 6, 7 & 8; # 10 & 16 pg. 2 & 3; 3 & 13; AND # 12 & 16 pg. 1.
50	ACQ	—	—	—	AUDIT'S QUALIFICATION FOR R. R. THOMAS (LEAD AUDITOR), R. S. HUFFMAN, F. H. GREEN, J. W. ASHMORE, T. BARNES, C. S. JOHNSON, J. WATZ, L. DOUZART, D. BRANDOW, H. SCHUMACHER, J. L. KERRY AND P. B. FLETCHER.
51	P.O.	# 803-3	—	7/25/84	TO CONSOLIDATED CASTING CORP. DALLAS, TX. FOR DISC.

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DWG - DRAWING
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PRO - PROCEDURE
QAM - QA MANUAL
QCD - QC DOCUMENT

LTR - LETTER
VAR - VENDOR AUDIT REPORT
IAR - INTERNAL AUDIT REPORT
ACQ - AUDIT'S QUALIFICATION
EE - Employee Instructions

J.C. HARRIS/
INSPECTOR CARRY D. VAUGHAN
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52	P.O.	47496-3	-	1/4/85	TO CADMET, CORP., MADISON HTS, MICH. FOR WEDGE
53	PRO	QACP-7-3	5	4/10/84	"USE & CONTROL OF REJECTED DISPOSITION ORDERS"
54	PRO	QACP-8-3	9	4/10/84	"PROCESSING OF PURCHASE ORDERS"
55	PRO	QACP-8-1	9	3/9/84	"VENDOR QUALITY SURVEYS AND AUDITS"
56	PRO	QACP-7-1	13	3/14/83	"VENDOR MATERIAL INSPECTION AND CONTROL"
57	PRO	QACP-1-4	14	4/16/84	"ASME CODE SECTION III QUALITY ASSURANCE PROGRAM, INDOCTRINATION AND TRAINING"
58	PRO	QACP-1-8	3	8/16/83	"TRAINING, EXAMINATION AND CERTIFICATION OF AUDITORS"
59	PRO	QACP-1-6	13	10/11/84	"SYSTEM SURVEYS AND AUDITS"
60	PRO	Q71-53	0	-	"RECEIVING INSPECTION OF STANDARD NUCLEAR LINE VALVE MATERIAL"
61	RDO	87184	-	-	REJECTION DISPOSITION ORDER
62	RDO	87182	-	-	"
63	RDO	90071	-	-	"
64	RDO	90092	-	-	"
65	RDO	90079	-	-	"

TYPE OF DOC:

DWG - DRAWING
SPEC - SPECIFICATION
PRO - PROCEDURE
QAM - QA MANUAL
QCD - QC DOCUMENT

LER - LETTER
RDO - REJECTION DISPOSITION ORDERS
QACP - QUALITY ASSURANCE PROGRAM
QAM - QA MANUAL
QCD - QC DOCUMENT

J.C. HARPER
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66	RDO	90093	-	-	RESECTION DISPOSITION ORDER
67	RDO	82433	-	-	" " "
68	RDO	90076	-	-	" " "
69	RDO	81779	-	-	" " "
70	RDO	83580	-	-	" " "
71	PRO	003.00	-	3/28/87	EVALUATING AND REPORTING OF DEVIATIONS AND/OR NONCOMPLIANCES AFFECTING SAFETY RELATED TO NRC REGULATION 10 CFR PART 21

TYPE OF DOC:

DWG - DRAWING
SPEC - SPECIFICATION
PRO - PROCEDURE
QAI - QA MANUAL
QCD - QC DOCUMENT
P.O. - PURCHASE ORDER

LTR - LETTER
RDO - RESECTION DISPOSITION ORDERS
EI - Engineering Instructions
QA - Supplier Quality Assurance Certification
AQ - AQL's QUALIFICATION