

VENDOR INSPECTION REPORT

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

Report No. 99900066/78-02

Company: Texas Pipe Bending Company
Post Office Box 5188
Houston, Texas 77012

Inspection Conducted: July 17-21, 1978

Inspector:

D. M. Hunnicutt
for I. Barnes, Contractor Inspector, Vendor
Inspection Branch

8/2/78
Date

Approved by:

D. M. Hunnicutt
D. M. Hunnicutt, Chief, Components
Section II, Vendor Inspection Branch

8/2/78
Date

Summary

Inspection on July 17-21, 1978 (99900066/78-02)

Areas Inspected: Implementation of 10 CFR 50, Appendix B, criteria and applicable codes and standards, including action on previous inspection findings; control of production welding and audits (vendor). The inspection involved thirty-four (34) inspector-hours on site.

Results: In the three (3) areas inspected, the following deviations and unresolved items were identified.

Deviations: Action on Previous Inspection Findings - Failure to comply with corrective action commitments relative to resolution of welding material qualification data deficiencies (Enclosure, Item A); transmittal copy for a certain drawing was not furnished to the Engineering Clerk, as required by corrective action commitments (Enclosure, Item B).

Control of Production Welding - Control of temporary attachment material was not consistent with Criterion IX of 10 CFR 50, Appendix B, and Section 5

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of the QA Manual (Enclosure, Item C); frequency of performance of maintenance checks on a certain power source was not consistent with Criterion IX of 10 CFR 50, Appendix B, and corrective action commitments (Enclosure, Item D).

Unresolved Items

Action on Previous Inspection Findings - Absence of documented evidence of quality management review of vendor nonconformance files (Details Section, paragraph B.10).

Audits (Vendor) - Vendor audit system does not assure accomplishment of committed vendor corrective actions with respect to survey findings (Details Section, paragraph D.3.b).

DETAILS SECTION

A. Persons Contacted

- *B. A. Graham, Executive Vice President
- *G. R. Shepherd, Vice President, Engineering
- *A. T. Cureton, Vice President, Manufacturing
- *W. S. Smith, Manager, Quality Assurance
- *W. W. Trujillo, Assistant Manager, Quality Assurance
- *W. J. Buchanan, Manager
- *T. R. Dismukes, Manager, Pipe Mill
- *G. Edge, Manager, Material Takeoff
- *L. W. Hensley, Project Coordinator
- M. J. Hewlett, Welding Engineer
- *B. V. Kielman, Supervisor, Quality Control
- *R. P. Meineke, Manager, Quality Control
- M. R. Wood, Supervisor, Documentation

*Attended exit meeting.

B. Action on Previous Inspection Findings

1. (Closed) Deviation (Report No. 76-03): Lack of assurance relative to maintenance of inert gas shield during welding, as a result of use of personnel cooling fans in the proximity of the welding station.

The inspector verified by observation of tungsten inert gas stations and welding practices, that welding foremen were controlling use of personnel cooling fans to prevent loss of the the inert gas shield during production welding.

2. (Closed) Deviation (Report No. 77-02): Failure of welding foreman to select or document welding procedure used for attachment of Code plates.

The inspector verified by shop observation and review of Fabrication Control Sheets, that the selected welding procedure for attachment of Code plates, was being assigned by supervision prior to performance of the operation.

3. (Closed) Deviation (Report No. 77-04): Designated welding procedures for attachment welds to a pressure boundary were not in

compliance with ASME Section IX requirements and attachment material was not identified with respect to suitability for welding.

The inspector verified that the committed Nonconformance Reports had been issued and processed and that the instructions and review measures to preclude recurrence had been implemented.

4. (Closed) Deviation (Report No. 77-04): Use of a different "Document Check List" than the one shown in the QA Manual.

The inspector verified that a revised "Document Check List" had been approved by the AIA and implemented.

5. (Closed) Deviation (Report No. 77-04): Documentation file for an assembly was observed to contain incomplete materials information relative to a submerged arc welding materials combination used in fabrication of the assembly.

The finding has been closed on the basis that the inspector verified that a review had been made to establish the extent of utilization of the referenced materials. As a result of the failure to implement all of the committed corrective actions, a new deviation has been prepared. (See Enclosure, Item A).

6. (Closed) Deviation (Report No. 77-04): Failure to list certain materials (wire inserted asbestos gaskets) on shop drawings.

The inspector verified that the referenced materials had been processed in accordance with corrective action commitments and that future procurement now classified the materials as nuclear items.

7. (Closed) Deviation (Report No. 77-04): Failure to send certain original shop drawings and Fabrication Control Sheets to the Manager-Quality Assurance for finalizing inspection "Hold Points" with the Authorized Nuclear Inspector.

The inspector verified that current released original nuclear shop drawings being utilized in fabrication had been transmitted to QA/QC for "Hold Point" selection. The inspector ascertained, however, that engineering practice was not totally in compliance with committed corrective actions (See Enclosure, Item B).

8. (Closed) Deviation (Report No. 77-04): Revisions to certain drawings not released by engineering to allow reassessment of "Hold Points" by the Authorized Nuclear Inspector (ANI).

The inspector verified that current revised nuclear shop drawings being utilized in fabrication had been transmitted to QA/QC for reassessment of hold points by the ANI in a manner consistent with QA Manual and corrective action commitments.

9. (Closed) Deviation (Report No. 77-04): Sign-off "Final Release" by Quality Control indicating documentation and records were complete, although certain operations had not been signed-off on one Fabrication Control Sheet to denote completion.

The inspector verified that the documentation mechanics utilized by Texas Pipe Bending Company, had been changed to require sign-off of "Final Release" by Quality Control only after completion of all operations.

10. (Closed) Deviation (Report No. 77-04): Failure to request a detailed corrective action from a vendor supplying products with a continuing level of nonconformities.

The inspector verified that the filing system for NCRs had been revised to provide for a review of those vendors with two (2) or more NCRs occurring within a thirty (30) day period.

During review of implementation of corrective action commitments, the inspector ascertained that Quality Management review of vendor nonconformance files was not being documented either to demonstrate actual performance or to show basis for actions taken. This item is considered unresolved.

C. Control of Production Welding

1. Objectives

The objectives of this area of the inspection were to verify that production welding was controlled in accordance with applicable NRC and ASME Code requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of QA Manual, Section 5, revision dated April 10, 1978, "Welding."

- b. Observation of two (2) gas tungsten arc and one (1) submerged arc production welding operations.
- c. Comparison of welding parameters used with respect to the requirements of the applicable welding procedure specifications.
- d. Examination of components identified in b. above relative to fabrication status indicated by the applicable Fabrication Control Sheets.
- e. Verification of compliance with welding material release system for welding materials observed in production use.
- f. Review of personnel qualifications for production welding operations witnessed.
- g. Evaluation of compliance of Texas Pipe Bending Company with respect to program commitments in the area of welding operation and equipment surveillance.
- h. Visual Examination of nuclear assemblies in current fabrication.

3. Findings

a. Deviations from Commitment

- (1) See Enclosure, Item C.
- (2) See Enclosure, Item D.

b. Unresolved Items

None

D. Audits (Vendor)

1. Objectives

The objectives of this area of the inspection were to verify that:

- a. Procedures have been prepared and approved by the company to prescribe a system for auditing, which is consistent with NRC and ASME Code requirements.

- b. The audit procedures are being implemented.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of QA Manual, Section 3, revision dated May 18, 1978, "Procurement and Receiving Inspection."
- b. Review of QA Manual, Section 10, revision dated April 10, 1978, "Audits."
- c. Review of criteria used for performing vendor surveys and examination of survey records for two (2) vendors presently referenced on the Approved Vendors List.

3. Findings

- a. Deviations from Commitment

None

- b. Unresolved Item

The present system used by Texas Pipe Bending Company for approval of vendors does not assure that committed vendor corrective actions with respect to survey findings are, in fact, accomplished. Example: A current approved vendor had committed to make certain QA Manual revisions by January 1, 1978, but had not actually made the revisions as of this inspection.

E. Exit Meeting

A post inspection exit meeting was held on July 21, 1978, with the management representatives denoted in paragraph A above. The inspector summarized the scope and findings of the inspection and expressed his concern relative to the finding shown as item A in the Notice of Deviation of this report. Management was also informed that future inspections would encompass activities in the pipe mill, as a result of the recent start of production of welded nuclear pipe. Management acknowledged the statements by the inspector with respect to the inspection findings.