

APPENDIX  
NOTICE OF VIOLATION

Omaha Public Power District  
Fort Calhoun Station

Docket: 50-285/87-08  
License: DPR-40  
EA No. 87-71

During an NRC inspection conducted on March 23-27, 1987, a violation of NRC requirements was identified. The violation involved failure to control special processes. In accordance with the "General Statement of Policy and Procedure for NRC Enforcement Actions," 10 CFR Part 2, Appendix C (1985), the violation is listed below:

Criterion IX of Appendix B to 10 CFR Part 50 and the approved QA program require that measures shall be established to assure that special processes, including welding, heat treatment and nondestructive testing are controlled and accomplished by qualified personnel using qualified procedures in accordance with applicable codes, standards, specifications, criteria, and other special requirements.

Contrary to the above, the licensee failed to control special processes in the following examples:

1. Three contract welders (Symbols 1-B, 1-0, and 5-D) were allowed to remain designated as qualified to specific procedures when they should have been disqualified in accordance with Standing Order G-12A for not having used the specific welding process for which they qualified at least once in the previous 90 days.
2. The performance qualification records for twelve contract welders did not show that they had met the requirements of AWS D1.1-83 in that the records did not show the welders as having welded test coupons at all appropriate metal thicknesses for the range specified.
3. Two contract welders (Symbols 1-C and 1-E), designated as qualified to WPS No. 6, were not properly qualified to ASME Section IX for the electrode type according to their performance qualification records.
4. The postweld heat treatment specified in WPS No. 1 was not qualified to ASME Section IX by the supporting procedure qualification reports.
5. Welding and inspection instructions were inadequate, in that, Standing Orders G-12A and G-26A did not provide procedures for welding flare bevel groove joint designs for AWS D1.1-83 applications or directions for measuring flare bevel groove welds. Additionally, the weld symbol for flare bevel groove welds on the design drawings for Modification Request No. FC-81-180 was incomplete and did not comply with the requirements of Figure 32(b) in AWS A2.4-79. Therefore, the welds did not meet the requirements of AWS-D1.1-83.

This is a Severity Level IV violation. (Supplement 1)(285/8708-01)

Pursuant to the provisions of 10 CFR 2.201, Omaha Public Power District is hereby required to submit to this office within 30 days of the date of the letter transmitting this Notice, a written statement or explanation in reply, including for each violation: (1) the reason for the violation if admitted, (2) the corrective steps which have been taken and the results achieved, (3) the corrective steps which will be taken to avoid further violations, and (4) the date when full compliance will be achieved. Under the authority of Section 182 of the Atomic Energy Act of 1954, as amended, this response shall be submitted under oath or affirmation. Where good cause is shown, consideration will be given to extending the response time.

Dated at Arlington, Texas,  
this *16th* day of *May* 1988.