

U.S. NUCLEAR REGULATORY COMMISSION
REGION I

Report No. 50-412/86-05

Docket No. 50-412

License No. CPPR-105

Category A

Licensee: Duquesne Light Company
Robinson Plaza Building No. 2
Suite #210, PA. Route 60
Pittsburgh, Pennsylvania 15077

Facility Name: Beaver Valley Power Station, Unit 2

Inspection At: Shippingport, Pennsylvania

Inspection Conducted: February 24-28, 1986

Inspectors: Richard H. Harris for Rob W. Wiggins 3/28/86
R.A. McBrearty, Reactor Engineer date

Richard H. Harris 3/27/86
R.H. Harris, NDE Technician date

Approved by: J. Wiggins 3/27/86
J. Wiggins, Chief Materials & Processes date
Section, EB, DRS

Inspection Summary: Inspection on February 24-28, 1986 (Report No. 50-412/86-05)

Areas Inspected: Routine, unannounced inspection of licensee action on previous inspection findings and Preservice Inspection (PSI) activities including review of program, implementing procedures and observations of work in progress.

Results: No violations were identified.

DETAILS

1. Persons Contacted

Duquesne Light Company	(DLC)
R. Coupland	Director QC
*D.W. Denning	Assistant Director QC
L.E. Arch	Principal Engineer
J.F. Konkus	Senior Engineer
*W.H. Sikorski	Director ISI
*A.F. Mosso	NDE Coordinator
*J.B. Anderson	ISI Program Coordinator
*C.E. Kirschner	Supervisor-QA Engineer
*R. Wallauer	Compliance Engineer
*D.P. Weakland	Supervisor ISI Service
Stone And Webster Engineer Company	(SWEC)
*W. Baranowski	Administrator
*J.A. Hultz	Assistant P.M.
*A.A. Dasenbrock	Senior Construction Manager
*D. Lamson	Assistant Resident Engineer
*H.W. Durkin	Superintendent Of Engineering
Nuclear Energy Service	(NES)
*M. Shallis	Site Supervisor
*T.J. Koch	Project Manager
USNRC	
*L.J. Privity	Resident Inspector

*Denotes those present at exit meeting.

2. Licensee Action on Previous Inspection Findings

(Closed) Violation (412/85-14-01). Failure to provide clear access to welds for ISI. The inspector found that "Field Construction Procedure For Component Support Control", FCP-207, was revised to address the access required for ISI. Additionally, Nonconformance & Disposition Report (N&D) No. 85-06 and N&D No. 85-08 was issued regarding the two welds which were listed in the original finding. The actions taken by the licensee will serve to minimize recurrence of the problem and based on the inspector's review of those actions, this item is considered closed.

(Open) Unresolved Item (412/85-15-01); Potential PSI problems due to weld overlay of piping and lack of vendor As-Built Drawings and RT maps. The inspector found that the ultrasonic technique which is being used for the examination of the piping welds containing weld overlay was qualified at the EPRI NDE Center at Charlotte, North Carolina using samples containing cracks. Additionally, the technique was used at the Perry Nuclear Power Plant for the examination of overlaid welds. Based on the above, the

ultrasonic technique was deemed acceptable. The portions of the original item regarding As-Built Drawings and RT maps were not inspected at this time and remain open.

3. Preservice Inspection (PSI) Program Review

The inspector reviewed the licensee's PSI Program to ascertain compliance with ASME Code and regulatory requirements. The following were included in the inspector's review:

- Procedure No. 2.13, Revision 2, "ASME Section XI Integrated Preservice Inspection Program"
- Procedure No. 2.13.5, Revision 2, "ASME Section XI Preservice Inspection Plan For Class 2 Pressure Retaining Components"
- Procedure No. 2.13.6, Revision 1, "ASME Section XI Preservice Inspection Visual Examination Criteria For Pressure Retaining and Component Supports"
- Procedure No. 2.13.7 Revision 1, "ASME Section XI Preservice Inspection Plan For Class 1 Pressure Retaining Components"
- Specification No. 10080-DMS-0002, Revision 2, "Specification For Pre-service Steam Generator Eddy Current Inspection Beaver Valley Power Station Unit No. 2"

The inspector found that the program contains provisions to assure that the required examinations will be performed and that the resulting data are controlled by the licensee.

No violations were identified.

4. Procedure Review

The inspector reviewed PSI procedures to ascertain compliance with ASME Code, Section XI requirements. The following were included in the inspector's review:

- GP-102, Revision 1, General Inspection Requirements
- UT-300, Revision 1, General Requirements for Ultrasonic Examinations
- UT-303, Revision 3, Ultrasonic Examination of Austenitic Systems
- LP-101, Revision 1, Solvent Removable Visible Dye

The inspector found that the reviewed procedures were technically acceptable for their intended use.

No violations were identified.

5. Observations of Work in Progress

The inspectors observed ultrasonic examinations in progress to ascertain compliance with applicable examination procedures and with regulatory requirements. Portions of the examination of the following welds were included in the inspectors' observations:

- Weld 2 - RCS -8-F1, Loop "C" Crossover Leg
- Weld 2 - RCS -8-F2, Loop "C" Crossover Leg
- Weld 2 - RCS -004-F1, Loop "B" Hotleg
- Weld 2 - SIS -067-F510, Safety Injection System pipe to valve weld containing weld overlay.

The above listed welds were examined using refracted longitudinal angle beam focused transducers. The ultrasonic equipment was calibrated using the appropriate calibration standard. The scanning sensitivity was 10 dB greater than the reference level, and indications were recorded at the reference level. The inspectors found that the examinations were done by qualified technicians in accordance with approved procedures.

No violations were identified.

6. Review of Personnel Records

The personnel records of (4) four NDE Technicians were reviewed to ascertain qualification and certification in accordance to ASME and ASNT-TC-1A requirements.

No violations were identified.

7. Equipment Certification Records

The inspector reviewed records of the following ultrasonic transducers to ascertain that Code and regulatory requirements were met:

- Serial Number I-22765, 0° single element
- Serial Number J-22462, Focused, dual element
- Serial Number J-22463, Focused, dual element
- Serial Number F-16030, Focused, dual element
- Serial Number F-20320, Focused, dual element

The inspector found that the records were incomplete in that information was not available regarding the focal length of the focused transducers used for the examination of cast stainless steel welds and overlaid welds. This is considered unresolved pending the licensee making available the necessary documentation (412/86-05-01).

8. Unresolved Items

Unresolved items are matters about which more information is required to ascertain whether they are acceptable, violations or deviations. An unresolved item is discussed in paragraph 7 of this report.

9. Exit Meeting

The inspectors met with licensee representatives, denoted in paragraph 1, at the conclusion of the inspection on February 28, 1986. The inspectors summarized the purpose and scope of the inspection and the findings. At no time during this inspection was written material provided by the inspectors to the licensee.