

Bob H... 10-3-84

TEXAS UTILITIES GENERATING CO.
- CPSES -



TUGCO INSTRUCTION
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NON-ASME

CONTROL OF MATERIAL TRACEABILITY FOR SITE FABRICATED
STRUCTURAL/MISCELLANEOUS STEEL

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FOR INFORMATION ONLY

1.0 REFERENCES

- 1-A QI-QP-11.14-1 "Inspection of Site Fabrication and Installation of Structural and Miscellaneous Steel"
- 1-B QI-QP-11.4-22, "QC Surveillance of Protective Coatings Unique Identification Number Transfer"
- 1-C CPM-6.3, "Preparation, Approval and Control of Operation Travelers"
- 1-D CP-QP-18.0, "Inspection Reports"
- 1-E CP-QP-16.0, "Nonconformances"

2.0 GENERAL

2.1 PURPOSE AND SCOPE

The purpose of this instruction is to describe material traceability requirements for seismic structural/miscellaneous steel fabrication per Reference 1-A.

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3.0 INSTRUCTION

3.1 ISSUANCE AND CONTROL OF MATERIALS

The shop foreman will notify the QC Inspector when it is necessary to withdraw safety related materials from the storage area. In this case, a Material Requisition (MR) will be prepared by the craft. The MR shall provide the quantity, description, heat/mark number, and a general description of the intended use of the material (e.g., shims, etc.). This MR shall be presented to QC for material traceability verification. QC verification shall be documented by the Inspector's signature and date on the MR.

NOTE: Conduit supports, cable tray supports, electrical equipment supports, and attachments associated with these supports do not require material identification or an MR for materials conforming to ASTM A-36 or ASTM A-500 Grade B specification.

The MR shall be presented to QC at the time of inspection to expedite material traceability verification.

3.2 SUBDIVISION OF MATERIALS

The QC inspector shall verify that if it is necessary to subdivide material, that traceability is transferred prior to cutting. QC verification shall be documented on the MR, Operational Traveler, or IR as applicable.

NOTE: In the event that the steel is coated and has a Protective Coatings Unique Identification Number stamped on it (a QP number indicating use in Reactor Building), the QC inspector shall also verify transfer of this number in accordance with Reference 1-B.

3.3 UNIQUE NUMBERING

The QC Inspector shall maintain a material traceability log for safety related miscellaneous and structural steel items fabricated in the shop requiring unique numbers as shown below.

Unique numbers may be applied to items in lieu of heat numbers when due to configuration, a unique number is more feasible.

NOTE: Catalog type items such as nuts, bolts, and washers that require only a Certificate of Compliance shall not be encompassed within the scope of this instruction.



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The QC Inspector shall assign a consecutive unique I.D. control number beginning with "1001" to each unique item or group of items being fabricated for field installation.

Upon assignment of a unique I.D. control number, the QC Inspector shall enter it on the Miscellaneous/Structural Steel Traceability Log, Attachment 1, along with the following information:

- a. Assembly Quantities - The total number of unique assemblies or items being issued or fabricated.
- b. Drawing No. - The B&R miscellaneous or structural steel fabrication drawing number.
- c. Sheet - The B&R miscellaneous or structural steel fabrication drawing sheet number.
- d. Revision - The B&R miscellaneous or structural steel fabrication drawing revision number.
- e. Date - The date that fabrication of the item(s) is completed.
- f. Assembly - The unique assembly title/number of the item being issued or fabricated as shown in the Bill of Materials on the drawing.
- g. Sub-Assembly Items - The size, type and grade of material used for "Q" items to make the assembly ✓
- h. Item Quantity - The total number of each item used to make the required number of assemblies.
- i. Heat Number - The heat or lot number of each "Q" item used to make the assembly. ✓
- j. P.O. Number - The purchase order number on which the material was procured. ✓

3.3.1 Change of Sequence

The following conditions or variables shall warrant the assignment of a new unique I.D. control number:

- a. A change of P.O., heat or lot number
- b. A change of material, size, type or grade
- c. A change of assembly number or assembly dimensions
- d. A change of fabrication date
- e. A change of drawing number



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3.3.2 Field Fabricated Items

QC field inspection/verification shall be documented and processed in accordance with References 1-C or 1-D as applicable.

QC shall verify Heat Numbers applicable to material type being used and enter it in the comments section of the IR, or as directed by Operational Traveler.

3.4 DOCUMENTATION

The maintenance of operation travelers shall be in accordance with Reference 1-C.

The QC Inspector shall forward Miscellaneous/Structural Steel Traceability Log (MTL) sheets to the Permanent Plant Records Vault (PPRV). Inspection Reports, as applicable, shall be processed per Reference 1-D.

3.5 DISCREPANCIES

Discrepancies found during inspection shall be documented on the IR and/or a NCR per Reference 1-D and 1-E respectively, as directed by the QA/QC supervisor.

