

EVALUATION RESEARCH CORPORATION

UNCONTROLLED COPY

COMANCHE PEAK RESPONSE TEAM

QUALITY INSPECTION FOR ISSUE SPECIFIC ACTION PLAN VII.c

Change Notice 001

INSTRUCTION NO: QI-041

REVISION: 0

ISSUE DATE: 09/24/85

~~CONTROLLED COPY~~
CONTROL NO. _____

REINSPECTION OF FIELD FABRICATED TANKS

The QI identified above is hereby changed
as shown on the attached page of this notice.

Prepared by: Malcolm Wright Date: 9/20/85

Approved by: Albert A. Patten. Date: 9/20/85
Issue Coordinator

Approved by: Shirland Date: 9/24/85
for On-Site QA Representative

Approved by: J. H. Hamel Date: 9/24/85
QA/QC Review Team Leader

8606230333 860609
PDR FOIA
GARDE86-36 PDR

Item

Quality Instruction Change

1

Page 4, Attribute No. 10, first paragraph
Add:... CBI drawings "for vertical placement
only. The vertical tolerance is ± 1 inch."

ERC EVALUATION
RESEARCH
CORPORATION

QA/QC-RT-572

DESCRIPTION MEMORANDUM FOR
REINSPECTION OF
POPULATION: FIELD FABRICATED TANKS
CODE: FFTA
PROCEDURE: QI-041, REV. 0

September 20, 1985

TO: A. A. Patterson

FROM: J. Schauf

Attached is CHANGE NOTICE 001 to QI-041 for your approval. This change notice revises Section 5 Attribute 10, Nozzle Location.

The revision requires nozzles to be located in the vertical plane only and adds a tolerance for the verticle location.

Prepared by: *Malcolm M. Wright* 9/20/85
QA/QC Discipline Engineer

Approved by: *John P. L. L.*
QA/QC Lead Discipline Engineer

JS/sep

QA/QC-RT-371

DESCRIPTION MEMORANDUM FOR
REINSPECTION OF
POPULATION: FIELD FABRICATED TANKS
CODE: FFTA
PROCEDURE: QI-041, Rev. 0

September 11, 1985

TO: A. A. Patterson

FROM: J. Schauf

Please find attached the subject document for your approval.

The Reinspection Procedure was developed from information obtained from the following documents:

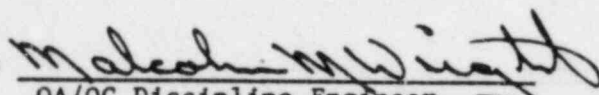
1. Project Specification 2323-MS-67, "Field Fabricated Tanks-Nuclear", Revision 1 dated March 18, 1977.
2. Project Specification, 2323-MS-67A, "Diesel Generator Oil Storage Tanks", Revision 0 dated January 24, 1977.
3. ASME III Section III, 1974 Edition including the Summer and Winter 1975 Addenda Subsections NA, ND and NF.
4. CBI Construction Drawings
 - A. Boric Acid Tank Contract Number 73122 Drawings 1 through 24.
 - B. Recycle Holdup Tank Contract Number 73121 Drawings 1 through 25.
 - C. Diesel Storage Tank Contract Number 81551 Drawings 1 through 24.
5. Design Change Authorization (DCA) No. 17228 Rev. 2 Anchoring of Permanent Equipment.
6. Technical Information Request (TIR) No. 014, Pipe Tolerance.
7. Technical Information Request (TIR) No. 015 Nozzle Location Tolerance.

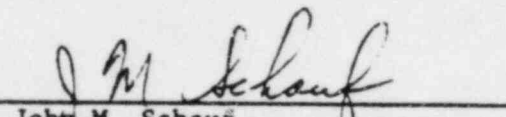
The specific sources for attributes which are included are shown in Attachment "A".

Those attributes which were considered but subsequently excluded and reasons for exclusions are contained in Attachment "B".

Attribute 16B, Base Material Defects, does not have at this time an accept/reject criteria. This criteria will be given in the Supplemental Inspection Procedures for each Verification Package. See Attachment "C" for details.

Prepared by:


QA/QC Discipline Engineer


John M. Schauf
QA/QC Lead Mechanical Engineer

cc: ERC File

JS/dan

ATTACHMENT A

FIELD FABRICATED TANKS

LIST OF SOURCE DOCUMENTS FOR EACH ATTRIBUTE

<u>ATTRIBUTE</u>	<u>SOURCE</u>
1. Name Plates	CBI Contract No. 81551 Drawing Nos 17 through 24 CBI Contract 73121 Drawing Nos 19 through 24 CBI Contract 73122 Drawing Nos 17 through 22
2. Shell Top Angle	CBI Contract 73121 Drawing No. 2 Contract 73122 Drawing No. 2
3. Anchor Bolt Ring	CBI Contract 73121 Drawing No. 5 Contract 73122 Drawing No. 5
4. Anchor Bolt Chairs	Same as Item No. 3
5. Anchor Bolt Tightness	DCA 17, 228 Rev. 2
6. Out of Roundness	ASME Section III Div. I Subsection ND 4224 ASME Section III Div. I Subsection ND 4221.1
7. Longitudinal/Seam Offsets	ASME Section III Div. I Subsection ND 3361.2 ASME Section III Div. I Subsection 3843
8. Bottom Plate Seam Offset	ASME Section III Div. I Subsection ND 4246.1

Attachment A
(Cont'd)

<u>ATTRIBUTE</u>	<u>SOURCE</u>
9. Nozzle Size and Type	CBI Contract 73121 Drawings No. 1, 9, 10, 11, 12, 14, 15 CBI Contract 73122 Drawings No. 1, 1A, 11, 14, 24 and 10 CBI Contract 81551 Drawings No. 1, 6, 9, 10, 12, 13, 14, 15, 16
10. Nozzle Location	Same as Item No. 9 TIR No. 015
11. Nozzle Insert Reinforcement Plate	CBI Contract 73121 Drawings No. 9, 10 CBI Contract 73122 Drawing No. 11
12. Nozzle and Manhole Reinforcement Pads	CBI Contract 73121 Drawings No. 8, 12, 14 CBI Contract 73122 Drawings No. 9, 14, 24
13. Seismic Restraints	CBI Contract 73121 Drawings No. 1, 6, 7 CBI Contract 73122 Drawings No. 1, 1A, 6, 7, 8
14. Internal Pipe	CBI Contract 81551 Drawings No. 9, 10 TIR No. 014
15. Welding	ASME Section III Div. I Subsection ND and NF
16. Base Material	The Base material defects attribute was selected for the purpose of investigating the base material in the vicinity of the weld for surface defects attributed to general welding activities. See Attachment "C".

Attachment A
(Cont'd)

<u>ATTRIBUTE</u>	<u>SOURCE</u>
17. Weld Rust	CBI Contract Quality Assurance Handbook Section III for CBI Contracts 73121 and 73122.
18. Material Rust	Same as Item No. 17.
NOTE: For Items Nos. 17 and 18, there has been concern that during welding, use of tools not designated for stainless steel have caused contamination and corrosion on the stainless steel welds and base material. This contamination is due to the embedment of foreign matter into the stainless steel materials. Therefore, the rust attribute was selected to inspect for excessive corrosion (i.e., pitting) that could lead to a minimum wall thickness violation.	
19. Grout	CBI Contract 73121 Drawing No. 1 CBI Contract 73122 Drawing No. 1, 1A CBI Contract 81551 Drawing No. 1

ATTACHMENT "B"
EXCLUDED ATTRIBUTES

The following attributes were considered for inclusion in the checklist but were subsequently excluded for the reasons presented:

1. Tank Location: The location of the tank foundations predetermines the tank locations and the foundation is not included in this population.
2. Tank Diaphragms: The Tank Diaphragms, even if located in safety related Tanks, are not considered to be safety related by Gibbs and Hill letter number GTN-22585.
3. Shell Stiffener Rings and Saddle Supports: The Diesel Storage Tanks have Shell Stiffener Rings and Saddle Supports. All of these tanks are buried and inaccessible for exterior inspection. A documentation review will be done.

ATTACHMENT "C"

ALTERNATE ACCEPT/REJECT CRITERIA

The Accept/Reject criteria for base metal defects (Attribute No. 16B) is going to be given in the Supplemental Inspection Procedures for each Reinspection Verification Package. This will allow the QI to be issued while awaiting TUGCO's response to our question on the maximum acceptable depth of a base metal surface defect.

ERC EVALUATION
RESEARCH
CORPORATION

QA/QC-RT-354

TO: T. Tyler, H. Levin/J. Honekamp, D. Snow, C. Moelhman,
C. Hale-NRC

FROM: QA/QC Review Team
Records Management

DATE: August 12, 1985

SUBJECT: Document Transmittal

The following documents are attached:

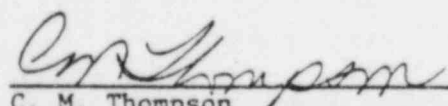
Population Items list for:

Field Fabricated Tanks

Rev. 0

July 29th, 1985

If you have any questions regarding this transmittal, please call
extension 331.


C. M. Thompson
Records Management
QA/QC Review Team

Attachments

cc: ERC File

J. Hansel

J. Christensen

V. Hoffman

D. Alexander

A. Patterson

W. Bailey

R. Brown

J. Schauf

B. Shair

A. Burke

J. Adam (4)

T. Lanza

A. Lew

A. Tewfik

K. Carlson

K. LeBlanc (WOA)

VII.c. File