



UNITED STATES
NUCLEAR REGULATORY COMMISSION
REGION V
1990 N. CALIFORNIA BOULEVARD
SUITE 202, WALNUT CREEK PLAZA
WALNUT CREEK, CALIFORNIA 94596

CONFIDENTIAL
YES ☒
NO ☐

4. You

SUMMARY OF SPECIAL INSP. -RELATED INFORMATION

DIABLO CANYON

| | | |
|--|---------------------------|-----------------|
| DATE 1/12/84 | TIME INITIATED ~ 3:00p | TIME ~ 3: -p |
| PARTICIPANTS NEC: E. H. Girard OTHER: NAME Leonard Price (Electrical Inspector) | | |
| ORGANIZATION Foley | YES ON SITE 8 months | |
| LOCATION Diablo Canyon site | | |
| CALLED NO. | | CALLING NO. |

MEETING
INTERVIEW ✓
TELEPHONE CALL
COLLECT () YES () NO
OTHER

COPY

WARY:

1. ARE YOU, OR ARE YOU AWARE OF, IMPROPER MANAGEMENT PRESSURES
AND/OR QUESTION: TO "CUT CORNERS" (i.e. sacrifice safety to meet schedules, etc)?

Reply: No. — Except that he doesn't believe that the procedure
for checking anchor bolt angle is proper. They check the installed
bolt but should check the hole angle instead. JOHN FAIR IS HANDLING
THIS ISSUE.

2. Question: Do you feel intimidated or for any reason do you have
reservations about bringing quality concerns to the attention
of ^{your} management, PG&E or the NRC?

Reply: Yes. Worries about Wilson but has not let it stop
him from identifying problems. When Wilson fired Pete
Maseros it pretty much stopped everyone from writing up any
problems for a few days.

3. Do you have other concerns?

Reply: There are problems with drawing control & weld
symbols. Changes come thru that change revisions that aren't out.

Note: I brought Phil Morrill (NRC PV) to talk to him (Price)
about drawing problems. (OVER)

TYPED BY
E. H. Girard

DATE
1/13/84

PAGE
OF
1

4. You knew Ivan Viner. Do you know how to contact him?

Reply: Yes. Pacer furnished telephone number on 1/13/84

801-864-4337

5. Do you have any concerns that you think would affect the future safe operation of the plant?

Reply: No.

Previous EXPERIENCE:

Diablo Canyon electrical inspector since 4/33

Piping - inspector at Sealbrook 1/83 - 4/83

" " at Fermi 2/80 - 4/82

Task: Allegation # 101

ATS. No. RV 23A-0073

Characterization: H. P. FOLEY USED/USES UNQUALIFIED WELDERS AND UNQUALIFIED WELDING PROCEDURE SPECIFICATIONS

Initial Assessment of Significance: IF SUBSTANTIATED, THE AFFECT ON SAFETY RELATED STRUCTURAL STEEL AND RACEWAY SUPPORT WELDING COULD RENDER THE QUALITY OF THAT WORK "INDETERMINATE."

Source: CONFIDENTIAL ALLEGOR ON 12/2/83 VIA MEMO TO AL RUFF, RII INSPECTOR

Approach to Resolution:

Status:

Review Lead: RV

Support:

Support:

Estimated Resources: 8 MAN DAYS

Estimated Completion: 3/1/83

1. REVIEW CIRCUMSTANCES AND RESOLUTION OF FOLEY NCR 8802-924
2. REVIEW 100% OF FOLEY WELDER QUALIFICATIONS FME CODE/STD CONFORMANCE
3. REVIEW WELDING PROCEDURE SPECIFICATIONS NOS. 31, 32, 35, 36, 86 (AND PROCEDURAL QUALIFICATION BASIS) FOR CONFORMANCE TO AWS D1.1.
4. EXAMINE COMMENT SHEETS FOR REV. 9, AND COMPARE TO ^{ISSUED} PROCEDURE, OF GCP-5A FOR AWS COMPLIANCE
5. EXAMINE GCP-5A REVISIONS 3, 4, 5 AND 9 FOR AWS D1.1 COMPLIANCE
6. EXAMINE GCP-5B, REVS 3 AND 4; GCP-5C, REV. 03 AND GCP-5D, REV. 03 FOR COMPLIANCE WITH AWS D1.1.

THE HOWARD P. FOLEY COMPANY

NONCONFORMANCE REPORT

Page 1 of 6

NUMBER:

8802-92A

DESCRIPTION: QCP-5A - Quality Control Procedure
for AWS Welding D1.1.
The above referenced Procedure is not in accordance
with the referenced Code - AWS D1.1.

ATTACHMENTS

Yes ☐ No ☐

DATE:

9-6-83

HOLD TAG #
REMOVED N/A

BY _____ DATE _____

REF. EPF/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATION VariousCLASS I ☒ NON-CLASS I ☒INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☒ PROCEDURE ☒ CODE X

DOCUMENT TITLE AND NUMBER: (SEE LIST OF PROCEDURES AND CODES ON PAGE 2)

DESCRIPTION OF NONCONFORMANCE: (Including Cause)

The referenced inspection criteria, H.P. Foley Q.A. Manual, states in part:
"...special processes are performed in accordance with the requirements of
applicable design drawings, specifications, procedures, codes and standards
by qualified personnel."

In violation of this Q.A. Manual is the referenced Procedure (QCP-5A)
because it is not in accordance with the above referenced Code (AWS D1.1).
Also, please note:

(CONTINUED ON PAGE 2)

INITIATED BY Shen B. VinesDATE 9-1-83

Q.C. SUPERVISOR REVIEW

DATE _____

H.P. FOLEY DISPOSITION:

VOID
1/29/83

SRM FOR L.R. WILSON

See attached memorandum.

DISPOSITION BY _____

DATE _____

QUALITY REVIEW _____

DATE _____

P.G. & E. DISPOSITION OR CONCURRENCE: _____

INFORMATION ONLY

P.G. & E. Co.

DATE _____

DISPOSITION ACCOMPLISHED

VERIFIED BY _____

DATE _____

Q.C. SUPERVISOR _____

DATE _____

13/

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO.
8802-924

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☒
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

PAGE 2 OF 6

DATE
9-6-83

INSPECTION CRITERIA: (CONTINUED FROM PAGE 1)

QCP-5A - Quality Control Procedure for AWS Welding D1.1

AWS D1.1-82 Structural Welding Code - Steel

H.P. Foley Q.A. Manual, Section IX, Control of Special Processes

10 CFR 50 Appendix "B", Section IX, Control of Special Processes

DESCRIPTION OF NONCONFORMANCE: (Including Cause) (CONTINUED FROM PAGE 1)

1. The Procedure (QCP-5A), Paragraph #1 "Scope", states in part, "This Procedure outlines the basic requirements to cover...gas metal arc welding."

The Code (AWS D1.1), Paragraph 5.1.2, requires a welding procedure specification to be prepared for the applicable process. This has not been done.

NOTE #1: The welding procedure specifications are currently for Shielded Metal Arc Welding and Flux Cored Arc Welding (FCAW).

NOTE #2: FCAW is not noted in the Procedure's Scope.

2. The Procedure (QCP-5A), Paragraph 3.2.1, states in part, "....the Production Superintendent (is) to insure Production forces under his supervision are kept informed of and are working to the latest requirements specified in the Quality Procedure."
This has not been done. Welders are frequently found to be unaware of even the welding procedure specification that they are using. The welders are not formally trained in the procedure.

3. The Procedure (QCP-5A), Paragraph 6.1.2, requires that the base metals prepared by oxygen cutting--surface roughness values not to exceed 1000 mil or 2000 mil, as applicable.

An ANSI Surface Roughness Gauge is not in the H.P. Foley Tool Room, Calibration Lab, Field or the Q.C. Department Tool Locker.

NOTE #1: This requirement is taken from the Code (AWS D1.1) at Paragraph 3.2.2. Also, see Note 4 of that paragraph.

NOTE #2: Discovered in the Purchasing Office was an AWS C4-1-77 Oxy-fuel Gauge. However, these gauges are not applicable to this referenced Procedure or Code.

4. The Procedure (QCP-5A), Paragraph 7.6.1.1, references welding processes FCAW-GMAW and SMAW.

The Code (AWS D1.1), Paragraph 5.1.2, requires a welding procedure specification to be prepared for the applicable process. This has not been done for the GMAW process.

NOTE: See Item #1 of this NCR.

5. The Procedure (QCP-5A), Paragraph 8.8, states..."caulking of welds, unless specifically noted by Constructor, is prohibited."
The Code (AWS D1.1), Paragraph 3.9, states: "Caulking of welds shall not be permitted."

(CONTINUED ON PAGE 3)

INFORMATION ONLY

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO.
8802-924

PAGE 3 OF 6

DATE
9-6-83

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☒
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

DESCRIPTION OF NONCONFORMANCE: (Including Cause) (CONTINUED FROM PAGE 2)

NOTE: The Code (AWS D1.1), Appendix 1, "Terms and Definitions", states "Caulking. Plastic deformation of weld and base metal surfaces by mechanical means to seal or obscure discontinuities."

6. The Procedure (QCP-5A), Paragraph 10.3.1, references AWS D1.1 Current Revision.

The Current Revision is not in the Q.C. Library, and to the Writer's knowledge, the Current Revision is not on site.

NOTE #1: Current is 1983.

NOTE #2: The Procedure (QCP-5A), Paragraph 2, references AWS D1.1-75. This year Code is not in the Q.C. Library.

NOTE #3: Some site personnel have in their possession an AWS D1.1-75 with the 1976 and 1977 Addenda. There is, to the Writer's knowledge, not one of the referenced Code (1975) on site.

7. The Procedure (QCP-5A), Paragraph 10.2.5, allows the straightening of distorted members by the use of localized heat (i.e., not to exceed 1100° F).

The Code (AWS D1.1), Table 4.2, Note 3, records the maximum temperature for Group "4" materials as 400° F. to 450° F., depending on the material thickness.

NOTE #1: Group "4" materials are intended primarily for use in dynamic loading (bridges, seismic requirements, etc.). Please reference ASTM 1983 - Designation: A514-83.

NOTE #2: The steels in Group "4" are tempered.

8. The Procedure (QCP-5A), references AWS D1.1 Current Revision. Same as Item #6 of this NCR and also same as Item #3.

NOTE: Procedure (QCP-5A), Paragraph 10.3.3, does not reference year of Code.

9. The Procedure (QCP-5A), Appendix "A", Paragraph 3.5.7, references minimum fillet weld size for FCAW as 1/8".

NOTE #1: The Code (AWS D1.1), Table 2.7 Note ** states, "Minimum size for bridge applications is 3/16".

NOTE #2: The Code (AWS D1.1), Paragraph 1.1.1, states the basic division of the Code for buildings (static loading) and for bridges (dynamic loading). It is believed, by the Writer, that the structural steel work on this Project is built with seismic (dynamic) engineering criteria, so therefore, all work detailed with 1/8" fillet welds is discrepant in accordance with the Code criteria.

NOTE #3: The Procedure (QCP-5A) does not reference minimum fillet weld sizes for the welding processes SMAW or GMAW as does the Code (AWS D1.1), @ Table 2.7.

NOTE #4: If it is noted in response to this NCR, for it is not in the Procedure, that the structural/electrical work is to the building (static loading) section of the Code, then numerous supports are in violation of the Code (AWS D1.1), Paragraph and Figure 8.8.5. Example S-310, REV. 23; S-339, REV. 27; and others. (CONTINUED ON PAGE 4)

INFORMATION ONLY

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO.
5802-929

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☒
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

PAGE 4 OF 6

DATE
9-6-83

DESCRIPTION OF NONCONFORMANCE: (Including Cause) (CONTINUED FROM PAGE 3)

NOTE #5: The Code (AWS D1.1-82) specifies the minimum fillet weld size and requires that this size be made in a single pass. This requirement is intended to insure sufficient heat input in order to reduce the possibility of cracking in either the heat affected zone or weld metal, especially in a restrained joint. The Procedure does not reference this (minimum fillet weld size) requirement.

10. The Procedure (QCP-5A), Appendix "A", Paragraph 8.2, states... "Only the responsible P.G. & E. Welding Engineer or Designee is permitted to set parameters beyond the ranges specified on the WPS."
The Code (AWS D1.1), Section 5, "Qualification", provides for the qualification of weld joints by their acceptance to Sections 2, 3, 4, as well as Section 8, 9, or 10, as applicable, or by their qualification per ref. Paragraph 5.2.
The Code does not allow the welding procedure specifications to be exceeded. If a greater range of the parameters is required, a new WPS is to be established. Reference Section 5.
11. The Procedure (QCP-5A), Appendix "B", Paragraph 6.2. This is the same as Item #10 of this NCR.
12. The Procedure (QCP-5A) Section "D" Stud Welding, Paragraph D3.2.5 states: "All studs shall be installed reasonably perpendicular to the surface to which they are attached."
The Code (AWS D1.1 Commentary), Paragraph 7.6, states in part: "Studs applied to a vertical surface may require modified arc shields and modified arc shields may also be required when welding to other than front surfaces. Since this and other special cases are not covered by the manufacturer's stud base qualification, the Contractor shall be responsible for the performance of these tests."
NOTE #1: The Procedure does not reference any additional requirement for vertical, overhead, etc., welding.
NOTE #2: The referenced Procedure Paragraph permits all position welding of automatically controlled time welded studs.
13. The Code (AWS D1.1) requires tests to be performed by the Contractor (H.P. Foley) for other than flat position welding of automatically controlled time welded studs. This has not been performed.
14. The Procedure (QCP-5A), Paragraph D3.2.6 states: "If the reduction in length of studs as they are welded becomes less than normal (i.e., the length of the stud is more than 1/16" greater than specified), welding shall be stopped immediately and not resumed until the cause has been corrected."
The Procedure (QCP-5A) also notes the references for welding as D1.1-82 and D1.1-75 (Electrical only) at Paragraph 2, "References." The referenced Procedure Paragraph D3.2.6 is taken from the AWS D1.1-75 Code.
The stud welding section of the Procedure should be based upon the requirements of D1.1-82, Section 7 and Appendix "K" per the reference section of the Procedure (QCP-5A).
(CONTINUED ON PAGE 5)

INFORMATION ONLY

HPF/JMH

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO. 8602-92A

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☒
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

PAGE 5 OF 5

DATE 9-6-83

DESCRIPTION OF NONCONFORMANCE: (Including Cause) (CONTINUED FROM PAGE 4)

14. (Continued)

NOTE #1: AWS D1.1-82 is basically different from the D1.1-75 Edition for the qualification process and procedural requirements.

NOTE #2: The referenced Procedure Paragraph on stud reduction has been deleted since 1978 from the D1.1 Code and the stud length reduction is found in the Manufacturer's Qualification Test Data for each and every diameter stud, along with its weld time cycles (in 1/60 seconds) and welding current. Also, please reference AWS C5.4, Table 4 - Typical Length Reductions of Studs in Arc Welding; and Table 5 - Typical Welding Conditions for Stud Welding of Steel; and Paragraph 6 - Welding Procedure (Studs).

NOTE #3: AWS C5.4, Recommended Practices for Stud Welding, is referenced in the Code, AWS D1.1-75-83. Also, AWS C5.4 cross references itself with AWS D1.1.

15. The Procedure (QCP-5A) Weld Procedure Specifications are not in accordance with the code AWS D1.1. Reference QCP-5A, WPS 1, Position of Welding - ALL (Vertical Upwards).

It is the intent of the code (AWS D1.1) that code users detail the position of welding (i.e. Flat, Vertical, Overhead, Horizontal) in order that the amps & volts parameters are conducive to produce quality welds.

NOTE: This is typical throughout the weld procedure specifications.

16. The Procedure (QCP-5A) Weld Procedure Specifications are not in accordance with the code AWS D1.1-82. The Weld Procedure Specifications are not detailed.

NOTE #1: Instead of detailing out the groove preparation dimensions, the Procedure states, The groove preparation (i.e. Root opening "R", Roof face "F", Groove Angle "A") Engineering variables as noted in the code and then includes the "As Fit up" tolerances.

Note: This allows the welder to engineer his own joint configuration.

17. The Procedures (QCP-5A) Weld Procedure Specification WPS-81 and WPS-82 weld symbol is for a Flare Bevel Groove Weld. The referenced DCC 4362 (Found in Remarks block of WPS-82) paragraph "C" states in part; Dr. Moss Davis (AWS) agrees that Flared single level (SIC) Groove Welds (for superstrut) shall be considered Fillet Welds...

NOTE# 1: The H. P. Foley letter to AWS dated February 21, 1978 Figure B details it as a Fillet Weld, AWS confirms it as a Fillet Weld and the Procedure details as a Groove Weld.

NOTE# 2: The material thickness is not noted on the WPS's.

NOTE# 3: WPS-81 Remarks block references DCC 4361. This should be DCC 4362 as noted above also as noted in WPS 78, 79 and 80.

18. Reference the above Item 17 Note# 2 of this NCR. The Weld Procedure Specifications WPS-81 and WPS-82 material thickness is not noted. The Joint Design sketch for WPS 81 and 82 can be / could have been mistaken for Tube steel to Building steel application using E-60XX electrodes.

CONTINUED ON PAGE 6: . . .

INFORMATION ONLY

HPF/TKR

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO. 8802-924

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☐
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

PAGE 6 OF 6

DATE 9-6-83

DESCRIPTION OF NONCONFORMANCE: (Including Cause) CONTINUED FROM PAGE 5:

18. NOTE # 1: The incorrectly referenced DCC 4361 (WPS-81) and DCC 4362 (WPS-8) is not readily available to craft and inspection personnel for it is a P.G.&E. DOCUMENT.
NOTE# 2: The incorrect Weld symbol (for Superstrut) is correct for Tube steel.
19. Reference Item 18 of this NCR. This condition is also applicable for WPS-78, 79 and 80 prior to PCN# 12.
20. The Procedure QCP-5A, WPS-62 is not in accordance with the Code AWS D1.1. This Joint Configuration is not prequalified per AWS D1.1-82 or any other Code year. If this Joint has been qualified by H. P. Foley it is not noted, also which is not noted are the Joint details, such as material thickness, root opening, radius, etc., so it is not known what material this WPS is to be used on or, have been used on.
21. The Procedure QCP-5A, WPS-62 details a dashed horizontal line on the vertical item on the right side of the sketch. It is not known the intent of this dashed horizontal line. If the WPS is showing the effective throat of the weld then this is indeed a Non-conforming condition for it is excessive (Joint penetration) detailed on the WPS.
NOTE# 1: Actual Joint Detail performance tests are required per AWS D1.1-82. The Joint Detail and Welding Variables (i.e. Electrode size, Amps, Volts, Welding positions, Root opening, etc.) should be shown on the W.P.S.
NOTE# 2: This information is required to make accurate Engineering and Inspections.
NOTE# 3: The Procedure contains in it's written form 29 ea "may be", 3 ea "should be", 1 ea "if necessary", 1 ea "preferably", 2 ea "reasonably", 3 ea "as practical", 1 ea "where practical", 1 ea "when practical", 1 ea "where possible", 1 ea "as possible", 1 ea "when possible", 1 ea "Same general position", 1 ea "reasonable smooth and regular".

INFORMATION ONLY

TO: Ivan Vines *auth*

FROM: Rick Wilson, Quality Director

REF: NCR 8802-924, Notes of discussion 9/27/83

DATE: September 29, 1983

The following is an evaluation of the referenced NCR and the response there to:

1. - Item 1 is not a violation of Code, but is an inconsistency between the scope and content of the procedure. Engineering will process a PCN. Item 1 has not resulted in a non-conformance.
2. Resubmit this item on a separate NCR.
3. All oxygen cut surfaces are dressed by grinding and do not exceed the 1000 uin requirement in paragraph 3.2.2 of the AWS Code. There is no need for a roughness gage. This item has not resulted in a non-conformance.
4. This item is not a code violation, it is much like Item 1. Engineering will process a PCN. There is no non-conforming condition.
5. No caulking of welds has been performed. Engineering will process a PCN to revise the procedure.
6. Q.A. has a 1975 AWS D1.1.
7. AWS temperatures are interpass and preheat for welding and do not deal with binding of shapes. There are no group 4 materials on-site.
8. This is not a non-conforming condition.
9. Engineering is requesting information from the Owner as to the design basis. It should be noted that H. P. Foley's responsibility is to erect in accordance with the design supplied by the Owner. EDR 1337-1432 response to Note 4. Resubmit Note 5 on a separate NCR.
10. This has not resulted in a non-conforming condition. Engineering is processing a PCN to revise the wording in the procedure.

NCR
10-4-85
8802-942



THE
EDWARD P. FOLEY
COMPANY

NCR
10-3-85
8802-938

INFORMATION ONLY

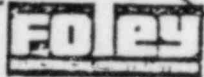
11. See Item 10.
12. No Class 1 automatic stud welding has been performed on the project since the 1942 Code has been in effect. Engineering is processing a PCN to remove automatic stud welding from the procedure.
13. See Item 12.
14. See Item 12.
15. There is no violation of the code. Electrode utilized by H. P. Foley is designated by the Code as "all position" and the range of amperage and voltage is as specified by the manufacture.
16. The WPS's in use by H. P. Foley utilize the full range of tolerances allowed in the Code. This in and of itself is not a non-conformance. The Owner has approved each WPS and H. P. Foley is erecting the material as specified by the design documents. H. P. Foley is addressing your concerns to the Owner via an EDR.
17. There is no non-conformance. Engineering is revising the WPS to eliminate conflicts in terminology.
18. See Item 17.
19. See Item 17.
20. Resubmit on separate NCR.
21. See Item 20.

So that there is consistency in the use of NCR's and IR's; this project uses the ANSI n45.2.10 definitions. Questions concerning design are processed through H. P. Foley Engineering on an Engineering Disposition Request (EDR), and questions concerning procedure should be processed through H. P. Foley Engineering or Quality Assurance on Procedure Change Requests.

RW:tt

cc NCR 8802-924

INFORMATION ONLY



THE

HOWARD P. FOLEY
COMPANY

10-4-83
8802-941

THE HOWARD P. FOLEY COMPANY

TRANSMITTAL

TO CLYDE NEEDHAM DATE 10/5/83
ENGINEERING MANAGER JOB NO. NY-576
SPEC. NO. 8802

WE HEREBY TRANSMIT - FOR YOUR APPROVAL
FOR YOUR INFORMATION

IN (NCR) 8802-938

- ☒ FOR YOUR RECOMMENDED DISPOSITION
☐ FOR CORRECTIVE ACTION
☐ FOR YOUR SIGNATURE

THANK YOU

Tom

DATE RECEIVED _____

RECEIVED BY _____

YOUR ORIGINAL SIGNED AND DATED BY _____

ORIGINAL

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT

| | |
|-------------|------------------|
| Page 1 of 1 | NUMBER: 8802-938 |
|-------------|------------------|

DESCRIPTION: LONGITUDINAL RESTRAINTS FOR
STATION BATTERY'S FILLET WELDS WERE MADE UTILIZING
MULTI-PASS WELD TECHNIQUE

ATTACHMENTS

Yes ☐ No ☒

DATE:

10-3-83

HOLD TAG
REMOVED

BY

DATE

REF. RFP/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATION Battery Room

CLASS I ☒ NON-CLASS I ☐

INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE ☒ CODE AWS D1.1-82

DOCUMENT TITLE AND NUMBER: SK-8-OWS Rev 0, QCP-5A Struct. Weld., AWS D1.1-82
WRF 5105

DESCRIPTION OF NONCONFORMANCE: (Including Cause) The Longitudinal Restraints for
Station Battery's Fillet welds were made utilizing Multi-pass weld technique.
The Code (AWS D1.1-82) specifies the minimum fillet weld size and requires that this
size be made in a single pass. This requirement is intended to insure sufficient heat
input in order to reduce the possibility of cracking in either the heat affected zone
or weld metal, especially in a restrained joint.

2. The H.P.F. Drawing SK-8-OWS Rev 0 is different from the PG&E Drawing of the same
number. The H. P. Foley does not have PG&E concurrence. The complete work package
traveler was not seen in the field only, the H.P.F. Drawing.

INITIATED BY

DATE

Q.C. SUPERVISOR REVIEW

DATE

H.P. FOLEY DISPOSITION:

DISPOSITION BY

DATE

QUALITY REVIEW

DATE

P.G. & E. DISPOSITION OR CONCURRENCE:

*Added info - is different? I put a work copy, info
can be added for clarity and sake of construction and
no PG&E concurrence is required. If C.A. has
concurred that's all that's needed*

INFORMATION ONLY

THE HOWARD P. FOLEY COMPANY

TRANSMITTAL

TO CLYDE NEEDHAM

ENGINEERING MANAGER

DATE 10/5/83

JOB NO. WY-576

SPEC. NO. 8802

WE HEREBY TRANSMIT - FOR YOUR APPROVAL
FOR YOUR INFORMATION

TRANCR 8802-940

- ☒ FOR YOUR RECOMMENDED DISPOSITION
☐ FOR CORRECTIVE ACTION
☐ FOR YOUR SIGNATURE

Tim,

Take a look at this and see what you can do to clarify it.

THANK YOU

Tom

DATE RECEIVED

RECEIVED BY

OR ORIGINAL SIGNED AND DATED TO

FORM H.P.F. 1

133

INFORMATION ONLY

ORIGINAL

THE HOWARD P. FOLEY COMPANY

NONCONFORMANCE

NUMBER:

8602-940

DESCRIPTION: THE PROCEDURE QCP-5A, WPS-62 IS NOT IN ACCORDANCE WITH THE PROCEDURE SPECIFICATION (WPS) IS A JOINT CONFIGURATION

ATTACHMENT:

DATE:

10-4-83

YES ☒ NO ☐

HOLD TAG
REMOVED

N/A

REF. HPF/IR NUMBER:

BY _____ DATE _____

UNIT I ☒ UNIT II ☒ /LOCATION

CLASS I ☒ NON-CLASS I ☐

INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER: Welding AWS DL1 QCP-5A

DESCRIPTION OF NONCONFORMANCE: (Including Cause) The Procedure QCP-5A, WPS-62 is not in accordance with the Code AWS DL1. This Joint Configuration is not prequalified per AWS DL1-82 or any other Code year. If this Joint has been qualified by H. P. Foley it is not noted, also which is not noted are the Joint Details, such as material thickness, root opening, radius, etc., so it is not known what material this WPS is to be used on or, have been used on.

INITIATED BY

DATE

Q.C. SUPERVISOR REVIEW

DATE

H.P. FOLEY DISPOSITION:

DISPOSITION BY

DATE

QUALITY REVIEW

DATE

P.C. & E. DISPOSITION OR CONCURRENCE:

Recommended Disposition
RECOMMENDATION ONLY

THE HOWARD P. FOLEY

DIABLO CANYON JOE SITE

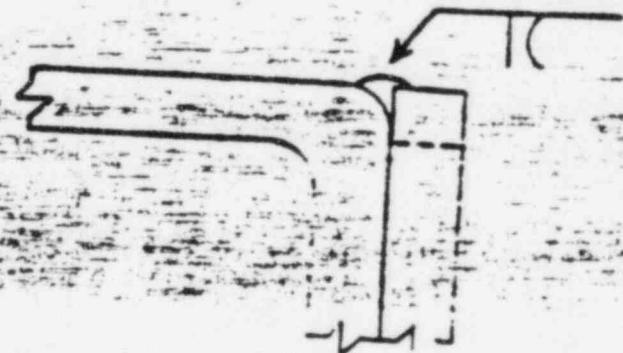
(PS) PROCEDURE SPECIFICATION NO.

PS-2 LCP-3A

Material Specification _____ Group I and II per Table 4.1.1 AWS D1.1
 Welding Process _____ Shielded Metal Arc
 Manual or Machine _____ Manual
 Position of Welding _____ All (Vertical-Up)
 Filler Metal Specification _____ SFA A5.1
 Filler Metal Classification _____ E7018
 Flux _____ N/A
 Weld Metal Grade _____ 70,000 PSI
 Shielding Gas _____ N/A
 Single or Multiple Pass _____ Multiple Pass
 Single or Multiple Arc _____ Single
 Welding Current _____ Direct
 Polarity _____ Reverse
 Root Treatment _____ None
 Preheat and Interpass Temperature _____ Up to and thru 3/4", none (*); over 3/4" and thru 1 1/2"
 50°F; over 1 1/2" and thru 2 1/2", 150°F; over 2 1/2", 225°F. *When base metal temperature is below
 32°F, base metal shall be preheated to and maintained at or above 70°F during welding.

| NO. OF ASSES | ELECT SIZE | CURRENT | |
|-----------------|---------------|---------|-------|
| | | AMPS | VOLTS |
| Required | 3/32 | 70-100 | 20-30 |
| | 1/8 | 110-150 | 20-30 |
| | 5/32 | 150-210 | 20-30 |

REMARKS:
 Maximum pass width 4 dia. of elec. being
 used; clean after each pass, no severe
 undercutting permitted on any intermediate
 passes.



This procedure may vary due to fabrication sequence, fit-up, pass size, etc.
 within the "Limitation of Variables" given in the applicable welding code.
 Structural Steeling Code, etc.

INFORMATION ONLY
 Recommended Disposition

THE HOWARD P. FOLEY COMPANY

NONCONFORMANCE REPORT

Page 1 of 1

NUMBER:

8802-940 Rev 1

DESCRIPTION: ~~THE PROCEDURE~~ ~~WPS~~ SA, WELDING
PROCEDURE SPECIFICATION (WPS) IS NOT QUALIFIED

ATTACHMENTS

Yes ☐ No ☐

DATE:

10-7-83

HOLD TAG * N/A
REMOVED

REF. HPF/IR NUMBER: N/A

BY _____ DATE _____

UNIT I ☒ UNIT II ☒ /LOCATION

CLASS I ☒ NON-CLASS I ☐

INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER: Welding AWS D1.1 QCP-5A

DESCRIPTION OF NONCONFORMANCE: (Including Cause) There is a deficiency in the above referenced Weld Procedure Specification (WPS) which renders the quality of all items utilizing the above referenced W.P.S. as indeterminate.

The above referenced WPS has inadequate documentation for its qualification for its use.

The weld joint details such as material thickness, root opening, radius, initial pass electrode size, etc., are not noted. It is not known what material this W.P.S. is to be used on, or has been used on.

INITIATED BY

DATE _____

Q.C. SUPERVISOR REVIEW

DATE _____

H.P. FOLEY DISPOSITION:

DISPOSITION BY

DATE _____

QUALITY REVIEW

DATE _____

P.G. & E. DISPOSITION OR CONCURRENCE:

P. C. & E. Co.

DATE _____

DISPOSITION ACCOMPLISHED

VERIFIED BY

DATE _____

O.C. SUPERVISOR

1998

WWT/AM 7-18-83

134

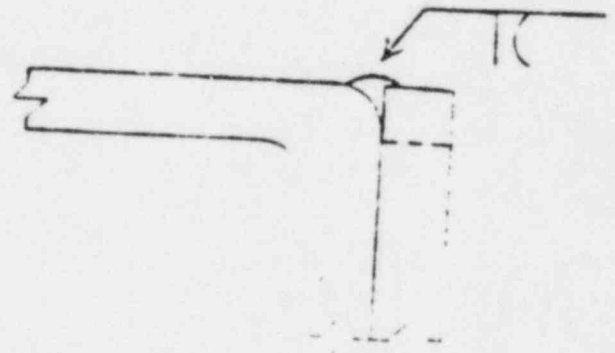
INFORMATION ONLY

Serial: _____
 Date: _____
 Material: _____
 Metal Classification: _____
 Weld Metal Grade: _____
 Shielding Gas: _____
 Single or Multiple Pass: _____
 Single or Multiple Arc: _____
 Welding Current: _____
 Polarity: _____
 Root Treatment: _____
 Preheat and Interpass Temperature: _____
 1" F. over 14" and thru 14", 150°F; over 15", 175°F. When base metal temperature is below 1" F. base metal shall be preheated to and maintained at or above 70°F during welding.

| NO. OF PASSES | ELEC. SIZE | CURRENT | |
|------------------|---------------|---------|-------|
| | | AMPS | VOLTS |
| As Required | 3/32 | 70-100 | 20-30 |
| | 1/8 | 110-150 | 20-30 |
| | 5/32 | 150-210 | 20-30 |

REMARKS:

Maximum pass width 4 dia. of elec. being used; clean after each pass, no severe undercutting permitted on any intermediate passes.



INFORMATION

THE HOWARD P. FOLEY COMPANY

TRANSMITTAL

TO CLYDE NEEDHAM
ENGINEERING MANAGER

DATE 10/5/83

JOB NO. WY-576

SPEC. NO. 8802

WE HEREBY TRANSMIT - FOR YOUR APPROVAL
FOR YOUR INFORMATION

IR (NCR) 8802-941

- ☐ FOR YOUR RECOMMENDED DISPOSITION
☐ FOR CORRECTIVE ACTION
☐ FOR YOUR SIGNATURE

THANK YOU

DATE RECEIVED _____

RECEIVED BY _____

ALL ORIGINALS SIGNED AND DATED TO _____

ORIGINAL

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT

NUMBER:
8602-041

DESCRIPTION:
THE PROCEDURE QCP-5A, WELDING PROCEDURE
SPECIFICATION (WPS) # 62 IS NOT DETAILED
CORRECTLY

ATTACHMENTS

Yes ☒ No ☐

DATE:
10-4-83

HOLD TAG
REMOVED N/A

REF. HPF/IR NUMBER: N/A

BY _____ DATE _____

UNIT I ☒ UNIT II ☒ /LOCATION

CLASS I ☐ NON-CLASS I ☐

INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER: WELDING AWS D1.1 QCP-5A

DESCRIPTION OF NONCONFORMANCE: (Including Cause) The Procedure QCP-5A, WPS-62
details a dashed horizontal line on the vertical item on the right side of the
sketch. It is not known the intent of this dashed horizontal line. If the WPS is
showing the effective throat of the weld then this is indeed a Non-conforming
condition for it is excessive (Joint penetration) detailed on the WPS. It is not
known what material this WPS is to be used on, or has been used on.
CONTINUED ON PAGE 2:

INITIATED BY

DATE

Q.C. SUPERVISOR REVIEW

DATE

H.P. FOLEY DISPOSITION:

DISPOSITION BY

DATE

QUALITY REVIEW

DATE

P.C. & E. DISPOSITION OR CONCURRENCE:

INFORMATION ONLY

Recommended Disposition

THE HOWARD P. FOLEY COMPANY
ORIGINAL NONCONFORMANCE REPORT - CONTINUATION SHEET

NO.
8802-941

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☐
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

PAGE 2 OF 2

DATE 10-4-83

DESCRIPTION OF NONCONFORMANCE: (Including Cause) CONTINUED FROM PAGE 1:

NOTE# 1: Actual Joint Detail performance tests are required per AWS D1.1-82. The Joint Detail and Welding Variables (i.e. Electrode size, Amps, Volts, Welding positions, Root opening, etc.) should be shown on the W.P.S.

NOTE# 2: This information is required to make accurate Engineering and Inspections.

NOTE#3: The Procedure contains in it's written form 29 ea "may be", 3 ea "should be", 1 ea "if necessary", 1 ea "preferably", 2 ea "reasonably", 3 ea "as practical", 1 ea "where practical", 1 ea "when practical", 1 ea "where possible", 1 ea "as possible", 1 ea "when possible", 1 ea "same general position", 1 ea "reasonably smooth and regular".

*What does this mean?
make it clear or leave it out.*

Recommended Disposition

THE HOWARD P. FOLEY COMPANY

TRANSMITTAL

TO CLYDE NEEDHAM
ENGINEERING MANAGER

DATE 10/5/83

JOB NO. WY-576

SPEC. NO. 8802

WE HEREBY TRANSMIT - FOR YOUR APPROVAL
FOR YOUR INFORMATION

TR/NCR 8802-942

- ☒ FOR YOUR RECOMMENDED DISPOSITION
☐ FOR CORRECTIVE ACTION
☐ FOR YOUR SIGNATURE

THANK YOU

Tom

RECEIVED

RECEIVED BY

ORIGINAL SIGNED AND DATED TO

FORM H.P.F./T.

ORIGINAL

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT

| | |
|--|---------------------|
| Page 1 | NUMBER: 8802-942 |
| ATTACHMENTS Yes <input type="checkbox"/> No <input checked="" type="checkbox"/> | DATE: 10-4-83 |
| HOLD TAG + N/A REMOVED | |
| BY _____ DATE _____ | |
| CLASS I <input type="checkbox"/> NON-CLASS I <input type="checkbox"/> | |

DESCRIPTION:
PROCEDURE VIOLATION - QCP-5A

REF. HPT/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATIONINSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER: Q.C. PROCEDURE FOR AWS WELDING D1.1

DESCRIPTION OF NONCONFORMANCE: (Including Cause) The Procedure (QCP-5A), Paragraph 3.2.1, states in part, "...the Production Superintendent (is) to insure Production forces under his supervision are kept informed of and are working to the latest requirements specified in Quality Procedure." This has not been done. Welders are frequently found to be unaware of even the welding procedure specification that they are using. The welders are not formally trained in the procedure.

What procedure?

INITIATED BY

DATE

Q.C. SUPERVISOR REVIEW

DATE

H.P. FOLEY DISPOSITION:

DISPOSITION BY

DATE

QUALITY REVIEW

DATE

P.G. & E. DISPOSITION OR CONCURRENCE:

INFORMATION ONLY

Recommended Disposition

ORIGINAL

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT

| | |
|--|---------------------------|
| Page <u>1</u> of <u>1</u> | NUMBER: 8802-942 Rev 1 |
| ATTACHMENTS Yes <input type="checkbox"/> No <input checked="" type="checkbox"/> | DATE: 10-7-83 |
| HOLD TAG # REMOVED | |
| BY _____ DATE _____ | |
| CLASS I <input type="checkbox"/> NON-CLASS I <input type="checkbox"/> | |

DESCRIPTION:
PROCEDURE VIOLATION - QCP-5A Paragraph 3.2.1

REF. HPF/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATION

INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER: QCP-6 Para. 4.4; 4.5; 4.5.1; 4.5.2

DESCRIPTION OF NONCONFORMANCE: (Including Cause) The Procedure (QCP-5A), Paragraph 3.2.1, states in part, "...the Production Superintendent (is) to insure Production forces under his supervision are kept informed of and are working to the latest requirements specified in Quality Procedure." This has not been done. Welders are frequently found to be unaware of even the welding procedure specification that they are using. There is no documentation, or training records, for some welders being indoctrinated to QCP-5A.

Steven B. Viner 10-7-83
INITIATED BY DATE

Jimmy Roell 10-7-83
Q.C. SUPERVISOR REVIEW DATE

H.P. FOLEY DISPOSITION:

DISPOSITION BY _____ DATE _____ QUALITY REVIEW _____ DATE _____

P.G. & E. DISPOSITION OR CONCURRENCE:

INFORMATION ONLY

P.G. & E. Co. _____ DATE _____

DISPOSITION ACCOMPLISHED

VERIFIED BY _____ DATE _____

O.C. SUPERVISOR _____ DATE _____

1. PENCH 7-18-83

To : Mr. Roselli, Quality Sup. 100
From: James J. Jones, DC Inspector I
REF NCR 8802-924 / VOIDING ON 9/27/83
DATE: SEPT 30, 1983

Mr. Roselli,

I DO NOT AGREE WITH THE VOIDING OF
THE ATTACHED N.C.R. OR THE ATTACHED LETTER
FROM THE QUALITY DIRECTOR, MR. R. WILSON.

Also, it is hereby NOTED THAT THIS VOIDING OF
THE ABOVE REFERENCED NCR IS NOT WHAT WAS
DISCUSSED AND AGREED ON AT THE ABOVE REFERENCE
MEETING, THE CONTENTS OF THE LETTER IS DIFFERENT
IN SOME AREAS OF THE NCR THAN THAT WHAT
WAS DISCUSSED.

I FIRMLY BELIEVE AN IN DEPTH REVIEW OF THE
ENTIRE H. P. FOLEY WELDING PROGRAM IS IN ORDER
The attached letter REFERENCES ANSI N45.2.10
DEFINITIONS - THE ONLY AVAILABLE ANSI N45.2.10 IS
10 YEARS OLD (1973) IS THIS ACCEPTABLE?

Please respond with directions pertaining

NCR 8802-124 AND ITS VOIDING.

Very truly yours,

James J. Jones, DC Inspector I

James J. Jones

ELECTRICAL

UNIT I ☒
UNIT II ☒

THE HOWARD P. FOLEY COMPANY
PRODUCTION ENGINEERING DEPT.
ENGINEERING DISPOSITION REQUEST

No 10066

To G. Glascock Subject GCP 5A
From R. Knowles Welding

Problem May we assume that unless otherwise
specified vendor supplied material i. e.
cabinets motors ect. is Group I per
table 4.1.1 AWS D1.1.

Signed

R. Knowles

Date 10/6/83

Reply YES.

Signed

G. J. Glascock

Date 10/6/83

THE HOWARD P. FOLEY COMPANY

ORIGINAL

NONCONFORMANCE REPORT

Number:

8833XR-23

Date:

2-7-83

DESCRIPTION: C-6180 CONN CH
Weld 7A&7B to Ext. Col. 11' V 12'
Plate MK A005-1
Elv. 187' ±

ATTACHMENTS

8833XR-14

BY ☒ REMOVEDBY *Adub*

DATE 4-7-83

REF. HPF/IR NUMBER 8833XR-14

UNIT I ☒ UNIT II ☐ / LOCATION FUEL HANDLING BLDG. EL. 187' CLASS I ☒ NON-CLASS I ☐INSPECTION CRITERIA: DRAWING ☒ Rev 4 SPECIFICATION ☐ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER: 6180-F1-13-005; QCP-5A

DESCRIPTION OF NONCONFORMANCE: (Including Cause)

The above preheated plate welds were accepted by Quality Control
(see attached HPF/WIS).

Upon cooling weld 7A cracked its full length, and weld 7B cracked 1/2 its
length. (Both 4" welds).

Plate (MK A005-1) plate is warped by 1/2" in 20" of length.

INITIATED BY

DATE

QUALITY MANAGER

DATE

PROJECT MANAGER

DATE

DISPOSITION INCLUDING MEANS TO PREVENT RECURRENCE:

Remove Plate A-005-1 and replace. Grind area of cracked welds flush and
liquid penetrant test to ensure that cracks did not propagate into base
metal.

Hold training meeting with Production supervision on distroction control.

DISPOSITION BY

DATE

PROJECT MANAGER

DATE

QUALITY MANAGER

DATE

PACIFIC GAS AND ELECTRIC CO.

DATE

DISPOSITION ACCOMPLISHED

PT Accomplished and found Acceptable on 3-3-83

Training meetings held 3-4-83.

SUPERVISOR

DATE

SUPERVISOR

DATE

WALL & HALL

THE HOWARD P. FOLEY CO. ACCEPTANCE

PACIFIC GAS AND ELECTRIC CO. ACCEPTANCE

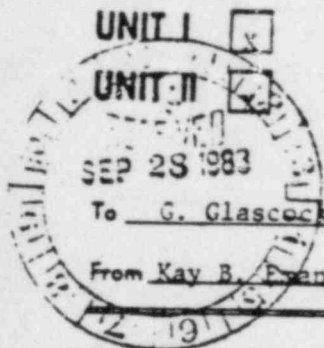
CLOSED 3-17-83

SIGNATURE

ELECTRICAL

THE HOWARD P. FOLEY COMPANY
PRODUCTION ENGINEERING DEPT.
ENGINEERING DISPOSITION REQUEST

No 9756



Subject Detail versus Procedure

050030

HR Problem Question has arisen concerning detail versus procedural requirements. Note 1
RIL of the 050029 Drawing states that the detail prevails for conduit over the procedure.
JP Numerous situations arise when the support details conflict with the procedure.
SM Reference S-18-1, REV. 30A embedment criteria versus embedment criteria in
KE QCPE-9, Paragraph 4.7.6. Can it be assumed in all cases that the detail drawing
BU prevails over procedure in reference to the 050030 details also?
LA
MD

Signed

Kay B. Emanuelson

Date 9/26/83

Reply YES.

Signed

G. Glascock

Date

9/27/83

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT

| | |
|---|---------------------|
| Page 1 of 2 | NUMBER: 8802-943 |
| ATTACHMENTS Yes <input type="checkbox"/> No <input type="checkbox"/> | DATE: 10-5-83 |
| HOLD TAG # REMOVED | N/A |
| BY | DATE |

DESCRIPTION:

Class One Support Rework

REF. HPF/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATION Various

CLASS I ☒ NON-CLASS I ☐

INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER:

Initiation of Work - QCP-17 REV. 1

DESCRIPTION OF NONCONFORMANCE: (Including Cause)

QCP-17, REV. 1, Paragraph 1d. (Scope) states: "Class One Electrical Raceway Support rework shall be handled in accordance with Appendix D." Appendix D, Paragraph D2.2 states that: "P.G. & E. will issue a 'work request' for any support rework (i.e. modifications, deletion) and verification inspection." Contrary to "Conduit" Change Orders are being issued to cover "Support" work. These Change Orders do not reference any work request and do not fall within the scope of Appendix D.
(CONTINUED ON PAGE 2)

P. J. McNamee
INITIATED BY DATE 10-5-83

Q.C. SUPERVISOR REVIEW DATE

H.P. FOLEY DISPOSITION:

*Fixed - ON 10-6-83
by Pete*

DISPOSITION BY DATE

QUALITY REVIEW DATE

P.G. & E. DISPOSITION OR CONCURRENCE:

INFORMATION ONLY

P.G. & E. Co. DATE

DISPOSITION ACCOMPLISHED

VERIFIED BY DATE

Q.C. SUPERVISOR DATE

HPF/MCR 7-18-83

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO.

8802-943

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☒
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

PAGE 2 OF 2

DATE

10-5-83

DESCRIPTION OF NONCONFORMANCE: (Including Cause) (CONTINUED FROM PAGE 1)

This is in violation of QCP-3, REV. 6 "Processing and Control of Deviations and Nonconformances." Paragraph 3.2 of QCP-3 states: "The Production Superintendent or Designee assigned by the Project Manager shall be responsible for notifying Quality of deviations and nonconformances and accomplishing all work in accordance with the specifications, design drawings and procedures."

Per ANSI N45.2.10: "Quality Assurance Terms and Definitions": a nonconformance is "a deficiency in characteristic, documentation or procedure which renders the quality of an item unacceptable or indeterminate. Examples of nonconformance include: physical defects, test failures, incorrect or inadequate documentation, or deviation from prescribed processing, inspection or test procedures."

INFORMATION ONLY

UNIT I
UNIT II

☒ X
☐

1983

CIVIL

THE HOWARD P. FOLEY COMPANY
PRODUCTION ENGINEERING DEPT.
ENGINEERING DISPOSITION REQUEST

No 1486

BM To F.M. Russell
DJ From D. Jones
BC Subject Structural Welding Requirements

LF Problem Per specification #8802 welding is to be performed in accordance.
BB with building section requirements of the AWS Welding Code for
JG Structural Steel. However applicable section of the AWS Code is not
CA referenced in other job specifications.

ES It is our understanding that all Structural Welding should conform
AD with the additional requirements of section 8 - Buildings : Is this
correct ?

Signed



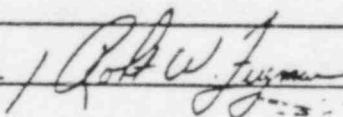
AD

Date

10/7/83

Reply WELDING SHALL BE PERFORMED TO THE REQUIREMENTS
OF THE SECTION RELATING TO BUILDINGS AND THE GENERAL
CODE SECTIONS. THE CODE REQUIREMENTS FOR BRIDGES DO
NOT APPLY UNLESS SPECIFICALLY REFERENCED.

Signed FORREST RUSSELL



Date

October 7, 1983

Rick

To: Ivan Vines

CHECK THIS OUT

DAVE

138

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT

| | |
|--|---------------------------|
| Page <u>1</u> of <u>2</u> | NUMBER: 8802-871 Rev.2 |
| ATTACHMENTS Yes <input type="checkbox"/> No <input checked="" type="checkbox"/> | DATE: 10-13-83 |
| HOLD TAG # REMOVED | |
| BY _____ DATE _____ | |
| CLASS I <input checked="" type="checkbox"/> NON-CLASS I <input type="checkbox"/> | |
| PROCEDURE <input checked="" type="checkbox"/> | |

1

that the Weld Rod Type, Size,

[Signature] 10-13-83
SUPERVISOR REVIEW DATE

sign-off of support.
ity of welds.
rician Welders.
ctrical supports.
ntinued on next page)

[Signature] 10/13/83
Y REVIEW DATE

[Signature] 10/13/83
E. Co *[Signature]* DATE

SUPERVISOR DATE

H: CR 7-18-83

Original

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO.

8802-871 Rev.2

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☒
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

PAGE 2 OF 2

DATE 10-13-83

H.P. FOLEY DISPOSITION: (Continued)

- 4) Accept rod size "As Is" if visual inspection is acceptable.
 - a) Remove and replace weld if lack of fusion is noted.
- 5) Accept Ht.# "As Is" - Only acceptable filler material is issued to the Rod Control Station.
- 6) Revise QCP-5A to require the Electrical Welder to enter Size, Heat No., and Type of rod used on the applicable "Work Copy" documentation C. to verify it's entry.
- 7) Record this NCR Number on affected SIWS's or WIS's.
- 8) Accept missing WPS No. "As Is" based on Item #1), above.

ELECTRICAL

UNIT I



RK

VT

UNIT II



JS-3

LW-3

THE HOWARD P. FOLEY COMPANY
 PRODUCTION ENGINEERING DEPT.
 ENGINEERING DISPOSITION REQUEST

No. 9186

JAN 21 1983

To H. Coley/R. Dizon/R. Montorola Subject WR-01238 DCI-EC-3604-4

From R. Knowles

Problem On detail S-190 (CSR-127-4-52) the recommended "fix" can not be done. Do you have an alternate method?

On detail S-428 (CSR-127-6-343) the weld symbol shows we have to weld all the way around. Can we weld on three sides only?

Signed

R. Knowles

Date 1-21-83

Reply

① YES, use attached new "fix" (Page 1) as approved by OPEG. (S-190) CSR-127-4-52

② YES, 3 welds will be sufficient. see attached (Page 2) for CSR-127-6-343. (S-428)

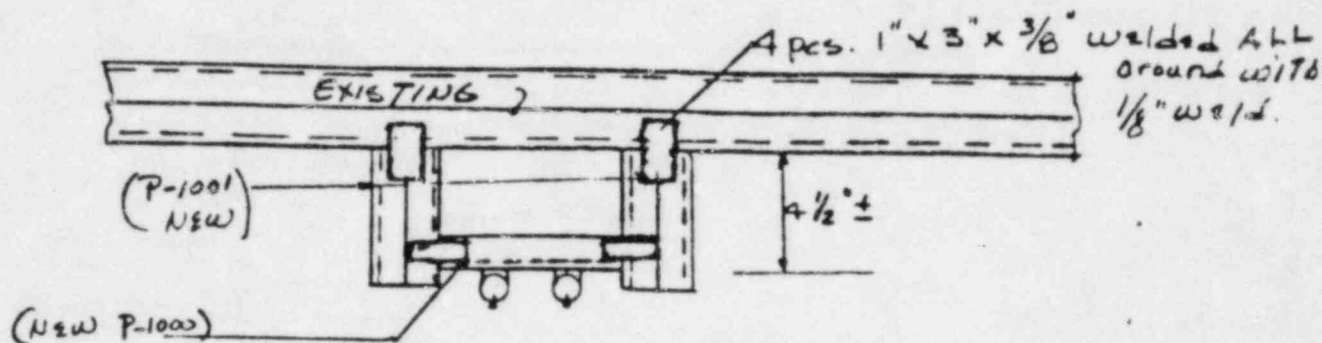
Signed

R. V. Malt

Date

1/24/83

Page 1



NEW FIX FOR SUPPORT NO. 6SR-127-4-52
DETAIL 3-190

Per DCI-EC-3604-4 and W.R. E-1238

TO: ED EPSTEIN (OPEG)

1. We cannot modify support per detail 3-190 as supplied by Engineering. Above sketch is suggested. Do you concur?

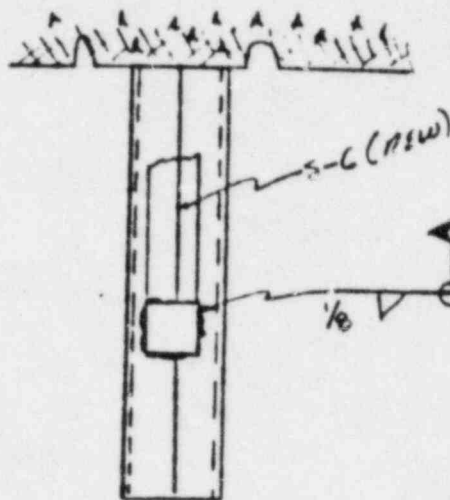
2. YES, Per ED EPSTEIN (1-21-83)

| | |
|------------------------------|---------------|
| PACIFIC GAS & ELECTRIC CO. | |
| APPROVED FOR CONSTRUCTION | |
| ENGINEERING DEPARTMENT | |
| BY: <i>[Signature]</i> | DATE: 1/21/83 |

R.V. Montezola
1/21/83

Jan. 21, 1983

Page 2

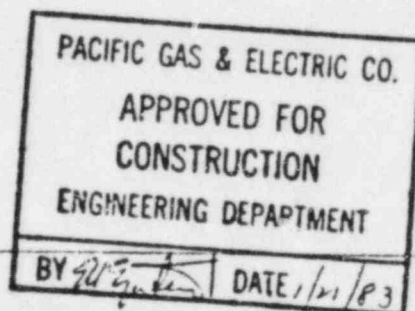


(Proposed) ① Because
of space limitation we
can only weld 3 sides
(bottom & 2 sides),
Is This good enough ?

TO: ED EPSTEIN (OPEG)

FOR Support No. CSR-127-6-343 Detail S-42
PER DCI-EC-3604-4 and W.R. E-1238

1. Welding 3 sides of the S-6 brace is good
enough. PER ED EPSTEIN (OPEG)



R.V. Montano /
1/21/83

TO Rick Wilson

In reference to NCR #939, your disposition of a request for procedure change was unacceptable to Pete since several hundred supports were already installed without work requests. After NCR #939 was voided, Pete clarified this nonconformance on NCR #943. It was not Petes intent to "not follow managements direction" by not writing a procedure change request. He merely felt that the definition of a nonconformance should be more clearly defined. Pete Mesaros has been a QC inspector for many years and is more quality oriented than any inspector you will find. It was quite a let down to everyone after coming back from your meeting to find out that you terminated one of your top professionals for trying to do his job. Don't you think it would have been more appropriate to call Pete into your office where you could at least explain your disposition rather than terminating him and intimidating the rest of the QC Inspectors.

Signed: Michael D. Toggart
Exec QC Inspector

To: Jimmy Roselli, Quality Supervisor
From: Ivan G. Vinick, Q.C. Inspector II
REF: NCR 8802-924 / VOIDING ON 9/27/83
DATE: SEPT 30, 1983

Mr. Roselli,

I DO NOT AGREE WITH THE VOIDING OF
THE ATTACHED N.C.R. OR THE ATTACHED LETTER
FROM THE Quality Director, Mr. R. Wilson.

Also, it is hereby noted that this voiding of
THE ABOVE REFERENCED NCR IS NOT WHAT WAS
DISCUSSED AND AGREED ON AT THE ABOVE REFERENCE
MEETING, THE CONTENTS OF THE LETTER IS DIFFERENT
IN SOME AREAS OF THE NCR THAN THAT WHAT
WAS DISCUSSED.

I FIRMLY BELIEVE AN IN DEPTH REVIEW OF THE
ENTIRE H. P. FOLEY WELDING PROGRAM IS IN ORDER
THE ATTACHED LETTER REFERENCES ANSI N45.2.10
DEFINITIONS - THE ONLY AVAILABLE ANSI N45.2.10 IS
10 YEARS OLD (1973) IS THIS ACCEPTABLE?

PLEASE RESPOND WITH DIRECTIONS PERTAINING TO
NCR 8802-924 AND ITS VOIDING - THE ATTACHED LETTER
DATED SEPT 29, 1983 ITS EVALUATION AND RESPONSE.

Again, other non-conforming AREAS ARE IN THE PROGRAM.

Sincerely,

I. G. Vinick

To: Ivan Vines, Q.C. Inspector II
From: Terry Roselli, Q.C. Supervisor
Ref: NCR 8802-924 - Voiding

10-10-83

Mr. Vines,

Contained herein is my response to your letter dated 9-30-83. Your first concern dealt with the voiding of NCR 8802-924 and the letter that was ~~sent~~ sent to you by Mr. Rick Wilson giving direction to yourself about how to address each item of the above mentioned NCR. Mr. Wilson, as the Quality Director, has determined that this NCR should be voided and addressed item-by-item per his memorandum, and is within ^{procedural} ~~his~~ rights to do so per QCP-3.

The second concern dealt with a meeting that was held with yourself, Terry Roselli, Dave Jones and Rick Wilson. The discussion dealt with ^{engineering} ~~managements~~ and Q.C. and Q.C. managements comments on NCR 8802-924. I agree that the memo does not reflect all agreements that were made. I suggest that we adhere to the direction of the memorandum that is attached to the NCR and follow up with a letter to Rick Wilson itemizing those areas that are still of concern.

The third concern dealt with your feeling that an in-depth review of the entire H.P. Foley welding program is in order. This concern should be addressed to Rick Wilson and engineering via a letter also.

The fourth concern dealt with ~~with~~ the 1973 edition of ANSI N45.2.10. I have checked with Quality Assurance Supervisor Jim Thompson and the 1973 edition of ANSI N45.2.10 is what he has in his reference library. As such, the 1973 edition is acceptable for H.P. Foley on this site.

In closing I wish to state that the overall responsibility for Quality lies with Management and their implementation and control of the Quality Program. You have presented some of your concerns, in N48802-924, and Management has made their decision and consequently are now responsible for that decision. It is your responsibility as an Inspector to make management aware of conditions that management must address. You, as an Inspector, cannot be held accountable for decisions made by Management. If you feel that items of concern were not addressed appropriately, I will help in bringing these concerns of yours to the Quality Director.

Sincerely

T. J. R. Rull

DESCRIPTION:

WILSON, MILDRED STACEY. 1903-1904. 511-12-1.

51. $\frac{1}{2} \ln 2$

DATE: _____

Yes ☐ No ☐

$$r = \frac{1}{2} \text{ m} = 0.5 \text{ m}$$

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| 1990 | 1991 | 1992 | 1993 | 1994 | 1995 | 1996 | 1997 | 1998 | 1999 | 2000 | 2001 | 2002 | 2003 | 2004 | 2005 | 2006 | 2007 | 2008 | 2009 | 2010 | 2011 | 2012 | 2013 | 2014 | 2015 | 2016 | 2017 | 2018 | 2019 | 2020 | 2021 | 2022 | 2023 | 2024 | 2025 | 2026 | 2027 | 2028 | 2029 | 2030 | 2031 | 2032 | 2033 | 2034 | 2035 | 2036 | 2037 | 2038 | 2039 | 2040 | 2041 | 2042 | 2043 | 2044 | 2045 | 2046 | 2047 | 2048 | 2049 | 2050 | 2051 | 2052 | 2053 | 2054 | 2055 | 2056 | 2057 | 2058 | 2059 | 2060 | 2061 | 2062 | 2063 | 2064 | 2065 | 2066 | 2067 | 2068 | 2069 | 2070 | 2071 | 2072 | 2073 | 2074 | 2075 | 2076 | 2077 | 2078 | 2079 | 2080 | 2081 | 2082 | 2083 | 2084 | 2085 | 2086 | 2087 | 2088 | 2089 | 2090 | 2091 | 2092 | 2093 | 2094 | 2095 | 2096 | 2097 | 2098 | 2099 | 2100 | 2101 | 2102 | 2103 | 2104 | 2105 | 2106 | 2107 | 2108 | 2109 | 2110 | 2111 | 2112 | 2113 | 2114 | 2115 | 2116 | 2117 | 2118 | 2119 | 2120 | 2121 | 2122 | 2123 | 2124 | 2125 | 2126 | 2127 | 2128 | 2129 | 2130 | 2131 | 2132 | 2133 | 2134 | 2135 | 2136 | 2137 | 2138 | 2139 | 2140 | 2141 | 2142 | 2143 | 2144 | 2145 | 2146 | 2147 | 2148 | 2149 | 2150 | 2151 | 2152 | 2153 | 2154 | 2155 | 2156 | 2157 | 2158 | 2159 | 2160 | 2161 | 2162 | 2163 | 2164 | 2165 | 2166 | 2167 | 2168 | 2169 | 2170 | 2171 | 2172 | 2173 | 2174 | 2175 | 2176 | 2177 | 2178 | 2179 | 2180 | 2181 | 2182 | 2183 | 2184 | 2185 | 2186 | 2187 | 2188 | 2189 | 2190 | 2191 | 2192 | 2193 | 2194 | 2195 | 2196 | 2197 | 2198 | 2199 | 2200 | 2201 | 2202 | 2203 | 2204 | 2205 | 2206 | 2207 | 2208 | 2209 | 2210 | 2211 | 2212 | 2213 | 2214 | 2215 | 2216 | 2217 | 2218 | 2219 | 2220 | 2221 | 2222 | 2223 | 2224 | 2225 | 2226 | 2227 | 2228 | 2229 | 2230 | 2231 | 2232 | 2233 | 2234 | 2235 | 2236 | 2237 | 2238 | 2239 | 2240 | 2241 | 2242 | 2243 | 2244 | 2245 | 2246 | 2247 | 2248 | 2249 | 2250 | 2251 | 2252 | 2253 | 2254 | 2255 | 2256 | 2257 | 2258 | 2259 | 2260 | 2261 | 2262 | 2263 | 2264 | 2265 | 2266 | 2267 | 2268 | 2269 | 2270 | 2271 | 2272 | 2273 | 2274 | 2275 | 2276 | 2277 | 2278 | 2279 | 2280 | 2281 | 2282 | 2283 | 2284 | 2285 | 2286 | 2287 | 2288 | 2289 | 2290 | 2291 | 2292 | 2293 | 2294 | 2295 | 2296 | 2297 | 2298 | 2299 | 2300 | 2301 | 2302 | 2303 | 2304 | 2305 | 2306 | 2307 | 2308 | 2309 | 2310 | 2311 | 2312 | 2313 | 2314 | 2315 | 2316 | 2317 | 2318 | 2319 | 2320 | 2321 | 2322 | 2323 | 2324 | 2325 | 2326 | 2327 | 2328 | 2329 | 2330 | 2331 | 2332 | 2333 | 2334 | 2335 | 2336 | 2337 | 2338 | 2339 | 2340 | 2341 | 2342 | 2343 | 2344 | 2345 | 2346 | 2347 | 2348 | 2349 | 2350 | 2351 | 2352 | 2353 | 2354 | 2355 | 2356 | 2357 | 2358 | 2359 | 2360 | 2361 | 2362 | 2363 | 2364 | 2365 | 2366 | 2367 | 2368 | 2369 | 2370 | 2371 | 2372 | 2373 | 2374 | 2375 | 2376 | 2377 | 2378 | 2379 | 2380 | 2381 | 2382 | 2383 | 2384 | 2385 | 2386 | 2387 | 2388 | 2389 | 2390 | 2391 | 2392 | 2393 | 2394 | 2395 | 2396 | 2397 | 2398</ |
|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|--------|

[illegible]

10

REF. HTF, IN NUMBER: 178

UNIT I ☒ UNIT II ☒ LOCATION ☐ COMMENTS ☐

CLASS 1 ☐ 2nd CLASS 1 ☐

INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER: OCP-5A Rev. 9 Para. 13.2.1

DESCRIPTION OF NONCONFORMANCE: (Including Cause)

There are a number of Class I welds that the Weld End Type, Size and WPS are unverifiable per CCP-5A Para. 13.2.1.

INFORMATION ONLY

INITIATED BY *[Signature]*

INITIATED BY

195683
DATE

Q.C. SUPERVISOR REVIEW

DATE _____

H.P. FOLEY DISPOSITION:

- 1) Visually inspect welds in question to existing visual acceptance criteria.
- 2) Accept weld filler metal type As Is.
 - a) 6010 and 7018 are the only types issued to Electrician Welders.
 - b) Both 6010 and 7018 are acceptable for use on electrical supports.

(DISPOSITION CONTINUED ON PAGE 2)

APPROVAL OF DISPOSITION

DISPOSITION BY

DATE _____

QUALITY REVIEW

DATE _____

P.G. & E. DISPOSITION OR CONCURRENCE:

PG-4E
- 15
AB

OK by us

142 ~~152~~

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO.
0002-071 Rev

PAGE ____ OF ____

DATE
1-1-81

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☐
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

H. P. FOLEY DISPOSITION: CONTINUED FROM PAGE 1:

- 3) Accept rod size As Is if visual inspection is acceptable.
 - a) Remove and replace weld if lack of fusion is noted.
- 4) Accept Ht. # As Is - Only acceptable filler material is issued to the rod control station.
- 5) Revise QCP-5A to require the welder to enter size, heat No. and type of rod used on the applicable "Work Copy" documentation. QC to verify it's entry.
- 6) Record this NCR Number on affected SHS's, WIS's.

INFORMATION ONLY

APPROVAL OF DISPOSITION

Original

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT

| | |
|--|---------------------------|
| Page <u>1</u> of <u>2</u> | NUMBER: 8802-871 Rev.2 |
| ATTACHMENTS Yes <input type="checkbox"/> No <input checked="" type="checkbox"/> | DATE: 10-13-83 |
| HOLD TAG # REMOVED | |
| BY _____ | DATE _____ |

DESCRIPTION:
WPS#, Weld Rod Size and Type Unverifiable

REF. HPF/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATION Documentation Files

CLASS I ☒ NON-CLASS I ☐

INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER: QCP-5A Rev.9, Para. 13.2.1

DESCRIPTION OF NONCONFORMANCE: (Including Cause)

There are a number of Class I Raceway Support Welds that the Weld Rod Type, Size, and WPS are unverifiable per QCP-5A, Para. 13.2.1.

Larry Webb
INITIATED BY
13 OCT 83
DATE

Tom Roult
Q.C. SUPERVISOR REVIEW
10-13-83
DATE

H.P. FOLEY DISPOSITION:

- 1) Welds shall be visually accepted prior to final sign-off of support.
 - a) Visual inspection confirms structural integrity of welds.
 - 2) 6010 and 7018 are the only types issued to Electrician Welders.
 - 3) Both 6010 and 7018 are acceptable for use on electrical supports.
- (Continued on next page)

C.W. Needham
DISPOSITION BY
10-13-83
DATE

2 RWT
QUALITY REVIEW
10/13/83
DATE

P.G. & E. DISPOSITION OR CONCURRENCE:

L. J. Allen
P.G. & E. Co
10/13/83
DATE

DISPOSITION ACCOMPLISHED

VERIFIED BY

WORK COPY

Q.C. SUPERVISOR

DATE

143

18-83

ginal

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO.

8802-871 Rev.2

PAGE 2 OF 2

DATE

10-13-83

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☒
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

H.P. FOLEY DISPOSITION: (Continued)

- 4) Accept rod size "As Is" if visual inspection is acceptable.
 - a) Remove and replace weld if lack of fusion is noted.
- 5) Accept Ht.# "As Is" - Only acceptable filler material is issued to the Rod Control Station.
- 6) Revise QCP-5A to require the Electrical Welder to enter Size, Heat No., and Type of rod used on the applicable "Work Copy" documentation. Q.C. to verify it's entry.
- 7) Record this NCR Number on affected SIWS's or WIS's.
- 8) Accept missing WPS No. "As Is" based on Item #1), above.

WORK COPY

QCE:

10/24/83

TWIMC,

FOLLOWING ARE COMMENTS ON DISPOSITION OF NCR 8802-871, REV.2:

ITEM 1) THIS STATEMENT IS REDUNDANT; VISUAL INSPECTION PRIOR TO FINAL SIGNOFF IS AN EXISTING REQ'T. OF CRITERIA.

ITEMS 1)a), 2), & 3) ARE INFORMATION DATA ONLY, NOT DISPOSITION DATA, & SHOULD BE SEPARATED & SO NOTED.

ITEM 2) IS NOT TRUE; E6011 HAS ALSO BEEN ISSUED — SEE WPS 45, REV.2, QCP-5A.

ITEM 5) DEALS W/ TOPIC WHICH, ALTHOUGH IT SHOULD HAVE BEEN, WAS NOT INCLUDED IN ORIG. BRUAWK.

ITEM 6) DOES NOT INCLUDE IN ITS SPECIFIED CORRECTIVE ACTION ANY DISCUSSION OF THE WPS — SHALL THE WELDER ENTER THIS ON THE "WORK COPY" DOCUMENTATION?


a. SHALL QC XFER THESE DATA TO THE RWIR?

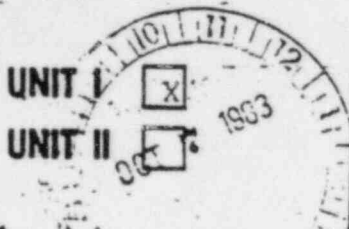
b. SHALL QC REMOVE (OR COPY) THIS ANNOTATED "WORK COPY" DOCUMENTATION TO SUPPORT HIS ENTRIES (IF REQ'D.) ON RWIR?

ITEM 7) REFERS TO SIWSs, BUT THE DOCUMENTS INVOLVED ARE RWIRS.

NOTE: NO SPECIFIC "ACCEPT-AS-IS" STATEMENT IS INCLUDED IN DISPOSITION FOR WELD ROD TYPE, AS IS DONE FOR ROD SIZE (4), HT. (#5), & WPS (#8).

Respectfully,
R. R. Tigg

144 



CIVIL

Nº 1486

THE HOWARD P. FOLEY COMPANY
PRODUCTION ENGINEERING DEPT.
ENGINEERING DISPOSITION REQUEST

BM
DJ
BC
LF
BB
JG
CA
ES
AD

To F.M. Russell Subject Structural Welding Requirements
From D. Jones

Problem Per specification #8802 welding is to be performed in accordance
with building section requirements of the AWS Welding Code for
Structural Steel. However applicable section of the AWS Code is not
referenced in other job specifications.

It is our understanding that all Structural Welding should conform
with the additional requirements of section 8 - Buildings : Is this
correct ?

Signed

Date

10/7/83

Reply WELDING SHALL BE PERFORMED TO THE REQUIREMENTS
OF THE SECTION RELATING TO BUILDINGS AND THE GENERAL
CODE SECTIONS. THE CODE REQUIREMENTS FOR BRIDGES DO
NOT APPLY UNLESS SPECIFICALLY REFERENCED.

Signed FORREST RUSSELL

Date

October 7, 1983

Rick

To: Ivan Vines

CHECK THIS OUT

DAVE

Original

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT

Page 1 of 2

NUMBER:
8802-871 Rev.2

DESCRIPTION:

WPS#, Weld Rod Size and Type Unverifiable

ATTACHMENTS

Yes ☐ No ☒DATE:
10-13-83HOLD TAG #
REMOVED

REF. HPF/IR NUMBER: N/A

BY _____ DATE _____

UNIT I ☒ UNIT II ☒ /LOCATION Documentation FilesCLASS I ☒ NON-CLASS I ☐INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER: QCP-5A Rev.9, Para. 13.2.1

DESCRIPTION OF NONCONFORMANCE: (Including Cause)

There are a number of Class I Raceway Support Welds that the Weld Rod Type, Size, and WPS are unverifiable per QCP-5A, Para. 13.2.1.

Larry W. [Signature] 13 OCT 83
INITIATED BY _____ DATE _____*[Signature]* 10-13-83
Q.C. SUPERVISOR REVIEW _____ DATE _____

H.P. FOLEY DISPOSITION:

- 1) Welds shall be visually accepted prior to final sign-off of support.
 - 2) Visual inspection confirms structural integrity of welds.
 - 2) 6010 and 7018 are the only types issued to Electrician Welders.
 - 3) Both 6010 and 7018 are acceptable for use on electrical supports.
- (Continued on next page)

C.W. Needham 10-13-83
DISPOSITION BY _____ DATE _____*[Signature]* 10/13/83
QUALITY REVIEW _____ DATE _____

P.G. & E. DISPOSITION OR CONCURRENCE:

[Signature] 10/13/83
P.G. & E. Co. _____ DATE _____

DISPOSITION ACCOMPLISHED

VERIFIED BY _____ DATE _____

Q.C. SUPERVISOR _____ DATE 145

7-18-83

HP

Original

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO.

8802-871 Rev.2

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☒
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

PAGE 2 OF 2

DATE 10-13-83

H.P. FOLEY DISPOSITION: (Continued)

- 4) Accept rod size "As Is" if visual inspection is acceptable.
 - a) Remove and replace weld if lack of fusion is noted.
- 5) Accept Ht.# "As Is" - Only acceptable filler material is issued to the Rod Control Station.
- 6) Revise QCP-5A to require the Electrical Welder to enter Size, Heat No., and Type of rod used on the applicable "Work Copy" documentation. Q.C. to verify it's entry.
- 7) Record this NCR Number on affected SIWS's or WIS's.
- 8) Accept missing WPS No. "As Is" based on Item #1), above.

INFORMATION ONLY

Original

THE HOWARD P. FOLEY COMPANY

NONCONFORMANCE REPORT

Page 1 of 2

NUMBER:

8802-871 Rev.2

DESCRIPTION:

WPS#, Weld Rod Size and Type Unverifiable

ATTACHMENTS

Yes ☐ No ☒

DATE:

10-13-83

HOLD TAG #

REMOVED

BY

DATE

REF. HPF/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATION Documentation FilesCLASS I ☒ NON-CLASS I ☐INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER: QCP-5A Rev.9, Para. 13.2.1

DESCRIPTION OF NONCONFORMANCE: (Including Cause)

There are a number of Class I Raceway Support Welds that the Weld Rod Type, Size, and WPS are unverifiable per QCP-5A, Para. 13.2.1.

Randy W. [Signature]
INITIATED BY13 OCT 83
DATE*[Signature]*
Q.C. SUPERVISOR REVIEW10/13/83
DATE

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- (Continued on next page)

C.W. Needham
DISPOSITION BY10-13-83
DATE*[Signature]*
QUALITY REVIEW10/13/83
DATE

P.G. & E. DISPOSITION OR CONCURRENCE:

[Signature]
P.G. & E. Co
10/13/83
DATE

DISPOSITION ACCOMPLISHED

VERIFIED BY

DATE

Q.C. SUPERVISOR

DATE

146



7-18-83

HP.

Original

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO.

8802-871 Rev.2

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☒
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

PAGE 2 OF 2

DATE 10-13-83

H.P. FOLEY DISPOSITION: (Continued)

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Original

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT

Page 1 of 2

NUMBER:
8802-871 Rev.2

DESCRIPTION:

WPS#, Weld Rod Size and Type Unverifiable

ATTACHMENTS

Yes ☐ No ☒

DATE:

10-13-83

HOLD TAG #
REMOVED

BY _____ DATE _____

REF. HPF/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATION Documentation FilesCLASS I ☒ NON-CLASS I ☐INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER: QCP-5A Rev.9, Para. 13.2.1

DESCRIPTION OF NONCONFORMANCE: (Including Cause)

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Randy W. [Signature]
INITIATED BY13 OCT 83
DATE*[Signature]*
Q.C. SUPERVISOR REVIEW10/13/83
DATE

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(Continued on next page)

C.W. Needham
DISPOSITION BY10-13-83
DATE*2 R.W. [Signature]*
QUALITY REVIEW10/13/83
DATEP.G. & E. ~~DISPOSITION~~ OR CONCURRENCE:*[Signature]*
P.G. & E. Co
10/13/83
DATE

DISPOSITION ACCOMPLISHED

VERIFIED BY

DATE

Q.C. SUPERVISOR

147
DATE

7-18-83

HP:

Original

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO.

8802-871 Rev.2

CONTINUATION OF: DESCRIPTION OF NONCONFORMANCE ☒
PROPOSED DISPOSITION ☐
DISPOSITION ACCOMPLISHED ☐

PAGE 2 OF 2

DATE 10-13-83

H.P. FOLEY DISPOSITION: (Continued)

- 4) Accept rod size "As Is" if visual inspection is acceptable.
 - a) Remove and replace weld if lack of fusion is noted.
- 5) Accept Ht.# "As Is" - Only acceptable filler material is issued to the Rod Control Station.
- 6) Revise QCP-5A to require the Electrical Welder to enter Size, Heat No., and Type of rod used on the applicable "Work Copy" documentation. Q.C. to verify it's entry.
- 7) Record this NCR Number on affected SIWS's or WIS's.
- 8) Accept missing WPS No. "As Is" based on Item #1), above.

THE HOWARD P. FOLEY COMPANY

NONCONFORMANCE REPORT

Day Shift

ORIGINAL

Page 1 of 1

NUMBER:

8802-861

DESCRIPTION:

WELDERS AND WELD PROCEDURES QUALIFIED TO WRONG
AWS CODE

ATTACHMENTS

Yes ☐ No ☒

DATE:

6-13-83

HOLD TAG # N/A
REMOVED

BY _____ DATE _____

REF. HPF/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATIONCLASS I ☒ NON-CLASS I ☐INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☒ PROCEDURE ☒

DOCUMENT TITLE AND NUMBER: Spec. 8802 6.1

QCP-5A

AWS D1.1-82

Par. 1.2.2

DESCRIPTION OF NONCONFORMANCE: (Including Cause)

Specification 8802, Paragraph 6.1 states, H.P.F. is required to comply with the "Code for Arc & Gas Welding in Building Construction, published by AWS".

H.P.F. QCP-5A Revision 9 requires welder qualifications and production welding to be in compliance with AWS D1.1-82. D1.1-82, Paragraph 1.2.2 specifies a minimum base metal thickness of 1/8" and states that AWS D1.3 should apply to base metals less than 1/8". Contrary to this requirement, H.P.F.'s Welder and Procedure Qualification and Production Welding in the Electrical support work has been performed in accordance with AWS D1.1 instead of D1.3.

T. Canning 6-14-83
INITIATED BY DATE

T. Canning 6-14-83
Q.C. SUPERVISOR REVIEW DATE

DISPOSITION:

Revise QCP-5 and QCP-5A to call out D.1.1 - 75 for electrical welding Spec 8802, as per attached letter from PG&E (June 14, 1983).

Previous work was accomplished as per the attached procedures. Accept as is. Procedure qualifications was performed and is acceptable.

R. K. L. 6/15/83 *T. Canning* 6/14/83 *W. G. E. CO.* 6/30/83
DISPOSITION BY DATE QUALITY REVIEW DATE P.G. & E. CO. DATE

DISPOSITION ACCOMPLISHED

QCP 5 REVISED REF. PCN#5
QCP 5A REVISED REF. PCN#8

PREVIOUS WORK "ACCEPTED AS IS" PER ABOVE STATED DISPOSITION

H. C. L. 6/15/83
VERIFIED BY DATE

H. C. L. 6/15/83
Q.C. SUPERVISOR DATE

FOR INFORMATION ONLY

Close to File (date) _____

Task: Allegation or Concern No. 98

FILE COPY

GH
Final
3-5-84

ATS No.: RV-83-A-0085

BN No.

Characterization

A vendor in the nuclear industry (Brand Industrial Services Company, (BISCO) is improperly installing penetration seals. They may be involved at Diablo Canyon.

Implied Significance to Plant Design, Construction, or Operations

Improperly installed penetration seals may fail during accident conditions, resulting in a failure to contain or limit liquid or gaseous effluents to a room or section in the Auxiliary Building.

Assessment of Safety Significance

This allegation was received in Region V on December 2, 1983 and subsequently investigated and resolved in SSER No. 21 (dated December, 1983). The staff concluded in SSER No. 21 that BISCO had never performed any work either as a contractor or as a subcontractor at Diablo Canyon. Subsequent to the writing of SSER No. 21, BISCO contracted with PG&E to work on 179 safety-related pressure seals at the Diablo Canyon site. BISCO completed their contracted work on February 1, 1984 and is no longer onsite.

To resolve the allegation that BISCO improperly installed penetration seals, the staff examined the BISCO Quality Assurance Manual (BQAM), the BISCO quality control procedures, records of employee qualification and certification, records of completed work, and examined a number of the BISCO installed penetration seals.

The staff's examination of the BISCO Quality Assurance Program indicated that the program complied with the requirements of 10 CFR 50, Appendix B and ANSI N45.2, and that quality control personnel were certified and qualified in accordance with the program requirements. Examination of ten BISCO installed penetration seals in the Unit 1 Auxiliary Building did not reveal any discrepancy from the licensee and/or the BISCO requirements.

The staff's inquiry into the extent of the licensee's QA/QC surveillance of BISCO's in-process work revealed that no formal audit or surveillance had been performed. The licensee's explanation was that BISCO's work scope was so limited, i.e. for a short period of time, that a formal audit was not scheduled. However, the licensee is in the process of performing a quality control inspection of 5% of BISCO's work to verify proper installation of the pressure seals.

Staff Position

The staff concludes that this allegation does not represent a safety concern at Diablo Canyon. This conclusion is based on the staff's review of the BISCO's quality assurance program, quality control procedures implemented

during BISCO's work at Diablo Canyon, and the field examination of the BISCO installed penetration seals.

Action Required

The licensee's audit results of BISCO's work will be reviewed during the regularly scheduled NRC Inspection program.

Problem Statement

① Allegation #(s): No. 98

ATS No.(s): R III 83A ~~84~~ 85

BN(s): N/A

This document lists (or directly references) each allegation or concern brought to the attention of NRC personnel. The purpose of this statement sheet is to assure that all points raised by the allegor are covered.

If the problem statement is not clear as to who, what, where, when, or why regarding the issue, the commentary section will amplify the statement. The commentary section will also be used if there is apparent conflicting information or if there is no or very little original information available which describes the concern(s). (This can occur if, for example, a line concern was received in an interview).

Problem Statements (use extra sheets as necessary)

Allegation#

Verbatim Statement or Reference

① No.98

A vendor in the nuclear industry (Brand Industrial Services, Company, BISCO) is improperly installing penetration seals. They may be involved with Diablo Canyon.

Commentary

See attached sheets.

Date This Statement was Completed 3/5/84

Gonzalo Hernandez
Technical Reviewer Signature