EG&G ENERGY MEASUREMENTS GROUP

San Ramon Operations
2801 OLD CROW CANYON ROAD, SAN RAMON, CA • TEL (415) 837-5381 • MAIL BOX 204, SAN RAMON, CA 94583

B
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In reply please refer to: WOW: 84-06

5 December 1983

Mr. Dennis Kirsh
U. S. Nuclear Regulatory Commission
1450 Maria Lane, Suite 210
Walnut Creek, California 94596

Subject: INSPECTION STATUS REPORT
Reference: Memo; D. Kirsh to W. Wade dated 30 November 1983

This report provides the information requested in the reference memo. Attachment 1 tabulates the information by category with the exception of concrete expansion - anchor bolt data which is not available. Anchor bolts were inspected against the appropriate Foley or Pullman specifications (QCP9, QCPE9, and ESD 223) when they were used for the installation.

Aside from population data, the information was derived from records maintained for the inspections conducted under FIN B-8552. The inspections were conducted between July and November 1983 and some are incomplete. As a consequence, a description of the discrepancy and an assessment of the significance is provided only for completed inspections.

Attachment 2 illustrates the information stored in the data file for this project. The computer was asked to list all completed inspection items having a discrepancy for which a quality assurance (QA) report and/or a citation has been initiated. Incomplete inspection items for which QA reports have been initiated were also added since these reports provide the descriptive information needed to assess significance.

If further explanation or additional information is required please contact me at my office in San Ramon.

W. O. WADE
MECHANICAL ENGINEERING DEPARTMENT

WOW:cog

Distribution:

LLNL
G. Cummings
M. Eli
R. Bogdanowicz

EG&G/SRO
R. Pong
A. Debeling
C. Morton

NRC
T. Bishop
P. Narbut
P. Morrill

M-12

ATTACHMENT I

SUMMARY of DIABLO CANYON INSPECTION * DEC. 5, 1983

of '82 MODIFICATIONS FROM the INDEPENDENT DESIGN VERIFICATION PROGRAM

CATEGORY	NUMBER OF ITEMS INSPECTED	NUMBER OF DISCREPANC. (INSPECTION COMPLETED)	NUMBER OF DISCREPANC (INSPECTION INCOMPLETE)	NUMBER OF NON-DISCREP. (INSPECTION COMPLETED)	NUMBER OF MODIFIED SAFETY-RELATED ITEMS IN POPULATION	NUMBER OF SAFETY-RELATED ITEMS IN POPULATION	DISCREPANCY	SIGNIFICANT
ELECTRICAL RACEWAY SUPPORT	124	16	17	91	2200	26,601	• E0019 - ANCHOR BOLT ALIGNMENT	N
		150 ?	1 ?				• E0020 - AS-BUILT LOCAT. DIMENSION	N
							• E0022 - CITATION - THRU-BOLT	Y
						**	• E0026 - LOOSE ANCHOR NUT	N
							• E0027 - LOOSE SPRING NUTS	N
							• E0028 - LOOSE SPRING NUTS	N
							• E0032 - LOOSE SPRING NUT	N
						**	• E0033 - LOOSE ANCHOR NUT	N
							• E0039 - LOOSE CONDUIT CLAMP	N
							• E0043 - WRONG SIZE CHANNEL IRON	N
						**	• E0044 - THREAD ENGAG. & AS BUILT DIMENSIONS	N

* INSPECTION TEAM FROM LAWRENCE LIVERMORE NATIONAL LABORATORY.

SUMMARY of DIABLO CANYON INSPECTION* DEC. 5, 1983

of '82 MODIFICATIONS FROM the INDEPENDENT DESIGN VERIFICATION PROGRAM

CATEGORY	NUMBER OF ITEMS INSPECTED	NUMBER OF DISCREPANC. (INSPECTION COMPLETED)	NUMBER OF DISCREPANC. (INSPECTION INCOMPLETE)	NUMBER OF NON-DISCREP. (INSPECTION COMPLETED)	NUMBER OF MODIFIED SAFETY-RELATED ITEMS IN POPULATION	NUMBER OF SAFETY-RELATED ITEMS IN POPULATION	DISCREPANCY	SIGNIFICANT
ELECTRICAL RACEWAY SUPPORTS (cont'd)							• E0075 - LOOSE SPRING NUT.	N
							• E0077 - LOOSE SPRING NUTS.	N
							• E0078 - LOOSE SPRING NUT.	N
							• E1002 - MISSING UNISTRUT BOLTS.	N
							• E1014 - USED WRONG FASTENERS.	N
ANCHOR BOLTS	—	—	—	—	—	—		

* INSPECTION TEAM FROM LAWRENCE LIVERMORE NATIONAL LABORATORY.

DEC. 5, 1983

SUMMARY of DIABLO CANYON INSPECTION * of '82 MODIFICATIONS FROM the INDEPENDENT DESIGN VERIFICATION PROGRAM

ATEGORY	NUMBER OF ITEMS INSPECTED	NUMBER OF DISCREPANC. (INSPECTION COMPLETED)	NUMBER OF DISCREPANC. (INSPECTION INCOMPLETE)	NUMBER OF NON-DISCREP. (INSPECTION COMPLETED)	NUMBER OF MODIFIED SAFETY-RELATED ITEMS IN POPULATION	NUMBER OF SAFETY-RELATED ITEMS IN POPULATION	DISCREPANCY	SIGNIFICANT
							M0261 - IMPROPER WELD.	N
NCHOR BOLTS	—	—	—	—	—	—	—	
PTURE RESTRAINTS	11	0	3	8	22	332	—	
NCHOR BOLTS	—	—	—	—	—	—	—	
VAC SUPPORTS	14	3	1	10	604	1124	M0330 - WELD LOCATION.	N
							M0331 - PROTECTIVE PAINT.	N
							M0344 - THREAD ENGAGEMENT	N
NCHOR BOLTS	—	—	—	—	—	—	—	

INSPECTION TEAM FROM LAWRENCE LIVERMORE NATIONAL LABORATORY.

SUMMARY of DIABLO CANYON INSPECTION * DEC. 5, 1983

of '82 MODIFICATIONS FROM the INDEPENDENT DESIGN VERIFICATION PROGRAM

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PIPE SUPPORTS	280	11	6	263	4969	7114	M0023 - AS BUILT ORIENTATION.	N
							M0025 - LOOSE ANCHOR.	N
							M0029 - TURNBUCKLE LOCKNUTS MISSING.	Y
							M0047 - NO U-BOLT LOCKNUTS.	N
							M0085 - WELD PASS SEPARATION - ANCHOR BOLT ALIGNMENT.	N
							M0087 - MISSING WELD.	N
							M0088 - UNDER SIZE WELD.	N
							M0138 - STRUT ALIGNMENT	N
							M0160 - MISPLACED WELD.	N
							M0200 - STRUT ALIGNMENT.	N

* INSPECTION TEAM FROM LAWRENCE LIVERMORE NATIONAL LABORATORY.

SUMMARY of DIABLO CANYON INSPECTION* DEC. 5, 1983

of '82 MODIFICATIONS FROM the INDEPENDENT DESIGN VERIFICATION PROGRAM

CATEGORY	NUMBER OF ITEMS INSPECTED	NUMBER OF DISCREPANC. (INSPECTION COMPLETED)	NUMBER OF DISCREPANC. (INSPECTION INCOMPLETE)	NUMBER OF NON-DISCREP. (INSPECTION COMPLETED)	NUMBER OF MODIFIED SAFETY-RELATED ITEMS IN POPULATION	NUMBER OF SAFETY-RELATED ITEMS IN POPULATION	DISCREPANCY	SIGNIFICANT
STRUCTURAL MEMBERS	58	6	4	48	2130	—	S0003 - WALL PLATE GAP - SPALLED CONCRETE AT ANCHORS.	N
							S0046 - ANCHOR BOLT ALIGNMENT.	N
							S0049 - INSUFF. WELD LENGTH.	N
							S0061 - WELD REINFORCEMENT.	N
							S0062 - WELD REINFORCEMENT	N
							S0063 - LACK OF FUSION, SLAG INCLUSION STITCH WELD SPACING, BASE METAL DAMAGE.	Y
ANCHOR BOLTS	—	—	—	—	—	—	—	

* INSPECTION TEAM FROM LAWRENCE LIVERMORE NATIONAL LABORATORY.

ATTACHMENT II

LOG NUM	LOC	UNIT	ITEM	PART NUMBER	START DATE	COMPLETE DATE	CRIT	CONTACTS	AFF	STATUS	STATUS DATE	INSP	MAN HRS
E0019	AUX BLDG	1	RACEWAY SUPPORT	14/CSR-127-3480	7/13/83	10/19/83	QCP 3						
							QCP 5A						
							QCP 9						
							QCP E9	MONTEROLA	BE				
								CAMPBELL	FO				
								MORRISON	P6	PHYSICAL	9/23/83	MWE	8.0
										MVR-E2625	9/23/83		
										ACCEPTED	10/19/83	MWE	7.0
E0020	AUX BLDG	1	RACEWAY SUPPORT	10/CSR1274328	7/13/83	10/31/83	QCP 3						
							QCP 5A						
							QCP 9						
							QCP E9	MONTEROLA	BE				
								CAMPBELL	FO				
								MORRISON	P6	RECORDS	9/23/83	MWE	8.0
										MVR-E2625	9/23/83		
										ACC-W/D-QA	10/31/83	MWE	5.0
E0022	AUX BLDG	1	RACEWAY SUPPORT	12/H-115-6-105	7/13/83	8/29/83	QCP 3						
							QCP 5A						
							QCP 9						
							QCP E9	MONTEROLA	BE				
								CAMPBELL	FO				
								HERNANDEZ	NR	CITATION	8/20/83	MWE	2.0
										MVR-E2618	8/20/83		
										ACCEPTED	8/29/83	MWE	5.0
E0026	AUX BLDG	1	RACEWAY SUPPORT	K-154-1-112	8/05/83	10/15/83	QCP 3						
							QCP 5A						
							QCP 9						
							QCP E9	MONTEROLA	BE				
								CAMPBELL	FO				
								MORRISON	P6	PHYSICAL	9/15/83	MWE	5.0
										MVR-E2653	9/15/83		
										ACC-W/D-QA	10/15/83	MWE	8.0
E0027	AUX BLDG	1	RACEWAY SUPPORT	9/K-140-4-140	8/05/83	10/15/83	QCP 3						
							QCP 5A						
							QCP 9						
							QCP E9	MONTEROLA	BE				
								CAMPBELL	FO				
								MORRISON	P6	PHYSICAL	9/15/83	MWE	5.0
										MVR-E2653	9/15/83		
										ACC-W/D-QA	10/15/83	MWE	7.0
E0028	AUX BLDG	1	RACEWAY SUPPORT	9/K-140-4-136	8/05/83	10/15/83	QCP 3						
							QCP 5A						
							QCP 9						
							QCP E9	MONTEROLA	BE				
								CAMPBELL	FO				
								MORRISON	P6	PHYSICAL	9/15/83	MWE	5.0
										MVR-E2653	9/15/83		
										ACC-W/D-QA	10/15/83	MWE	8.0
E0032	CONTAINMENT	1	RACEWAY SUPPORT	246-140-8-E300B	10/15/83		QCP 3						
							QCP 5A						
							QCP 9						
							QCP E9	MORRISON	P6				
								CAMPBELL	FO	PHYSICAL	10/20/83	MWE	5.0
										MVR-E-2698	10/20/83		
E0033	CONTAINMENT	1	RACEWAY SUPPORT	10/F-140-5-965	10/15/83		QCP 3						
							QCP 5A						
							QCP 9						
							QCP E9	MORRISON	P6				
								CAMPBELL	FO	PHYSICAL	10/20/83	MWE	5.0
										MVR-E-2699	10/20/83		
E0039	PENETRAT BLDG	1	RACEWAY SUPPORT	146EBW1151313	10/18/83	10/31/83	QCP 3						
							QCP 5A						
							QCP 9						
							QCP E9	MORRISON	P6				
								CAMPBELL	FO	PHYSICAL	10/20/83	MWE	3.0
										MVR-E-2703	10/20/83		
										ACC-W/D-QA	10/31/83	MWE	2.0
E0043	TURBINE BLDG	1	RACEWAY SUPPORT	11/C-104-8-10	10/19/83	11/17/83	QCP 3						
							QCP 5A						
							QCP 9						
							QCP E9	MORRISON	P6				
								CAMPBELL	FO	PHYSICAL	10/19/83	RMB	7.0
										RECORDS	10/19/83	MWE	6.0

									MVR E-2705	10/31/83		
									ACC-W/D-QA	11/17/83	RMB	1.0
E0044 TURBINE BLDG	1 RACEWAY SUPPORT	15/A-119-3-44	10/19/83	11/15/83	QCP 3							
					QCP 5A							
					QCP 9							
					QCP E9	MORRISON	P6					
						CAMPBELL	FO	DIMENSION	10/19/83	RMB	7.0
								RECORDS	10/19/83	MWE	6.0
								MVR E-2704	10/31/83		
								MVR E-2706	10/31/83		
								ACC-W/D-QA	11/15/83	RMB	1.0
E0075 TURBINE BLDG	1 RACEWAY SUPPORT	45/A-119-5-48	10/26/83	11/01/83	QCP 3							
					QCP 9							
					QCP E9	MORRISON	P6					
						MELLO	FO	RECORDS	10/26/83	RMB	1.0
								PHYSICAL	10/26/83		
								MVR-E-2711	10/26/83		
								ACC-W/D-QA	11/01/83	RMB	1.0
E0077 TURBINE BLDG	1 RACEWAY SUPPORT	50/A-107-7-88	10/27/83	11/02/83	QCP 3							
					QCP 5A							
					QCP 9							
					QCP E9	MORRISON	P6					
						MELLO	FO	RECORDS	10/27/83	RMB	1.0
								PHYSICAL	10/27/83		
								MVR-E-2713	10/27/83		
								ACC-W/D-QA	11/02/83	RMB	1.0
E0078 TURBINE BLDG	1 RACEWAY SUPPORT	50/A-119-2-15	10/27/83	11/02/83	QCP 3							
					QCP 5A							
					QCP 9							
					QCP E9	MORRISON	P6					
						MELLO	FO	RECORDS	10/27/83	RMB	1.0
								PHYSICAL	10/27/83		
								MVR-E-2714	10/27/83		
								ACC-W/D-QA	11/02/83	RMB	1.0
E1002 AUX BLDG	1 RACEWAY SUPPORT	CSR-127-4-56	11/08/83	11/17/83	QCP E9	CAMPBELL	FO					
						MORRISON	P6	MVR-E-2729	11/17/83	RP	3.0
E1014 CONTAINMENT	1 RACEWAY SUPPORT	H-85-1-42	11/08/83	11/17/83	QCP E9	CAMPBELL	FO					
						MORRISON	P6	MVR-E-2729	11/17/83	RP	3.0
M0023 CONTAINMENT	1 PIPE HANGER	12-196SL	7/07/83	10/12/83	ESD 223	TINKLE	P6					
						GAUDIUSO	P6	RECORDS	9/02/83	MWE	8.0
								MVR-M-4542	9/02/83	MWE	6.0
*M0025 (see next page)								ACCEPTED	10/12/83			
M0029 N/A	1 PIPE HANGER	46-9V	7/11/83	7/11/83	ESD 223	HOWELL	BE					
						TINKLE	P6	CITATION	7/11/83	AGD	1.0
										RP	1.0
M0047 N/A	1 PIPE HANGER	22-396SL	7/13/83	7/13/83	ESD 223	TINKLE	P6					
						HOWELL	BE	DR-5184	7/13/83	AGD	2.0
										RP	1.0
M0085 AUX BLDG	1 PIPE HANGER	55S-172R	7/19/83	9/02/83	ESD 223	TINKLE	P6					
						GIACOLONI	BE					
						GAUDIUSO	P6	PHYSICAL	8/20/83		
								WELD	8/20/83	MWE	5.0
								MVR-M4511	8/20/83	MWE	1.0
								ACCEPTED	9/02/83		
M0087 CONTAINMENT	1 PIPE HANGER	57N-38R	7/20/83	9/02/83	ESD 223	GAUDIUSO	P6					
						TINKLE	P6					
						HOWELL	BE	WELD	8/20/83	MWE	5.0
								RECORDS	8/20/83		
								MVR-M4511	8/20/83		
								ACCEPTED	9/02/83	MWE	1.0
M0088 CONTAINMENT	1 PIPE HANGER	57N-28V	7/20/83	9/02/83	ESD 223	TINKLE	P6					
						GIACOLONI	BE					
						GAUDIUSO	P6	WELD	8/20/83	MWE	5.0
*M0138 (see next page)								MVR-M4511	8/20/83			
								ACCEPTED	9/02/83	MWE	1.0
M0160	1 PIPE HANGER	73-39R	8/09/83	9/15/83	ESD 223	TINKLE	P6					
						GADICO	P6					
						DOLE	P6	MVR M-4533	9/15/83	RGS	1.0
										CHM	1.0
M0200	1 PIPE HANGER	92-103R	8/17/83	9/15/83	ESD 223	TINKLE	P6					
						GADICO	P6					
						DOLE	P6	DR 5144	9/15/83	EWR	1.0
										CHM	3.0
M0261 N/A	1 PIPE HANGER	22-547SL	8/24/83	8/24/83	ESD 223	TINKLE	P6					
						LORTIE	BE	MVR 4542	8/24/83	AGD	1.0
M0330	1 HVAC SUPPORT	SKC-HV570	8/11/83	9/20/83	QCP 40	BERGSTEDT	FO					
						O'CONNOR	P6	IR8827-71	9/20/83	RGS	1.0
										CHM	3.0

M0131	1 HVAC SUPPORT	SKC-HV56B	8/11/83	9/20/83	QCP 40	BERGSTEDT	FO						
						O'CONNOR	PG	IR8827-71	9/20/83	RBS	1.0		
										CHM	3.0		
M0344	1 HVAC SUPPORT	SKC-HV367	8/11/83		QCP 40	NOVACK	FO						
						CARLSON	FO						
						BERGSTEDT	FO	IR8827-73	9/20/83	RBS	1.0		
										CHM	2.0		
S0003 CONTAINMENT	1 ANNULUS	6181-C1-13-610	7/14/83		QCP 3								
					QCP 5A								
					QCP C7								
					QCP 9	KOHLER	BE						
						KITCHEN	PG						
						BERG	FO	PHYSICAL	9/15/83				
								QA	9/15/83				
								NCR5422272	9/15/83	MWE	5.0		
S0046 N/A	1 SWITCH GEAR	6422-T1-13-871	8/25/83	8/31/83	QCP 3	PALARMO	PG	NCR	8/31/83	AGD	1.0		
								5422-255	8/31/83				
S0049 N/A	1 SWITCH GEAR	6422-T1-13-874	8/25/83	8/31/83	QCP 3	PALARMO	PG	NCR	8/31/83	AGD	1.0		
								5422-246	8/31/83				
S0061 FUEL HANDLING	1 FUEL HANDLING	6180-F1-13-026-016	9/22/83	10/20/83	QCP 3								
					QCP 5A								
					QCP C7	KOHLER	BE						
						TINGLEY	FO						
						CANNING	FO						
						MUNRO	BE	WELD	10/14/83	MWE	3.0		
								NCR-8833	10/14/83				
								ACC-W/O-QA	10/20/83	MWE	2.0		
S0062 FUEL HANDLING	1 FUEL HANDLING	6180-F1-13-026-116	9/22/83	10/20/83	QCP 3								
					QCP 5A								
					QCP C7	KOHLER	BE						
						TINGLEY	FO						
						CANNING	FO						
						MUNRO	BE	WELD	10/14/83	MWE	3.0		
								NCR-8833					
								ACC-W/O-QA	10/20/83	MWE	2.0		
S0063 TURBINE BLDG	1 TURBINE BLDG	6424-T1-13-794	11/01/83		QCP 3								
					QCP 5A								
					QCP C7								
					QCP 9	KOHLER	BE						
						HARRISON	BE						
						BERG	FO						
						MARTINSON	FO						
						KIRSCH	NR	WELD	11/01/83	MWE	16.0		
								NCR	11/03/83	RMB			
								5422-332	11/03/83				
								NCR	11/03/83				
								5422-333	11/03/83				
								NCR	11/03/83				
								5422-341	11/03/83				
								NCR	11/10/83	MWE	10.0		
								5422-351	11/10/83				
								CITATION	11/18/83	MWE	10.0		
M0025 AUX BLDG	1 PIPE HANGER	855-66R	7/07/83	9/15/83	ESD 223	TINKLE	PG						
						SMITH	BE						
						BAUDIUSD	PG	PHYSICAL	9/02/83	MWE			
										MWE			
								MVR (4503)	9/02/83				
								ACCEPTED	9/15/83				
M0138 TURBINE BLDG	1 PIPE HANGER	384-393R	8/02/83	9/15/83	ESD 223	TINKLE	PG						
						HOWELL	BE	PHYSICAL	9/02/83				
								DR-5144	9/02/83	MWE			
								ACCEPTED	9/15/83	MWE			

NRC Form 307

ALLEGATION DATA FORM

Instructions on reverse side

Related to Allegation No. RV-83-A-0028

U.S. NUCLEAR REGULATORY COMMISSION

RECEIVING OFFICE

1. Facility(ies) Involved: (If more than 3, or if generic, write GENERIC)

(Name) DIABLO CANYON UNITS 1 AND 2

Docket Number (If applicable): 50-275; 50-323

2. Functional Area(s) Involved: (Check appropriate box(es))

- [ ] operations
- [X] construction
- [ ] safeguards
- [ ] other (Specify)
- [ ] onsite health and safety
- [ ] offsite health and safety
- [ ] emergency preparedness

3. Description: (Limit to 100 characters)

ALLEGATIONS MADE AGAINST BECHTEL CONSTRUCTED UNIT 1 CONTAINMENT BUILDING

4. Source of Allegation: (Check appropriate box)

- [X] contractor employee
- [ ] licensee employee
- [ ] NRC employee
- [ ] organization (Specify)
- [ ] other (Specify)
- [ ] security guard
- [ ] news media
- [ ] private citizen

5. Date Allegation Received: MM 03 DD 11 YY 83

6. Name of Individual Receiving Allegation: (First two initials and last name) T. W. BISHOP/P. J. NIEDZIELSKI

7. Office: RS

ACTION OFFICE

8. Action Office Contact: (First two initials and last name) D. F. KIRSCH

9. FTS Telephone Number: 463-3723

10. Status: (Check one)

- [ ] Open, if followup actions are pending or in progress
- [ ] Closed, if followup actions are completed

11. Date Closed: MM DD YY

M-13

12. Remarks: (Limit to 50 characters)

12.1 Man-hours/Date

13. Allegation Number: Office RV - Year 83 - A - Number 0028

44

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 ☒ /LOCATION

CLASS 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.

INITIATED BY [signature] DATE 6-14-83

Q.C. SUPERVISOR REVIEW [signature] DATE 6-14-83

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.

DISPOSITION BY [signature] DATE 6/15/83

QUALITY REVIEW [signature] DATE 6/14/83

P.G.& E. CO. [signature] DATE 6/30/83

DISPOSITION ACCOMPLISHED

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

PREVIOUS WORK "ACCEPTED AS IS" PER ABOVE STATED DISPOSITION

VERIFIED BY [signature] DATE 7/11/83

Q.C. SUPERVISOR [signature] DATE 7/11/83

FOR INFORMATION ONLY
Close to File (date) 7/11/83

FOIA-84-21

N-1 1.

HPF/NCR 5-20-83

ORIGINAL

NONCONFORMANCE REPORT

DESCRIPTION:
Welds, weld rod size [illegible] type [illegible]

DATE:

REF. HDR/IR NUMBER:

UNIT I [X] UNIT II [X] LOCATION [illegible]

CLASS I [X] NON-CLASS I [ ]

INSPECTION CRITERIA: DRAWING [ ] SPECIFICATION [ ] PROCEDURE [X]

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

DESCRIPTION OF NONCONFORMANCE: (Including Cause)

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

INFORMATION ONLY

INITIATED BY 12/6/83 DATE

Q.C. SUPERVISOR REVIEW 8/2/83 DATE

H.P. POLEY 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 8/1/83 QUALITY REVIEW DATE 8/1/83

P.G.& E. DISPOSITION OR CONCURRENCE:

OK by PGXE

NB

ASME

DISPOSITION APPROVED

N-2

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO. 0002-R21 Rev 2

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

PAGE ___ OF ___

DATE 4-1-87

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 SIWS's & WIS's.

INFORMATION ONLY

APPROVAL OF DISPOSITION

HPF 4311

THE HOWARD P. FOLEY COMPANY

NONCONFORMANCE REPORT

Page 1 of 6

NUMBER: 8902-92A

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 [X] UNIT II [X] /LOCATION Various

CLASS I [X] NON-CLASS I [X]

INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION [X] PROCEDURE [X] 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)

Steven B Vines 9-6-83

INITIATED BY DATE

Q.C. SUPERVISOR REVIEW DATE

H.P. FOLEY DISPOSITION:

VOID 11/29/83

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

NPF/NCR 7-18-83

N-3 3.

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. 8802-92

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

PAGE 3 OF 6

DATE 9-6-83

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

HPF 7/CR

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO. 5802-929

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

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

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO. B602-929

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

PAGE 5 OF 6

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/HCR

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO. 8802-924

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

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 Vinen

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.

NCR 10-4-83 8802-942

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.

NCR 10-3-83 8802-938

10. This has not resulted in a non-conforming condition. Engineering is processing a PCN to revise the wording in the procedure.

Foley

THE WARD P. FOLEY COMPANY

INFORMATION ONLY

11. See Item 10.

12. No Class 1 automatic stud welding has been performed on the project since the 1982 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.

8802-940
10-4-83

FOLEY

THE
HOWARD P. FOLEY
COMPANY

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.

10-4-83
8802-941

RW:tt

cc NCR 8802-924

INFORMATION ONLY

ELECTRICAL

UNIT I [X]
UNIT II [X]

SEP 28 1983

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

No 9756

To G. Glascock

Subject Detail versus Procedure

From Kay B. Emanuelson

050030

Problem Question has arisen concerning detail versus procedural requirements. Note 1 of the 050029 Drawing states that the detail prevails for conduit over the procedure. Numerous situations arise when the support details conflict with the procedure.

Reference S-18-1, REV. 30A embedment criteria versus embedment criteria in QCPE-9, Paragraph 4.7.6. Can it be assumed in all cases that the detail drawing prevails over procedure in reference to the 050030 details also?

Signed Kay B Emanuelson Date 9/26/83

Reply YES.

Signed A.J. Howard Date 9/27/83

N-4

4

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 [8802-938]

[X] FOR YOUR RECOMMENDED DISPOSITION
[ ] FOR CORRECTIVE ACTION
[ ] FOR YOUR SIGNATURE

THANK YOU

[Tom]

DATE RECEIVED ____
RECEIVED BY ____
RETURN ORIGINAL SIGNED AND DATED TO ____

FORM H.P.F./T.

N-5

ORIGINAL

THE HOWARD P. FOLEY COMPANY

NONCONFORMANCE REPORT

Page 1 of 1

NUMBER: 8802-938

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

ATTACHMENTS Yes ☐ No ☒

DATE: 10-3-83

HOLD TAG # REMOVED BY _____ DATE _____

REF. RFT/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATION Battery Room

CLASS I ☒ NON-CLASS I ☐

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

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

DESCRIPTION OF NONCONFORMANCE: (Including Cause) 1. 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 [signature] DATE 10-5-83

Q.C. SUPERVISOR REVIEW [signature] DATE 10-5-83

H.P. FOLEY DISPOSITION:

[illegible] this is generic and not specific to our Battery Rack. I don't know if PG&E's Engineering Department has the latest revision of the generic drawing.

[illegible] DATE

QUALITY REVIEW [illegible] DATE

P.G.& E. DISPOSITION OR CONCURRENCE:

Added info or different? If it's a work copy, info can be added for clarity and cost of construction and no PG&E Concurrence is required. If QA has control that's all that's needed

INFORMATION ONLY

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 ____
IR/NCR 8802-942

- [x] FOR YOUR RECOMMENDED DISPOSITION
- [ ] FOR CORRECTIVE ACTION
- [ ] FOR YOUR SIGNATURE

THANK YOU

Tom

FORM RECEIVED ____
RECEIVED BY ____
RETURN ORIGINAL SIGNED AND DATED TO ____

FORM H.P.F./T.

INFORMAL

N-6

6.

ORIGINAL

THE HOWARD P. FOLEY COMPANY

NONCONFORMANCE REPORT

Page 1 of 1

NUMBER: 8802-942

DESCRIPTION:

PROCEDURE VIOLATION - QCP-5A

ATTACHMENTS Yes ☐ No ☒

DATE: 10-4-83

HOLD TAG # N/A REMOVED

BY _____ DATE _____

REF. MPT/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATION

CLASS I ☐ NON-CLASS I ☐

INSPECTION 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?

Lee L. Vinson 10-4-83

INITIATED BY DATE

Gary Roell 10-5-83

Q.C. SUPERVISOR REVIEW DATE

M.P. FOLEY DISPOSITION:

SIGNATURE DATE QUALITY REVIEW DATE

P.G.& E. DISPOSITION OR CONCURRENCE:

INFORMATION ONLY

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

IR NCR 8802-940

[X] FOR YOUR RECOMMENDED DISPOSITION

[ ] FOR CORRECTIVE ACTION

[ ] FOR YOUR SIGNATURE

Clyde,

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

THANK YOU

Tom

DATE RECEIVED

RECEIVED BY

AN ORIGINAL SIGNED AND DATED TO

TCAM H.P.F.

N-7

INFORMATION ONLY

THE HOWARD P. FOLEY COMPANY

ORIGINAL

NONCONFORMANCE REPORT

Page 1 of 1

NUMBER: 8802-940

DESCRIPTION: THE PROCEDURE QCP-5A, WELDING PROCEDURE SPECIFICATION (WPS) IS NOT QUALIFIED

ATTACHMENT: Yes [X] No [ ]

DATE: 10-4-83

HOLD TAG # REMOVED N/A

BY _____ DATE _____

REF. HPF/IR NUMBER:

UNIT I [X] UNIT II [X] /LOCATION

CLASS I [X] NON-CLASS I [ ]

INSPECTION CRITERIA: DRAWING [ ] SPECIFICATION [ ] PROCEDURE [X]

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

DESCRIPTION OF NONCONFORMANCE: (Including Cause) 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.

Steve G. Vinson 10-4-83
INITIATED BY DATE

Ian Rorell 10.5.83
QA/C SUPERVISOR REVIEW DATE

H.P. FOLEY DISPOSITION:

DISPOSITION BY DATE

QUALITY REVIEW DATE

P.G.& E. DISPOSITION OR CONCURRENCE:

Recommended Disposition
INFORMATION ONLY

THE HOWARD P. FOLEY CORP.

DIABLO CANYON JOB SITE

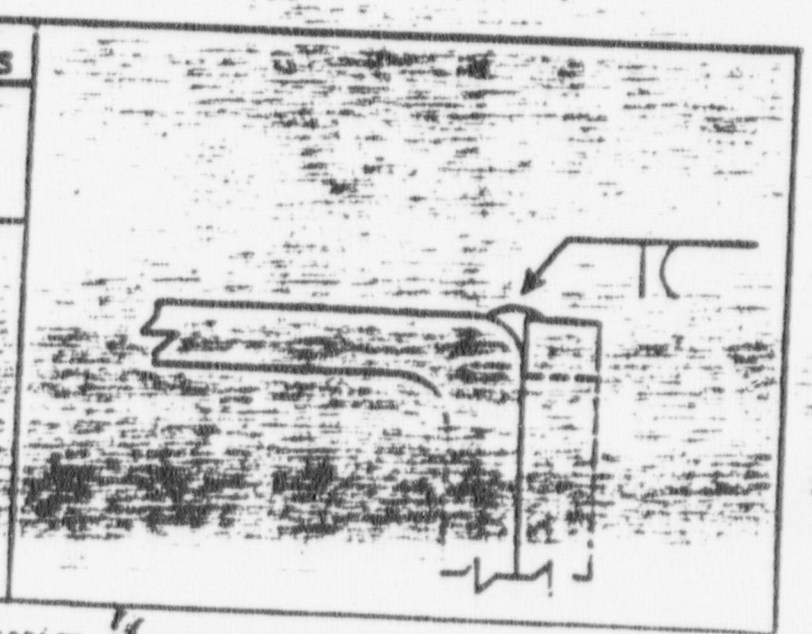
(PS) PROCEDURE SPECIFICATION NO. WPS-5A WCP-5A

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 1½" 50°F; over 1½" and thru 2½", 150°F; over 2½", 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 PASSES	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



This procedure may vary due to fabrication sequence, fit-up, pass size, etc within the "Limitation of Variables" given in the American Welding Society

INFORMATION ONLY

Recommended Disposition

THE HOWARD P. POLEY COMPANY

NONCONFORMANCE REPORT

Page 1 of 2

NUMBER: 8802-943

DESCRIPTION: Class One Support Rework

ATTACHMENTS Yes ☐ No ☐

DATE: 10-5-83

HOLD TAG # N/A
REMOVED
BY _____ DATE _____

REP. HPF/IR NUMBER: N/A

UNIT I [X] UNIT II [X] /LOCATION Various — CLASS I [X] NON-CLASS I ☐

INSPECTION CRITERIA: DRAWING ☐ SPECIFICATION ☐ PROCEDURE [X]

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, deletions, additions or complete replacement) and verification inspection." Contrary to this, "Conduit" Change Orders are being issued to cover "Support" work. These Conduit Change Orders do not reference any work request and do not fall within the scope of Appendix D.
(CONTINUED ON PAGE 2)

R. Munro 10-5-83
INITIATED BY DATE

Q.C. SUPERVISOR REVIEW DATE

H.P. POLEY DISPOSITION:

FIRED ON 10-6-83
by by [Pete]

DISPOSITION BY DATE

QUALITY REVIEW DATE

P.G.& E. DISPOSITION OR CONCURRENCE:

INFORMATION ONLY

P.G.& E. Co. DATE

DISPOSITION ACCOMPLISHED

N-8

VERIFIED BY DATE

Q.C. SUPERVISOR DATE

HPF/NCR 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."

CIVIL

№ 1486

UNIT I [X]
UNIT II [ ]

OCT 1983

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

BM
DJ

To F.M. Russell Subject Structural Welding Requirements

From D. Jones

BC
LF
BB
JG
CA
ES
AD

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 referanced 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 [signature] 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 / Robt W. Fugman Date October 7, 1983

RICK

To: IVAN VINES

CHECK THIS OUT

DAVE

N-9 9.

ORIGINAL

THE HOWARD P. FOLEY COMPANY

NONCONFORMANCE REPORT

Page 1 of 1

NUMBER: 8802-938 Rev 1

DESCRIPTION: VARIOUS MINIMUM SIZED FILLET WELDS WERE MADE UTILIZING THE MULTI-PASS WELD TECHNIQUE

ATTACHMENTS Yes ☐ No ☒

DATE: 10-7-83

HOLD TAG # REMOVED BY _____ DATE _____

REF. HPF/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATION VARIOUS

CLASS I ☒ NON-CLASS I ☐

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

DOCUMENT TITLE AND NUMBER: QC Procedure for Structural Welding QCP-5A AWS D1.1

DESCRIPTION OF NONCONFORMANCE: (Including Cause) There is a deficiency in the above referenced procedure which renders the quality of the items utilized in conjunction with the procedure as unacceptable. The above referenced code specifies the minimum fillet weld size and requires that this size be made in a single pass. The above reference procedure does not note this requirement and welds have been made in violation of this requirement.

Steven S Vance 10-7-83
INITIATED BY DATE

Tom Rowell 10-7-83
Q.C. SUPERVISOR REVIEW DATE

H.P. FOLEY DISPOSITION:

DISPOSITION BY DATE

QUALITY REVIEW DATE

P.G.& E. DISPOSITION OR CONCURRENCE:

P.G.& E. Co. DATE

DISPOSITION ACCOMPLISHED

VERIFIED BY DATE

Q.C. SUPERVISOR DATE

HPF/NCR 7-18-83

N-10

101

ORIGINAL

THE HOWARD P. FOLEY COMPANY

NONCONFORMANCE REPORT

Page 1 of 1

NUMBER: 8802-940 Rev 1

DESCRIPTION: ~~PIP PPC EDMR QCP-5A~~, WELDING PROCEDURE SPECIFICATION (WPS) IS NOT QUALIFIED

ATTACHMENTS Yes [X] No [ ]

DATE: 10-7-83

HOLD TAG # N/A REMOVED

BY _____ DATE _____

REF. HPF/IR NUMBER: N/A

UNIT I [X] UNIT II [X] /LOCATION

CLASS I [X] NON-CLASS I [ ]

INSPECTION CRITERIA: DRAWING [ ] SPECIFICATION [ ] PROCEDURE [X]

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.

[signature] 10-7-83
INITIATED BY DATE

[signature] 10-7-83
Q.C. SUPERVISOR REVIEW DATE

INFORMATION ONLY

H.P. FOLEY DISPOSITION:

DISPOSITION BY DATE

QUALITY REVIEW DATE

P.G.& E. DISPOSITION OR CONCURRENCE:

P.G.& E. Co. DATE

DISPOSITION ACCOMPLISHED

VERIFIED BY DATE

Q.C. SUPERVISOR DATE

HPF/NCR 7-18-83

N-11

11.

Material Specification
Base Metals
Thickness of Plates
Position of Welding
Position of Weld
Filler Metal Specification
Filler Metal Classification
Flux
Weld Metal Grade
Shielding Gas
Single or Multiple Pass
Single or Multiple Arc
Welding Current
Polarity
Root Treatment
Preheat and Interpass Temperature

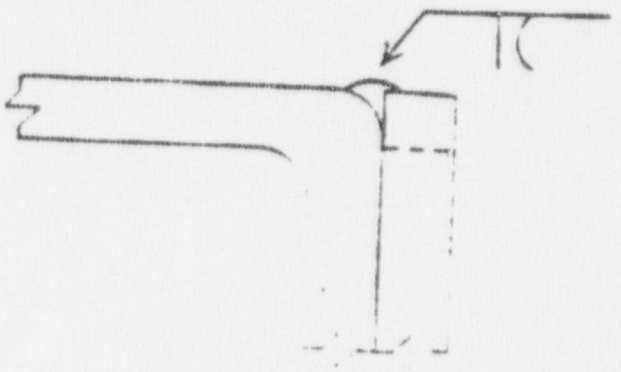
SFA A5.1
E7018
All
70,000 PSI
N/A
Multiple Pass
Single
Direct
Reverse
None

Up to and thru 3/4", none (*); over 3/4" and thru 1½" 50°F; over 1½" and thru 2½", 150°F; over 2½", 212°F. *When base metal temperature is below 70°F, base metal shall be preheated to and maintained at or above 70°F during welding.

NO. OF PASSES	ELEC. SIZE	CURRENT AMPS	CURRENT 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.



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

RETURN ORIGINAL SIGNED AND DATED TO

FORM H.P.F./T.

THE HOWARD P. FOLEY COMPANY

ORIGINAL

NONCONFORMANCE REPORT

Page 1 of 1

NUMBER: 8802-941

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

ATTACHMENTS Yes [X] No [ ]

DATE: 10-4-83

HOLD TAG # REMOVED N/A

BY _____ DATE _____

REF. HPF/IR NUMBER: N/A

UNIT I [X] UNIT II [X] /LOCATION

CLASS I [ ] NON-CLASS I [ ]

INSPECTION CRITERIA: DRAWING [ ] SPECIFICATION [ ] PROCEDURE [X]

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:

Ben B. Vinson 10-4-83
INITIATED BY DATE

Greg Rull 10.5.83
QTC. SUPERVISOR REVIEW DATE

E.P. FOLEY DISPOSITION:

DISPOSITION BY DATE

QUALITY REVIEW DATE

P.G.& 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

ORIGINAL

NONCONFORMANCE REPORT

Page 1 of 1

NUMBER: 8802-942 Rev 1

DESCRIPTION:

PROCEDURE VIOLATION - QCP-5A Paragraph 3.2.1

ATTACHMENTS Yes ☐ No ☒

DATE: 10-7-83

HOLD TAG # REMOVED

BY _____ DATE _____

REF. HPF/IR NUMBER: N/A

UNIT I ☒ UNIT II ☒ /LOCATION

CLASS I ☐ NON-CLASS I ☐

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.

Bryan S. Vinson 10-7-83
INITIATED BY DATE

Jerry Rorell 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

Q.C. SUPERVISOR DATE

I. PENICK 7-18-83

N-12

12.

To: [illegible] Rossi[illegible] / Quality Supervisor
From: [illegible] G. Jones / Q.C. Inspector II
REF NCR 8802-924 / Meeting of 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 aggreed 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 belive 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 [illegible] NCR E802-924 and it's voiding [illegible] the attached letter dated Sept [illegible] 1983 its evaluation and res[illegible]

Again, other non-conforming areas are in the [illegible]

[illegible]

[illegible]

ELECTRICAL

UNIT I ☒
UNIT II ☒

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

№ 10066

To G. Glascock Subject GCP5A

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 D. J. Glascock Date 10/6/83

THE HOWARD P. FOLEY COMPANY

ORIGINAL NONCONFORMANCE REPORT

Page 1 of 1

Number: 8833XR-23

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

YES ☐ NO ☐
ATTACHMENTS

Date: 2-7-83

REF. HPF/IR NUMBER 8833XR-14

HOLD TAG # 8833XR-14
☒ REMOVED
BY [signature] DATE 4-7-83

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.

[signature] 2-17-83 INITIATED BY DATE

[signature] 2-17-83 QUALITY MANAGER DATE

[signature] 2-23-83 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 distrotion control.

[signature] 2/22/83 DISPOSITION BY DATE

[signature] 2-28-83 PROJECT MANAGER DATE

[signature] 2/22/83 QUALITY MANAGER DATE

[signature] 2-24-83 PACIFIC GAS AND ELECTRIC CO. DATE

DISPOSITION ACCOMPLISHED

PT Accomplished and found Acceptable on 3-3-83
Training meetings held 3-4-83.

[signature] 3-3-83 INSPECTOR DATE

[signature] 3-17-83 SUPERINTENDENT DATE

[signature] 3/17/83 QUALITY MANAGER DATE

THE HOWARD P. FOLEY CO. ACCEPTANCE

CLOSED for file 4/7/83

[signature] 3-17-83 PROJECT MANAGER DATE

PACIFIC GAS AND ELECTRIC CO. ACCEPTANCE

[signature] 3-24-83 SIGNATURE DATE

CIVIL

UNIT I ☒
UNIT II ☐

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

No. 1486

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 referanced 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 [signature] 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 / [signature] Date October 7, 1983

RICK

To: [illegible]

CHECK THIS OUT

DAVE

N-13

13.

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 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.

Danny W. Hall 13 OCT 83
INITIATED BY DATE

Tony Boull 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.
   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 10-13-83
DISPOSITION BY DATE

R W [illegible] 10/13/83
QUALITY REVIEW DATE

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

D.L. Shroad 10/13/83
P.G.& E. C[illegible] DATE

DISPOSITION ACCOMPLISHED

_____ _____
VERIFIED BY DATE Q.C. SUPERVISOR DATE

H ICR 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 ☐

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" documumentation. 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.

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 24 1983

To M. Coley/R. Dizon/R. Monterola Subject WR-D1238 DC1-EC-3604-A

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

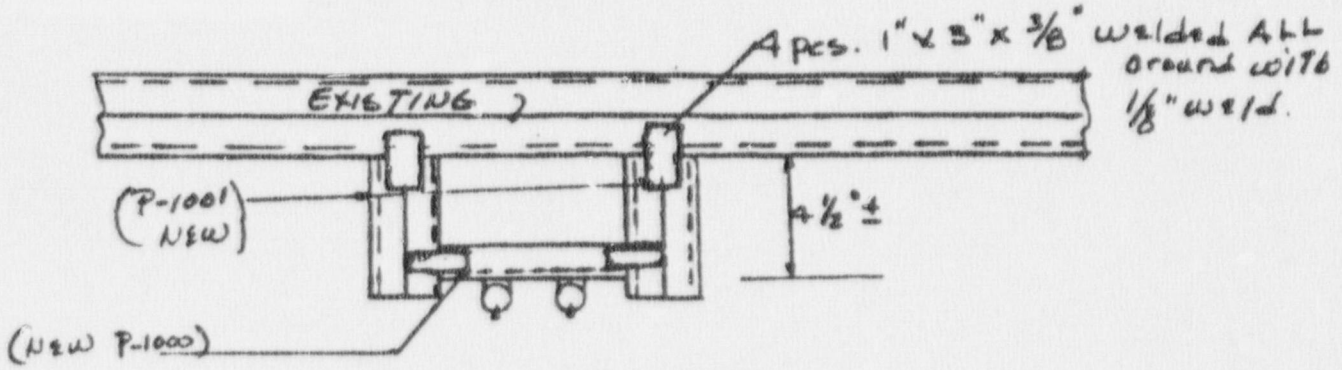
Reply ① YES, 452 attached new "fix" (Page1) as approved by OPEG. (S-190) CSR-127-4-52

② YES, 3 welds will be sufficient. See attached (Page2) for CSR-127-6-343. (S-428)

Signed R.V. Mayo W.M. Coley Date 1/24/83

Attachment

Page 1



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

DETAIL S-190

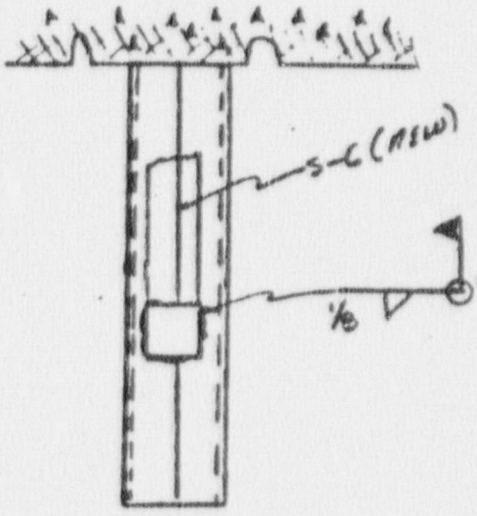
Per DCI-EC-3604-[illegible] and W.R. E-1238

TO: ~~ED EPSTEIN (OPEG)~~

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

2. YES, Per ~~ED EPSTEIN~~ (1-21-83) R.V. Montevola 1/21/83

PACIFIC GAS & ELECTRIC CO.
APPROVED FOR CONSTRUCTION
~~ENGINEERING DEPARTMENT~~
BY [illegible] DATE 1/21/83



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-42E
PER DC1-EC-3604-4 and W.R. E-1238

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

PACIFIC GAS & ELECTRIC CO.
APPROVED FOR CONSTRUCTION
ENGINEERING DEPARTMENT
BY [signature] DATE 1/21/83

R.V. Montero
1/21/83

Part of EDR 1486 Package in Alleg. file 101

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 [Pete's] intent to "not follow management's 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. Taggart]
Elec QC Inspector

TO: [Tommy Roselli, Quality Supervisor]
FROM: [Ivan G. Vines, Q.C. Inspector II]
REF NCR [8802-924] MEETING OF [9/27/83]
DATE: [Sept 30, 1983] 9/K

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 AGGREED ON AT THE ABOVE REFERENCED MEETING, THE CONTENTS OF THE LETTER IS DIFFERENT IN SOME AREAS OF THE NCR THAN THAT WHAT WAS DISCUSSED.

I FIRMLY BELIVE 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 PROCEDURE.

SINCERELY,
[I. G. Vines]

10-10-83

TO: Iven Vines, Q.C. Inspector ~~II~~

From: Terry Rosell, Q.C. Supervisor

Ref: NCR E802-924 voiding

Mr. Vines

Contained herein is my response to your letter dated 9-30-83. Your first concern dealt with the voiding of NCR E802-924 and the letter that was ~~&~~ 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 ~~this~~ procedural rights to do so per QCP-3.

The second concern dealt with a meeting that was held with yourself, Terry Rosell, Dave Jones and Rick Wilson. The discussion dealt with ~~management and~~ a/c & engineering and QC managements comments on NCR E802-924. 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 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 NCR 802-924, 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

Tony Rowell

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 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.

Ramon Wilson — INITIATED BY — 13 OCT 83 — DATE

G. Vincent Boult — 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

R.W. [illegible] — QUALITY REVIEW — 10/13/83 — DATE

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

D.J. Garrood — P.G.& E. Co. — 10/13/83 — DATE

DISPOSITION ACCOMPLISHED

VERIFIED BY _____ DATE _____ Q.C. SUPERVISOR _____ DATE _____

WORK COPY

NCR 18-83

N-14 14

ginal

THE HOWARD P. FOLEY COMPANY
NONCONFORMANCE REPORT - CONTINUATION SHEET

NO. 8802-871 Rev.2

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

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" documumentation. 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: