



**UNITED STATES
NUCLEAR REGULATORY COMMISSION**
REGION II
245 PEACHTREE CENTER AVENUE N.E., SUITE 1200
ATLANTA, GEORGIA 30303-1200

July 7, 2021

Mr. Mike Annacone
Vice President, Columbia Fuel Operations and Manager, Columbia Plant
Westinghouse Electric Company
5801 Bluff Rd
Hopkins, SC 29061

SUBJECT: WESTINGHOUSE ELECTRIC COMPANY – INTEGRATED INSPECTION
REPORT 07001151/2021002

Dear Mr. Annacone:

On June 30, 2021, the U.S. Nuclear Regulatory Commission (NRC) completed an inspection at Westinghouse Electric Company. On June 22, 2021, the NRC inspectors discussed the results of this inspection with you and other members of your staff. The results of this inspection are documented in the enclosed report.

No violations of more than minor significance were identified during this inspection.

This letter, its enclosure, and your response (if any) will be made available for public inspection and copying at <http://www.nrc.gov/reading-rm/adams.html> and at the NRC Public Document Room in accordance with Title 10 of the *Code of Federal Regulations* 2.390, "Public Inspections, Exemptions, Requests for Withholding."

Sincerely,

/RA/

Noel A. Pitoniak, Chief (Acting)
Projects Branch 2
Division of Fuel Facility Inspection

Docket No. 07001151
License No. SNM-1107

Enclosure:
As stated

cc w/ encl: Distribution via LISTSERV®

SUBJECT: WESTINGHOUSE ELECTRIC COMPANY – INTEGRATED INSPECTION
 REPORT 07001151/2021002 dated July 7, 2021

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**U.S. NUCLEAR REGULATORY COMMISSION
Inspection Report**

Docket Number: 07001151

License Number: SNM-1107

Report Number: 07001151/2021002

Enterprise Identifier: I-2021-002-0116

Licensee: Westinghouse Electric Company

Facility: Columbia Fuel Fabrication Facility

Location: Hopkins, SC

Inspection Dates: June 21 to June 25, 2021

Inspectors: L. Cooke, Fuel Facility Inspector
J. Rivera Ortiz, Sr. Fuel Facility Project Inspector
R. Womack, Sr. Fuel Facility Projects Inspector

Approved By: Noel A. Pitoniak, Chief (Acting)
Projects Branch 2
Division of Fuel Facility Inspection

Enclosure

SUMMARY

The U.S. Nuclear Regulatory Commission (NRC) continued monitoring the licensee's performance by conducting an integrated inspection at Westinghouse Electric Company, in accordance with the fuel cycle facility inspection program. This is the NRC's program for overseeing the safe operation of licensed fuel cycle facilities. Refer to <https://www.nrc.gov/materials/fuel-cycle-fac.html> for more information.

List of Violations

No violations of more than minor significance were identified.

Additional Tracking Items

None.

PLANT STATUS

The Westinghouse Facility converts uranium hexafluoride (UF₆) into uranium dioxide using a wet conversion process and fabricated fuel assemblies for use in commercial nuclear power reactors. During the inspection period, normal production activities were ongoing.

INSPECTION SCOPES

Inspections were conducted using the appropriate portions of the inspection procedures (IPs) in effect at the beginning of the inspection unless otherwise noted. Currently approved IPs with their attached revision histories are located on the public website at <http://www.nrc.gov/reading-rm/doc-collections/insp-manual/inspection-procedure/index.html>. Inspections were declared complete when the IP requirements most appropriate to the inspection activity were met consistent with Inspection Manual Chapter (IMC) 2600, "Fuel Cycle Facility Operational Safety and Safeguards Inspection Program." The inspectors reviewed selected procedures and records, observed activities, and interviewed personnel to assess licensee performance and compliance with Commission rules and regulations, license conditions, site procedures, and standards.

FACILITY SUPPORT

88051 - Evaluation of Exercises and Drills

The inspectors observed and evaluated the licensee's graded biennial exercise conducted on June 22, 2021, as well as briefings and post-drill evaluations involving both on-site and off-site participants, to verify compliance with 10 CFR 70.22(i)(3)(xii), the Emergency Plan, and Chapter 9 of the license application. The scenario included a spill of special nuclear material, followed by a simulated medical emergency and a spill of ammonia solution near the initial spill of SNM. The exercise was designed to test emergency response actions for plant evacuation and accountability, control of spilled material, assessment of plant conditions and potential hazards, and treatment of plant personnel with medical needs. External emergency responders included Columbia Fire, Richland County Emergency Services, South Carolina Department of Health and Environmental Control, and PRISMA Richland Hospital.

Exercise Planning (IP Section 02.01)

The inspectors reviewed the emergency exercise scenario, discussed the exercise objectives with licensee personnel, observed the exercise drill controller briefing, and walked down plant areas before the exercise to verify compliance with the Emergency Plan, Emergency Plan Implementing Procedure and 10 CFR 70.22(i)(3)(xii). The inspectors reviewed the following:

- the frequency of exercises conducted by the licensee
- the scenario as it related to testing all elements of the Emergency Plan and probability
- pre-staging of equipment in preparation for the exercise
- duties and responsibilities for exercise personnel including controllers, evaluators, and observers
- confidentiality of the scenario and objectives

Exercise Execution and Emergency Plan Implementation (IP Section 02.02)

The inspectors observed the initiation of the emergency exercise in the selected process area and the activation of the Incident Commander post and the Emergency Operations Center (EOC) to verify compliance with the Emergency Plan, Emergency Plan Implementing Procedures, and 10 CFR 70.22(i)(3)(xii). The inspectors observed or reviewed the following:

- the licensee's analysis of plant conditions including assessment and classification of the accident scenario
- staffing for EOC and Incident Command positions
- protective action recommendations implemented by the EOC
- timeliness of notifications to the NRC and local government agencies
- onsite communication to occupational workers as it related to protective action recommendations
- occupational workers participation in evacuation protective actions and the process to conduct personnel accountability
- Emergency Director's command and control of the EOC
- Incident Commander's control of the emergency response team and coordination of actions with off-site emergency responders
- health physics collection and use of applicable radiation survey and environmental monitoring results during assessment of the accident scenario
- response coordinators' recommendations regarding conditions for terminating the event and restarting normal operations
- recovery and re-entry recommendations implemented by the EOC
- members of the licensee's emergency response team assembly at designated assembly areas and the arrival of off-site emergency responders including fire and medical emergency services
- emergency response team's actions including assessment of the affected area, actions to medically treat and transport contaminated workers, and implementation of emergency plan procedures
- response to emerging situations to address the exercise scenario and meet the exercise objectives

Critiques, Exercise Control, and Identification and Resolution of Problems (IP Section 02.03)

The inspectors observed the staff critiques of the emergency exercise and reviewed the licensee's related corrective action program entries to verify compliance with the Emergency Plan, Emergency Plan Implementing Procedure and 10 CFR 70.22(i)(3)(xii). The inspectors conducted the following:

- observed the post-drill critiques conducted by the licensee
- reviewed the After Action Report identifying deficiencies captured during critiques including items planned for entry into the licensee's corrective action program

INSPECTION RESULTS

No issues were identified.

EXIT MEETINGS AND DEBRIEFS

The inspectors verified no proprietary information was retained or documented in this report.

- On June 22, 2021, the inspectors presented the integrated inspection results to Mike Annacone and other members of the licensee staff.

DOCUMENTS REVIEWED

Inspection Procedure	Type	Designation	Description or Title	Revision or Date
88051	Corrective Action Documents Resulting from Inspection	2019-7994		
	Miscellaneous	N/A	Westinghouse CFFF Emergency Exercise Planning - Worksheet for Developing Emergency Exercises	June 2021
		N/A	Master Scenario Events List (MSEL)	June 2021
		N/A	Exercise Evaluator Checklists for Emergency Operations Center	June 2021
		N/A	After Action Report Westinghouse CFFF Biennial Exercise – 2021	June 2021
	Procedures	CA-134	Columbia Plant Significant Event Response Guidelines	2
		N/A	Site Emergency Plan for the Columbia Fuel Fabrication Facility	21
		ROP-05-002	Performing Smear Surveys	16
		ROP-06-002	Roof Effluent Air Sampling and Counting	29
		ROP-06-003	Ambient Environmental Air Monitoring for Radioactivity	15
		ROP-07-001	Health Physics Response to Emergency Events	14
		SEP-002	Classification	6
		SEP-005	Evacuation, Emergency Shelter, Accountability, and General Response	13
		SEP-007	Notification Guidelines for NRC and Other Agencies	52
		SEP-013	Post Incident Analysis	2
		SEP-018	Emergency Operations Center (EOC) Operations	5
		SEPF-009-12	Command Check Sheet - Radiological Airborne Release Inside of Building	6
		SEPF-009-14	Chemical Area Evacuations	2
		SEPF-009-3	Command Check Sheet - Injured Employee	16
		SEPF-009-4	Command Check Sheet - Ammonia Release	4
SEPF-018-1		Emergency Director Checklist	9	
SEPF-018-12	Maintenance Checklist	0		
SEPF-018-2	Safety Checklist	3		

Inspection Procedure	Type	Designation	Description or Title	Revision or Date
		SEPF-018-3	EH&S Checklist	3
		SEPF-018-4	Regulatory Checklist	3
		SEPF-018-5	Communications Checklist	6
		SEPF-018-6	Operations Checklist	6