



**UNITED STATES
NUCLEAR REGULATORY COMMISSION**
WASHINGTON, D.C. 20555-0001

October 5, 2026

Joyce Hamman
Vice President of Quality
NAC International, Inc.
2 Sun Court, Suite 220
Peachtree Corners, GA 30092

SUBJECT: NAC INTERNATIONAL, INC. – NRC INSPECTION REPORT 07100018/2026201

Dear Joyce Hamman:

From August 24, 2026, through August 27, 2026, the U.S. Nuclear Regulatory Commission (NRC) conducted an announced onsite team inspection at Kanadevia Corporation (KVC) in Nagasu, Kumamoto, Japan. KVC is under contract with NAC International, Inc. (NAC) to fabricate components associated with the Model Volunteer packaging, Certificate of Compliance (CoC) Number (No.) 9403. The enclosed report presents the results of this inspection. The team conducted an exit meeting on August 27, 2026.

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,

A handwritten signature in cursive script that reads "David E. Hills".

Signed by David Hills on 10/05/26

David E. Hills, Chief
Spent Fuel Storage and Transportation Oversight
Branch
Division of Decommissioning, Fuels, ISFSIs and
Transportation

Docket No. 07100018

Enclosure:
As stated

cc w/ encl: GovDelivery Subscriber

SUBJECT: NAC INTERNATIONAL, INC. – NRC INSPECTION REPORT 07100018/2026201
DATED: OCTOBER 05, 2026.

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U.S. NUCLEAR REGULATORY COMMISSION
Inspection Report

Docket Number: 07100018

Report Number: 07100018/2026201

Enterprise Identifier: I-2026-201-0032

Certificate Holder: NAC International, Inc.

Facility: Kanadevia Corporation

Location: Nagasu, Kumamoto, Japan

Inspection Dates: August 24, 2026, to August 27, 2026

Inspectors: J. Tapp, Sr. Transportation and Storage Safety Inspector, Team Leader
M. Davis, Sr. Transportation and Storage Safety Inspector
R. Patel, Transportation and Storage Safety Inspector

Approved By: David E. Hills, Chief
Spent Fuel Storage and Transportation Oversight Branch
Division of Decommissioning, Fuels, ISFSIs and Transportation

Enclosure

SUMMARY

The U.S. Nuclear Regulatory Commission (NRC) continued monitoring the Certificate of Compliance (CoC) holder's performance by conducting an NRC inspection of NAC International, Inc. (NAC), at Kanadevia Corporation (KVC) in accordance with inspection requirements contained in the NRC's inspection procedures.

List of Findings and Violations

No violations of more than minor significance were identified.

Additional Tracking Items

None.

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>. Samples were declared complete when the IP requirements most appropriate to the inspection activity were met consistent with Inspection Manual Chapter (IMC) 2690, "Inspection Program for Storage of Spent Reactor Fuel and Reactor-Related Greater-Than-Class C Waste at Independent Spent Fuel Storage Installations and for 10 CFR Part 71 Transportation Packaging's." The inspectors reviewed selected procedures and records, observed activities, and interviewed personnel to assess CoC holder performance and compliance with Commission rules and regulations, license conditions, site procedures, and standards.

86001 - Design, Fabrication, Testing, and Maintenance of Transportation Packaging's

The "Documents Reviewed" section of this report contains a list of the selected records.

Design, Fabrication, Testing, and Maintenance of Transportation Packaging's (1 Sample) Quality Assurance Program (IP Section 02.02)

The inspectors evaluated the implementation of the NRC-approved quality assurance program (QAP) and fabrication activities to verify compliance with the requirements of the CoC Number (No.) 9403, revision 0. The inspectors reviewed implementing procedures associated with the design, modification, maintenance, assembly, testing, repair, and procurement activities. The inspectors evaluated the independence of the quality assurance organization.

10 CFR Part 21 (IP Section 02.03)

The inspectors reviewed quality procedures to verify whether provisions were in place for reporting defects that could cause a substantial safety hazard or a failure to comply with the notification of nonconformances and condition reports identified during quality activities. The inspectors reviewed selected records and interviewed personnel to verify that NAC and KVC effectively implemented the program requirements of Title 10 of the *Code of Federal Regulations* (10 CFR) Part 21 according to fabrication specifications and the NRC-approved QAP. The inspectors also reviewed postings within the facility to determine whether KVC complied with 10 CFR 21.6, "Posting Requirements," as applicable.

Design Control (IP Section 02.04)

The inspectors reviewed selected procedures, fabrication specifications, and design records to verify fabrication and quality related activities were compliant with the technical specifications, requirements in the final safety analysis report, and NRC regulatory requirements. The inspectors focused on how NAC the CoC holder of the Volunteer transportation cask, applied the design requirements to important-to-safety (ITS) components and verified application of a graded approach to identifying ITS components during design and fabrication. Specifically, the inspectors reviewed the design activities for the following:

- Drawings, fabrication sequence diagrams, and design specifications of the cask body weldment
- Inner Shell

- Top and Bottom Forging

Fabrication, Assembly and Testing (IP Section 02.05 and 02.06)

The inspectors evaluated fabrication, assembly, and test controls of ITS components by reviewing the following activities:

- Dimensional inspection of the Inner Shell and Flange
- Receipt Inspection of machined Inner Shell and Flange of Cask Body weldment
- Dye penetrant examination of the Inner Shell and Flange of Volunteer Cask Body weldment
- Visual weld inspection of the Flange and Inner Shell of Cask Body Weldment
- Ultrasonic Thickness measurement of the Inner Shell and Flange Weldment
- Surface Finish Inspection of the Inner Bottom Plate of Cask Body weldment
- Welding process specifications and controls
- Measuring and Test Equipment controls include the following equipment:
 - Ultrasonic thickness gage
 - Calipers
 - Master Angle gauge
 - Micrometer
 - Thermometer
 - Light meter
 - Surface roughness gauge
 - Welding power supply

Procurement Controls (IP Section 02.07)

The inspectors evaluated procurement processes, including receipt inspection, material traceability, and commercial-grade dedication by reviewing the following:

- Procurement and fabrication specifications for flange and inner shell
- Purchase orders for stainless steel plates, top and bottom forgings, and welding materials
- Calibration records for M&TE
- Certifications for testing and calibration services

Nonconformance and Corrective Action (IP Section 02.08)

The inspectors reviewed selected records and interviewed personnel to verify implementation of the nonconformance control and corrective action programs. The inspectors evaluated nonconformance reports and corrective action reports, including those associated with previous NRC violations.

Personnel Training and Certifications (IP Section 02.09)

The inspectors reviewed records and interviewed personnel to verify that trained and certified individuals performed quality-related activities in accordance with approved quality procedures. The inspectors reviewed completed training records for personnel conducting audits, inspections, welding and nondestructive examinations to assess and confirm that individuals complied with applicable quality procedures.

Audit Program (IP Section 02.10)

The inspectors reviewed external and internal audit programs to verify audits were scheduled, planned, and performed in accordance with applicable regulations and QAP requirements. The inspectors sampled external audits and supplier evaluations for the suppliers of procured ITS components and services to verify each supplier was audited and an annual assessment performed for continued placement on the approved suppliers list.

- Three Internal audit reports for 2025
- Qualification records for two lead auditors and one auditor
- Supplier of the Stainless-Steel Plates
- Supplier of Forged Products
- Supplier of the Welding Material

INSPECTION RESULTS

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

EXIT MEETINGS AND DEBRIEFS

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

- On August 27, 2026, the inspectors presented the inspection results to Joyce Hamman and other members of the CoC holder staff.

DOCUMENTS REVIEWED

Inspection Procedure	Type	Designation	Description or Title	Revision or Date
86001	Calibration Records	AA 387	Angle Gauge	01/09/2025
		EK 365	Electric Meter Calibration	05/16/2025
		LC320	Slide Caliper	
		U107AS7055	Ultrasonic Thickness Meter	8/31/2026
		XA A25	Clearance Gauge Calibration	10/11/2024
		XA A39	Hair Hygrometer with Thermometer	07/31/2025
		XA A49	Surface Roughness Gauge	
	Corrective Action Documents	C-25-C-05	Liquid Penetrant Examination	12/3/2025
		C-25-C-07	Unclear Cause Inconsistent with Corrective Actions	12/17/2025
		C-25-C-09	UTT Records	2/20/2026
	Corrective Action Documents Resulting from Inspection	C-26-C-05	WPS Reference in Check Sheet	0
		C-26-C-06	NDE Written Practice Approval	0
		C-26-C-07	Calibration Room M&TE Calibration	0
	Drawings	509-D-02	Cask Body Weldment - Cask Body Detail (Step 1) Flange + Inner Shell	1
		509-D-02	Fabrication Drawing Cask Body Weldment Cask Body Detail Flange +Inner Shell	1
		509-D-03	Cask Body Weldment	1
		509-D-04	Cask Body Weldment - Cask Body Detail (Step 3) - Inner Shell + Inner Bottom Plate	1
		509-D-22	Cask Body Weldment Inner Bottom Plate	0
		509-D-23	Cask Body Weldment Flange	1
		509-FSD-01	Fabrication Sequencing Drawing (FSD) Cask Body	5
		70000.38-120	Cask Body Weldment	1
		70000.38-L100	Packaging Assembly	1P
		70000.38-L110	Cask Assembly	1P
		70000.38-L120	Cask Body Weldment	2P
	Miscellaneous		Internal Audit Schedule for 2025	4/1/2026
			Internal Audit Schedule for 2026	8/17/2026
		509-NCR-01	Outer Shell RT	0

Inspection Procedure	Type	Designation	Description or Title	Revision or Date
		509-QAP	KVC- Project Quality Assurance Plan	1
		A-68	Auditor Certification	4/2/2026
		CMTR-20260101	Certified Material Test Report for Inner Shell Stainless Steel Plates	01/27/2026
		CMTR-2603001	Certified Material Test Report for Inner Bottom Plate	03/27/2026
		CMTR-PT2602004	Certified Material Test Report for Welding Material	02/19/2026
		Document Control List	NAC-Volunteer Cask	7/30/2026
		IA-25-03-R	Internal Audit of Procurement Dept. 3	3/13/2026
		IA-25-07-R	Internal Audit of Process Equipment Quality Assurance	3/30/2026
		IA-25-08-R	Internal Audit of KVEC	3/27/2026
		KSK0812	Purchase Order Number for Calibration Services	05/30/2023
		KSK0981	Purchase Order Number for Calibration Services	09/09/2024
		LA-26	Lead Auditor Certification	11/14/2025
		LA-27	Lead Auditor Certification	7/6/2026
		M-41-1-1	KVC - Weld Material List	1
		M-41-1-2	KVC - Weld Material Request Card	1
		M-41-1-3	KVC- Welding Record	1
		Marking Pen Lot# 22C1475	Certificate of Compliance for Nuclear Marking Pen Lot# 22C1475	3/24/2022
		Master QA Record List	NAC-Volunteer Cask	9/8/2025
		P672397	Purchase Order Number for Welding Materials (GTAW)	03/05/2026
		PT-II-10	Certificate of NDE Personnel Qualification for Inspector ID# 10 as PT Level II, with annual exam	5/26/2026
		PT-III-05	Certificate of NDE Personnel Qualification for Inspector ID# 05 as PT Level II	10/4/2025
		Q-6-GM3-418	WQR for Welder ID# 006 in FCAW process, semi-auto, & FCAW and GMAW processes in 3 G position	3/13/2021
		Q-6SI-177	WQR for Welder ID# 006 to SAW process, machine	8/6/2020
		Q-6T3-260	WQR for Welder Id# 006 qualified in GTAW process manual and in 3G position	8/19/2026

Inspection Procedure	Type	Designation	Description or Title	Revision or Date
		QPL-01	KVC Qualified Personnel List (Nuclear Items for Foreign Customer)	Edition 2, Rev. 5
		QVL-01	KVC - Qualified Vendor List	1
		RT-II-14	Level II RT qualification record	2/5/2026
		RT-II-15	Certificate of NDE Personnel Qualification for Inspector ID# 15 as RT Level II, with annual eye exam	2/5/2026
		RT-III-08	Level III RT qualification record	3/26/2023
		ST-1	KVC Surface Finish Inspection Report for NAC Volunteer Cask Inner Body Plate P/N 509-D-22	8/28/2026
		UNB2862	Purchase Order Number for Stainless Steel Forgings (Inner Bottom Forging, Flange, Lid)	12/22/2025
		UNB6510	Purchase Order Number for Inner Shell Stainless Steel Plates	10/24/2025
		V-29-23-R	Supplier Audit for Forged Products	12/11/2023
		V-54-25-R	Supplier Audit for Welding Material	08/27/2025
		V-84-26-R	Supplier Audit for Stainless Steel Plates	03/05/2026
		VT-III-15	Certificate of NDE Personnel Qualification for Inspector ID# 15 to VT Level III, with annual eye exam	6/22/2026
		VT-III-2	Certificate of NDE Personnel Qualification for Inspector ID#2, as VT Level III, with annual exam	6/26/2026
		WQR Q-631--194	Welder Qualification Record for Welder ID# 061 to SAW process in 1G position	12/16/2022
		WQR Q-6T-258	Welder Qualification Record for Welder ID# 010 qualified to GTAW manual in 3G position	1/12/2026
	NDE Reports	PT-B-5	Penetrant Test Examination Report for NAC Volunteer Inner Shell Flange S/N 1	8/26/2026
		RT-B-2	Radiograph Test Report for Volunteer Outer Shell Weld Joint B-2, Serial# 1, Dwg 509-D-26	8/4/2026
		UT-T-1	Ultrasonic Thickness Dimensional Inspection report for NAC Volunteer Inner Shell/Flange Part Numbers 120-6 and 120-7 to drawing 509-D-03 Rev.1	8/25/2026
		VT/PT-A-1/B-1/3	Visual Weld/Liquid Penetration Examination Report for NAC Volunteer Inner Shell S/N 1, Step #14, Job# 18AN100509	8/26/2026
	Procedures	509-F-CL	Cleaning Procedure	0

Inspection Procedure	Type	Designation	Description or Title	Revision or Date
		509-F-HD	Handling and Storage Procedure	0
		509-F-SF	Surface Finish Procedure	0
		509-F-TAW	Control Procedure for Temporary Attachment Weld	0
		509-F-WPS	Welding Procedure for Volunteer Cask	3
		509-FSD-BA	FSD - Basket Assembly	2
		509-Q-01	NDE Personnel Qualification and Certification Standard	1
		509-T-DT	Dimensional Inspection Procedure for Cask Body Weldment	1
		509-T-FI	Fit Up Inspection Procedure	0
		509-T-RT	Radiographic Examination Procedure	0
		509-T-UT-T	Thickness Measurement (UT-T) Procedure	1
		509-T-VT/PT	Visual Weld Examination and Liquid Penetrant Examination Procedure	0
		509-V-03	Machining for Inner Shell Circumferential Weld Preparation	A
		I-10-1	KVC - Weld Visual Inspection Standard	Edition 9, Rev. 0
		M-04-1	Control of QA Manual	0
		M-05-1	Organization Chart	1
		M-06-1	KVC-Indoctrination and Training	1
		M-10-2	Design Control	1
		M-15-1	Document Control	1
		M-20-1	Purchase Control	1
		M-20-2	Control of Purchased Items	0
		M-25-1	KVC - Procedure for Material Identification and Verification	0
		M-30-1	KVC- Process Control	1
		M-31-1	Nonconformance Control	1
		M-32-1	Corrective Action	1
		M-41-1	KVC- Welding Control	1
		M-50-1	KVC - Examination, Inspection and Test Status	1
		M-60-1	Measuring and Test Equipment Control	0
		M-70-1	KVC - Handling, Storage, Shipping and Preservation	1
		M-80-1	Quality Assurance Records	1
		NQA-001	Quality Assurance Manual for Nuclear Items, Ninth Edition	1
		NQA-001	KVC Quality Assurance Manual For Nuclear Items	1

Inspection Procedure	Type	Designation	Description or Title	Revision or Date
		Q-01-04	KVC - Nondestructive Examination Personnel Qualification and Certification Standard	Edition 9, Rev. 0
		Q-01-2	KVC - Qualification Standard for Inspector and Test Personnel	Edition 9, Rev. 0
		Q-01-3	Audit Personnel Qualification Standard	Edition 9, Rev. 0
		Q-10-1	Calibration Standard for Measuring and Test Equipment	0
		Q-20-2	Reporting Standard of Defects and Noncompliance	1
		Q-80-2	KVC - Quality Records Control Standard	Edition 9, Rev. 0
		R-8GM-01N	PQR using FCAW	5
		R-8S-03N	PQR for SAW Process using machine	3
		R-8S-09	PQR for SAW process	0
		R-8T-06N	PQR for GTAW process	2
		R-8T/M-02N	Procedure Qualification Record (PQR) for GTAW, SMAW manual process	5
		WPS 509-S-08	KVC - WPS for GTAW, SAW, and FCAW process for circumferential joint for inner shell (B-1) and Outer Shell (B-2)	0
		WPS-509-S-01	KVC - WPS for GTAW, SAW and FCAW process for welding Longitudinal Joint of Inner Shell (A-1A, B, 2A, 2B)	0
	Shipping Records	RI-P-F02	Receiving Inspection Record Sheet for Upper and Lower Trunnions	7/22/2026
		RI-P-W02	Receipt Inspection Report for NAC Volunteer Cask weld wire E308L ASME SFA 5.22, Lot# G2601352	1/17/2026
		RI-P-W03	Receipt Inspection Report for NAC Volunteer weld wire VW 308L, Lot# M2602351	5/12/2026
		RI-P-W04	Receipt Inspection Report for NAC Volunteer weld material MG308L lot# M2601353 and weld material TVF300 lot# 52412004	4/1/2026
		RI-P-W0L	Receipt Inspection Record sheet for TG-308L weld wire SFA 5.9, HT# T2601354	4/16/2026
		RI-V-05	Receipt Inspection Report for NAC Volunteer Cask Body Weldment	12/31/2026
	Work Orders	509-CS-1202	CS for NAC Volunteer 120-2 Outer Shell	8/4/2026

Inspection Procedure	Type	Designation	Description or Title	Revision or Date
		509-CS-1205	CS for 120-5 NAC Volunteer Inner Bottom Plate	7/27/2026
		509-CS-1207	Check Sheet (CS) for 120-7 Cask Body Weldment Flange	4/6/2026
		509-CS-NCR-01	Rework Check Sheet for Outer Shell	0