

SAFETY INSPECTION REPORT AND COMPLIANCE INSPECTION

1. LICENSEE/CERTIFICATE HOLDER

Westinghouse Electric Company, LLC
P. O. Drawer R
Columbia, SC 29250

2. NRC/REGIONAL OFFICE

Spent Fuel Project Office
M/S O-13-D-13
Washington, DC 20555-0001

REPORT

07100708/2005202

3. LICENSEE/CERTIFICATE NUMBER(S)

71-0708

4. INSPECTION LOCATION

Columbia, SC

5. DATE(S) OF INSPECTION

October 31 - December 7, 2005

The inspection was an examination of the activities conducted under your license as they relate to radiation safety and to compliance with the Nuclear Regulatory Commission (NRC) rules and regulations and the conditions of your license or Certificate of Compliance (CoC). The inspection consisted of selective examinations of procedures and representative records, interviews with personnel, and observations by the inspector. The inspection findings are as follows:

- ☐ 1. Based on the inspection findings, no violations or nonconformances were identified.
- ☐ 2. Previous violation(s) or nonconformance(s) closed.
- ☒ 3. The violation(s), specifically described to you by the inspector as non-cited violations, are not being cited because they were self-identified, non-repetitive, and corrective action was or is being taken, and the remaining criteria in the NRC Enforcement Policy, NUREG-1600, to exercise discretion, were satisfied.
- 1 Non-Cited Violation(s) was/were discussed involving the following requirement(s) and Corrective Action(s):
- On June 10, 2005, Westinghouse issued Purchase Order 4500168745 to Chem-Strip of Alamance, Inc., of Burlington, NC, to provide services to chemically clean and paint BWR/Patriot inner shipping containers. This process involved cutting and welding of the end of each container lid. The lid is designated on Drawing 10014E28 as a safety-related component of the Patriot container. The Westinghouse requisition for this work did not identify the work as safety-related and there was no QA review and approval of the requisition.**
- ☐ 4. During this inspection certain of your activities, as described below and/or attached, were in violation or nonconformance of NRC requirements and are being cited. This form is a NOTICE OF VIOLATION OR NONCONFORMANCE, which may be subject to posting in accordance with 10 CFR 19.11.

(Violations, Nonconformances, and Corrective Actions)

STATEMENT OF CORRECTIVE ACTIONS

☐ I hereby state that, within 30 days, the actions described by me to the inspector will be taken to correct the violations identified. This statement of corrective actions is made in accordance with the requirements of 10 CFR 2.201 (corrective steps already taken, corrective steps which will be taken, date when full compliance will be achieved). I understand that no further written response to NRC will be required, unless specifically requested; **OR**

☒ Written Response requested in 30 days ☒ YES ☐ NO

TITLE	PRINTED NAME	SIGNATURE	DATE
LICENSEE	Norman Kent	<i>Norman Kent</i>	12/7/05
NRC INSPECTOR	James Pearson	<i>James Pearson</i>	12/7/05

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(Continued)

Westinghouse created Issue Report # 05-286-C003, submitted 10/13/05, identifying that (1) the PO was issued without the required QC approval, (2) the vendor was not on the approved supplier list, (3) the vendor's welding had not been done under a Westinghouse program, and (4) an inspection program had not been established for the vendor welding.

Q. C. Deviation or Notification (QCDN) No. 65309, dated 10/17/05, identified the defective condition as: The ends of the BWR Inner Box were welded back in place and painted without the weld being inspected. The requirement was cited as: Welds on safety-related parts are to be inspected to PS-WELD10, Rev. 01. The QCDN identified 19 units in the condition, and instructed that the completed boxes be inspected for weld defects. The QCDN appeared to indicate the welds had subsequently been inspected by Westinghouse, but the NRC inspector was informed that some of the welds had been painted over at the time of the inspection.

The above Issue Report and QCDN document that Westinghouse had identified deviations and initiated corrective actions prior to the start of the NRC inspection. However, the team noted that the refurbishment activities were ongoing at the time of the inspection and the team considered that the actions that had been taken did not appear to be adequate to resolve the issue for either the completed units or the ongoing work. Westinghouse acknowledged during discussions with the team that additional actions would be necessary.

The purchase order to Chem-Strip specified that welding was to meet Westinghouse Electric Co. Specification PS-WELD10 - Shielded Metal Arc Welding of Carbon Steel. No other welding procedure was provided to Chem-Strip. The inspector was informed that Chem-Strip was performing MIG welding. PS-WELD10 states that the weld joint design shall be shown on drawing and designated by AWS weld symbols. Most of the welding performed to replace the end of the container lid was on newly created joints not shown on licensing or fabrication drawings.

Westinghouse had copies of certificates of welding qualification for three Chem-Strip employees. Neither Chem-Strip nor the three issuers of the certificates were approved suppliers for Westinghouse. No test reports, welding records, or other objective evidence accompanied any of the certificates which were dated 1990, 1992, and 1996. While such documentation may be obtainable, it did not appear that Westinghouse had reviewed or validated any such information.

Westinghouse issued a letter stating that two Chem-Strip employees had been trained on the verification of container rework welds per PS-WELD10 and container drawings on October 27, 2005. The letter certified the individuals to perform weld inspections per the specification and drawing. There was no further documentation on the details of the training or the weld attributes to be inspected. PS-WELD10 is a general welding specification and the drawings do not show the weld joint design. The sign-off on the inspection sheet used by Chem-Strip only states "Inspected Welds." Also, there was no further documentation attesting to the qualification of the inspector, such as a written or practical examination, or the results of an eye examination normally required for a visual inspector.

Docket File Information
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3. LICENSEE/CERTIFICATE NUMBER(S) 71-0708	4. INSPECTION LOCATION Columbia, SC	5. DATE(S) OF INSPECTION October 31 - December 7, 2005	
6. INSPECTION PROCEDURES USED 86001	7. INSPECTION FOCUS AREAS Quality Assurance Program Implementation and NRC Inspection Followup		
SUPPLEMENTAL INSPECTION INFORMATION			
3. LICENSEE CONTACT Norman Kent		4. TELEPHONE NUMBER 803-647-3552	

PROGRAM SCOPE

10 CFR 71.105(b) states, in part, the certificate holder shall provide control over activities affecting quality of the identified materials and components to an extent consistent with their importance to safety, and as necessary to assure conformance to the approved design of each individual package used for the shipment of radioactive material.

Contrary to the above, cutting and welding was performed on important-to-safety components of Patriot shipping containers at Carolina Chem-Strip:

- (1) without adequate procedures for welding,
- (2) without adequate documentation of welder qualifications, and
- (3) without adequate provisions for inspection and documentation of completed welds.

INSPECTOR NOTES COVER SHEET

Licensee/Certificate Holder (name and address)	Westinghouse Electric Company, LLC P. O. Box 355 Pittsburgh, PA	5801 Bluff Road Columbia, SC
Licensee/Certificate Holder contact and phone number	Norman Kent 803-647-3552	
Docket No.	71-00708	
Inspection Report No.	07100708/2005202	
Inspection Date(s)	October 31 - December 7, 2005	
Inspection Location(s)	Westinghouse Office, 5801 Bluff Rd., Columbia, SC and a temporary refurbishment work area located on Ferguson Street in Columbia, SC	
Inspectors	Jim Pearson, Frank Jacobs, and Carlos Navarro	
Summary of Findings and Actions	<p>The inspection involved a review of Westinghouse's Quality Assurance (QA) Program implementation at their office in Columbia, SC. Since Westinghouse was actively performing maintenance and refurbishment activities on 10 CFR Part 71 transportation packages during the inspection as well as performing loading and unloading operations on Part 71 packages, the Inspectors focused on these activities to make the inspection as performance based as possible. The inspectors reviewed multiple QA implementing procedures, drawings and specifications and witnessed many operations where loading, unloading and refurbishment were performed to help determine how well Westinghouse was controlling these Part 71 quality related activities.</p> <p>Overall Westinghouse activities were found to be in compliance with NRC Part 71 requirements and with Westinghouse's own NRC approved QA program. The team made multiple observations where procedure and/or process clarity was needed or where weakness was evident in the control of activities. Since these observations were not QA program violations or violations of 10 CFR Part 71 or Part 21 the observations were merely discussed with Westinghouse Management during daily inspection debriefs.</p> <p>Westinghouse has initiated Issue Report # 05-286-C003 for an area identified during the inspection. The area identified was a violation of Part 71 in that required procedures for quality related activities were not sufficient to control the refurbishment activities performed in regard to the BWR/Patriot inner shipping containers.</p>	
Lead Inspector Signature Date	James J. Pearson <i>James J. Pearson</i> 12/08/05	
Inspector Notes Approval Section Chief Signature Date	<i>[Signature]</i> 12/8/05	

MANAGEMENT CONTROLS

The inspectors reviewed the QA Policy provided with the Westinghouse (W) QA program. The inspectors also noted from a review of the W Quality Management System (QMS), rev. 5, section 1.1.2.3 "Graded Quality" that requirements are to be applied as necessary to achieve the level of quality specified. The inspectors noted this QMS Section requires procedures to control requirements for items and services based on the complexity of the work and function of the item or service. The inspectors noted that the review of Figure 4 of QMS and additional quality relayed procedures provides for planned independent quality functions and section 2.3.2 Quality of the W QMS, addresses the functional requirements of quality managers and the organization. In addition, collective reviews of W procedures indicated that overall they provided appropriate management and organizational controls at the working level.

The inspectors reviewed CA-007, "Corrective and Preventive Action," revision 17, 5/26/05, and interviewed the Corrective Action (CA) Coordinator. The Coordinator stated that there was a large number of items in the CA system and that a problem with timely closure had been identified in both internal and external audits. The Coordinator stated that recent changes appeared to have increased management awareness and support, with noticeable improvements in closure timeliness in some areas. The inspector selected and reviewed nine corrective action program system documents referred to by W employees as CAPs.

The inspector observed that the requirements of 10 CFR Part 21 were conspicuously posted as required, addressed in applicable procedures, included in applicable procurement documents. The inspectors also reviewed the W procedure, PQR-1, Revision 4, "Procurement Quality Requirements." The inspectors noted that this procedure includes guidance on the invocation of Part 21 requirements in regard to supplier's activities for both items and services provided to W. In addition the inspector reviewed a purchase order (PO) for carbon steel sheet for repairing the MCC model packages. The PO was in order and Part 21 was invoked acceptably. No concerns were noted in the corrective action area.

The inspectors noted that W had developed a series of three procedures to provide program guidance in regard to various levels of supplier quality. The inspector reviewed procedure QCS-1/PF102, Revision 1, "Supplier Quality System Requirements, Level I" and select portions of the other two procedures; QPR-3/QPR-4/QPR-5, Revision 1, "Supplier Quality System Requirements, Level II" & QCS-2, Revision 4, "Supplier Quality System Requirements, Level III." All three of the procedures provided specific requirements for W suppliers at the appropriate level on the 18 quality criteria found in 10 CFR Part 71, Subpart H for the design, testing and manufacture of items or services supplied to W.

A Westinghouse Technical Trainer provided the inspector a tour of procedures, forms and also provided a demonstration of training record tracking for loading personnel on ETAPS. The inspector interviewed the Document Administrator for "Electronic Training And Procedure System" (ETAPS) to determine how the system functioned. The system administrator described operation and functions of ETAPS and how, as the administrator, he controls the security and contents of the system. The team also reviewed portions of CA-002, "Columbia Plant Procedure System", rev. 28 and discussed operation and control of the ETAPS in regard to procedural control with the Administrator. The procedure reviewed, also addressed control of review, approval, and release for use, as well as controls for use of the current/approved documents by W personnel. The administrator demonstrated the availability and control aspects of ETAPS and also described the responsibilities of W personnel in regard to hard copy

procedures and any procedural change process. The team found document controls in regard to activities affecting quality were effectively controlled.

The inspector reviewed procedure WEC 17.1, rev. 6, "Internal Assessments." The procedure provides responsibilities and requirements for the performance of W internal assessments. The inspector reviewed a portion of the W 2005 internal audit schedule. Pages 1 and 2 of the schedule provided a listing of areas under "Nuclear Fuel" (Columbia facility) to be audited in 2005. A total of five audits were scheduled to be performed at the Columbia facility. The inspector noted that the schedule listed the intended team leader, as well as the team members.

The inspector reviewed W Internal Assessment WEC-05-02, Columbia Supply Chain Management/Quality (receipt inspection) performed 8/2-5/05. The inspector noted that the assessment identified 12 issues, of which all were identified in the CAPs. The inspector noted the findings were clearly summarized. Participants and meeting attendees were listed. The applicable assessment related documents were listed. Assessment details were provided and effectiveness statement was included. The assessment was performed based on criteria defined in the "Internal Assessment Plan QP & SM-05-0147" dated July 12, 2005.

In addition the inspector reviewed the W Formal and Informal Compliance Inspection Table - 2005 which provides a listing of the expected compliance inspections to be performed in 2005. The inspector noted that these inspections are to be performed by a trained and certified auditor or a technical expert according to W procedure RA-102, Rev.14, "Environmental Health and Safety Compliance Inspection." In addition the inspector reviewed sample Environmental Health and Safety Inspection reports performed in January 2005 and May 2005. These inspections are monthly formal regulatory compliance inspections required by the RA-102 procedure. These particular inspections included the dock, packing and transportation areas, which were focal points of this NRC inspection. The inspection findings were appropriately documented in the inspection report.

The inspector also reviewed the Compliance Inspection Schedule - 2005 to determine if W had prepared a plan to provide oversight on quality activities. The inspector noted that the schedule covered varied areas of responsibility and assignments included a wide variety of facility operations personnel.

The inspector reviewed the W Lead Auditor Qualification Status listing dated 11/03/05. The inspector chose samples of lead auditors from the listing and reviewed the qualifications, training transcripts, participation records and annual evaluation sheets of those personnel. The inspector noted that W was acceptably tracking the dates for the next evaluation of the auditor, the last audit performed date, as well as the certification date and due date for each lead auditor. The files for the lead auditors reviewed were extensive, detailed and found to be acceptable.

W personnel described to the inspector the implementation of TRN-076, "Annual Training Needs Assessment" which was conducted in February, 2005. The annual assessment is required by WEC 18.1, paragraph 7.1. The inspector noted that some of the slides from the presentation of the assessment process were sample forms, which when completed, show how the assessment help identify gaps where training may be needed.

DESIGN CONTROLS

Though no new package design work was reviewed by the inspectors, some aspects of the design process were reviewed in regard to determining the level of the W QA program implementation. The inspector interviewed the CAD Administrator for the Westinghouse Matrix One system. The administrator described how Matrix One is password protected and that the system includes: Eng. Change notices (ECN) all drawings and both material and product specifications. The administrator described and demonstrated how records capture is automatic from the Matrix One system to an optical disk upon approval (usually in 24 hours) of the document.

The inspector noted that with the Matrix One system, whether the user is a supplier or a customer, they are supplied current work or job related documents in pdf. format. The administrator described that some users do have web access to "limited" job related documents. The administrator went on to describe to the inspector that the one of the responsibilities of a member of the Product Assurance organization is to perform as a reviewer/approver on designated documents.

The inspector reviewed portions of Procedure EP-404 for "Engineering Change Notice" rev. 23, and Procedure EP-401, for "Engineering Drawings", rev. 17. The inspector interviewed a product design engineer in regard to the control of W designs and design changes. The engineer provided the inspector with a demonstration of the various types of engineering documents which are available on the Westinghouse "Product Engineering Home Page" and the engineer described the use and access of the system which is password protected. The inspector noted that all general engineering direction for nuclear fuel engineers exists on this home page site.

FABRICATION CONTROLS

Though no fabrication had occurred recently at the W facility, some processes and procedures were reviewed in regard to both fabrication and maintenance activities.

To evaluate the W process for material procurement of parts/components the inspectors reviewed the W procedure, PQR-1, Revision 4, "Procurement Quality Requirements." The inspectors noted that this procedure provides guidance on how the supplier's quality assurance program must comply with specified W documents to ensure the proper quality of items and services supplied to W. The inspector's also noted that this procedure provides guidance on use of hold points as well as the necessary supplier quality assurance records. The inspectors also reviewed W procedure SCM-504, "Source Surveillance," Rev. 1. The inspector noted that this document provides reasonable responsibilities and guidance for the source surveillance process.

The inspector also reviewed the Qualified Suppliers Listing (QSL) which was dated 11/3/05. The inspector took a sample of suppliers from various other engineering documents and verified that they were qualified suppliers under the W process by locating those suppliers on the W QSL. From the sample of suppliers the inspector chose to review a W External Auditing Source Evaluation, WES-2003-097 for Nova Machine Products Corporation and WES-2005-024 for ISG Plate to determine the oversight process for suppliers. The inspector noted that the evaluations were based primarily on NIAC Audits # 1134, performed by Johnson Pump Company on May 19-21, 2003 and #11524, performed by Trentec on March 1-3, 2005

respectively. The inspector noted that both of the audit plans and the audit checklists were both detailed and properly completed.

MAINTENANCE CONTROLS

The team observed the refurbishment activities being performed at the Westinghouse Ferguson Street facility. The WEC personnel had procedure TR-219, "Refurbish Patriot BWR Shipping Packaging," revision 2, 10/13/05, at the work-site and were using Form No. CF-75B-014, "Patriot BWR Outer Box Refurbishment Routing," revision 0, 7/28/05, to document the work being performed. The inspectors noted various fabrication configurations among the Patriot inner shipping containers that were not in accordance with the CoC drawing. Also, significant repairs to some containers were observed that could affect the structural integrity of the containers and possibly be outside the licensing basis. Additionally, the refurbishment process involved sawing off one end of each container lid and welding the removed portion back onto the lid. While a small portion of the total cut and re-weld was in weld joints shown on the CoC drawing, this action did create new weld joints not shown on the CoC drawing. The inspection team informed W Management that the possible nonconforming conditions should be discussed with the NRC licensing staff for resolution.

The inspectors witnessed the refurbishment team members working in repositioning the grid clamps on an MCC-3 packaging. The inspector noted that the clamps needed to be relocated for the next type of fuel assembly planned to be carried in that packaging. The inspector verified from procedure containing the data for these locations that the positioning was accurate. The inspector determined that the work was performed according to procedure TST-TR-217, Refurbish MCC Shipping Packaging, Revision 1, Section 7.0, which was located at the worksite.

The inspector drew a sample of personnel from a current (11/1/05) listing of MCC refurbishment personnel. The ETAPS Back-up administrator demonstrated for the inspector how to find refurbishment training records for the sample personnel chosen. All personnel training records in the sample were found and viewed by the inspector on the ETAPS system. From the samples chosen, the inspector determined that overall W personnel have appropriate training completed for their associated work activities.

The inspector verified, with the help of Westinghouse Staff, the appropriate spare parts identities and the demonstrated storage controls for each box as well as the locations for use on the package. The inspector noted that traceability was maintained by heat and lot numbers of the parts/components. The inspector also reviewed the W procedure, SCM-504, Revision 1, "Source Surveillance" since it provides the guidance on conducting and reporting the source surveillance activities of suppliers of spare parts to W as specified in W procurement documents.

The inspector verified that the handling process for the package was proper in that the release of the refurbished package occurred with a TAC designation from the refurbishing area that indicates the package is not to be used for shipment until it is properly painted.

The inspector reviewed procedure WEC 6.1, "Control of Purchased Items and Services," revision 7, 7/15/05. Procurements determined by the requisitioner to be safety-related are required to have the requisition reviewed by Quality Assurance. If the requisitioner does not indicate the material or service being procured is safety-related, the requisition is not reviewed by QA. The inspector interviewed a procurement specialist and reviewed several requisitions and purchase orders for material and services. A requisition for carbon steel sheet to repair

MCC shipping containers indicated the material to be safety-related. The requisition had been reviewed by QA and appropriate quality requirements had been specified in the requisition and purchase order, including the applicability of 10 CFR Part 21. The purchase order had been placed with a qualified supplier. The inspector requested and reviewed the requisition and purchase order for the Patriot shipping container refurbishment underway at the time of the inspection. The requisition did not indicate the services to be safety-related and had not been reviewed by QA. The procurement specialist stated that she had no responsibility or expertise for reviewing the quality requirements in a requisition or determining if QA should have approved the requisition. The inspector interviewed the shipping clerk who prepared the requisition and was told that the procurement of these services was not indicated to be safety-related by the engineering personnel managing the refurbishment project. A violation has been issued to Westinghouse in regard to the control of the Patriot refurbishment issue.

The inspector interviewed a product design engineer in regard to the control of refurbishment materials and activities. The engineer provided the inspector with a demonstration of the various types of engineering documents which are available on the Westinghouse "Product Engineering Home Page" and the engineer described the use and access of the system which is password protected. The inspector noted that all general engineering direction for nuclear fuel engineers exists on this home page site. These engineering documents are available for all engineering personnel to use for proper control of functions and processes.

The inspector determined that the MCC refurbishment activities were well controlled and that the leakage test required by the certificate was properly performed for the package inspected.

The inspector was able to inspect the "Tools and Gauge Inspection and Calibration" area. The inspector interviewed a tool calibration technician and discussed applicable procedures used for tool and equipment calibration. The inspector used the following sample items to verify implementation of an acceptable measuring and test equipment program: QC11260 Pressure Gauge, CM22757 and CM22671 Torque Wrenches , CM4036 Caliper and CM4037 Micrometer.

The inspector was able to review the applicable procedures required for calibration of torque wrenches. The inspector determined that tools and equipment were identified according to W procedural requirements. The inspector also determined how the Tool and Gauge Team verified that tools with proper ranges and sensitivities were used for associated work activities.

The Tool and Gauge Team demonstrated to the inspector how they control traceability of W tools and equipment and how they determine acceptable calibration prior to issuance. The Tool and Gauge Team also demonstrated how they handle out of calibration tools and equipment and described the corrective actions that may need to be taken in regard to application of this out of calibration equipment or tools. The inspector reviewed procedure QCI No. 000140, Revision 51, "Tool and Gauge Control" and verified the demonstrations of the Tool and Gauge Team to be accurate.

The inspector was able to collect data for several pieces of equipment used in three areas of interest: MCC refurbishing area, fuel loading area, Patriot refurbishing area. The inspector determined that all equipment contained a specific and separate identifying number designation, a calibration expiration date, and an inspector calibration stamp. These are designated standards for W and the inspector determined that they were being accomplished.

The Tool and Gauge Team provided examples, to the inspector, of a variety of records for tools within the Westinghouse facility. The documentation for the control of this equipment was maintained in a computer database. The inspector determined that the Tool and Gauge Team

have acceptable procedures and are maintaining control of that equipment. The inspector verified that procedures are in place to require return of M&TE items for re-calibration on a scheduled basis.

The Inspector performed some dimensional checks on the PATRIOT packagings and found dimensions within tolerances specified on CoC Drawings. The following dimensions were verified on drawing 10014E30. Sheets 1, 2 and 3. Packaging: height & width; Impact Indicator: length; Lid: thickness, Sheet 2: Detail A: length, width, height, Sheet 3, Section A-A: hole size. The inspector examined pressure gauges CM4036 & CM4037 which were found in this work area and used as samples of M&TE.

During the loading of fuel assemblies into a 927 package, the inspector reviewed section 7.1 of W procedure MOP-730313 Rev. 21, Packing Model 927 Shipping Packaging and was able to follow the team activities step by the step as they were performed. The inspector verified that the proper revision of the procedure was used and they properly recorded the packaging serial number (S/N) on the required documentation. In regard to loading operations at W the inspector also reviewed MOP-730713, Revision 89, Loading Fuel Assemblies in MCC3 and MCC4 Shipping Packagings.

The inspector was able to witness a portion of the unloading process of the Traveller package (Serial No. TS20) which was used in this instance to ship BWR fuel pins from Sweden. This was the second time Westinghouse performed this task in a Traveller. The Process Engineer with the crew was following step by step the unloading procedures (MOP-730315). Westinghouse was properly performing an accountability of the package contents by optical scanning the fuel bar code. The computer software verifies that the content of the package is accurate. During the shipment activities from Sweden, package S/N TS20 was sent mistakenly with four extra fuel rods. Westinghouse was expecting this error and found and properly recorded this in their records. The inspector noted that there were additional extra fuel rods sent by the Sweden (two more) in another package. Westinghouse informed the staff they found the location of the other two fuel rods and added them in the accountability by the Safeguard Coordinator.

The inspector reviewed packing training records, job descriptions and "statements of certification" Form No: CAF-006-33 Revision 2 for four "A" operators who were witnessed performing loading operations during the inspection. The inspector also reviewed Proc. CA-006, rev. 13. "Columbia Plant Hourly Employee Training Policy" and QC Form 404, rev. 8, in evaluating acceptable training implementation.

The inspector interviewed the Product Assurance Engineer responsible for receiving inspection. The inspector reviewed receiving inspection records and selected samples of nonconforming material to evaluate the disposition process. Quality Control Instruction (QCI) 310353 was used for determination of inspection requirements for incoming material. The inspector requested and reviewed inspection records for some of the fasteners, Receiving Lot Nos. 05-4267 and 05-4513, that had been observed being used at the Ferguson Street facility. If incoming material is not found in the QCI, the Product Assurance Engineer contacts the requisitioner and together they determine the inspection attributes. This process was tracked for Receiving Lot No. 05-4513. No discrepancies or concerns were noted.

The inspector interviewed a supply chain representative in regard to recent receipt inspection activities that may have occurred at W from recent fabrication activities, primarily for the Traveller packages. From the interview, the inspector noted that the recent Traveller packages essentially received their acceptance inspection at the fabrication prior to shipment to W.

The inspector also reviewed selected portions of QA-004, "Equipment And Process Qualifications And/Or Verifications", Revision 25. The inspector determined the procedure establishes acceptable guidance for control of processes affecting the quality of items and services. This includes W manufacturing and inspection processes and equipment.

The inspector reviewed W procedures, PR-201, Revision 1, "Quality Assurance Record Retention And Control;" PR-205, Revision 1, "Imaging of Quality Records;" CA-004, "Columbia Plant Records Management Policy," Revision 13. The inspector noted that these procedures define the policies, responsibilities, definitions and handling processes that establish the control of the W records management program.

The inspector interviewed the Manager of Customer Quality and the Manager - Product Records. Both managers described the process for records capture and provided a tour of the on-site records storage facility. The managers described to the inspector that Westinghouse stores records on an optical disk with one image stored on site, a second image is stored offsite and hard copy is stored in a Pennsylvania mine.

A records handler provided the inspector with a demonstration of a system identified as Application Extender. The system allows records handlers job access. The system can be used by a variety of personnel and only allows access to view records.
Interviewed Procurement Specialist.