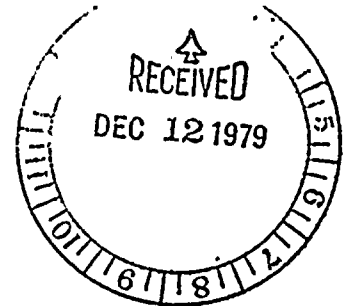


Washington Public Power Supply System  
A JOINT OPERATING AGENCY

P. O. Box 968 3000 GEO. WASHINGTON WAY RICHLAND, WASHINGTON 99352 PHONE (509) 946-9681

December 10, 1979  
G02-79-226



Nuclear Regulatory Commission  
Region V  
Office of Inspection and Enforcement  
Suite 202, Walnut Creek Plaza  
1900 N. California Boulevard  
Walnut Creek, California 94596

Attention: Mr. R. H. Engelken, Director

Subject: WPPSS NUCLEAR PROJECT NO. 2  
DOCKET NUMBER 50-397, CPPR-93  
CORRECTIVE ACTION PROGRAM FOR  
RESOLUTION OF PIPE WHIP RESTRAINT  
DOCUMENTATION PROBLEMS

Reference: Letter R.H. Engelken to N.O. Strand,  
dated 11/21/79, subject "Stop Work,  
Installation of Quality Class I Pipe  
Whip Restraints Provided Under Contract 90,  
WNP-2"

Dear Mr. Engelken:

The referenced letter established NRC concerns relative to the corrective action program for resolving deficiencies associated with the Pipe Whip Restraints manufactured under Contract 90.

The present status of this situation and planned corrective action tasks are described in Attachment 1 to this letter. Note the Attachment generically describes the major tasks to be accomplished but does not describe the detailed specific actions needed to complete the stated tasks. The detailed action plans are being developed by WNP-2 personnel and are available for your review.

As identified in Item 4 of Attachment 1, a procedure describing actions and approvals necessary to release any restraints from the stop work order will be developed. This procedure will be provided to your Inspectors for their review.

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79-144

Regarding your concern relating to fraudulent records, Leckenby Corporation has isolated the records associated with Contract 90 in a secured area with access limited to authorized personnel.

The actions described herein constitute what we consider to be reasonable measures to resolve this matter in a timely and effective manner. If you have any questions regarding these actions, contact Roger Johnson, WNP-2 Project QA Manager at extension 2712.

Very truly yours,

*D. L. Renberger*

D. L. RENBERGER  
Assistant Director  
Technology

DLR/RTJ/ln

cc: J. R. Lewis - BPA  
J. G. Davis - Director, NRC, Washington, D.C.  
J. M. Blas - B&R, NY  
J. J. Verderber - B&R, NY

Attachments: 2

WASHINGTON PUBLIC POWER SUPPLY SYSTEM  
NUCLEAR PROJECT NO. 2  
DOCKET NUMBER 50-397, CPPR-93

PIPE WHIP RESTRAINT  
CORRECTIVE ACTION PLAN

Purpose

To resolve both specific and general QA record deficiencies associated with 179 Pipe Whip Restraints manufactured under Contract 2808-90.

Present Construction Status of Restraints

Installed and inspection complete	30
Installed but rework & inspection not complete	21
Not installed	<u>128</u>
Total	179

All Pipe Whip Restraints are on hold.

Tasks To Be Accomplished For Corrective Action

1. Review data packages for all Pipe Whip Restraints identifying specific documentation discrepancies and transmitting list of discrepancies, by CAR, to Leckenby. Action to be accomplished by Project Quality Assurance.
2. Identify all Pipe Whip Restraints known to be impacted by the welding and NDE problems identified on Attachment 2. Responsibility for resolution of each discrepant item is shown on Attachment 2.
3. Project QA to establish criteria and define a field sampling program for the performance of ultrasonic and magnetic particle testing to verify the adequacy of the hardware.
4. QA will develop and document a procedure for the release of individual restraints as documentation and welding problems are resolved, and as sufficient inspection data is generated by the field program.
5. QA will identify individual Pipe Whip Restraints which require repair due to non-resolution of problems.

Detailed action plans are being developed for each of the above tasks.

# PIPE WHIP RESTRAINT PUNCH LIST

Kil Engelen  
NRC  
Attachment 2

Page 1 of 2

Rev. 1

Date 12-6-79

NO.	PROBLEM	AFFECTED PWS.	RESPONSIBILITY FOR ACTION	STATUS
1.	Signature on Welder Qualification Records signed by two people.	Identify	Leckenby/Grable CAR	CWR # <u>DC 22</u>
2.	Welder Qualification Records do not include test results.	Identify	Leckenby/Grable CAR	
3.	ESW Operators qualified prior to qualification of welding procedure.	All	Grable/AWS	
4.	ESW Operators qualified outside essential variables of procedure.	All	Grable/AWS	
5.	No record of RE-PWHT after defects removed.	Identify	Bean/NCR	
6.	PWRs straightened after PWHT.	Identify	Bean/NCR	
7.	ESW procedures not qualified in PWHT condition.	Identify	Grable/NCR	
8.	Thickness limit of ESW procedure violated.	Identify	Bean/NCR	
9.	Conflict between Code & Contract requirements for ESW impact tests.	Identify	Grable/RFI Engineering	
10.	Wrong filler metal on A537.	Identify	Bean/Engineering	
11.	Mr. Baldinger's NDE certs not available.	All	Leckenby	
12.	Mr. Hamilton's NDE certs not complete.	All	Leckenby	
13.	UT examinations not done correctly (straight beam prior to angle beam).	Identify	Bean	



PIPE WHIP RESTRAINT PUNCH LIST

Page 2 of 2

Rev. 1

Date 12-6-79

NO.	PROBLEM	AFFECTED PWS.	RESPONSIBILITY FOR ACTION	STATUS
14.	Additional UT tests not performed after rejectable defects.	Identify	Bean/NCR	
15.	Code suggests "Spot RT" on UT.	All	Grable/NCR/Eng.	