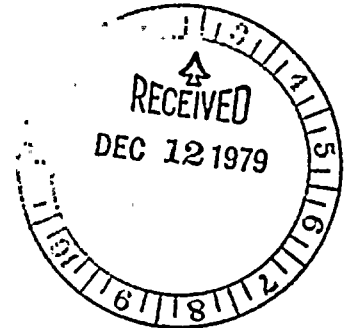


Washington Public Power Supply System
A JOINT OPERATING AGENCY

P. O. Box 988 3000 GEO. WASHINGTON WAY RICHLAND, WASHINGTON 99352 PHONE (509) 375-5000

December 10, 1979
G02-79-227

Docket No. 50-397



Mr. R. H. Engelken, Director
NRC Region V
Suite 202, Walnut Creek Plaza
1990 N. California Blvd.
Walnut Creek, California 94596

Subject: WPPSS NUCLEAR PROJECT NO. 2
DOCKET NUMBER 50-397
STOP WORK, REPAIRS AND ATTACHMENTS
TO THE SACRIFICIAL SHIELD WALL, WNP-2

Reference: NRC Letter #GI2-79-176, same subject,
dated November 21, 1979

Dear Mr. Engelken:

The purpose of this letter is to submit the WPPSS closure program for outstanding concerns on construction of the WNP-2 Sacrificial Shield Wall.

Reviews in progress in the last several months, have included consideration of:

- Void indications, void location, repair, and testing.
- Design of repair for the fabrication noncompliance on plug welds.
- Contractor review of construction records.
- AE review of contractor fabrication drawings for compliance with design requirements.

Engineering approach for resolution of void and plug welds concerns is formulated and available for review. Attachment 1 is the program addressing visual weld deficiencies, NDE records, personnel qualifications,

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and plate bending procedures. Attachment 2 is a WPPSS procedure for NRC review of associated corrective action plans prior to resumption of any individual segment of the work. Attachment 3 is the schedule for performance of the Attachment 1 program.

This response is intended to provide description of the WPPSS Program for closure of outstanding concerns on the WNP-2 Sacrificial Shield Wall. Results will be submitted in a final report.

Very truly yours,

D L Renberger

D. L. RENBERGER
Assistant Director
Technology

DLR:ANK:cph

- Attachments: (1) WNP-2 Program for the evaluation of the
Sacrificial Shield Wall (12/3/79)
- (2) PMI 5-1000 Sacrificial Shield Wall Processing
and Controlling Limited Work Releases
- (3) Schedule/Logic for Sacrificial Shield Wall
Evaluation Program

cc w/att: JG Davis, NRC
ND Lewis, EFSEC, Olympia
JR Lewis, BPA
JJ Verderber, B&R, NY
RC Root, B&R Site
WNP-2 Files

WNP-2 PROGRAM FOR THE EVALUATION
SACRIFICIAL SHIELD WALL

DATE:

PREPARED BY:

J. L. Good
M. Parise
H. R. Tuthill

J. L. Good, Asst. Resident Proj. Engr.

M. Parise, Asst. Construction Manager

H. Tuthill, Asst. Proj. QA Manager

APPROVED BY:

G. T. Harper
W. C. Bibb

G. T. Harper, Tech. Support Manager

W. C. Bibb, Project Manager

12-3-79

Attachment I
Page 2 of 5

INDEX

- 1) Purpose
- 2) Responsibilities
- 3) Program Scope
- 4) S.S.W. Report
- 5) Description of the Quality Documentation Review
- 6) Description of the B&R Engineering Review of Leckenby Drawings
- 7) Flow Chart

S.S.W. EVALUATION PROGRAM

I. Purpose:

The purpose of the S.S.W. Evaluation Program is to perform a complete review of the Contractor performance on the S.S.W. and to determine what action must be taken to correct any deficiencies which are found.

II. Responsibilities:

The S.S.W. Evaluation Program is under the control and supervision of the following site individuals who are responsible for coordinating all aspects of the review.

- 1) J. L. Good - Asst. Resident Proj. Engr.
- 2) H. Tuthill - Asst. Project QA Manager
- 3) M. Parise - Asst. Res. Construction Mgr.

The S.S.W. Evaluation Program will be controlled in accordance with the attached flow chart and the S.S.W. team shall issue a final report documenting the results of the review.

III. Program:

As shown on the attached flow chart, the program will include:

- 1) A documentation review by the Contractor (WBG) and a B&R Engineering Review to determine deficient areas/concerns.
- 2) A Reinspection program to verify the accuracy of Leckenby's documentation and to clarify/resolve deficient areas/concerns.
- 3) Correlation of data and issuance of final report.

IV. S.S.W. Report:

This report shall address the following items and will include a summary of findings and/or conclusions:

- 1) WBG Quality Documentation Review
- 2) B&R Engineering Review (Including Shield Adequacy)
- 3) Allegations about the S.S.W.
- 4) Results of the S.S.W. Evaluation Team Review
- 5) Results of the Reinspection portion of the S.S.W. Evaluation Program.

V. Description of the Quality Documentation Review

(Reference: WBG letter WBGWNP2-215-79-3057 dated 7/30/79).

A review is being performed by the B&C/G Quality Assurance Department for the purpose of establishing baseline quality requirements as well as the credibility of those quality assurance records submitted by the Leckenby Company.

VI. Description of the Engineering Review of Leckenby Drawings

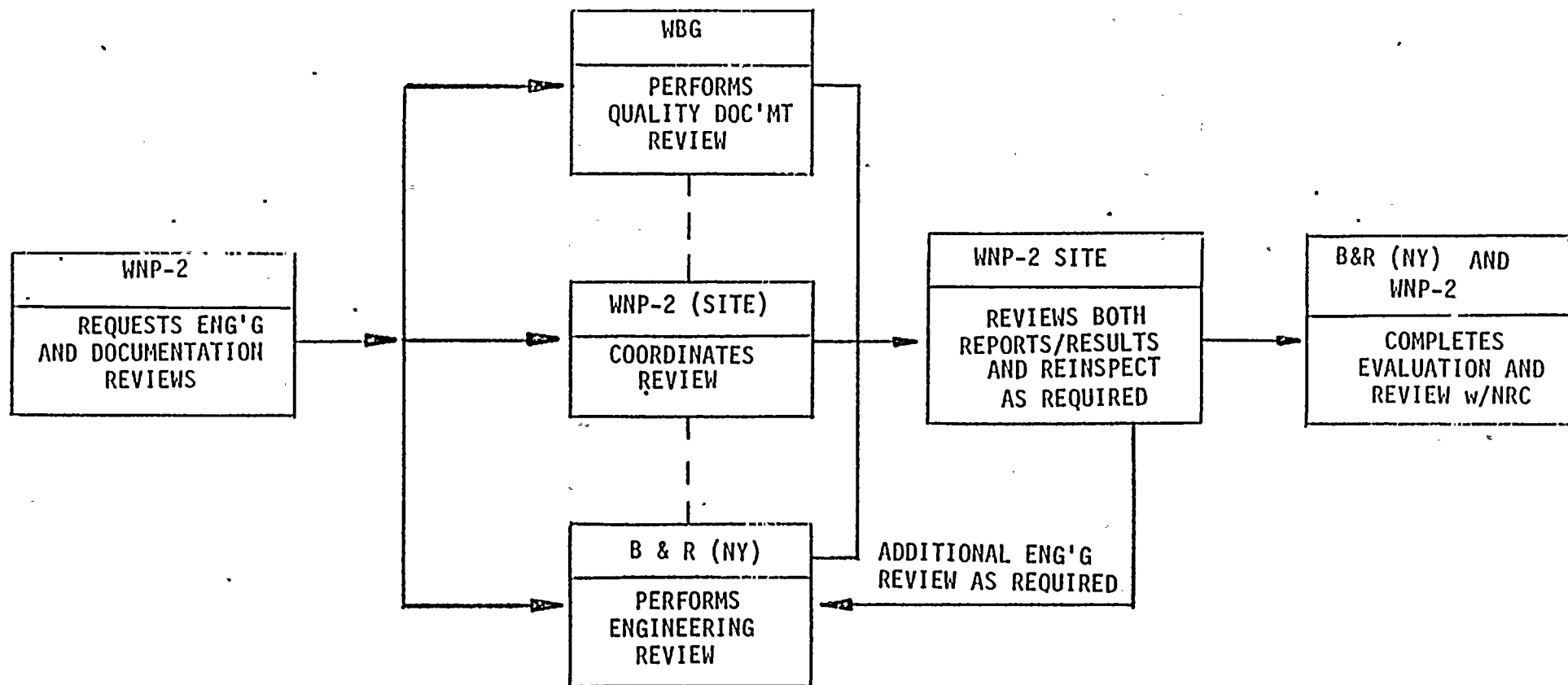
(Reference: B&R IOM #EM-79-188, dated March 6, 1979)

A review of the Leckenby Drawings being performed by the B&R engineering organization to determine the completeness of the documentation of the welding of the S.S.W. The review will include the following:

- 1) Evaluate the credibility of the documents.
- 2) Determine the completeness of the documentation.
- 3) Verify all structural components were accounted for.
- 4) Determine extent of deficient welds.
- 5) Insure traceability of all information on weld maps.

In addition, B&R engineering is developing a comprehensive inspection program to verify the shielding adequacy of the S.S.W. The potential for generic shielding deficiencies was realized through the discovery of two (2) specific shielding concerns. The program entails investigation, documentation and shielding fix (with high level of confidence) where necessary.

SAC. SHIELD WALL EVALUATION





PROCEDURE APPROVAL ROUTING SHEET

PROCEDURE/INSTRUCTION NO: PMI 5-1000	PROPOSED REV. NO: Temporary	MANUAL: WNP-2 Project Instructions	
TITLE: Sacrificial Shield Wall (SSW) - Processing and Controlling Limited Work Releases			
ROUTING SEQUENCE:			
ORGANIZATION	NAME	CONCURRENCE SIGNATURE (APPROVAL OF CONTENT)	DATE
CM	GI Wells	<i>George Wells</i>	12/6/79
TS	GT Harper, Jr.	<i>GT Harper, Jr.</i>	12/6/79
APQAPM	HR Tuthill	<i>H.R. Tuthill</i>	12/6/79
DPM	RC Root	<i>RC Root</i>	12/7/79

☒ NEW ☐ REVISED ☐ INTERIM (EXPLAIN BELOW)

REASONS FOR CHANGE: To document method of controlling limited work releases on Sacrificial Shield Wall.

COMMENTS WERE MINOR AND RESOLVED ☐ AND/OR AS NOTED BELOW:

N/A

MCS COORDINATOR:

712
H. F. Bundy

DIVISION:

Projects

DATE

12/6/79

WASHINGTON PUBLIC POWER SUPPLY SYSTEM

WNP-2 PROJECT INSTRUCTION

PMI 5-1000

REV:

Temporary

RESP. ORGN:

CM

APPROVED:

PROJECT MANAGER

TITLE: SACRIFICIAL SHIELD WALL (SSW) - PROCESSING AND CONTROLLING LIMITED WORK RELEASES

1.0 PURPOSE AND SCOPE

This procedure will be used in verifying the criteria necessary to allow limited release of work on the SSW to repair or attach by the process of welding.

2.0 DEFINITIONS

None

3.0 PROCEDUREResponsibilityAction

- | | |
|---|--|
| Construction Superintendent (CS) for Dry Well | .1 When requesting that the SSW Evaluation Team consider allowing work to be performed on the SSW, gets a "Limited Work Release" (LWR) Form from Assistant Resident Construction Manager (ARCM). |
| | .2 Fills out form with applicable information and gives to the Assistant Resident Project Engineer (ARPE) - L. Good or designee - for Engineering review/approval. |
| ARCM | .3 Assigns number and maintains log of LWRs. |
| ARPE | .4 Receives LWR form and has the required Engineering disciplines (Civil/Structural, Mechanical and Welding) review LWR and determine if it has any affect on the current review/evaluation of the SSW and completes applicable portions of LWR. |
| | .5 If LWR is rejected by Engineering, returns LWR to ARCM. |
| | .6 If LWR is approved, gives to the Assistant Project Quality Assurance Manager (APQAM) for his review and approval. |
| APQAM | .7 Reviews LWR, fills out applicable portion of form, and returns with QA disposition to ARCM. |
| *ARCM | .8 If LWR is approved returns to CS. |

*Responsible for coordinating with NRC until their concurrence is no longer required.

EFFECTIVE DATE:	SUPERSEDES ISSUE DATED:	QUALITY AFFECTING:	
Dec 7, 1979	New	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO	PAGE 1 OF 5

<u>Responsibility</u>	<u>Action</u>
3.0 (Cont.)	
CS	.9 Reviews LWR <u>after</u> it has been approved by Engineering and APQAM.
	.10 Coordinates work with Welding Engineering to assure proper control and surveillance.
4.0 <u>REFERENCES</u>	
None	
5.0 <u>ATTACHMENTS</u>	
5.1 <u>LWR Form</u>	
5.2 <u>Flow Chart for Evaluation of LWR</u>	

LIMITED WORK REQUEST FORM
(LWR)

PMI 5-1000
Temporary

Attachment II
Page 4 of 6

No. _____

Page 1 of 2

Drawing # _____

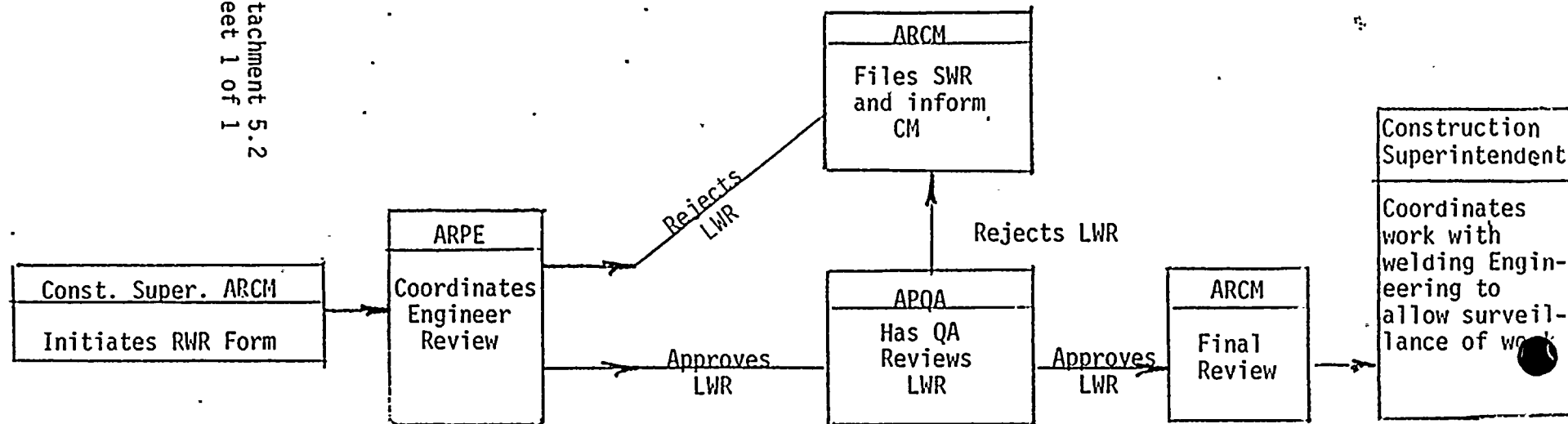
<u>CM</u> 1. The following area of the SSW will be worked:	AZ ⁰	Elevation	Remarks

CM 2. Item or Nature of the work:

Attachment 5.1
Sheet 1 of 2

3. Work Procedure #84		AZ ⁰	Elevation	Remarks	
Eng. Application on previous known area					
4. Shielding Program Interface:		AZ ⁰	Elevation	Record Release	
Eng.				Yes	No
PQA. Leckenby's Documentation Verification		SAT	UNSAT	Remarks	
5. Weld Procedures					
6. Welder Qualification					
7. Mil Test Reports					
8. Inspection Records					
9. Inspector Qualification					
Approval For Work		ENGINEERING		Attachment 5.1	
				Sheet 2 of 2	
		Mech.	Civil	Welding	Const.Mgt. Quality Assurance

Date: _____



S.S.W. - - SAC SHIELD WALL
 L.W.R. - - LIMITED WORK REQUEST
 C.M. - - CONSTRUCTION SUPERINTENDENT
 A.R.P.E. - - ASST. RESIDENT PROJECT ENGINEER
 A.R.C.M. - - ASST. RESIDENT CONSTRUCTION MANAGER
 A.P.Q.A. - - ASST. PROJECT QA MANAGER

FLOW CHART FOR EVALUATION OF LWR

SCHEDULE/LOGIC FOR SAC SHIELD WALL EVALUATION PROGRAM

(Reference: WNP-2 Program for the Evaluation of the SSW 12/3/79)

	Part III-1 Review WBG report; perform independence review of documentation, interface w/ Engineering review and develop a list of concerns/problem areas.					
		Part III-2 Develop re-inspection program to re-inspect as much as possible to reduce the number of concerns/problems. Develop list of concerns/problem areas and transmit to Engineering.				
				Part III-3 Engineering review of Site list of concerns/problem areas and develop final report.		
DEC 10	JAN 1	JAN 10	FEB 1	MAR 1	MAR 15	