



27562
J3 FER 8 A10 : 50

NRC-39

8303010538 830216
PDR ADCK 05000400
Q PDR

Reported Violation:

10 CFR 50, Appendix B, Criterion VII as implemented by PSAR Section 1.8.5.7 and CP&L's Corporate QA Program Section 4.1, requires that materials conform to procurement documents.

Contrary to the above, the resistant spot welds on the foundation cradle for the reactor make-up water pump 1B-SN were found to be incomplete and not conforming with the pump's seismic shock analysis report; the quality grade for the bolting materials that fasten the pump's cradle to the pump and to its platform could not be confirmed as conforming to the quality grade specified in the pump's shock analysis report.

This is a Severity Level IV Violation (Supplement II.D).

Denial or Admission and Reason for the Violation:

1. The violation is correct as stated. The spot welds were incomplete because of lack of fusion. The ultimate cause for this has not been determined but may be due to such factors as (i) insufficient electrode pressure, (ii) insufficient electrical current (and hence, lower temperature) through the resistance electrodes, (iii) insufficient period of time to complete the weld, etc.
2. The spot welds with reduced nugget sizes may have resulted due to incorrect size of electrode applied or one of the above mentioned factors.
3. The bolts referred to in the violation could not be confirmed as being the grade of material assumed in the seismic analysis report because no bolt head identification was available, nor was a Certificate of Compliance available. Bolt head identification for these bolts was not required at the time of procurement.

Corrective Steps Taken and Results Achieved:

1. Incomplete welds will be repaired.
2. Consultation with the supplier, Westinghouse, has confirmed that the undersize welds were still consistent with the seismic criteria applicable at SHNPP.
3. CP&L will replace these bolts in question with those of a known and identifiable grade of material consistent with design criteria.
4. The supplier will revise documents to reflect installed bolting material.

Attachment (Cont'd.)

Corrective Action Taken to Avoid Further Noncompliance:

1. Seismic Category I pumps of this type will be inspected to determine the structural integrity of the gusset stiffeners and take corrective action if necessary.
2. Seismic Category I pumps of this type will be reviewed to ensure that seismic design criteria are met.
3. Seismic Category I pumps of this type will have unidentifiable bolting replaced with that of a known type as noted in corrective action above.
4. A procedure to control and accomplish items 1 through 3 above will be prepared by April 22, 1983.

Date When Full Compliance Will Be Achieved:

Full compliance will be achieved by September 1, 1983.