If you have any questions on the enclosed documents or this matter, please do not hesitate to contact Mr. Neal A. Pillsbury, Director of Quality Programs at (603) 474-9521, extension 3341.

Very truly yours,

Ted C. Feigenbaum

Enclosure

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April 26, 1991

ENCLOSURE 1

PROCEDURE FOR THE REVIEW OF RADIOGRAPHS

PROCEDURE

FOR THE

REVIEW OF RADIOGRAPHS

Project Application	Copy No.	Assigned To
2007 – Seabrook RT Review		

APPROVALS

TITLE / DEPT. – SIGNATURE – DATE

REV NO	PREPARED BY	REVIEWED BY	APPROVED BY	NHY Engineering	NHY QA
0	Albert C. 6/12/07	Ken C. 6-04-07	4/25/07	4-26-07	Dudand Cook
1					
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REVISION LOG

NUCLEAR ENERGY SERVICES, INC.

DOCUMENT NO. 83A5642

REV NO.	DATE	PAGE NO.	DESCRIPTION	APPROVAL

FORM # NES 206 3/80

1. OBJECTIVE

The objective of this procedure is to develop a list of field welds for which radiographs exist in the NHY vault. This list will be developed from a data extraction of the completed data sheets shown in Figure 6.1.

2. GENERAL

This procedure applies to the review of radiographic packages for field welds and the recording of the approval signatures and approval dates. In addition the approved radiographs shall be reviewed to verify the system, weld number and station numbers on the film.

3. REFERENCES

3.1 ASME Boiler and Pressure Vessel Code, Section III and VIII, 1977 edition with Winter 1977 addenda.

3.2 ANSI B31.1 Power Piping with 1977 addenda.

3.3 NHY Procedure 17400, Request for Engineering Services (RES).

3.4 NHY Procedure 12720, Corrective Action Requests.

3.5 NES Procedure 83A5643, Procedure for the Review of Drawings.

3.6 NES Procedure 83A5641, Procedure for the Verification of Radiographic Records.

3.7 NHY Purchase Order No. 76945.

4. SCOPE

The scope of work includes field welds for the following:

4.1 ASME B&PV Code Section III, Class 1, 2 & 3 Piping

4.2 ASME B&PV Code Section III, Class 1 Supports

4.3 ASME B&PV Code Section VIII, Unfired Vessels

4.4 ANSI B31.1 Power Piping, Piping

5. TASK INPUT AND OUTPUT

5.1 INPUT DOCUMENTS

1. Radiographic Inspection Reports (RIR)
2. Radiographic Film

5.2 OUTPUT DOCUMENTS

1. Completed data sheets (Figure 6.1)
2. List of field welds which have radiographs

6. PROCEDURE

6.1 The review of the radiographic film packages will be completed one package at a time. (A radiographic film package contains all radiographic films and Radiographic Inspection Reports (RIR) for one weld.)

6.2 Information from the RIR will be recorded by the Document Reviewer in the heading and on the left side of the data sheet (see Figure 6.1):

- unit
- system/line number/ISO number
- weld number
- weld revision level
- data of exposure
- applicable construction code
- all views or station numbers
- weld station status (accepted/rejected)
- the approval name(s) * and date(s) signed
- the ANI's name * and date signed
- the YAEC's name * and date signed

* The initials as shown on the signature log shall be recorded in lieu of full name

NOTE: The YAEC signature may be noted on the exterior of the film packet jacket.

6.3 If any of the above information is not on the RIR, the space shall be left blank.

NOTE: Gloves shall be used when handling radiographic film.

6.4 The accepted radiographic films will be reviewed for the following information. The Document Reviewer will record on the right side of the data sheet:

- view or station number (enter on the same line as station number on left side)
- date exposed*
- system/line number/ISO*
- weld number*

* The Document Reviewer's initials shall signify that the information is identical to that entered from the RIR.

NOTE: This task does not involve re-interpretation of the radiographic film.

6.5 If during Step 6.4, the film cannot be found, the film data spaces on the right side of the data sheet shall be left blank. For views marked as rejected, the film data columns will be marked "N/A".

6.6 If the weld has rejected views, locate the RIR in the next revision and complete the Supplemental Data Sheet, (Figure 6.2) for that weld revision. Continue with Supplemental Data Sheets repeating steps 6.2 through 6.6 until all revisions are included.

6.7 The Document Reviewer shall complete the findings box on the data sheet; sign, date and page number the data sheet(s); and submit it to the Project Manager.

6.8 The Project Manager shall review each data sheet set for completeness and legibility, sign and date the data sheet(s).

6.9 If there is any missing information or discrepancies on the data sheet, the Project Manager shall report this to the NHY IRT Manager for resolution using NHY Procedure 17400, Request for Engineering Services or NHY Procedure 12720, Corrective Action Requests, as appropriate. NHY is responsible for providing a written resolution of discrepancies to the Project Manager.

6.10 As a data sheet is determined to be complete by the Project Manager, the field weld will be added to the list for which radiographs exist in the NHY records vault.

6.11 At the completion of each system, the Project Manager will submit copies of the data sheets and the list of field welds for which radiographs exist, for that system, to the NHY IRT Project Manager.

6.12 The work effort is continued in the Reference 3.6 procedure.

FIGURE 6.1

FIELD WELD RADIOGRAPH IDENTIFICATION

NES/NHY

Page ____ of ____

UNIT	SYSTEM	LINE NO.	ISO NO.	WELD NO.	REV.	EXPOSURE DATE

APPLICABLE CODE: ASME Section III ☐ ASME Section VIII ☐ ANSI B 31.1 ☐

RIR DATA

View or Station Nos.	Accept	Reject

FILM DATA

View or Station Nos.	Date Exposed	System/Line/ISO	Weld No.

Approvals		Date
		/ /
		/ /
		/ /
ANI		/ /
YAEC		/ /

Findings:		Yes	No	Comments
	Missing Views?			
	Missing Approvals?			
	Missing Film?			

Document Reviewer: _____ _____

Project Manager: _____ _____

Signature Date

FIGURE 6.2

SUPPLEMENTAL DATA SHEET

NES / NHY

Page ____ of ____

UNIT	SYSTEM	LINE NO.	ISO NO.	WELD NO.	REV.	EXPOSURE DATE

APPLICABLE CODE: ASME Section III ☐ ASME Section VIII ☐ ANSI B 31.1 ☐

PWR DATA		
View or Station Nos.	Accept	Reject

FILM DATA			
View or Station Nos.	Date Exposed	System/Line/ISO	Weld No.

Approvals		Date
		/ /
		/ /
		/ /
ANI		/ /
YAEC		/ /

Document Reviewer: _____ _____

Project Manager: _____ _____

Signature Date