

THE CINCINNATI GAS & ELECTRIC COMPANY



August 15, 1983
LOZ-83-0111

J. WILLIAMS, JR.
SENIOR VICE PRESIDENT
NUCLEAR OPERATIONS

Docket No. 50-358

U.S. Nuclear Regulatory Commission
Region III
799 Roosevelt Road
Glen Ellyn, Illinois 60137

Attention: Mr. J. G. Keppler
Regional Administrator

Gentlemen:

RE: WM. H. ZIMMER NUCLEAR POWER STATION - UNIT 1
NRC LETTER, DATED MAY 17, 1983, REQUEST FOR
INFORMATION CONCERNING WELDER QUALIFICATIONS
W.O. #57300, JOB E-5590, FILE NO. 956C

PRINCIPAL STAFF	
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By letter dated May 17, 1983, the NRC requested that CG&E "... provide a detailed accounting of the times for each individual welder, listed by 'stamp' in the enclosure, during the completion of the special welder's qualification program for the periods specified noting any special training, either onsite or offsite, provided the individual during implementation of the requalification program between July 20, and November 1, 1982. If no special training was provided for the listed individuals, your submittal should state that fact."

Our previous response, LOZ-83-0082, dated July 15, 1983, stated that CG&E was taking steps to confirm the accuracy and adequacy of the requested information prior to its submittal. CG&E has completed its review of the information contained in the attached report and believes the information accurately reflects the activities for each of the listed welders during the specified periods. The review also found that no special training, either onsite or offsite, was provided to the listed individuals. All documents used in the preparation of the report are available for NRC review at the site.

AUG 18 1983

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PDR ADOCK 05000358
A PDR

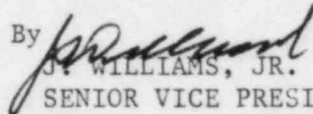
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Mr. J. G. Keppler
Regional Administrator
August 15, 1983
LOZ-83-0111
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If you have any questions or require additional information, please contact me at your convenience.

Very truly yours,

THE CINCINNATI GAS & ELECTRIC COMPANY

By 
J. WILLIAMS, JR.
SENIOR VICE PRESIDENT

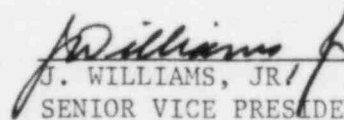
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ATTACHMENT

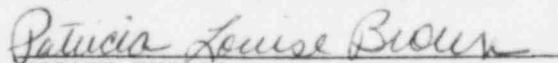
cc: NRC Office of Special Cases, Region III
ATTN: R. F. Warnick
NRC Senior Resident Inspector
ATTN: W. F. Christianson
NRC Zimmer Project Inspector, Region III
ATTN: E. R. Schweibinz

State of Ohio)
 SS
County of Clermont)

I have read the foregoing and it is true and correct to the best of my knowledge, information and belief.


J. WILLIAMS, JR.
SENIOR VICE PRESIDENT

Sworn to and subscribed before me this 16th day of August, 1983.


NOTARY PUBLIC
PATRICIA LOUISE BROWN
Notary Public, State of Ohio
My Commission Expires May 1, 1986

Attachment
Mr. J. G. Keppler
Regional Administrator
August 15, 1983
LOZ-83-0111

NRC REQUEST FOR INFORMATION
(NRC LETTER, DATED MAY 17, 1983)

SPECIAL

WELDER'S QUALIFICATION

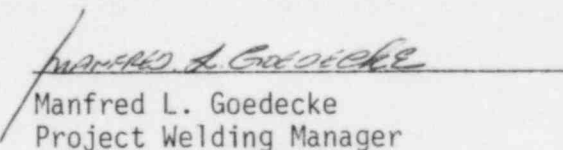
PROGRAM

**HENRY J. KAISER
COMPANY**

P.O. BOX 201, MOSCOW, OHIO 45153

August 15, 1983

I, Manfred L. Goedecke, do hereby affirm that the documents submitted herewith (Special Welder Qualification Program) were prepared under my direction and have been revised to accommodate comments from the Cincinnati Gas and Electric Company to further clarify sequents of events and are true and correct to best of my knowledge and belief.


Manfred L. Goedecke
Project Welding Manager

*Signed and sworn before me
this 15th day of August, 1983.*

Patricia Louise Brown

PATRICIA LOUISE BROWN
Notary Public, State of Ohio
My Commission Expires May 1, 1986

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*TRAINING

All training that was performed during the special welder performance qualification program was conducted on site at the Wm. H. Zimmer Nuclear Power Station, by H. J. Kaiser Company, in accordance with WCP-2, Appendix B.

7-20-82 - Setting Up (.28)
7-21-82 - 25% welded (.28)
7-22-82 - 90% welded (.28)
7-23-82 - Ready to cap
7-24-82 - Grinding ring out, inspection completed, coupon sent to NES
7-25-82 - Fitting Up (.7)
7-26-82 - 60% welded (.7)
7-27-82 - 90% welded (.7)
7-28-82 - Completed (.7) Inspection completed (.7), RT Accept (.28)
7-29-82 - Fit-up (.19) 40% welded (.19), RT Accept (.7)
7-30-82 - 80% welded (.19)
7-31-82 - Inspection completed, coupon sent to NES (.19), assigned booth (.1)
8-01-82 - 85% welded (.1)
8-02-82 - Inspection completed, coupon sent to NES (.1), Assigned booth (.62H).
8-03-82 - Setting Up (.62H), RT Accept (.19), RT Accept (.1)
8-04-82 - Absent
8-05-82 - 10% welded (.62H)
8-06-82 - 90% welded (.62H)
8-07-82 - Inspection completed, coupon sent to NES (.62H), welder waiting in test shop.
8-08-82 - Sunday - did not work
8-09-82 - RT pending (.62H) - in field 4 hours MSRB, NR-2-282, ETRA-6012,
- in field 4 hours RT-1-300 cut and end prep.
8-10-82 - RT pending (.62H) - in field 8 hours MSRB, NB-2-282
8-11-82 - RT pending (.62H) - in field 8 hours SRB test blocks, A-6102
8-12-82 - RT Reject (.62H) - in field 8 hours PSK-RT-35A-(9968-9106)
8-13-82 - In field 5.8 hours PSK-RT-35A-(9968-9106), Assigned booth (.62H)
8-14-82 - Two (2) hours training, Fit-up (.62H) Retest 30% welded retest
8-15-82 - Awaiting visual inspection (.62H)

8-16-82 - Coupon sent to NES (.62H), welder remained in test shop for the day

8-17-82 - RT pending (.62H) - in field 8 hours grinding J-bevel, PSK-RT-34

8-18-82 - RT Accept (.62H) - in field 8 hours grinding J-bevel, PSK-RT-34

STENCIL COPY

STENCIL COPY

[illegible]

8-30-82 - Assigned booth (.28)
8-31-82 - Fit-up (.28) 30% welded (.28)
9-01-82 - In process reject (.28), Fit-up (.56), 20% welded (.56)
9-02-82 - Coupon completed, inspection performed, coupon sent to NES (.56)
Assigned booth (.28)
9-03-82 - 30% welded (.28), RT Reject (.56)
9-04-82 - Saturday - did not work
9-05-82 - Sunday - did not work
9-06-82 - Holiday - did not work
9-07-82 - 95% welded (.28)
9-08-82 - Visual reject (.28), welder in Test Facility eight (8) hours
9-09-82 - 20% welded (.28) retest, 4 hours training
9-10-82 - 50% welded (.28)
9-11-82 - Saturday - did not work
9-12-82 - Sunday - did not work
9-13-82 - 90% welded (.28)
9-14-82 - 95% welded (.28)
9-15-82 - Moving machines, booths 1 - 6 closed
9-16-82 - Welding Complete, visual inspection complete, grinding for RT (.28)
9-17-82 - Grinding for RT (.28)
9-18-82 - Saturday - did not work
9-19-82 - Sunday - did not work
9-20-82 - Coupon sent to NES (.28), welder waiting in the test shop
9-21-82 - RT Accept (.28), fitting up (.7), in process reject (.7)
9-22-82 - Fit-up (.7) retest, 80% welded (.7)
9-23-82 - Coupon completed, inspection performed, coupon sent to NES (.7)
9-24-82 - RT accept (.7), welder assigned to the field

BADGE NO. 9-2125

BADGE NO. 9-2125

BADGE NO. 9-2125

[illegible]

7-20-82 - Assigned booth (.28)
7-21-82 - Fit-up (.28)
7-22-82 - 40% welded (.28)
7-23-82 - 50% welded (started vacation)
7-24-82 - Vacation
7-25-82 - Vacation
7-26-82 - Vacation
7-27-82 - Vacation
7-28-82 - Vacation
7-29-82 - Vacation
7-30-82 - Vacation
7-31-82 - Vacation
8-01-82 - Vacation
8-02-82 - 90% welded (.28)
8-03-82 - (.28) weld complete, visual inspection complete
8-04-82 - Grinding (.28)
8-05-82 - (.28) coupon sent to NES/Fit-up (.7)
8-06-82 - 50% welded (.7), RT accept (.28)
8-07-82 - Absent
8-08-82 - Absent
8-09-82 - (.7) weld complete, visual inspection complete, coupon sent
to NES, fit-up (.1)
8-10-82 - (.1) weld complete, visual inspection complete
coupon sent to NES, RT accept (.7)
8-11-82 - RT pending (.1) in field 8 hrs. clean up
8-12-82 - RT pending (.1) in field 8 hrs. system RR
8-13-82 - Welder remained in field, RT accept (.1)

STENCIL LIX

[illegible]

7-20-82 - Assigned booth (.51)

7-21-82 - Absent

7-22-82 - Absent

7-23-82 - 75% welded - 3G (.51)

7-24-82 - Completed 3G, Final Visual 3G(.51)accept, fit-up 4G (.51)

7-25-82 - Welder in test shop 4.5 hrs.

7-26-82 - Bend tests 3G accepted, fit-up 4G (.51)

7-27-82 - Absent

7-28-82 - Completed 4G, inprocess inspection (.51)

7-29-82 - Visual inspection complete, cut bend & prep specimens
Bend test accepted - 4G (.51)

STENCIL NDY

[illegible]

7-20-82 - Assigned booth (.28)
7-21-82 - Absent
7-22-82 - Fit-Up, (.28) 20% welded (.28)
7-23-82 - 50% welded (.28)
7-24-82 - 80% welded (.28)
7-25-82 - Weld complete, waiting inspection
7-26-82 - Inspection complete, grinding for RT, coupon sent to NES (.28)
7-27-82 - Fit-up (.7)
7-28-82 - 15% welded (.7), RT pending (.28)
7-29-82 - 70% welded (.7), RT acc. (.28)
7-30-82 - Completed test, waiting QC (.7)
7-31-82 - Visual inspection complete, coupon sent to NES,
RT pending (.7) - welder waiting in test shop
8-01-82 - RT pending (.7) - Sunday did not work
8-02-82 - RT pending (.7) - in field 8 hrs. downcomer clean up
8-03-82 - Welder remained in field, RT accepted (.7)

STENCIL
I.S.A.[illegible]

- 8-06-82 - Fitting Up (.80) 3G
- 8-07-82 - 20% welded (.80) 3G
- 8-08-82 - 90% welded (.80)
- 8-09-82 - Completed 3G, visual inspection complete, cutting 3G (.80)
Tacking Up 4G (.80)
- 8-10-82 - 20% welded (.80) 4G - 3G bend test pending
- 8-11-82 - 60% welded (.80) 4G - 3G bend test pending
- 8-12-82 - Absent
- 8-13-82 - Completed 4G (.80)
- 8-14-82 - Grinding 4G, final visual inspection complete 4G (.80)
- 8-15-82 - 70% welded 2G (.80)
- 8-16-82 - Completed 2G, visual inspection complete; grinding 2G & 4G
- 8-17-82 - Sent to NES (2G & 4G), welder in field 8 hours, PK-61882213
- 8-18-82 - RT Accept 2G & 4G, 3G accepted on a bend test (.80)
Welder remained in field

STENCIL Q6B

8-06-82 - Fit-up, (.28)

8-07-82 - Eng. rej. due to no root insp. performed (.28) 2 hrs. training
Fit, tack (.28) Retest

8-08-82 - 40% welded (.28) Retest

8-09-82 - 80% welded (.28) Retest

8-10-82 - Test weld complete, awaiting inspection (.28)

8-11-82 - Inspection Complete, grinding for RT (.28)

8-12-82 - Test Coupon sent to NES, welder waiting in test shop

8-13-82 - RT reject (.28) - in field 4.5 hours ECR 312, 9106, in field
3.5 hours RR Snubbers A3, B5

8-14-82 - Weekend, did not work

8-15-82 - Weekend, did not work

8-16-82 - 4 hours training* Fit-up (.28) Retest

8-17-82 - 20% welded retest (.28)

8-18-82 - 40% welded (.28)

8-19-82 - 75% welded (.28)

8-20-82 - 90% welded (.28)

8-21-82 - Saturday, did not work

8-22-82 - Sunday, did not work

8-23-82 - Absent

8-24-82 - Absent

8-25-82 - Absent

8-26-82 - Test completed, awaiting inspection

8-27-82 - Inspection Complete, grinding for RT (.28)

8-28-82 - Saturday, did not work

8-29-82 - Sunday, did not work

8-30-82 - Test coupon sent to NES, welder waiting in test shop

8-31-82 - RT Accept (.28), welder reassigned to the field

STENCIL LQT

[illegible]

7-19-82 - Assigned booth (.51)

7-20-82 - 65% welded, 3G, hurt hand at 3:30 PM (.51)

7-21-82 to 8-12-82 - Out of work on Workman's Compensation

8-13-82 - Assigned booth (.51)

8-14-82 - Fit-up, 4G

8-15-82 - Completed 4G, completed 3G, 4G bend test accept

8-16-82 - 3G bend test accept, welder assigned to field

NDO

[illegible]

7-20-82 - Setting up
7-21-82 - 50% welded (.28)
7-22-82 - Completed test (capped out) (.28)
7-23-82 - Inspection complete, grinding for RT, coupon sent to NES (.28)
7-24-82 - RT pending (.28), set-up new test (.7)
7-25-82 - 20% welded (.7)
7-26-82 - Completed (.7)
7-27-82 - Fit-up (.19) 10% welded (.19) final visual inspection HJK (.7)
7-28-82 - Inprocess visual reject (.19) 3 hrs. training, Fit-up (.19) Retest,
inspection pending CG&E (.7) RT reject (.28)
7-29-82 Absent, coupon sent to NES
7-30-82 - 30% welded (.19), RT accept (.7)
7-31-82 - 90% welded (.19)
8-01-82 - Completed (.19) coupon sent to NES, Fit-up (.34), 15% welded (.34)
8-02-82 - 60% welded (.34)
8-03-82 - RT accept (.19), visual reject (.34)

STENCIL
L.U.J.[illegible]

09-1169 KMA

During the time period between 10-5-82 and 10-17-82, welder was returned to the field and assigned work in accordance with his qualifications.

8-07-82 - Fit up complete (.28)
8-08-82 - 50% welded (.28)
8-09-82 - 80% welded (.28)
8-10-82 - 95% welded (.28)
8-11-82 - Capped out, waiting inspection (.28)
8-12-82 - Inspection complete, grinding for RT (.28)
8-13-82 - Assigned booth (.56), test (.28) sent to NES
8-14-82 - Tack up (.56)
8-15-82 - 30% welded (.56)
8-16-82 - 95% welded (.56) RT Rej. (.28)
8-17-82 - Completed (.56), coupon sent to NES
8-18-82 - 2 hrs. training, Fitting up (.28), reject RT (.56)
8-19-82 - 25% welded (.28)
8-20-82 - 40% welded (.28)
8-21-82 - Saturday, did not work
8-22-82 - Sunday, did not work
8-23-82 - 75% welded (.28)
8-24-82 - 85% welded (.28)
8-25-82 - Weld complete, waiting inspection
8-26-82 - Inspection completed, grinding for RT (.28)
8-27-82 - Fitting up (.7), sent to NES (.28)
8-28-82 - Saturday, did not work
8-29-82 - Sunday, did not work
8-30-82 - Tacked up (.7), RT Accept (.28)
8-31-82 - In process visual reject (.7), fitting up retest (.7)
9-01-82 - 10% welded (.7), visual rej. (.7)
9-02-82 - Fit-up on (.56), 20% welded on (.56)
9-03-82 - Completed (.56), visual inspection complete, coupon sent to NES
9-04-82 - Saturday, did not work

9-05-82 - Sunday, did not work

9-06-82 - Holiday, did not work

9-07-82 - RT pending (.56) - in field 2 hrs. start up 7851-8810
 - in field 6 hrs. IWRC-02-HR 2679-6951

9-08-82 - RT Reject (.56) - in field 6 hrs. IWRC-36-HR 2679-6951
 - in field 2 hrs. start-up 7851-8810

9-09-82 - Fitting up (.7)

9-10-82 - 50% welded (.7)

9-11-82 - Completed (.7), visual inspection complete, coupon sent to NES
 Fit-up (.56) Retest, Completed (.56) Retest, coupon sent to NES

9-12-82 - Sunday, did not work

9-13-82 - RT Reject (.7) - in field 6 hrs. INX-094-HG 2679-6954
 RT Reject (.56) in field 2 hrs. start up 7851-8810

9-14-82 - Welder in field 8 hrs.

9-15-82 - Welder in field 6 hrs., 3 hrs. craft training

9-16-82 - Absent

9-17-82 - Absent

9-18-82 - Saturday, did not work

9-19-82 - Sunday, did not work

9-20-82 - Fit-up (.7) Retest 10% welded (.7)

9-21-82 - 25% welded (.7)

9-22-82 - 75% welded (.7)

9-23-82 - Completed (.7), visual inspection complete, coupon sent to NES

9-24-82 - Welder in field 8 hrs., RT accept (.7)

9-25-82 - Saturday, did not work

9-26-82 - Sunday, did not work

9-27-82 - In field 8 hrs.

9-28-82 - 4.5 hrs. in field, assigned to Test Shop, Fitting up (.6)

9-29-82 - Visual reject (.6), 2 hrs. training, fit-up retest (.6)

9-30-82 - 20% welded (.6) Retest

10-01-82 - Complete (.6), visual inspection complete, coupon sent to NES 9.6)
10-02-82 - Saturday, did not work
10-03-82 - Sunday, did not work
10-04-82 - Welder in field 8 hrs. RT reject (.6)
10-05-82 thru 10-15-82 - Reference attached cover letter
10-16-82 - Saturday, did not work
10-17-82 - Sunday, did not work
10-18-82 - 3 hrs. training, Tacked up (.6)
10-19-82 - 25% welded (.6) worked 6.4 hrs.
10-20-82 - Completed (.6), visual inspection complete, test coupon sent to NES
10-21-82 - Welder assigned to the field, RT accept (.6)

WELDERS NAME

BADGE NO. 9-1169

STENCIL KHA

PROCEDURE (S)	POSITION(S)	TEST NO.	DATE TEST BEGAN	INPROCESS VISUAL ACC/REJ	FINAL VISUAL WELD ENGINEER ACC/REJ	FINAL VISUAL HJK-QA ACC/REJ	FINAL VISUAL CG&E-QA ACC/REJ	HJK TEST RESULTS	CG&E TEST RESULTS	TRAINING	TEST SHOP	SHIFT	REMARKS
3.1.28	6G	7202	8-7-82	Acc 8-8	Acc 8-12	Acc 8-12	Acc 8-12	Rej 8-16	Δ 8-16 Rej	Δ N/A	2	1	RT Rej
3.1.56	6G	7236	8-13-82	Acc 8-17	Acc 8-17	Acc 8-17	Acc 8-17	Rej 8-18	Δ 8-18 Rej	2 hours N/A Δ	2	1	RT Rej
3.1.28	6G	7287	8-17-82	Acc 8-20	Acc 8-26	Acc 8-26	Acc 8-26	Acc 8-30	Acc 8-30	N/A	2	1	
3.1.7	6G	N/A	9-1-82	Rej 9-1	N/A	N/A	N/A	N/A	N/A	N/A	2	1	Vis. Rej
3.1.7	6G	6727	9-9-82	Acc 9-11	Acc 9-11	Acc 9-11	Acc 9-11	Δ 9-13 Rej	Δ 9-13 Rej	N/A	2	1	RT Rej
3.1.56	6G	6730	9-11-82	Acc 9-11	Acc 9-11	Acc 9-11	Acc 9-11	Δ 9-13 Rej	Δ 9-13 Rej	N/A	2	1	RT Rej
3.1.7	6G	6776	9-15-82	Acc 9-20	Acc 9-23	Acc 9-23	Acc 9-23	Acc 9-24	Acc 9-24	N/A	2	1	
3.1.6	6G	N/A	9-28-82	Rej 9-29	N/A	N/A	N/A	N/A	N/A	Δ 2 hours	2	1	Vis Rej IF Root
3.1.6	6G	6807	9-30-82	Acc 10-1	Acc 10-1	Acc 10-1	Acc 10-1	Rej 10-4	Δ 10-4 Rej	Δ 10-18-82 3 hours	2	1	RT Rej
3.1.6	6G	6866	10-18-82	Acc 10-20	Acc 10-20	Acc 10-20	Acc 10-20	Acc 10-21	Acc 10-21	N/A	2	1	
Δ 3.1.7	6G		8-27-82	Rej 8-31	N/A					N/A			W.E.Rej VT
Δ 3.1.56	6G	6686	9-2-82	9-3-82	9-3-82	9-3-82	9-3-82	Rej 9-8	Rej 9-8	N/A			RT Rej

Δ 8-10-82

7-20-82 - Set-up (.28)
 7-21-82 - 35% welded (.28)
 7-22-82 - 90% welded (.28)
 7-23-82 - Capped Out (.28)
 7-24-82 - Inspection complete, grinding for RT (.28)
 7-25-82 - Sent to NES (.28), Set-up (.7)
 7-26-82 - 60% welded (.7)
 7-27-82 - 80% welded (.7)
 7-28-82 - Completed and sent to NES (.7), set-up (.56), RT accept (.28)
 7-29-82 - Fit-up (.56) Completed (.56), RT pending (.7)
 7-30-82 - Final visual (.56) coupon sent to NES (.56) Set-up (.19)
 7-31-82 - Fit-up insp. (.19) 60% welded (.19)
 8-01-82 - 90% welded (.19)
 8-02-82 - Completed and sent to NES (.19), set-up (.56)
 8-03-82 - RT Reject and set-up retest (.56), RT accept (.7) RT accept (.19)
 8-04-82 - Absent
 8-05-82 - Fit-up insp. (.56) 25% welded (.56)
 8-06-82 - Welding completed, final visual (.56), coupon sent to NES (.56),
 welder waiting in shop
 8-07-82 - Saturday - Did not work
 8-08-82 - Sunday - Did not work
 8-09-82 - RT accept (.56) retest
 8-10-82 - Vacation
 8-11-82 - Vacation
 8-12-82 - Vacation
 8-13-82 - Vacation
 8-14-82 - Saturday - Did not work
 8-15-82 - Sunday - Did not work
 8-16-82 - Fit-up (.56)

8-17-82 - 30% welded (.59)
8-18-82 - 75% welded (.59)
8-19-82 - 85% welded (.59)
8-20-82 - 95% welded (.59)
8-21-82 - Saturday - Did not work
8-22-82 - Sunday - Did not work
8-23-82 - Completed and sent to NES (.59)
8-24-82 - RT pending (.59), welder in field for 8 hours (INBB2BA 3/4")
8-25-82 - Welder in field, RT Accept (.59)

STENCIL

[illegible]

7-20-82 - Assigned booth
7-21-82 - Fit & Tack (.28)
7-22-82 - Inprocess visual reject, 3 hrs. training, fit-up retest (.28)
7-23-82 - Fit-up inspection rej. (.28) Training, Fit-up .28 Retest,
Inprocess rej. root (.28) retest
7-24-82 - Absent
7-25-82 - Training*
7-26-82 - Fit-up insp. acc. (.28) 25% welded (.28)
7-27-82 - 80% welded (.28)
7-28-82 - Completed test, waiting inspection (.28)
7-29-82 - Final Visual (.28) Grinding (.28)
7-30-82 - Coupon sent to NES (.28), welder waiting in test shop
7-31-82 - Saturday - Did not work, RT pending (.28)
8-01-82 - Sunday - Did not work, RT pending (.28)
8-02-82 - Welder waiting in Test shop, RT pending (.28)
8-03-82 - Welder in field 8 hrs. 1WR-561-HG RT Reject (.28)
8-04-82 - Fit-up (.28) retest
8-05-82 - 50% welded (.28) Retest
8-06-82 - 90% welded (.28), Retest
8-07-82 - Completed test, waiting inspection
8-08-82 - Final visual as welded (.28), Grinding
8-09-82 - Coupon sent to NES (.28), welder waiting in test shop
8-10-82 - Welder in field, RT accept (.28)

[illegible]

**HENRY J. KAISER
COMPANY**
P.O. BOX 201 • MOORE, N.J. 07033

EXPLODER'S NAME _____ EMPLOYEE No. 9-3152 DATE 7-22-82
 ACTUAL SECURITY NUMBER 296-40-8789 CRAFT PF LAB TEST No. 7057
 J. KATZ PROGRESS No. 3.1.28 Rev. -3 POSITION (S) 6G
 SERIAL SPECIFICATION P-1 SA-106 GR.3 TO P-1 SA-106 GR.3
 DESCRIPTION OF TEST COUPON 6" XKS
 THERMAL MATERIAL CLASSIFICATION (AMS) E-7018 SIZE 3/32", 1/8", 5/32"
 ASSUMABLE INSERT ☐ OPEN BUTT ☐ BACKING ☒
 HEAT TREATMENT 200° F. MIN. INTERPASS TEMPERATURE 500° F MAX.
 FE OF TAPPING RT ☒ END ☐
 WELDING ENGINEER Charles McCormick DATE 7 apr 1-14-83
6-23-82

WELDING ENGINEER	DATE
Q.A. INSPECTOR <i>R. L. Woff</i>	DATE <i>7-25-82</i>
COGE INSPECTOR <i>R. L. Woff</i>	DATE <i>7/25/82</i>
BEND TEST APPLICABLE <input type="checkbox"/> NOT APPLICABLE <input type="checkbox"/>	

• SAYPONG INTERNATIONAL, INC.

INTER-OFFICE MEMORANDUM

TO: John Flaherty
AT: Weld Engineering

DATE: January 14, 1983

FROM: Chuck McCormick
Senior Welding Engineer

COPIES TO

Attachment II to

AT: Weld Engineering

JOB NO.: 7070

SUBJECT: Welder, 9-3152

QC personnel entered booth #40 for surveillance purposes on 7-25-82. Welder # 9-3152 was working on the root layer of a 3.1.28 test coupon. Upon surveillance, QC immediately rejected the coupon.

Weld Engineering had not been notified by welder # 9-3152 that coupon was ready for visual of root layer. Weld Engineering had not performed a visual inspection of root layer, prior to QC rejecting coupon, or notified QC that coupon was ready for a root inspection. At this point of testing the root layer had not been completely cleaned up for inspection. Verbal reason for reject by QC was excessive grinding and slag traps.

Respectfully Submitted,

Chuck McCormick
Chuck McCormick
Senior Welding Engineer

7-31-82 - Fit-up and tack (.28)
 8-01-82 - 35% welded (.28)
 8-02-82 - 75% welded (.28)
 8-03-82 - 90% welded (.28)
 8-04-82 - Visual reject (.28), 4 hours training*
 8-05-82 - Evaluation prior to testing (training*) Training form dated 8-06-82
 8-06-82 - Absent
 8-07-82 - 15% welded (.28)
 8-08-82 - 80% welded (.28)
 8-09-82 - 95% welded (.28)
 8-10-82 - Welding completed, visual inspection complete, grinding for RT (.28)
 8-11-82 - Coupon sent to NES (.28), welder waiting in test shop
 8-12-82 - RT reject (.28), 4 hours training*
 8-13-82 - Fit & tacked (.28)
 8-14-82 - Absent
 8-15-82 - 60% welded (.28)
 8-16-82 - 80% welded (.28)
 8-17-82 - 90% welded (.28)
 8-18-82 - Completed test, waiting inspection
 8-19-82 - Inspection complete, grinding for RT (.28)
 8-20-82 - Coupon sent to NES (.28), welder waiting in test shop
 8-21-82 - Saturday - Did not work
 8-22-82 - Sunday - Did not work
 8-23-82 - RT pending (.28) - in field for 8 hours (LDV 016 HR 2679-6950)
 8-24-82 - Welder in field, RT accept (.28)

PBH
STENCIL

[illegible]

9-2157 L.T.Y.

7-20-82 - Assigned booth
7-21-82 - Tacked up (.28)
7-22-82 - 75% welded (.28)
7-23-82 - Visual reject (.28), fit-up retest (.28)
7-24-82 - Absent
7-25-82 - Absent
7-26-82 - 20% welded (.28) retest
7-27-82 - 65% welded (.28) retest
7-28-82 - Absent
7-29-82 - Visual reject (.28), 6 hours training*
7-30-82 - Setting-up (.28) retest
7-31-82 - Fit-up insp., comp. 50% welded (.28) retest
8-01-82 - 90% welded (.28) retest
8-02-82 - Capped out, waiting on QC
8-03-82 - Inspection complete, grinding for RT, coupon sent to NES (.28)
8-04-82 - Fitting up (.7), RT accept (.28)
8-05-82 - Fit-up insp. comp., 40% welded (.7)
8-06-82 - 75% welded (.7)
8-07-82 - Completed (.7), visual inspection complete, coupon sent to NES (.7)
8-08-82 - RT pending (.7), Sunday - Did not work
8-09-82 - RT pending (.7) - in field 8 hours, remove defects PSK HP 7, end
prep spool #190
8-10-82 - RT accept (.7) - welder in field

[illegible]

During the time period between 9-4-82 and 10-10-82, Welder
was returned to the field and assigned work in accordance with the qual-
ifications to SPPM 3.1.28.

On 10-11-82, due to a QA directive, was reassigned to the
HJK Test Shop.

(Reference attachments)

50-30 M.A.M.

8-06-82 - Fit-up (.28)

8-07-82 - 50% welded (.28)

8-08-82 - Completed, waiting inspection

8-09-82 - Coupon sent to NES, welder waiting in test shop

8-10-82 - RT accept (.28) (absent)

8-11-82 - Set-up new test - 3G (.80) Inprocess visual reject - 3G (.80),
noted amperage problem - 2 hours training*

8-12-82 - TAN #1 approved for (.80) to increase amp range

8-13-82 - Fit-up 3G, (.80), Completed 3G (.80)

8-14-82 - Final visual insp. comp. 3G, Fit-up 4G, 40% welded (.80)

8-15-82 - Completed 4G, cooling for inspection

8-16-82 - Fit-up insp. 2G (.80) 2G 90% welded (.80), VT reject, 3G, after
backing removed.

8-17-82 - Fit-up 3G (.80) Retest

8-18-82 - Absent

8-19-82 - Grinding 2G & 4G for RT, fitting up 3G (.80)

8-20-82 - 2 hours training*, 3G Fit-up insp. comp. 3G 50% welded (retest)

8-21-82 - Saturday - Did not work

8-22-82 - Sunday - Did not work

8-23-82 - Complete 3G, inspect & grind; 2G, 3G, 4G test plates sent to NES

8-24-82 - RT pending (.80) - in field 10 hours, repair leak chase wall liner
9965, 9674

8-25-82 - RT reject 3G & 4G (.80) RT accept 2G (.80), welder in field 10 hours-
repair leak chase wall liner

8-26-82 - 2 hrs. training Fit-up (.80), fit-up 3G (.80) retest

8-27-82 - Welder in field 10 hours - repair leak chase wall liner

8-28-82 - Saturday - Did not work

8-29-82 - Sunday - Did not work

8-30-82 - 4G retest 90% welded (.80); fit-up inspection 3G (.80) retest

8-31-82 - Inprocess visual reject 3G retest (.80) 3 hours training*
fit-up 3G retest, (.80) inprocess visual rej. 3G retest (.80)
completed 4G (.80) 4G bend test accept (.80)

9-01-82 - Absent

9-02-82 - 3 hrs. Training Fit-up 25% welded 3G (.80) Retest

9-03-82 - Complete 3G, visual inspection complete, Bend test accept 3G (.80)

9-04-82 thru 10-10-82 - Reference cover letter

10-11-82 - Evaluation prior to testing (.41), set-up (.41)

10-12-82 - Coupon completed and sent to NES (.41), welder sent to field

10-13-82 - Welder assigned to test shop, fit-up and 20% welded - 3G retest (.80)
RT accept (.41) see note #1

10-14-82 - 90% welded 3G (.80)

10-15-82 - Completed 3G, inspection & grinding, 3G bend test pending

10-16-82 - Saturday - Did not work

10-17-82 - Sunday - Did not work

10-18-82 - Welder in field, 3G bend test accept (.80)

WELDERS NAME

BADGE NO. 50-30

STENCIL MAM

PROCEDURE(S)	POSITION(S)	TEST NO.	DATE TEST BEGAN	INPROCESS VISUAL ACC/REJ	FINAL VISUAL WELD ENGINEER ACC/REJ	FINAL VISUAL HJK-QA ACC/REJ	FINAL VISUAL CG&E-QA ACC/REJ	HJK TEST RESULTS	CG&E TEST RESULTS	TRAINING	TEST SHOP	SHIFT	REMARKS
3.1.28	6G	7133	8-6-82	ACC/8-7	ACC/8-9	ACC/8-9	ACC/8-9	ACC/8-10	ACC/8-10	N/A	2	1	
* 3.1.80	3G	N/A	8-11-82	REJ/8-11	N/A	N/A	N/A	N/A	N/A	2 HRS.	2	1	VT REJ-NEED TO HAVE PROC. CHANGED FOR WIRE AMPERAGE
3.1.80	3G	N/A	8-13-82	ACC/8-13	ACC/8-14	ACC/8-14	ACC/8-14	REJ/8-16	N/A	2 HRS.	2	1	VT REJ. AFTER BACKING REMOVED (L.O.F.)
3.1.80	4G	7257	8-14-82	ACC/8-14	ACC/8-16	ACC/8-16	ACC/8-16	REJ/8-25	N/A	2 HRS.	2	1	RT REJ
3.1.80	2G	7257	8-16-82	ACC/8-17	ACC/8-17	ACC/8-17	ACC/8-17	ACC/8-25	ACC/8-25	N/A	2	1	
3.1.80	3G	N/A	8-26-82	REJ/8-31	N/A	N/A	N/A	N/A	N/A	3 HRS.	2	1	VT REJ
3.1.80	4G	7257	8-26-82	ACC/8-30	ACC/8-30	ACC/8-30	ACC/8-30	ACC/8-31	ACC/8-31	N/A	2	1	BEND ACC
3.1.80	3G	7257	9-2-82	ACC/9-2	ACC/9-3	ACC/9-3	ACC/9-3	ACC/9-3	ACC/9-3	N/A	2	1	BEND ACC
3.1.80	3G	6853	10-13-82	ACC/10-15	ACC/10-15	ACC/10-15	ACC/10-15	ACC/10-18	ACC/10-18	N/A	2	1	WELD TEST FOR RE-VERIFICATION PURPOSES ONLY
△ 3.1.80	3G	7257	8-17-82	8-20-82	ACC/8-23	ACC/8-23	ACC/8-23	REJ/8-25	REJ/8-25				RT REJ
△ 3.1.80	3G		8-31-82	REJ/8-31									
	△ 8-10-83												

* Amperage Range too Restrictive.
 TAN-1 to SPPM 3.1.80
 generated AND approved
 8-12-82. Ref Attachment I

TEMPORARY AMENDMENT NOTICE

Attachment I to

KE WELD PROCEDURE SPECIFICATION No. 3.1.80 R. 2 AMENDMENT/CHANGE No. TAN-1

WELDING PROCESS SHAW ISSUE DATE - 8-12-82

SUSPENSE DATE - Next Revision

DESCRIPTION OF CHANGE

Currently reads as follows: Amperage Page 6 of 6

3/32" - 78-85

Weld Joint:

1/8" - 100-120

3/32" T3 1/8" 1/8" 1/8" 1/8"

Backing Ring tolerances reads as follows:



BACKING RING

Changed to read: Amperage 3/32" - 70-110

1/8" - 85-125

Change Backing Ring tolerances to read as follows:

Weld Joint:

3/32" T3 1/8" 1/8" 1/8" 1/8"



BACKING RING

THE ABOVE CHANGE DOES NOT EFFECT THE ESSENTIAL VARIABLES OF THE ABOVE KE WELD PROCEDURE SPECIFICATION.

De W. D. D. 8-12-82 E. H. D. D. 8/12/82
PROJECT WELDING ENGINEER DATE WELD/NDE QA ENGINEER DATE

7-20-82 - Booth Assigned
7-21-82 - Fitting up (.28)
7-22-82 - Tacked up (.28)
7-23-82 - 10% welded (.28)
7-24-82 - 40% welded (.28)
7-25-82 - 80% welded (.28)
7-26-82 - 90% welded (.28)
7-27-82 - Absent
7-28-82 - Welding complete, waiting inspection (.28)
7-29-82 - Inspection complete, grinding for RT (.28)
7-30-82 - Coupon sent to NES (.28), welder waiting in test shop
7-31-82 - RT pending (.28) Saturday - Did not work
8-01-82 - RT pending (.28) Sunday - Did not work
8-02-82 - RT pending (.28) - in field 4 hours Drywell Steel El.561 #6107 extra work
 - in field 4 hours Drywell Steel El.561 #6257 extra work
8-03-82 - RT accept (.28) - in field 8 hours Drywell Steel El.561 #6250

STENCIL
RBC[illegible]

8-10-82 - Fit-up (.28), inprocess visual reject (.28), 8 hours training*
8-11-82 - Fitting up retest (.28)
8-12-82 - 30% welded (.28)
8-13-82 - 80% welded (.28)
8-14-82 - Absent
8-15-82 - Absent
8-16-82 - 90% welded (.28)
8-17-82 - Visual inspection completed, grinding for RT (.28)
8-18-82 - Grinding (.28)
8-19-82 - Coupon sent to NES (.28), Tacked up (.7)
8-20-82 - 50% welded (.7), RT accept (.28)
8-21-82 - Saturday - Did not work
8-22-82 - Sunday - Did not work
8-23-82 - Coupon sent to NES (.7), tacked up (.1)
8-24-82 - 80% welded (.1), RT pending (.7)
8-25-82 - Welding complete, visual inspection complete, coupon sent to NES (.1)
8-26-82 - RT accept (.7), RT reject (.1), welder in field 8 hrs.
8-27-82 - Fitting (.1) retest
8-28-82 - Saturday - Did not work
8-29-82 - Sunday - Did not work
8-30-82 - Fit-up inspection complete (.1) 50% welded (.1)
8-31-82 - Welding complete (.1), visual inspection complete and coupon sent
to NES
9-01-82 - RT accept (.1) - in field 8 hours (1RH-820-HR)

L. F. C.

[illegible]

7-20-82 - Fit-up (.28) per daily log
7-21-82 - 8% welded (.28) per daily log
7-22-82 - Test stopped, filler material problem per daily log
7-23-82 - 40% welded (.28) new test per daily log
7-24-82 - Saturday - Did not work
7-25-82 - Sunday - Did not work
7-26-82 - No welding performed, pipefitters left site
7-27-82 - Tuesday - Did not work
7-28-82 - Wednesday - Did not work
7-29-82 - Absent, personnel records indicate welder R. Skaggs terminated due to absenteeism.
9-01-82 - Personnel records show welder R. Skaggs rehired on this date
Tacked up (.28)
9-02-82 - 50% welded (.28)
9-03-82 - 85% welded (.28)
9-04-82 - Saturday - Did not work
9-05-82 - Sunday - Did not work
9-06-82 - Holiday - Did not work
9-07-82 - Final visual reject (.28), (evaluation prior to retest) per daily log
9-08-82 - 40% welded (.28) retest
9-09-82 - Welding complete, awaiting inspection
9-10-82 - Inspection complete, grinding for RT (.28); fitting-up (.7)
9-11-82 - Saturday - Did not work
9-12-82 - Sunday - Did not work
9-13-82 - RT accept (.28), final visual reject (.7), welder returned to field

STENCIL NFS

[illegible]

- 8-07-82 - Fit-up and tacked - 3G (.51)
- 8-08-82 - Inprocess visual reject, 4 hours training*, 10% welded - 3G retest (.51)
- 8-09-82 - 90% welded - 3G (.51)
- 8-10-82 - Welding complete - 3G (.51), tacked up - 4G (.51), bend test 3G pending
- 8-11-82 - 10% welded - 4G (.51), welder left early, bend test accept - 3G (.51)
- 8-12-82 - 40% welded - 4G (.51)
- 8-13-82 - Welding 4G (.51)
- 8-14-82 - Saturday - Did not work
- 8-15-82 - Sunday - Did not work
- 8-16-82 - Final visual acc (.51), bend test accept - 4G (.51), welder reassigned to field

LJS

[illegible]

9-1911 L.O.W.

Welder L.O.W., was terminated on 6-24-82, prior to the start of the Special Qualification program. On 8-2-82, he was rehired and at that time his original qualification for SPPM 3.1.18 was still in effect. At the time of rehire, he was assigned to the HJK Test Facility and was given the opportunity to add to his present qualification by testing on SPPM 3.1.28 and SPPM 3.1.56, the results were unsatisfactory. On 8-23-82, was returned to the field and assigned work in accordance with his original qualification of SPPM 3.1.18. On 9-15-82, he was reassigned to the HJK Test Facility. (Reference Attachments) On 10-14-82, was returned to the field and assigned work in accordance with his qualification 3.1.18. On 10-28-82, the welder was assigned to the HJK Weld Test Facility. (Reference Attachments)

8-02-82 - Req. for Welder Qual.
8-04-82 - Assigned booth (.56)
8-05-82 - Fitting up (.56)
8-06-82 - Fit up complete (.56)
8-07-82 - Saturday - Did not work
8-08-82 - Sunday - Did not work
8-09-82 - Inprocess visual reject (.56), 6 hours training* form dated 8-8-82
8-10-82 - 80% welded (.56) retest
8-11-82 - Final visual reject (.56), fitting up (.28)
8-12-82 - 25% welded (.28)
8-13-82 - 70% welded (.28)
8-14-82 - Saturday - Did not work
8-15-82 - Sunday - Did not work
8-16-82 - Welding completed (.28)
8-17-82 - Visual reject (.28), 30% welded (.28) retest
8-18-82 - 80% welded (.28) retest
8-19-82 - Welding complete (.28) retest
8-20-82 - Final visual reject (.28), 3 hours training*
8-21-82 - Saturday - Did not work
8-22-82 - Sunday - Did not work
8-23-82 thru 9-14-82 - Reference attached cover letter
9-15-82 - Fitting up (.1)
9-16-82 - Absent
9-17-82 - Absent
9-18-82 - Saturday - Did not work
9-19-82 - Sunday - Did not work
9-20-82 - Inprocess visual reject (.1), 3 hours training*

9-21-82 - 10% welded (.1) retest
 9-22-82 - 75% welded (.1) retest
 9-23-82 - Welding complete, visual inspection completed, coupon sent to NES (.1)
 9-24-82 - RT reject (.1)
 9-25-82 - Saturday - Did not work
 9-26-82 - Sunday - Did not work
 9-27-82 - Evaluation prior to retest (.1) welder in field 8 hrs.
 9-28-82 - cleaning coupons, retest (.1)
 9-29-82 - Visual reject by Weld Engineer (.1) retest, additional training*
 2 hrs., retest (.1)
 9-30-82 - Tacked up (.1), 15% welded
 10-01-82 - Visual reject by Weld Engineer (.1), fit-up (.56)
 10-02-82 - Saturday - Did not work
 10-03-82 - Sunday - Did not work
 10-04-82 - 90% welded (.56)
 10-05-82 - Welding complete and coupon sent to NES (.56), welder in field
 3.5 hours (1RI-19-SR)
 10-06-82 - RT pending (.56), in field 8 hours (INX-3376-HG)
 10-07-82 - RT reject (.56), welder on vacation
 10-08-82 - Absent
 10-09-82 - Saturday - Did not work
 10-10-82 - Sunday - Did not work
 10-11-82 - Tack up (.6)
 10-12-82 - Final visual reject (.6)
 10-13-82 - 1" socket weld, visual accept 3.1.1
 10-14-82 thru 10-27-82 - Reference attached cover letter
 10-27-82 - Setting up retest (.56)
 10-28-82 - Tacked up (.56)
 10-29-82 - 90% welded (.56)

10-30-82 - Saturday - Did not work

10-31-82 - Sunday - Did not work

11-01-82 - RT pending (.56), welder waiting in test shop

11-02-82 - RT accept (.56), welder assigned to field

[illegible]

ATTACHMENT 1 TO

*Welding Engineering should not have allowed fourth weld test to SPPM 3.1.1

**Performed socket weld test. Welding Engineering unable to use because ASME Section IX, 1971 Edition does not show a graphic for a socket weld test assembly. (Socket weld graphic not included in ASME Section IX until the 1974 Edition, Summer Addenda).

IMMEDIATE CORRECTIVE ACTION

Welding Engineering shall remove all current qualifications from subject welder and require complete requalification if welder returns to the employ of the Henry J. Kaiser Co.

NOTE: Welder laid-off on or about November 15, 1982 due to "Construction Slow down".

7-19-82 - Fitting-up (.28)
7-20-82 - Fit-up inspection (.28) 30% welded (.28)
7-21-82 - 80% welded (.28)
7-22-82 - 90% welded (.28)
7-23-82 - Waiting inspection (.28), welder remained in test facility
7-24-82 - Saturday - Did not work
7-25-82 - Sunday - Did not work
7-26-82 - Absent
7-27-82 - Waiting inspection (.28), welder remained in test facility
7-28-82 - Grinding (.28), final visual (.28)
7-29-82 - Test coupon sent to NES (.28), fitting-up (.56)
7-30-82 - RT accept (.28), Fitting up (.7), inprocess visual (.56)
7-31-82 - Fit-up inspection (.7) 75% welded (.7), final visual accept (.56)
8-01-82 - Welding complete, visual inspection complete, coupon sent to
NES (.7)
8-02-82 - RT pending (.7), welder in field 8 hours (WR-484SR installation)
8-03-82 - Welder in field, RT accept (.7)

WELDERS NAME

[illegible]