



USNRC REGION II
ATLANTA, GEORGIA

Carolina Power & Light Company

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P. O. Box 101, New Hill, N. C. 27562
July 7, 1983

Mr. James P. O'Reilly
United States Nuclear Regulatory Commission
Region II
101 Marietta Street, Northwest (Suite 2900)
Atlanta, Georgia 30303

NRC-96

Dear Mr. O'Reilly:

In reference to your letter of June 10, 1983, referring to RII: GFM/RP 50-400/83-18-02, the attached is Carolina Power and Light Company's reply to the violation identified in Appendix A.

It is considered that the corrective action taken is satisfactory for resolution of the item.

Thank you for your consideration in this matter.

Yours very truly,

R. M. Parsons
Project General Manager
Shearon Harris Nuclear Power Plant

RMP/sh

Attachment

cc: Messrs. G. Maxwell/R. Prevatte (NRC-SHNPP)
Mr. P. Kadambi (NRC)

Reported Violation:

10 CFR 50, Appendix B, Criterion IX as implemented by PSAR Section 1.8.5.9, CP&L Corporate Q.A. Program, Section 8.4.1.d, requires that measures be established to assure that special processes, including welding, are controlled and accomplished by qualified personnel using qualified procedures in accordance with applicable codes, standards, specifications, criteria and other special requirements.

Contrary to the above, on May 2, 1983, an inspection of the installation of grout rings on sections of service water piping in the fabrication shop revealed arc strikes in the heat affected zone and the base metal. This work had been inspected and accepted by responsible welding inspection personnel.

This is a Severity Level V Violation (Supplement II.E).

Denial or Admission and Reason for the Violation:

The violation is correct as stated.

In reference to the NRC reported inspection violation that the referenced grout ring welds had been accepted by Q.C. with arc strikes remaining present, a further investigation has revealed that a Welding Engineering Supervisor had noted the arc strikes in the base metal and weld H.A.Z. prior to Q.C. being contacted for performance of the final visual inspection. The arc strikes were marked (black marker) by the Welding Engineering Supervisor prior to their removal (carbide burr, grinding). After arc strike removal by craft personnel, the Q.C. inspector was requested to perform the final visual inspection. The location markings (black marker) remained on the pipe, indicating areas of arc strike removal, when the Q.C. inspector arrived for performance of the final visual inspection. The inspector accepted the welds upon completion of inspection (May 2, 1983). No further work was performed on these welds until it was later requested by the Q.A./Q.C. specialist during reinspection.

As a result of the NRC reported inspection violation, a Q.A./Q.C. specialist reinspected the welds on May 2, 1983 and noted one previously ground area which, under close observation, revealed the "minute" evidence of an apparent arc strike to which removal by carbide deburring had been attempted. This area was later reworked (lightly ground), at the request of the Q.A./Q.C. specialist, to remove any remaining traces of the apparent arc strike. All other areas were determined to be acceptable. There was no evidence of the inspector intentionally permitting arc strikes on weld joints and the location in question was borderline as to being acceptable prior to any additional rework.

Corrective Steps Taken and Results Achieved:

Deficiency and Disposition Report No. 1553 was generated to disposition this isolated incident.

Corrective Steps Taken to Avoid Further Noncompliance:

Q.A./Q.C. supervision has advised all Q.C. personnel to take extra precautions, when inspecting welds, to ensure that all arc strikes are completely removed prior to weld acceptance. All Q.C. Pipe Welding Inspectors have received additional training on identification of arc strikes.

Date When Full Compliance Will Be Achieved:

Full compliance was achieved on June 29, 1983.