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U.S. Nuclear Regulatory Commission

Before the Atomic Safety and Licensing Board

In The Matter Of
PHILADELPHIA ELECTRIC COMPANY
(Limerick Generating Station
Units 1 and 2)

Docket Nos. 50-352
and 50-353

AWPP'S RESPONSE TO APPLICANT'S MOTION TO DELETE
SPECIFIC INSTANCES IN SUPPORT OF CONTENTION VI-I
ADVANCED BY AIR AND WATER POLLUTION PATROL AS
UNRELATED TO WELDING OR WELDING RELATED QUALITY
ASSURANCE ACTIVITIES

Applicant states that the Board "In its Order Confirming Miscellaneous Oral Record Rulings (March 15, 1984), the Atomic Safety and Licensing Board confirmed its ruling made at the prehearing conference (Tr. 8326-27) that Applicant and NRC Staff may move by March 20, 1984 that one or more of AWPP's listed examples do not relate to welding or welding related quality assurance activities."

AWPP's representative states he possibly did not understand such oral ruling, nor was he given an opportunity to see transcript relating thereto.

This is evidenced by the fact that in an AWPP telephone call on March 19, 1984 to Mr. Cullen, who supervises the Document Room at Philadelphia Electric, Mr. Wetterhahn came to the phone and surprised me with the need to discuss the welding information examples AWPP submitted re VI-I contention. I informed Mr. Wetterhahn that I was occupied with work schedule and did not have time to discuss my contention. No mention was made that "as required by that order, the NRC Staff, AWPP and Applicant have attempted to discuss the pertinence to welding

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AIR and WATER

Pollution Patrol

BROAD AXE, PA.

(2)

AWPP's Response to Applicant's Motion to Delete continued:

and welding inspection of the specified items discussed below, but have been unable to do so.^{2/}" At footnote 2/ it states "Staff counsel attempted unsuccessfully to contact Mr. Romano on Saturday, March 17, 1984. Applicant's counsel spoke with Mr. Romano on Monday, March 19, 1984. Mr. Romano stated that he wanted to cooperate but could not discuss it on that date because of other things he had to do."

At the very late date of Saturday, March 17, 1984 Staff tried to reach me while I was away -- and only by accident did I inadvertently talk to Mr. Wetterhahn on March 19, and learned a discussion was to be held prior to the March 20, 1984 dead line. It is obvious that neither NRC nor Applicant, with all their staff, were espically concerned about the Board's order to discuss the pertinence of specified items AWPP submitted. I received the Applicant's (Wetterhahn) "Motion to Delete" certain specific items the next day. This meant any discussion that I would have held with Mr. Wetterhahn could have been after he had already written his "Motion to Delete". I move the Board advise Mr. Wetterhahn to not mischaracterize AWPP's effort to comply with the Board.

Further, as I stated, the instances I submitted were NRC I&E Reports describing examples of pertinent welding and QC items. There are hundreds more examples many buried in welding logs which Mr. Wetterhehn's evasivness, as we previously described, kept AWPP from discovering. Also it must be noted that my examples start with



AIR and WATER
Pollution Patrol
BROAD AXE, PA.
(3)

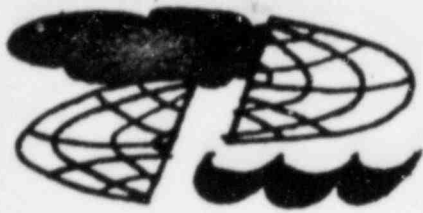
AWPP's Response to Applicant's Motion to Delete continued:

AWPP page number 138 and many numbers skipped in between 138 and 260. I expect to include all unsubmitted incidents, not just examples already submitted. This is necessary because those unsubmitted incidents are necessary to support my VI-I contention.

We did not at all include items in the "REPORT REGARDING THE INVOLVEMENT OF PHILADELPHIA ELECTRIC COMPANY MANAGEMENT IN ASSURING THE QUALITY OF WELDING AT LIMERICK GENERATING STATION." We certainly intend to include such infractions noted.

As it related to Applicant's page 2 item 1, re AWPP 141 (page 2 of Appendix A to IE Report 352/77-02) statement that "nowhere on page AWPP 141 or AWPP 144 is there any indication whatsoever that the deficiency relates to welding". AWPP cites the Applicant's own statement under 1 that spent fuel pool liner was contaminated "with slag iron residue from a thermal metal cutting process". Inasmuch as welding was taking place, the Applicant must verify that the metal deposits were not from careless dropping of molten metal from welding rods.

Further on AWPP designated page 141 the Applicant was required "upon receipt from Project Engineering of an acceptable Quality Assurance Manual (and changes thereto) it is forwarded to Document Control for logging..." But "contrary to the above, on March 8, 1977 the latest approved amendments (Nos. 3 and 4) to Testing and Inspection Procedure 3.20.A.1 were not entered in two controlled volumes of the Peabody Testing Quality Assurance Plan at separate on-



AIR and WATER
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BROAD AXE, PA.

(4)

AWPP's Response to Applicant's Motion to Delete continued:

site locations." This again illustrates Applicant's lack of control.

Re AWPP 144 (IE Report 352/77-02, page 8, item 1) Applicant corroborates the arbitrary and unilateral use of their "judgement" which the NRC properly characterizes as "narrow view" and as "not being consistent with the obvious intent of the specification in the related PSAR commitments, and the governing criteria of 10 CFR 50, Appendix B". Further, on page 144 under 77-02-03 is another violation indicating carelessness by the Applicant of QA/QC control that could directly or indirectly involve welding.

Re AWPP 210 (page 1 of Appendix A to IE Report 352/80-12) Applicant further indicts itself as not taking QC/QA seriously by answering at item 3, page 4 of its "Move to Delete" when it states discovery of "one individual, who was employed as a QC inspector performing receipt inspections without being properly certified as a qualified inspector to perform such function", cannot relate to welding. Receipt and improper inspection of material that might be used directly or indirectly in welding can affect welding quality and subsequent performance of the weld.

Re Applicant 4, page 4 of Applicant's "Motion to Delete" at AWPP 242 (page 1, of Appendix A to IE Report 352/81-01 and AWPP 245 (IE Report 352/81/01, pages 4 and 5) which report relates to an ASME Nuclear Class I pipe weld, the Applicant states "the liquid penetrant test indications on components which were involved were in



AIR and WATER
Pollution Patrol
BROAD AXE, PA.

(5)

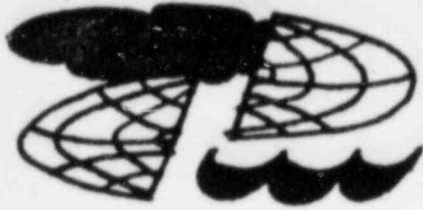
AWPP's Response to Applicant's Motion to Delete continued:
the base metal and unrelated to welding". Again the Applicant's QA program was accidentally found as violating specified procedures on apparant arbitrary re-use of its own judgement.

Further, Applicant page 4 item 4 talks of "non-destructive indications found on the surface of an ASME valve body casting". Thus, this matter does not involve welding, but only indications on the valve body itself". But as per p.5 of IE Report 352/81-01, the inspector noted "These indications were found while testing the pipe to valve weld"...not specifically on the surface of the valve ...but on the base metal, namely, "on the Nuclear Class I pipe weld DLA-107-1/16 FW II".

Further, Applicant improperly rationalizes that the weld was O.K. even though the weld had been performed adjacent to base metal which was found rejectable by liquid penetrant indications which however, the Applicant's QC did not properly follow up.

As to AWPP page (260A) page 1 of Appendix A to IE Report 352/83-19 item 1) discussed on page 5 of Applicant's "Motion to Delete", Applicant states the Notice of Violation refers to (Applicant's) "failure to provide cleanliness control following disassembly of a feed water system containment isolation valve". The Applicant then states "There is no stated relationship to welding or welding related quality assurance".

AWPP (Romano) states that welds made in an unclean area, and



AIR and WATER
Pollution Patrol
BROAD AXE, PA.

(6)

AWPP's Response To Applicant's Motion To Delete continued:

welds to be made to re-assemble the feedwater system isolation valve could be affected by rust or other corrosion effects because cleanliness controls were ignored.

As to AWPP 260A, 352/83-19, item 2, the infraction involves a deficiency, namely, the failure of the program established for engineering and quality inspection of pipe support safety-related hangers. Not only were the welds improperly designed and installed, but the inadequacies were not identified during the inspections. This specifically demonstrates failure to perform welding properly, and failure of Quality Control.

The Applicant refers to an attachment 1 to their pleading, which we did not receive.

As it relates to AWPP 260B (page 2 of Appendix A to IE Report 352/83-19 (item 7 of Applicant's "Motion to Delete"), Applicant's statement is prima facia admission that specified procedure following a deficiency was violated. Such skirting of required proper follow-up indicates, together with many such previous examples which Applicant feels were not important, less than complete respect for Quality Assurance.

Applicant's point 8, page 6 of their "Motion to Delete" referring to AWPP p.260C (Cover letter to IE Report 352/83-19), Applicant states, "This cover letter relates to an NRC concern over perceived weakness in the Quality Assurance and Quality Control programs applied to systems for which construction has been essentially com-



AIR and WATER
Pollution Patrol
BROAD AXE, PA.

(7)

AWPP's Response to Applicant's Motion to Delete continued:
pleted and which are then turned over to the startup organization
for testing".

The Jan 10, 1984 cover letter, and the fact that it is going
on to 8 years since the "Broomstick affair", with the hundreds of
NRC IE reported welding infractions to Jan. 1984 sums up the inade-
quacies of the Nuclear Industry's Quality Control and, therefore,
Quality Assurance and, therefore, safety of the public in a probable
nuclear accident at Limerick.

AWPP (Romano) sees more than "perceived weaknesses", AWPP sees
that less-than harsh disciplining of the Applicant when infractions
were found, has been taken advantage of by the Applicant. As a re-
sult, the NRC is deeply concerned in finding infractions even as
construction is being completed and ready for turnover to the start-
up organization.

As it related to Applicant's point 9 on page 6 of "Motion to
Delete", identified as AWPP 180B (NRC #1366), Applicant states
"this non-conformance report relates to a 'non-Q' item as stated in
block 19 of the NCR". The Applicant further states "there is no
reason for the Board to consider this matter since the Contention is
related only to safety related welding".

AWPP (Romano) states that 180B was used as an example (and will
submit many more) of the rationalizing away of improperly performed
welds.



AIR and WATER
Pollution Patrol
BROAD AXE, PA.

(8)

AWPP's Response To Applicant's Motion to Delete continued:

Further, as per Oct. 28, 1983 Memorandum and Order Confirming Rulings Made At Prehearing Conference, contention was reworded by the Board as follows:

"Applicant has failed to control performance of welding and inspection thereof in accordance with Quality Control and Quality Assurance procedures and requirements, and has failed to take proper and effective corrective and preventive actions when improper welding has been discovered".

Failure to follow any specified procedure on welding, and failure to adequately perform Quality Control and Quality Assurance and proper follow-up reveals a characteristic of improper performance and concern for performance irrespective of the item being performed...safety or non-safety related.

Further corroborating AWPP's contention that Applicant failed in too many aspects of control of welding including inspection and qualification of welders, is their own report of Philadelphia Electric Company management on their involvement in welding quality at Limerick. This report was also ordered by the Board on Oct. 28, 1983.

Primarily, the classical example was the "Broomstick Affair" where laxity in welder qualification, inspection including falsification of records, statements that all welds inspected by an inspector who O.K'd welds found so severely non-conforming as to indicate they were not at all inspected (re 76-06-01), and finally repeated statements by the Applicant to the NRC Atomic Safety and Licensing Board that all welds, accessible, and inaccessible were reinspected



AIR and WATER
Pollution Patrol
BROAD AXE, PA.

(9)

AWPP's Response To Applicant's Motion To Delete continued:

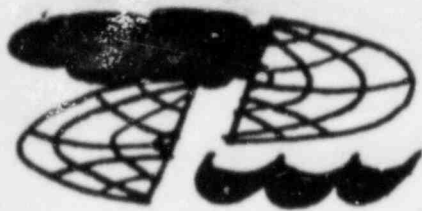
with the ultimate admission that such statements were not true.

On page 37-38 in "Applicant's Q.C. Involvement Report", it is admitted that the Applicant's audits could stand improvement in various areas. But Applicant does not reveal those areas so that AWPP could follow up on location, type and number of welds involved.

In the second paragraph on page 37, the Applicant speaking of welding audits states, "The lack of identification of such areas in an undertaking as large as the Limerick project would raise questions regarding the effectiveness of the Audits". (AWPP underlines, and concurs). Applicant continues: "The same audit (Applicant's) process that has identified such (welding) problems has also been used to verify that they (welding problems) have been satisfactorily resolved". AWPP states that the admitted inability of the Applicant's audit process to effectively identify problem welding areas cannot, at the same time, as the Applicant states, be used to verify such problems have been satisfactorily resolved.

Further, on page 37, in spite of the Applicant's description of its three level redundancy re inspections, the fact that there was "poor quality welding in the safety-related HVAC systems and components...", AWPP, in questioning how such poor quality welding can be admitted, sees it as proof the three level QA, QC has resulted in admitted poor welding, nevertheless.

Further, it was the responsibility to check and know the QA/QC



AIR and WATER
Pollution Patrol
BROAD AXE, PA.

(10)

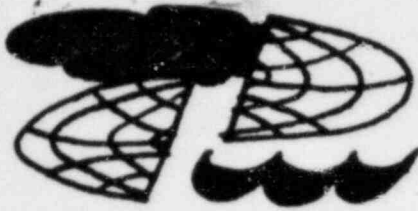
AWPP's Response To Applicant's Motion To Delete continued:

program of subcontractors met specifications. The Applicant admits locking the barn after the horse is stolen. In the case of a nuclear reactor this could be tragic.

Page 38 shows Applicant, very late, finding that, "subcontractors did not have enough inspectors to handle the work load and those it had were not performing at an adequate level". The Applicant states "this situation was remedied through increasing manpower and intensive training". That may have taken care of the manpower and training which should have previously been part of specified requirements, but what about the inferior welds and inspections?

Further, on page 40 the "piping and welding QC affair" came to light. AWPP states that while Applicant tries to rationalize the careless occurrences, no better example of QC auditing foul-up could ever be manufactured on purpose.

AWPP and the Board deserve a full review of the "HVAC Affair" and the "Piping and Welding QC Affair" which seems to be another "Broomstick Affair". AWPP moves the Board require affidavits on all pertinent phases of the HVAC and Piping and Welding QC affair. That is, the Applicant is to indicate number of welds involved, how many were accessible, how many inaccessible, and that all have been resolved properly.




AIR and WATER
Pollution Patrol
BROAD AXE, PA.

(11)

AWPP's Response To Applicant's Motion To Delete continued:

The Applicant on page 37 and page 38, and in particular page 40, gives a litany of faulty workmanship and faulty inspections in its report as to how Applicant assures proper performance of welding. Its report does not at all assure there has been quality welding at Limerick.

Respectfully submitted,
Air & Water Pollution Patrol


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FRR/jch