

## WISCONSIN PUBLIC SERVICE CORPORATION



P.O. Box 1200, Green Bay, Wisconsin 54305

March 30, 1984

Mr. J. G. Keppler, Regional Administrator  
Region III  
U.S. Nuclear Regulatory Commission  
799 Roosevelt Road  
Glen Ellyn, IL 60137

Dear Mr. Keppler:

Docket 50-305  
Operating License DPR-43  
Kewaunee Nuclear Power Plant  
I.E. Bulletin 83-07: Apparently Fraudulent  
Products Sold By Ray Miller, Inc.

The attachment to this letter responds to the "Action Requested of All Nuclear Power Reactor Facilities..." for the referenced IE Bulletin.

We have identified some material in our Kewaunee Plant sold by Ray Miller, Inc., however, all material purchased was through their Skokie, Illinois and West Caldwell branches and no material was identified where fraudulent practices were detected.

At least one thousand (1000) man-hours of Kewaunee Plant staff time was expended in the search and review of Quality Control documents pertaining to the purchase of material sold by Ray Miller, Inc. Another forty (40) hours of staff time was expended in preparing the documentation requested for the attached report.

To the best of my knowledge, the information contained in this letter is true and accurate.

Very truly yours,

*Carl W. Giesler*  
C. W. Giesler  
Vice President - Nuclear Power

DWS/js  
Attach.

cc - Mr. S. A. Varga, US NRC  
Mr. Robert Nelson, US NRC  
Director, Office of I&E, US NRC

Subscribed and Sworn to  
Before Me This 30th Day  
of March 1984

*Jeannette M. Stein*  
Notary Public, State of Wisconsin

My Commission Expires:

June 28, 1987

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Response to Requested Action of AllNuclear Power Reactor Facilities

- 1.(a) Our review of material supplied for the construction of the Kewaunee Nuclear Power Plant found that no material was supplied by any of those companies on the lists included in IE Bulletin 83-07 or IE Bulletin 83-07, Supplement 1.
  - (b) To the best of our knowledge none of the apparently fraudulent Ray Miller, Inc. materials were provided or used at the Kewaunee Nuclear Power Plant.
  - (c) Again, no fraudulent materials are installed or in stock at Kewaunee.
  - (d) The enclosed table identifies all the material we have found to be installed at the Kewaunee Plant supplied by Ray Miller, Inc. The table identifies the supplier/vendor, the Ray Miller Branch where the material was purchased from, pertinent remarks, our local supplier, the quantity, description of the material, the system in which it is installed, and the date of installation. Only seven fittings are identified to have been installed in safety-related systems.
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- 2.(a) All of the seven fittings identified are in the low pressure Residual Heat Removal System. We are confident no fraudulent material was supplied to Kewaunee because of the following purchase and receiving documentation:
    - (1) All safety-related material was ordered and received to required purchase specifications.

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- (2) Chemical and physical reports were required for all safety-related piping and components in addition to the normal certification of material conformance.
  - (3) We required that a check analyses independent of Ray Miller be performed by the manufacturer of safety-related piping and components to ensure the chemical and physical reports were true and accurate.
  - (4) Receipt inspection compared check analyses to the supplied chemical and physical report results and heat numbers of material received.
  - (b) We do not propose any actions concerning the material supplied from Ray Miller, Inc.
3. All identified Ray Miller material falls into the nonfraudulent data category and has been installed in Kewaunee Plant systems. We have no stock material supplied by Ray Miller, Inc.

MATERIAL SUPPLIED TO KNPP BY RAY MILLER, INC.

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SUPPLIER/VENDOR	RM BRANCH	REMARKS	ORDERED FROM	QTY	DESCRIPTION	SYST	DATE
-----	Skokie		W.S. Patterson	3	3/4 x 3" Sockolet A182F304	CVC	02-13-76
Metalalloy, Inc.	Skokie	Sent Direct	W.S. Patterson	3	3/4 x 3" Elbolet A182F304	CVC	02-26-76
Texas Metal Works	Kenmore	Sent Direct	W.S. Patterson	3	3/4 x 1500# S.W. R.F. Flange A182F316	CVC	02-13-76
Flowline Corp.	S.Charleston Skokie	Sold to Ship to	W.S. Patterson	2	3" Sch 10 45° LR ELL A403WP304	CVC	08-08-72
G.W. Taylor Forge	West Caldwell	Actual CMTR	W.S. Patterson	1	4x3 Sch 40 Red T A403WP304 .04 Min C	RHR ( )	03-28-72
G.W. Taylor Forge	West Caldwell	Check(OK) Analysis	W.S. Patterson	1	4x3 Sch 40 Red T A403WP304 .04 Min C	RHR (1)	03-28-72
Hawley Forge	Skokie	Actual CMTR	W.S. Patterson	1	2" 600# R.F. Flange Sch 40 A182F304	(1) RHR RV	03-20-72
Hawley Forge	Skokie	Actual CMTR	W.S. Patterson	1	3" 600# R.F. Flange Sch 40 A182F304	(1) RHR RV	03-20-72
Alloy Stainless Prod.	Skokie	Actual CMTR	W.S. Patterson	1	2 x 3/4" S.W. Red ELL 90° Sch 160 A182F316	SI Test Line	03-19-72
G.W. Taylor Forge	West Caldwell	Actual CMTR	W.S. Patterson	3	3" 90° L.R. ELL Sch 40 A403WP304 .04 Min C	RHR (1)	03-07-72
Alloy Stainless Prod.	Skokie	QA 2	W.S. Patterson	12	3/4" 45° S.W. 2000# ELLS A182F316	CVC	06-27-72
Alloy Stainless Prod.	Skokie	Actual CMTR	W.S. Patterson	18	3/4 x 1/2 3000# SCR D Red T A182F304	INST	06-13-73
Alloy Stainless Prod.	Skokie	Actual CMTR	W.S. Patterson	12	1 x 1/2 3000# SCR D Red T A182F304	INST	06-13-73
Alloy Stainless Prod.	Skokie	Actual CMTR	W.S. Patterson	6	1 x 1/2 3000# SCR D Red T A182F304	INST	06-13-73
-----	Skokie	-----	W.S. Patterson	306'	3/8 x .065 SMLS Tubing A213T316	INST	06-08-72
-----	Skokie	QA 3	W.S. Patterson	50	3/4 x 1/2 S.W. Inserts 3000# Sch 40 A182F304	MDS	05-17-72
-----	Skokie	QA 3	W.S. Patterson	100	3/4" SCR D Caps 3000# A182F304	MDS	05-17-72
-----	Skokie	QA 3	W.S. Patterson	2	1 1/2" SCR D Caps 3000# A182F304	MDS	05-17-72
-----	Skokie	QA 3	W.S. Patterson	100	1" SCR D Caps 3000# A182F304 .04 Min C	MDS	05-17-72
-----	Skokie	-----	W.S. Patterson	1356'	3/8 x .065 SMLS Tubing A213T316	INST	04-24-72
-----	Skokie	-----	W.S. Patterson	305'	1" Sch 80 SMLS Pipe A312T316	Stock	04-23-71
-----	Skokie	-----	W.S. Patterson	207'	1" Sch 40 SMLS Pipe A312T316	Stock	04-23-71
-----	Skokie	QA 3	W.S. Patterson	1	2" S.W. Cross 3000# A182F304	CVC	04-17-72



[illegible]