

DOCUMENTATION TRANSMITTAL

DMD  
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PRINCIPAL STAFF		
RA	PRP	
D/RA	DE	
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RC	DRMA	
PAO	SCS	
SGA	ML	
ENF	File	

To: Stone & Webster - CIO  
PO Box 1963  
Midland, MI 48640

Transmittal No: CIO-0055  
Date: May 25, 1984

Attention: Ralph Butler

The documentation listed below    is provided herewith, X was previously provided on 5-24-84 ; as requested by Ralph Butler .

Documentation Description: Nonconformance Report - C-01006

CIO    has X has not been placed on routine transmittal for the described documentation.

*Janne Kinne*  
Signature

50 329  
50-330

CC RJCook, NRC Site (w/a, unless voluminous)  
JJHarrison, NRC Region III (w/a, unless voluminous)  
DDJohnson, SMO (w/o)  
JGKeppler, NRC Region III (w/a, unless voluminous)  
BHPeck, SMO (w/o)  
NIRichel, SMO (w/o)  
RAWells, MPQAD (w/o)  
CMThompson - File 24.2 (w/a, unless voluminous)

MI0384-0001A-QL06

8406050274 840525  
PDR ADCK 05000329  
S PDR

IEO1  
JUN 1 1984

MITLAND PROJECT  
QUALITY ASSURANCE  
DEPARTMENT

# NONCONFORMANCE REPORT

## ORIGINAL

16 NCR NO.

C-01006

17 DATE ISSUED

1-20-84

18 REV

01/3/84

19

PAGE 1 OF 2 3638  
/AN

1 ITEM LOCATION

Aux. Bldg. Elev. 568' through 634'. See attached sheet for locations

2 ITEM DRAWING/PART NO.

Vendor 0085-2 & 2A

3 ITEM PART NAME

Watertight doors & frames

4 ITEM SERIAL NO.

N/A

5 ITEM DESCRIPTION

Contract A17AQ Julius Mock & Sons, Inc.  
Watertight doors & frames

6 ITEM STARTUP SYSTEM NO.

ORGC

7 REFERENCE DOCUMENT

Vendor Procedure WP.1

8 ASME A.N.I. REQUIRED

☐ YES ☒ NO

9 INSPECTION RECORD NO.

N/A

LOG NO.

N/A

REV NO.

N/A

10 RESPONSIBLE ORGANIZATION

Vendor

11 NONCONFORMANCE DISCOVERED DURING:

☐ DESIGN

☐ RECEIVING

☒ CONST

☐ RELEASE FOR INSPECT

☐ POST INSPECT

☐ TURNOVER

☐ POST TURNOVER

☐ PRE-OP  
TEST

☐ FINAL  
TURNOVER

☐ OVERINSPECT

12 REQUIREMENT

<sup>Δ</sup> SEE PAGE 2  
WP 3/2/84  
~~Spec C-304(Q) Rev. 13, Sec. 6.2 states that all structural steel and misc. steel to conform to visual acceptance of AWS D1.1, Sec. 9.25. The following exceptions and clarifications are to be applied; fillet weld sizes shall be shown in drawings and measured to the nearest 1/16", undercut shall not exceed 1/32" or 25% of base metal thickness (whichever is less), and piping porosity shall be acceptable provided total sum of diameters does not exceed 3/8" in any linear inch and not exceed 3/4" in any 12 linear inches. Additionally, isolated undercut of 1/16" for base metal thicknesses of 1/4" and over may be tolerated for an accumulated length of 2" in any 12 inches of weld.~~

13 NONCONFORMANCE

Welding on doors and frames 5,6,7,8,210,205,14,15,18,23,24,25,26,109,29,31,32,33,34,35, 40,43,44,45,46,53,65,77,84,88,108 contain non-conforming conditions (Eg. 'undercut', slag, porosity and undersized welds).

Welding on the above mentioned doors and frames is not in compliance with project approved vendor drawings and project approved welding procedure specifications.

See attached 31 drawings for results of a partial weld inspection completed by field welding engineers on <sup>Δ</sup> 2-10-84  
NP 3/2/84

14 NCR ORIGINATED BY (PERSON)

Randall Womack RANDALL WOMACK 1-19-84  
DATE

15 NCR ORIGINATED BY (DISCIPLINE)

Welding Engineer JRU

20 NUMBER OF HOLD TAGS (IF APPLIED)

62

21 LOCATION OF HOLD TAGS <sup>Δ</sup> NP 3/2/84

SEE Pg 2 of 2 3

22 POTENTIAL 50.55(e)

☒ YES

<sup>NP</sup> NO 3/2/84

24 ACTION ITEM NO.

S04345

26 ITEM PRIORITY CODE NO.

<sup>Δ</sup> NP 3/3/84  
53

28 NCR REVIEWED BY

Neil D. Bente 3/3/84

23 REPORTED TO MPOA MANAGER

<sup>NP</sup> 3/2/84 <sup>Δ</sup> N/A 3/2/84

25 DISCIPLINE:

A/C

27 TREND CODE

M-7

DATE:

1/24/84

CONTINUED ON REVERSE

F-2M/LA (Rev 1)

# 20 ~~CRUSE~~ VENDOR WORKMANSHIP

## 30 PROCESS CORRECTIVE ACTION

☒ YES ☐ NO QAR NO. \_\_\_\_\_

## 31 RECOMMENDED DISPOSITION

☐ REMARK ☐ SCRAP/REJECT ☐ REPAIR ☒ USE AS IS

## 32 CONDITIONAL RELEASE

☐ YES ☒ NO

## 31A ADDITIONAL INFORMATION PROJECT TO EVALUATE

*L. Hawley 7/2/84*  
SEE SH'S 37 + 38 OF 38 FOR PROJECT ENGINEERING'S DISPOSITION

## 33 DISTRIBUTION FOR ACTION PROJECT

## 34 DISPOSITION CONCURRENCE

*GA Linneman For EB Posrv 4/27/84*

PROJECT FIELD ENGINEER DATE  
LEAD DESIGN ORG *AVP 5-2-84*

*B. B. B. 5/2/84*

LEAD DESIGN ORG DATE  
PROJECT FIELD ENGINEER *8-2-84*

MPQAD CONCURRENCE DATE

PFQCE (ASME) DATE

PQAE (ASME) DATE

CP Co SMO (for turned over systems) DATE

A.N.I. (ASME) DATE

## 35 DISPOSITION ACTION TAKEN

RECEIVED

MAR 13 1984

Midland Project

*A*

## 36 METHOD OF DISPOSITION ACTION VERIFICATION

RESULT OF DISPOSITION ACTION VERIFICATION

☐ ACCEPTABLE ☐ UNACCEPTABLE

IF UNACCEPTABLE, REFERENCE  
SUPERCEDING NCR NUMBER \_\_\_\_\_

## 37 NCR CLOSED BY

MPQAD DATE

A.N.I. (ASME) DATE

MIDLAND PROJECT  
QUALITY ASSURANCE  
DEPARTMENT

NONCONFORMANCE REPORT  
CONTINUATION SHEET

NCR NO. C-01006

DATE ISSUED  
3/2/84

REV  
1

PAGE 2 OF 3638  
JAN

Page 1 continued;

Blk. 12 Requirement: Vendor, project approved welding procedure WP-1: Welding shall be performed in accordance with AWS D1.1 and in accordance with approved shop dwgs. . . . .

See attached copy of WP.1



**ORIGINAL**

**NONCONFORMANCE REPORT  
CONTINUATION SHEET**

NCR NO. C-01006

DATE ISSUED  
1-20-84

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DOOR AND FRAME LOCATION

FRAME	EL	AREA	ROOM	DOOR	WAREHOUSE 3
5					X
6					X
7					X
8					X
210	575	340A	40	SAME	
205	"	540A	1	SAME	
14	584	120K	126	WHSE 3	
15	"	103A	130	" "	
18	"	102A	131	" "	
23	"	120D	118	" "	
24	"	120C	117	" "	
25	"	120A	111	" "	
26	"	120B	113	" "	
29	"	102A	116	" "	
31	"	120F	121	" "	
32	"	120G	122	" "	
33	"	120H	124	" "	
34	"	120J	125	" "	
35	599	130H	216	" "	
40	"	130J	217	" "	
43	"	130F	214	" "	
44	"	130G	215	" "	
45	"	130D	212	" "	
46	"	130E	213	" "	
53	614	103B	328	" "	
65	"	102B	329	" "	
77	"	210B	358	" "	
84	"	210E	361	" "	
88	"	210C	359	" "	
108	634	150C	420	" "	
109	"	150R	421	" "	

**WELDING PROCEDURE NO. WP-10**

**TO BE USED WITH JOINT DETAILS SHOWN ON WELD PROCEDURES WP-11, 12, 13 & 14**

GENERAL

Welding shall be performed in accordance with AWS D1.1 and in accordance with approved shop drawing. Welding shall be performed by qualified welders only inside the shop. All joints are to be AWS prequalified. Process— The welding process shall be shielded metal arc., base material A36.

POSITION

The welding shall be done in the 1G, 1F or 2F position

PREHEAT

No preheating shall be used.

HEAT TREATMENT

No post weld heat treatment required.

BACKING STRIP

The welded joints shall not utilize a backing strip. Gouge root to sound metal before welding second side.

PREPARATION

Surfaces and edges to be welded shall be wire brushed and ground clean and smooth and shall be free of all loose mill scale.

ASSEMBLY

All parts to be joined shall be brought in to as close contact as possible. Gaps shall not exceed 1/8" and the joints shall be properly aligned and held in position by clamps, wedges or other suitable devices utilizing jigs and fixtures wherever possible. Assemblies shall be tack welded with single pass welds which are to be remelted and incorporated in to the continuous welds.

The weld sequence shall skip around the entire welding periphery and both sides of the joining surfaces to minimize distortion and shrinkage. Upon completion of welding, welds shall cool to ambient temperatures. Weld surfaces shall be peened and brushed clean of all slag and other impurities. Assemblies shall be straightened as required by hydraulic press or manual means. Welded joints shall not be painted until all welding has been completed and the assembly approved and tested.

Manufacturer: JULIUS MOCK & SONS, INC.

Authorized By: *Edward F. Drake* Q.A. Mgr.

Date 6-15-79 Issue 1 Sheet 1 of 2

Date \_\_\_\_\_ Issue \_\_\_\_\_

NOT TO BE USED FOR CONSTRUCTION

WELDING PROCEDURE NO. WP-1 (Cont'd.)

## CLEANING

ALL slag and flux and any defects that appear on a bead of welding shall be removed by chipping, or grinding before the next pass is started. Welds need not be removed unless cracked or defective, but they must be completely fused in the root bead.

## INSPECTION

Visually inspect welds for quality of workmanship.

The following are defect criteria:

- Cracks - not allowed.
- Craters - not allowed.
- Undercuts - Shall not be more than 0.01" deep when its direction is transverse to primary tensile stress in part that is undercut, nor more than 1/32" for all other situations.
- Overlaps/Concavities - not allowed.
- Convexity - MAX. 1/8"
- Porosity - The sum of diameters of piping porosity shall not exceed 3/8 in. in any lineal inch of weld and shall not exceed 3/4 in. in 12 in. length of weld.

## TECHNIQUE

For type and size of joint, see applicable drawings.

For welding technique see table below.

MATERIAL	TYPE OF WELD	ELECTRODE		WELD'G CURRENT	
		TYPE	SIZE	AMPS	VOLTS
Mild Steel ASTM.A.36	Fillet & Groove	E 7018	5/32"	180	

Weld Current - DC  
Polarity - Reverse

Manufacturer: JULIUS MOGK & SONS, INC.  
Authorized By: *Edward T. Arabe* Q.A. Mgr.  
Date 6/15/79 Issue 1 Sheet 2 of 2

Date \_\_\_\_\_ Issue \_\_\_\_\_

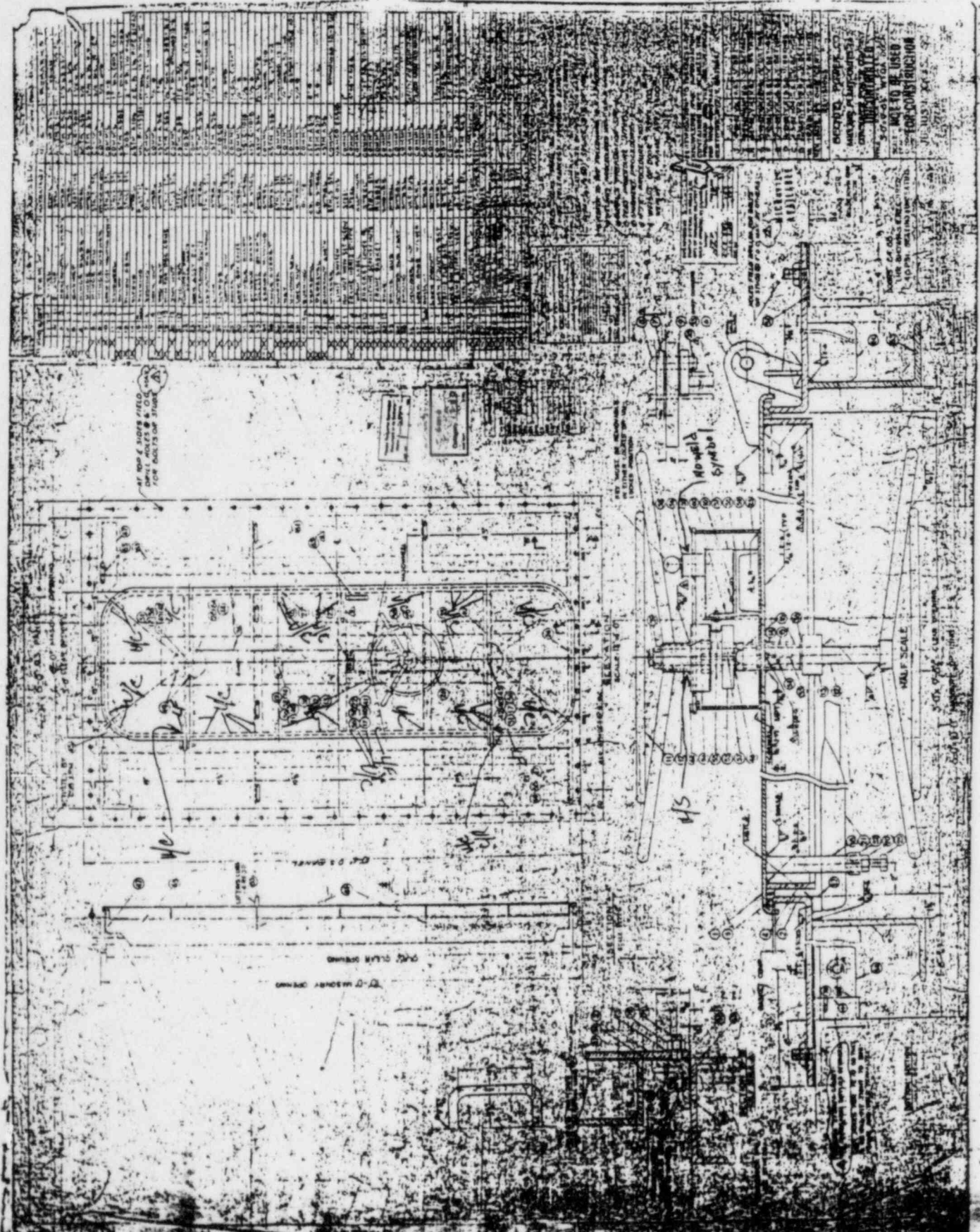
Date \_\_\_\_\_ Issue \_\_\_\_\_



UIC C-01006 Page 6 of 38  
 as Rev 1  
 3/2/84

Door # 88 (C)

Pages 6 thru 36  
 are just  
 reference copies.  
 The big prints  
 are in QC Vault.



1/4" = 1'-0"  
 1/8" = 1'-0"  
 1/16" = 1'-0"  
 1/32" = 1'-0"



Doc # 84C

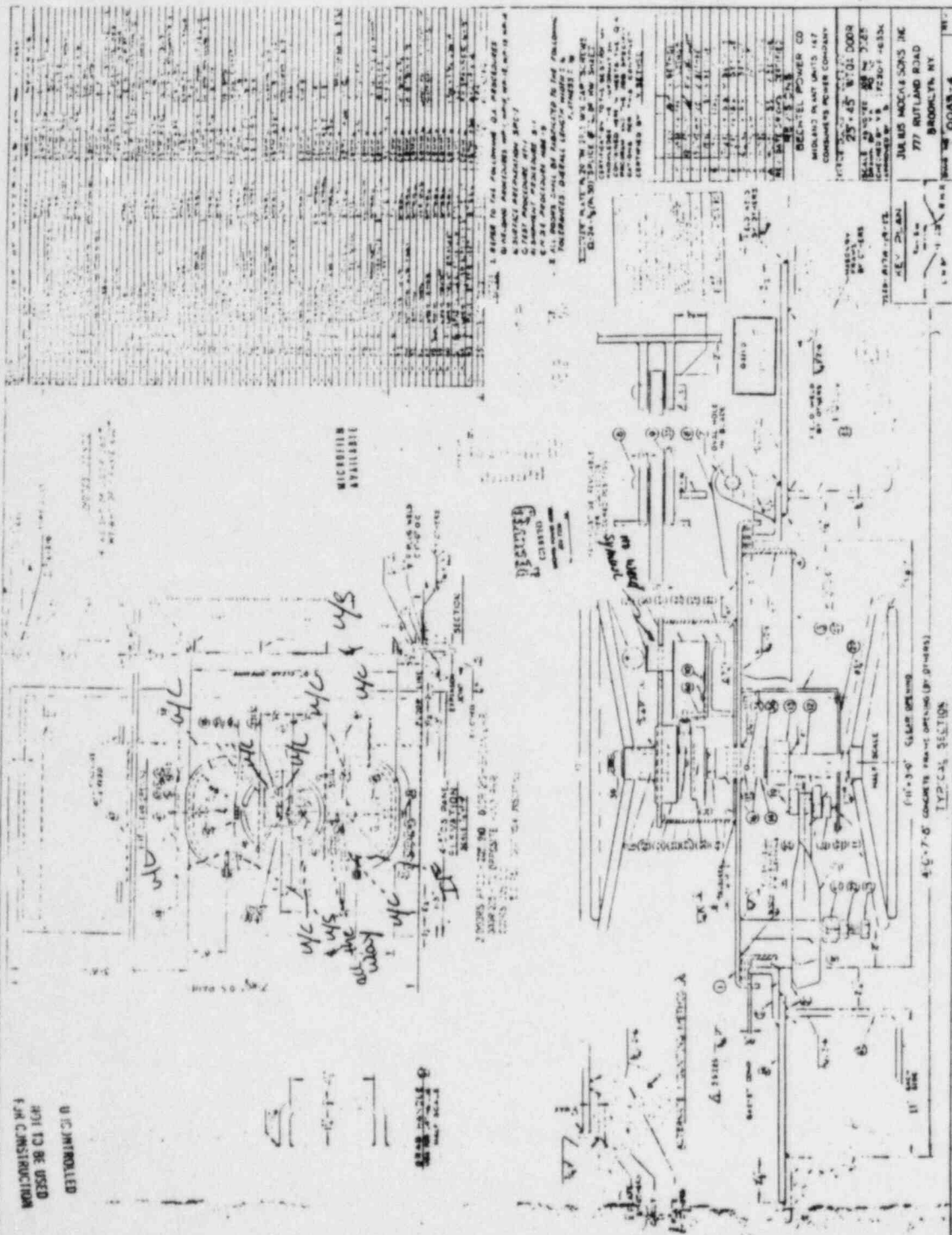
NCR C-01006 Page 7 of 2638  
05/2/84 Rev 1

UNCONTROLLED  
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FOR CONSTRUCTION

LF = Lack of fusion  
u/c = undercut  
P.O. = porosity  
C.L. = cold Lap

Door # 210

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NOT TO BE USED  
FOR CONSTRUCTION



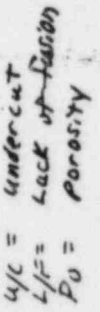
u/c = undercut  
u/s = under S.B.C  
IF = incomplete fusion

NCE C-01006 PAGE 8 OF 38  
REV 1  
05 3/2/84





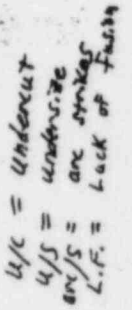




Q. 14 (C)

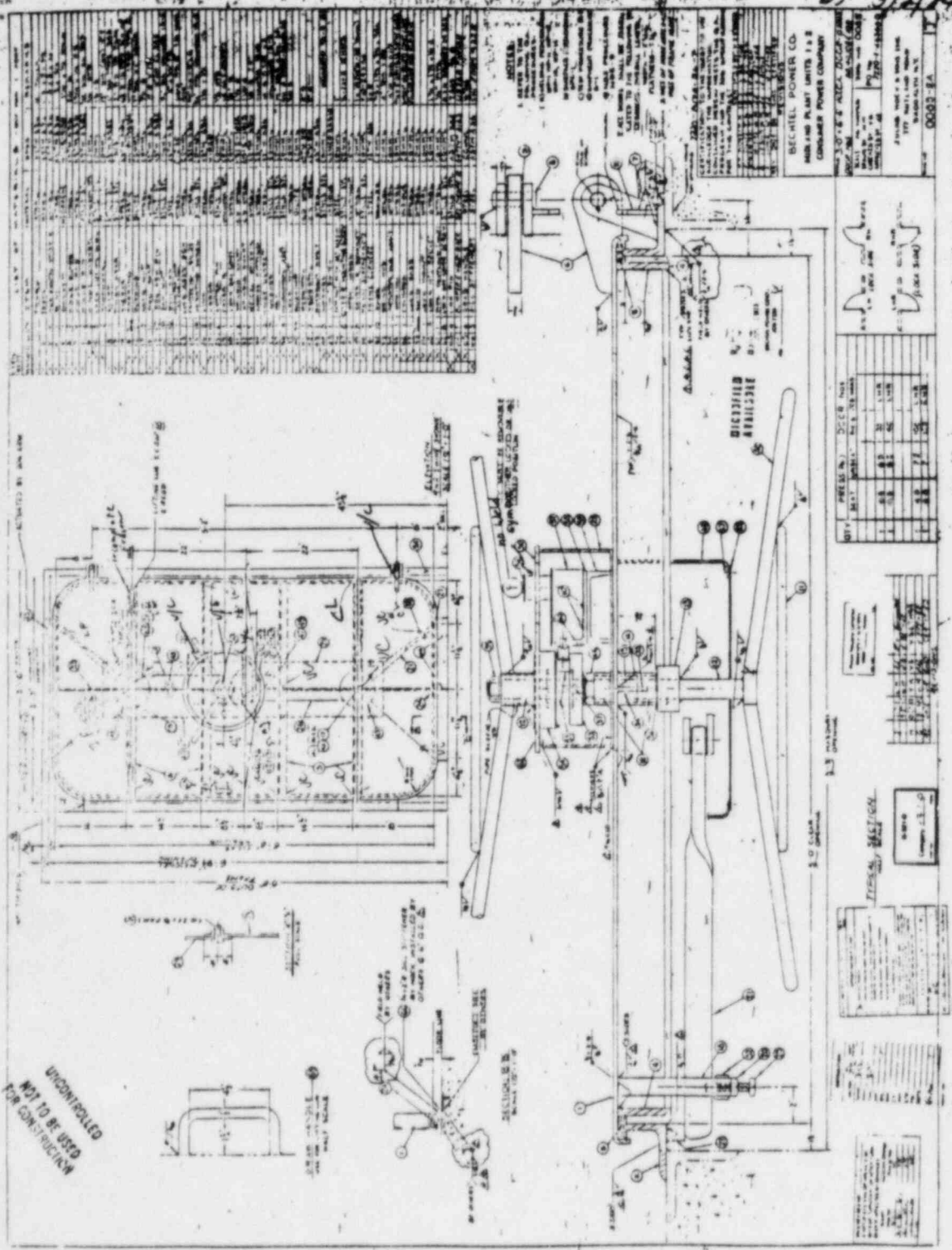


OS: 3/2/84



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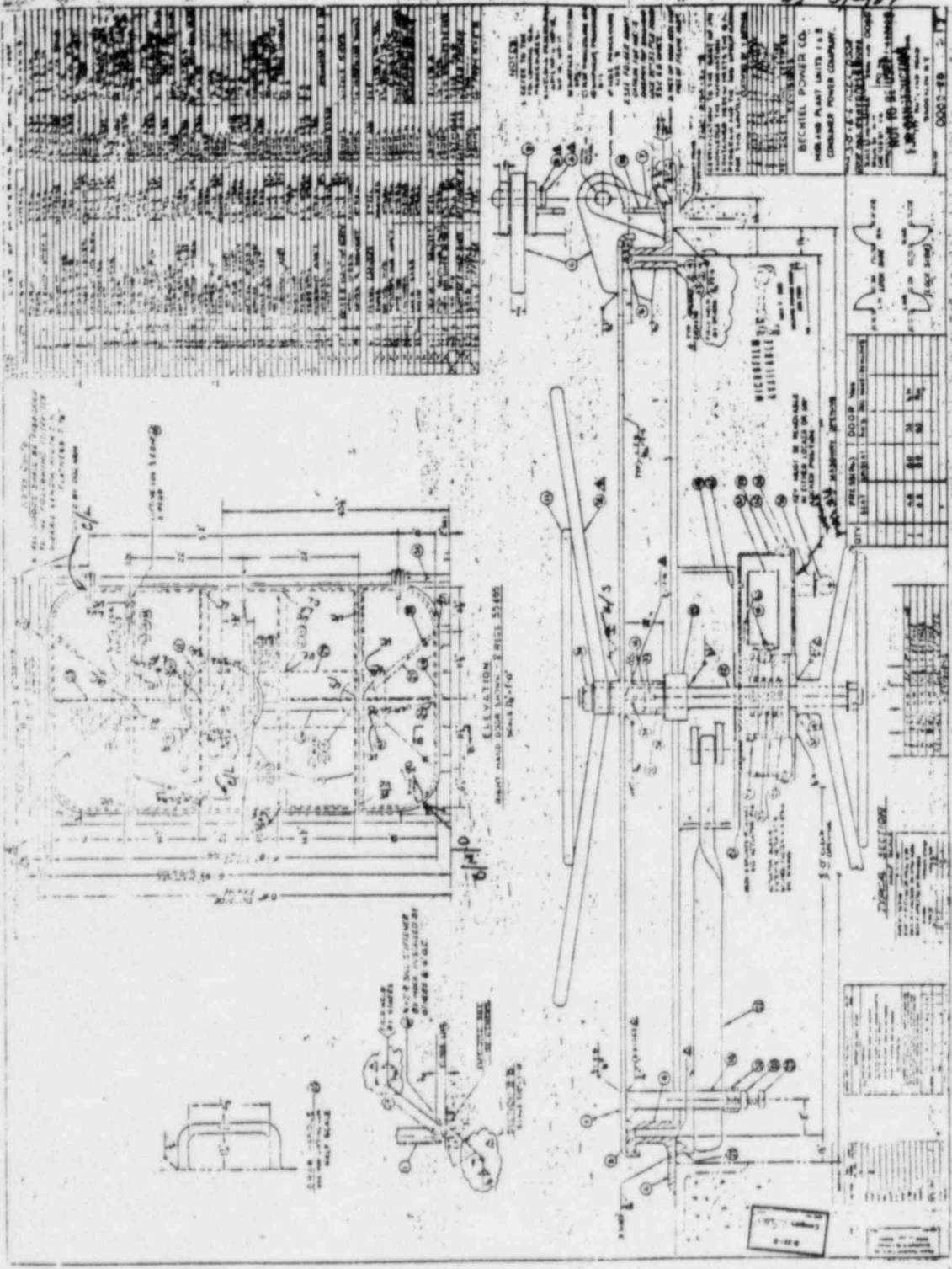
Doc # 109  
C



T.F. = incomplete fusion  
C.L. = cold lap  
slag = slag  
4/c = undercut  
4/5 = under size



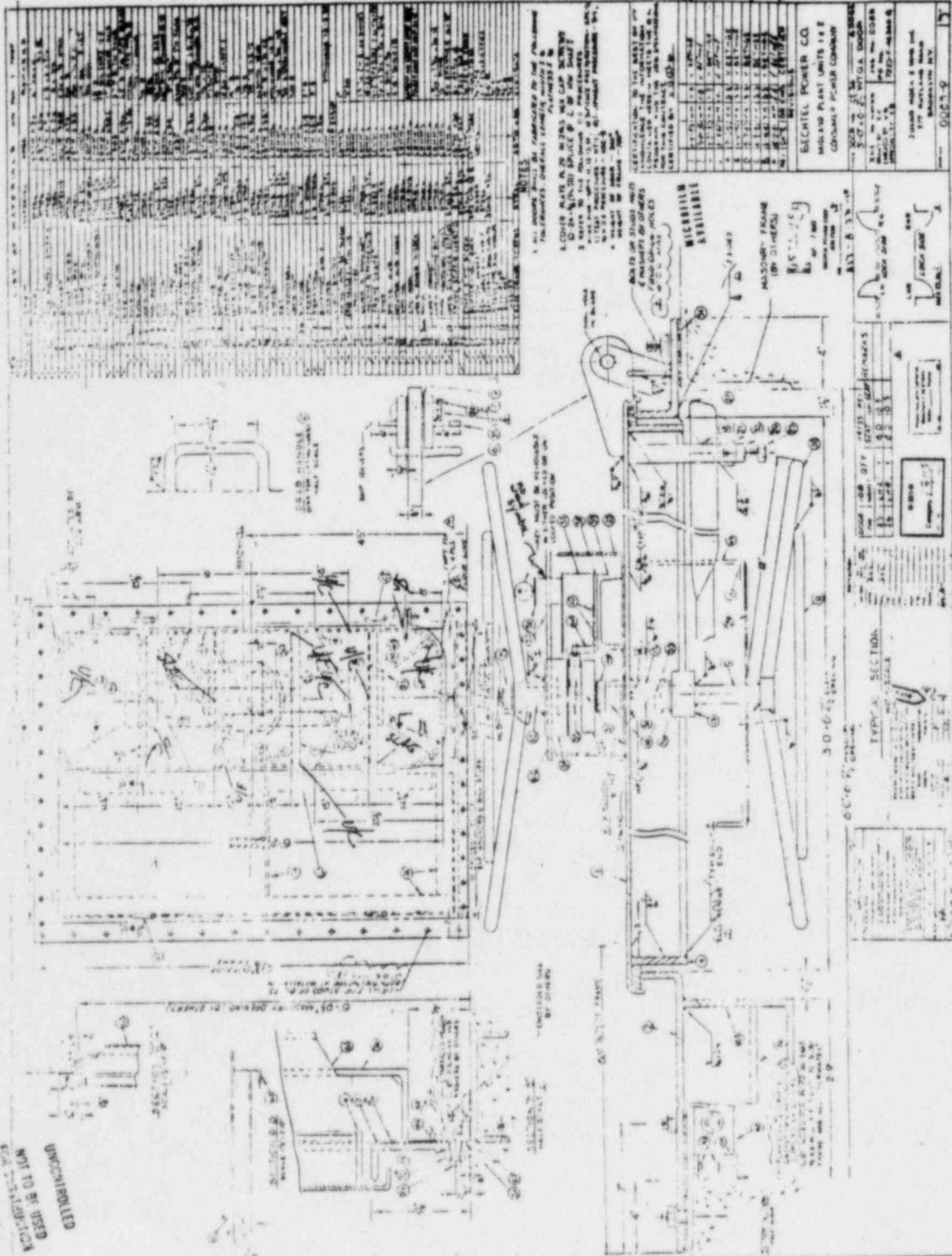
Door # 53



C.L. = Cold Lap  
 P.D. = Porosity  
 L.F. = Lack of Fusion  
 W.C. = Undercut  
 W.S. = Underfill

Rev 3/2/84

Jan

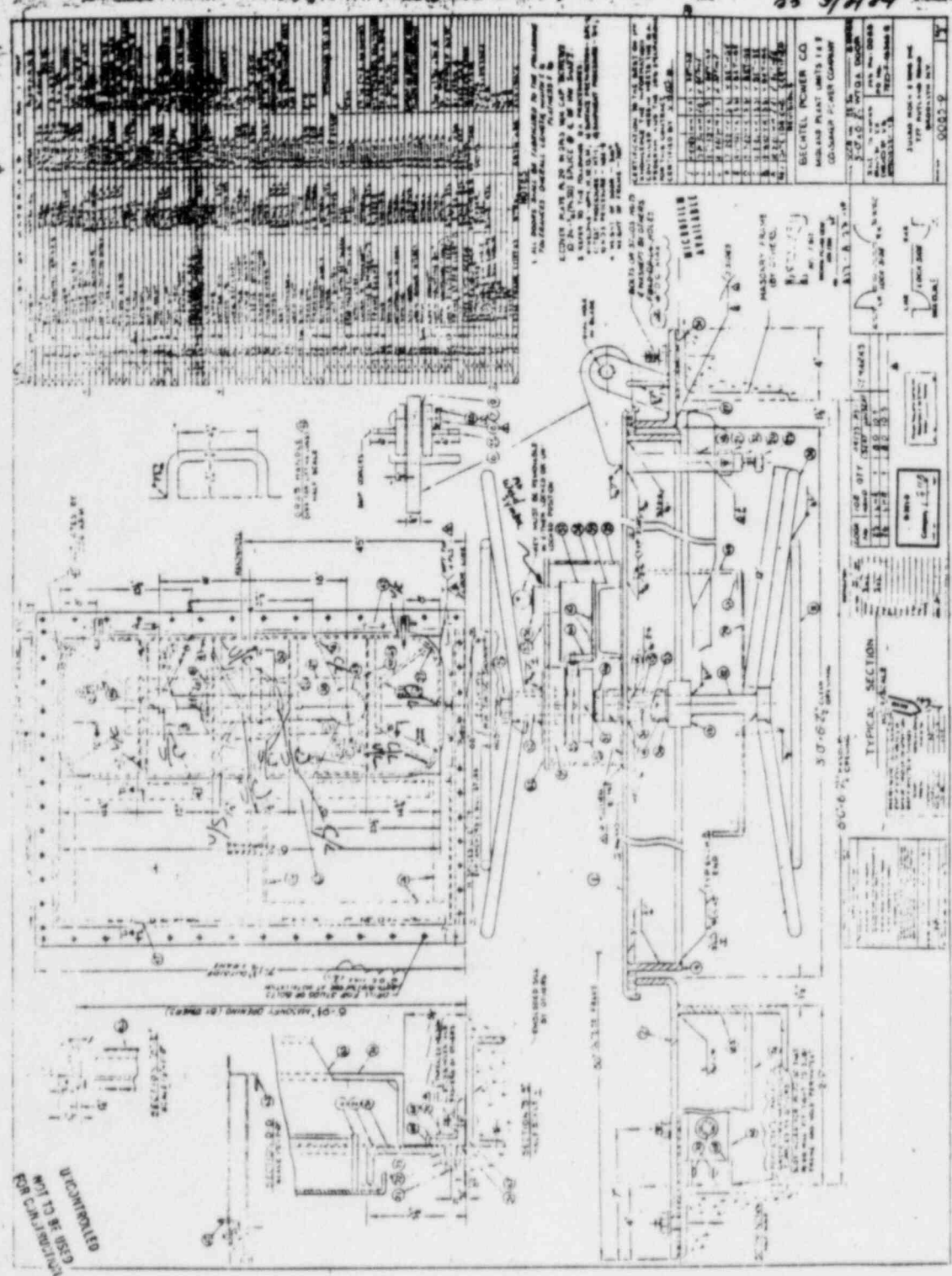


u/f = under file  
u/c = undercut  
u/s = under size

UNCONTROLLED  
NOT TO BE USED  
FOR FABRICATION

Rev 1  
23 3/2/84

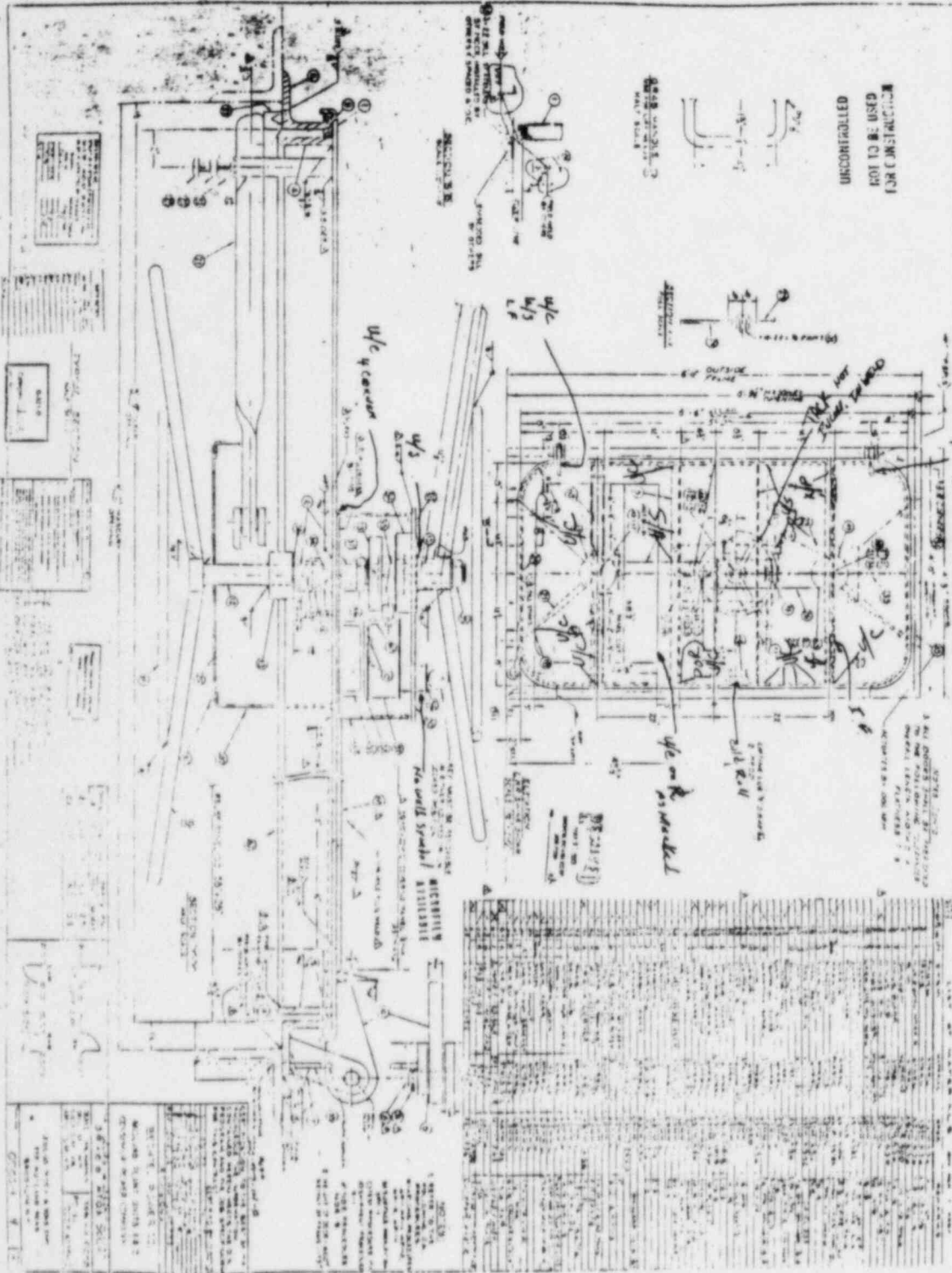
Q. 2



$\frac{c}{c} = \text{cold top/roll}$   
 $\frac{2c}{5h} = \text{under size}$   
 $\frac{4h}{5h} = \text{under cut}$

UNCONTROLLED  
NOT TO BE USED  
FOR CONJUGATION

Rev 1  
05/21/84



UNCONTROLLED  
NOT TO BE USED  
FOR CONSTRUCTION

W/C = undercut  
I.F. = incomplete fusion  
W/S = under 6.25  
L.F. = Lack Fusion/cold roll

Door # 24

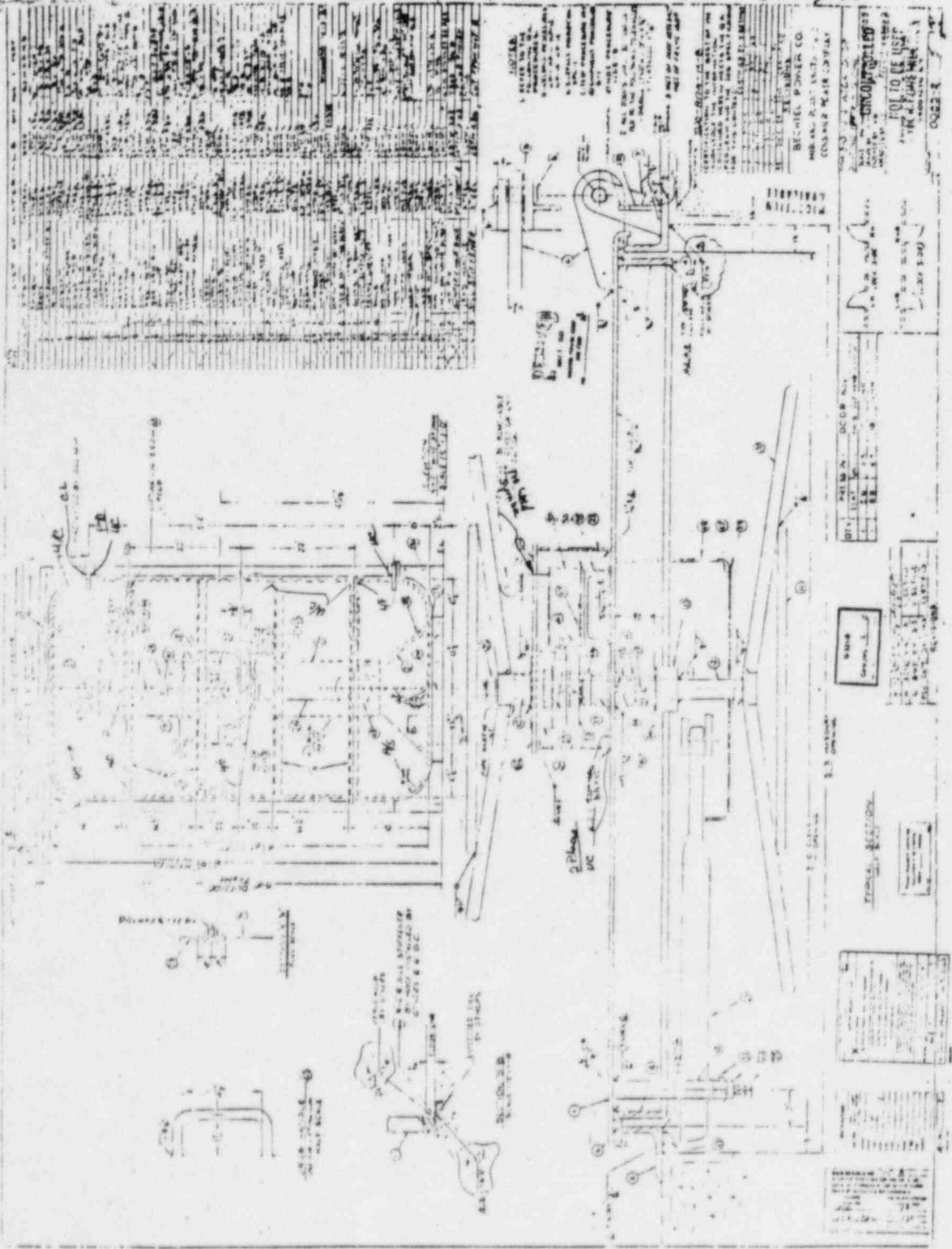




Rev  
05 3/24/84

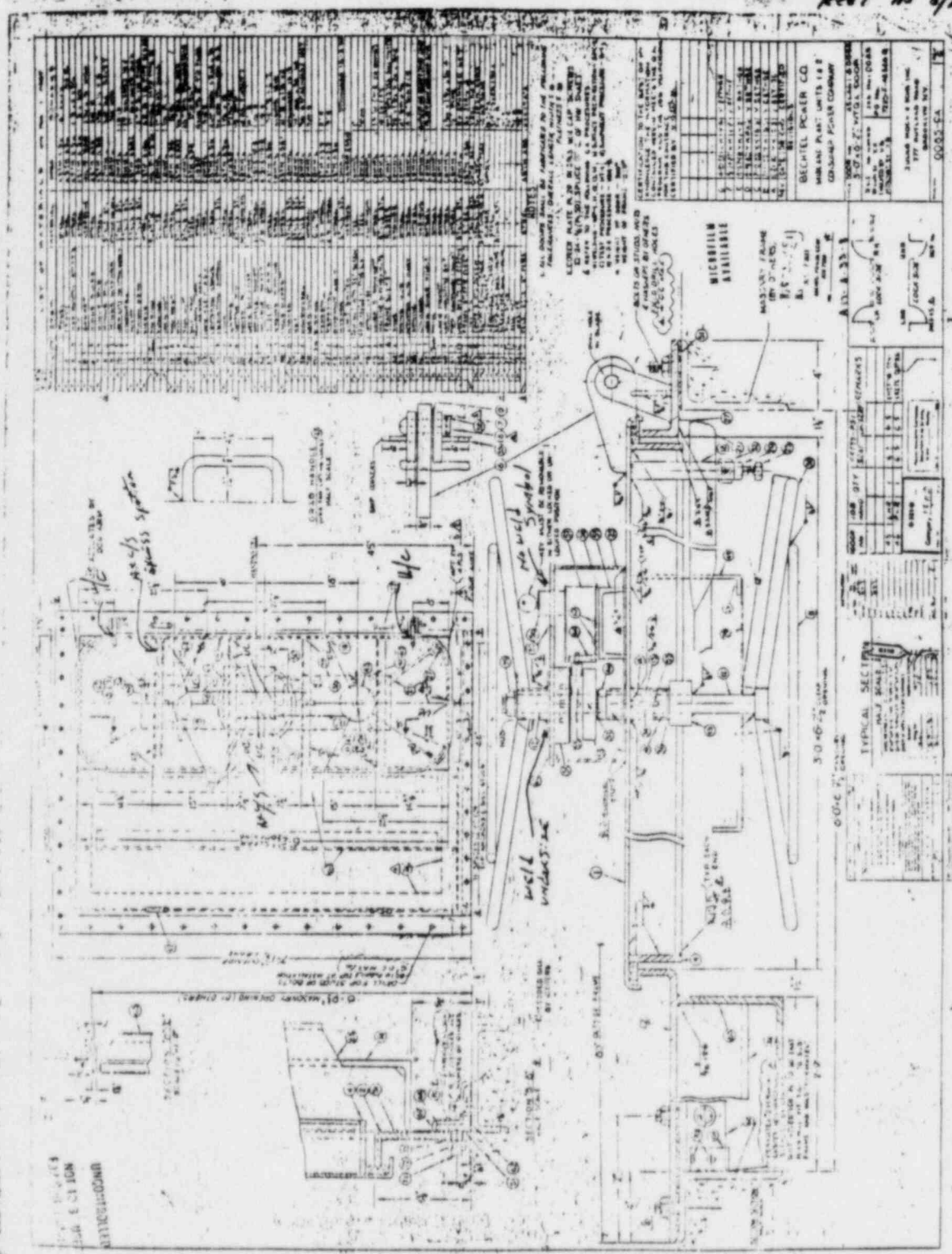
pm

Rev # 15 (C)



Wk = undercut  
L/P = Lick of Design  
C.L. = Cold Lap  
A/S = arc strikes  
YS = understrip

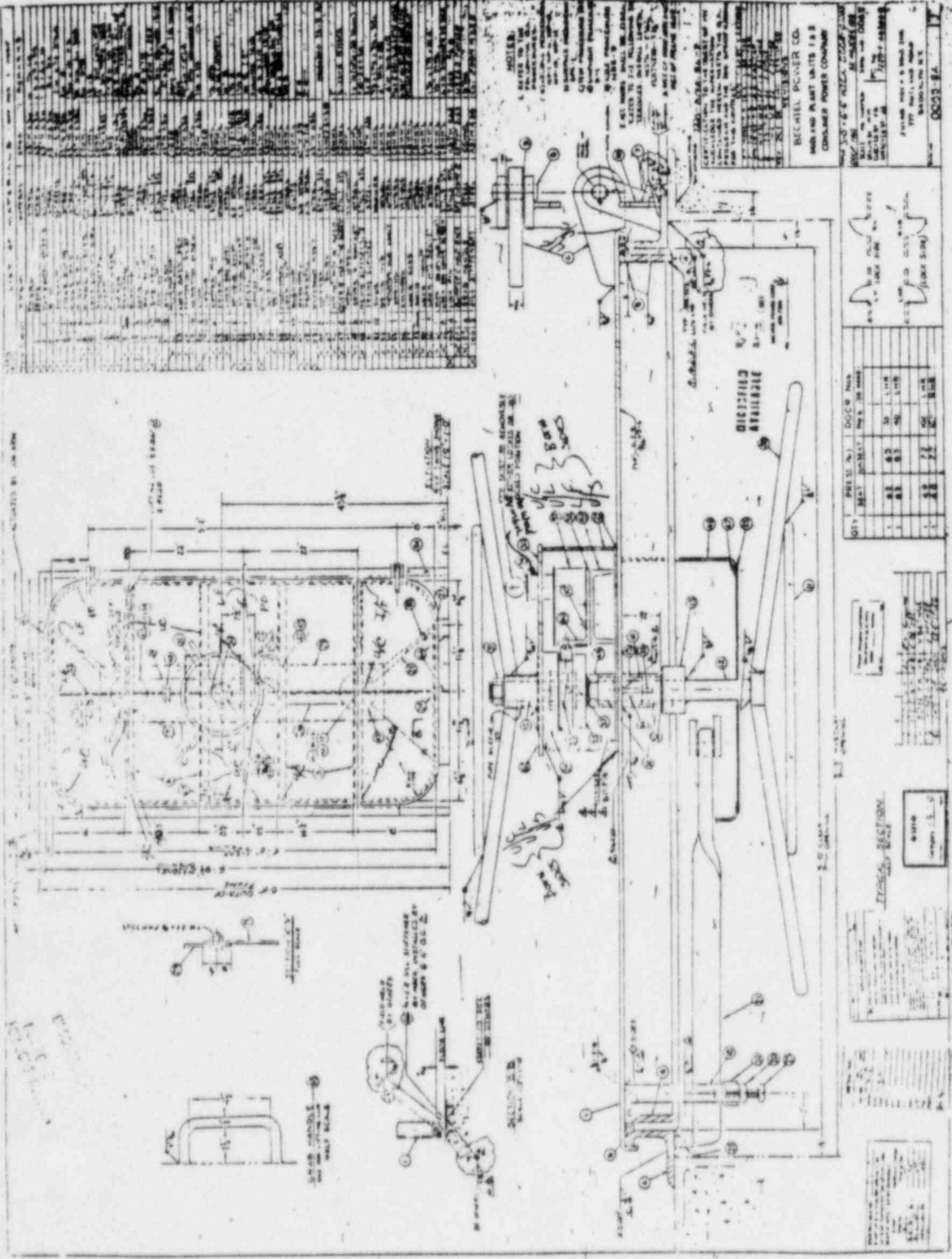
Door # 45 ©



up = undercut  
w/s = are strikes  
w/s = underside  
P.O. = porosity

N.R. C.O. 1000 Date Rec'd 2/2/84

Req # 108



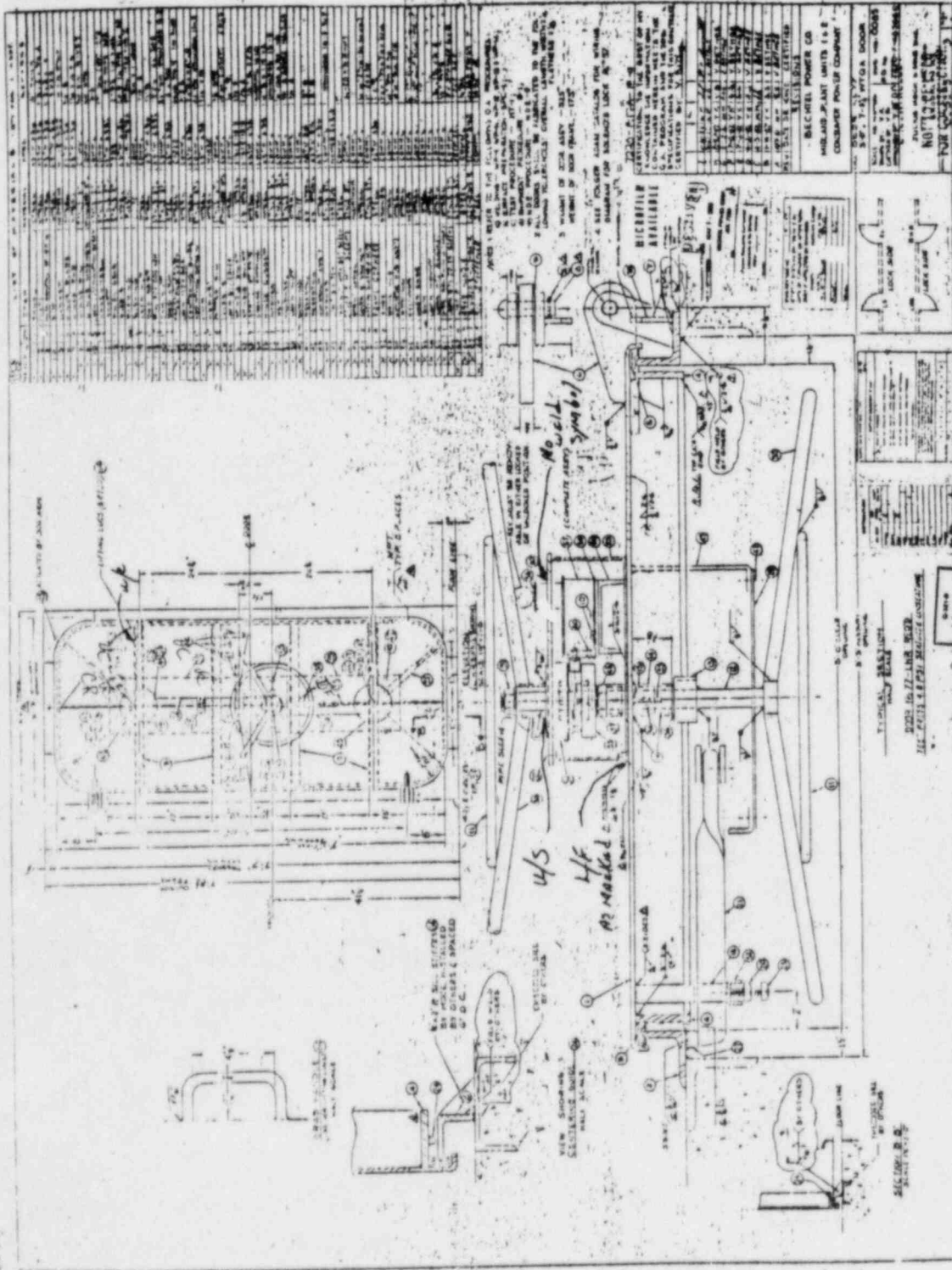
WC = undercut  
 WS = under size  
 WL = under length

WC undercut  
 WS under size  
 WL under length





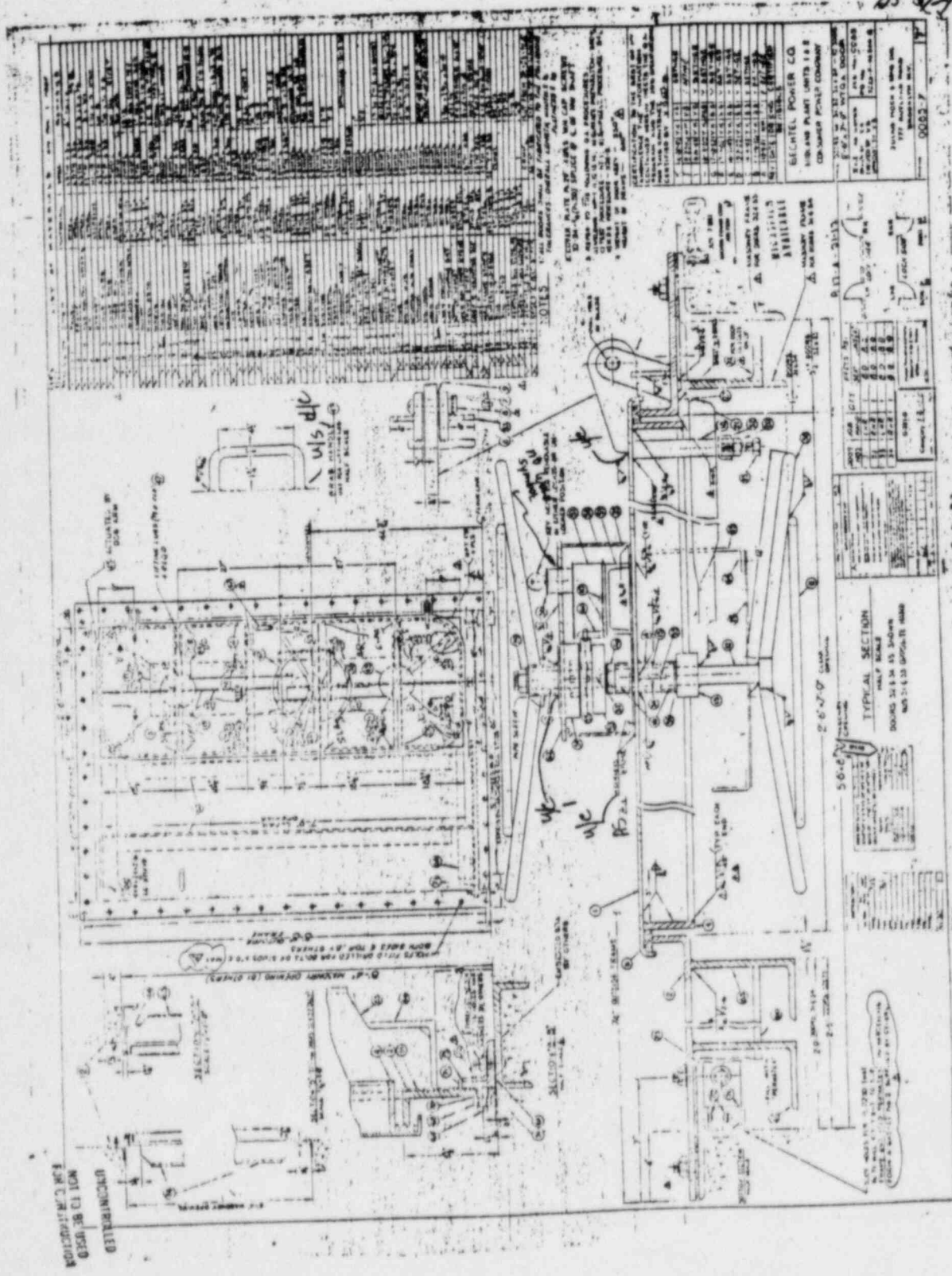
Door #77 ©



C.R. = cold roll  
 L/F = lack of fusion  
 C/L = undercut  
 W/S = under size



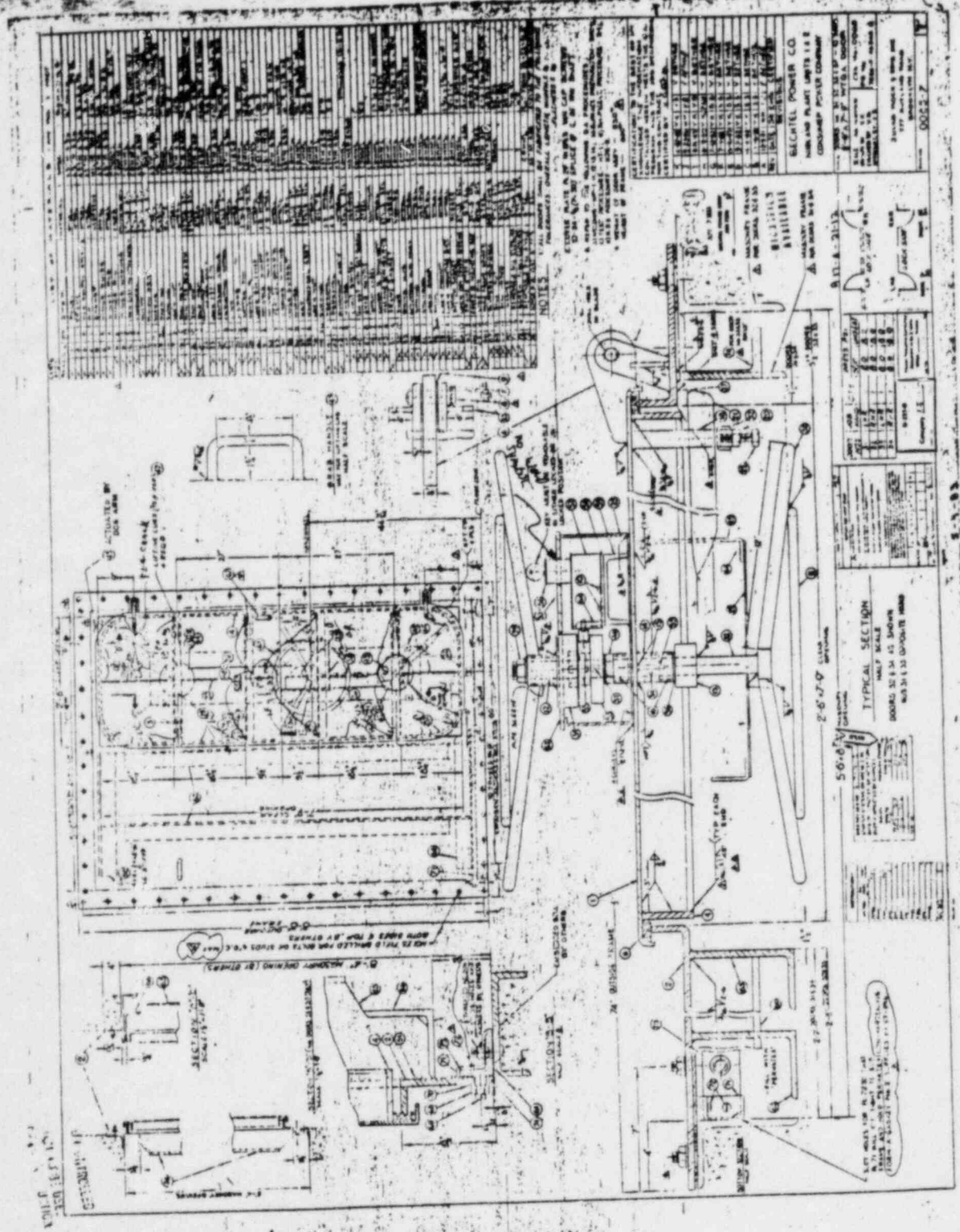
Door 32 (C)



u/c - undercar  
 A/S - arc strike  
 W/S - under size

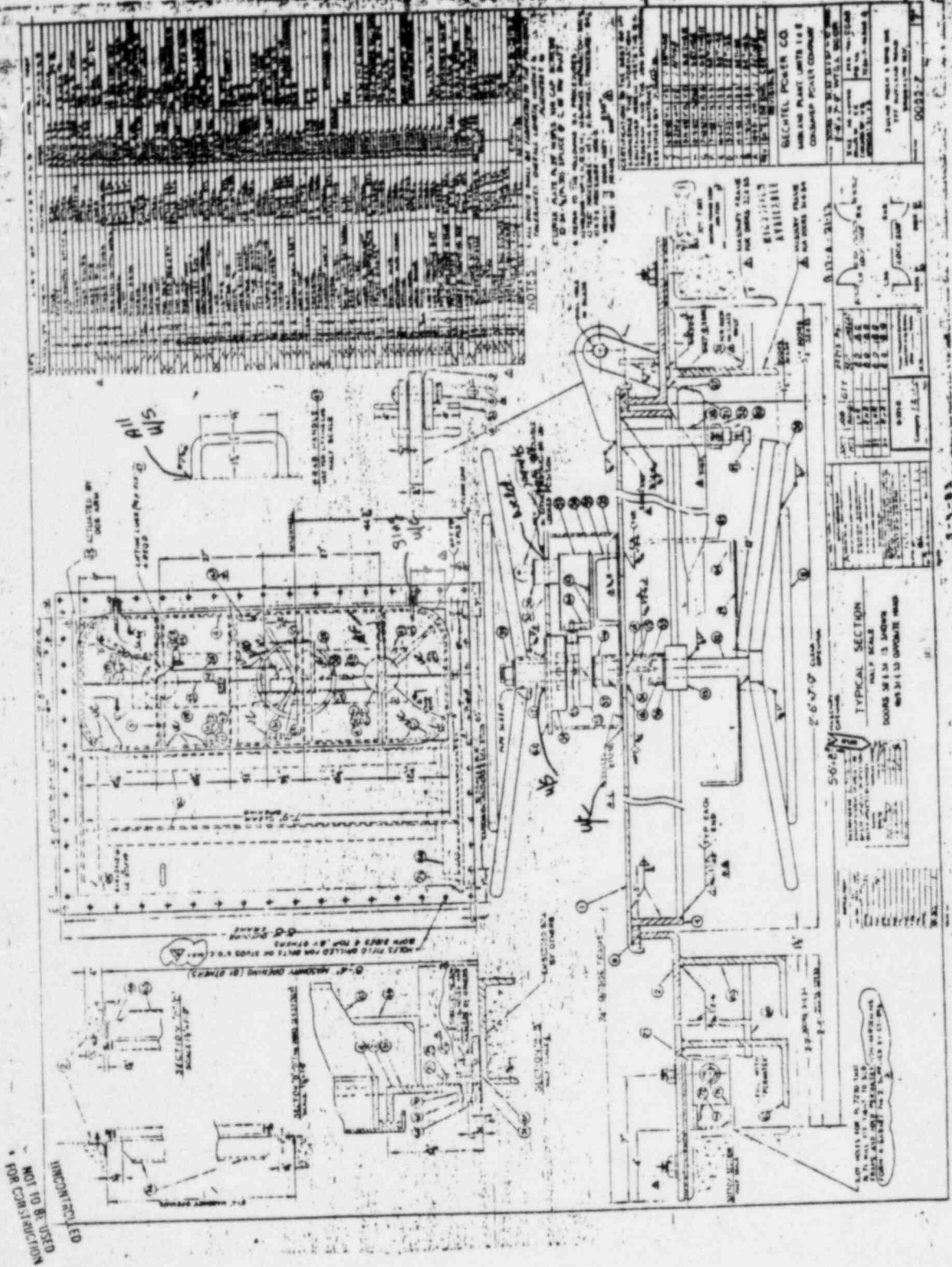


Door #34 (C)



u/c = undercut  
P.O. = porosity  
C.R. = cold roll / lap  
L.F. = lack of fusion

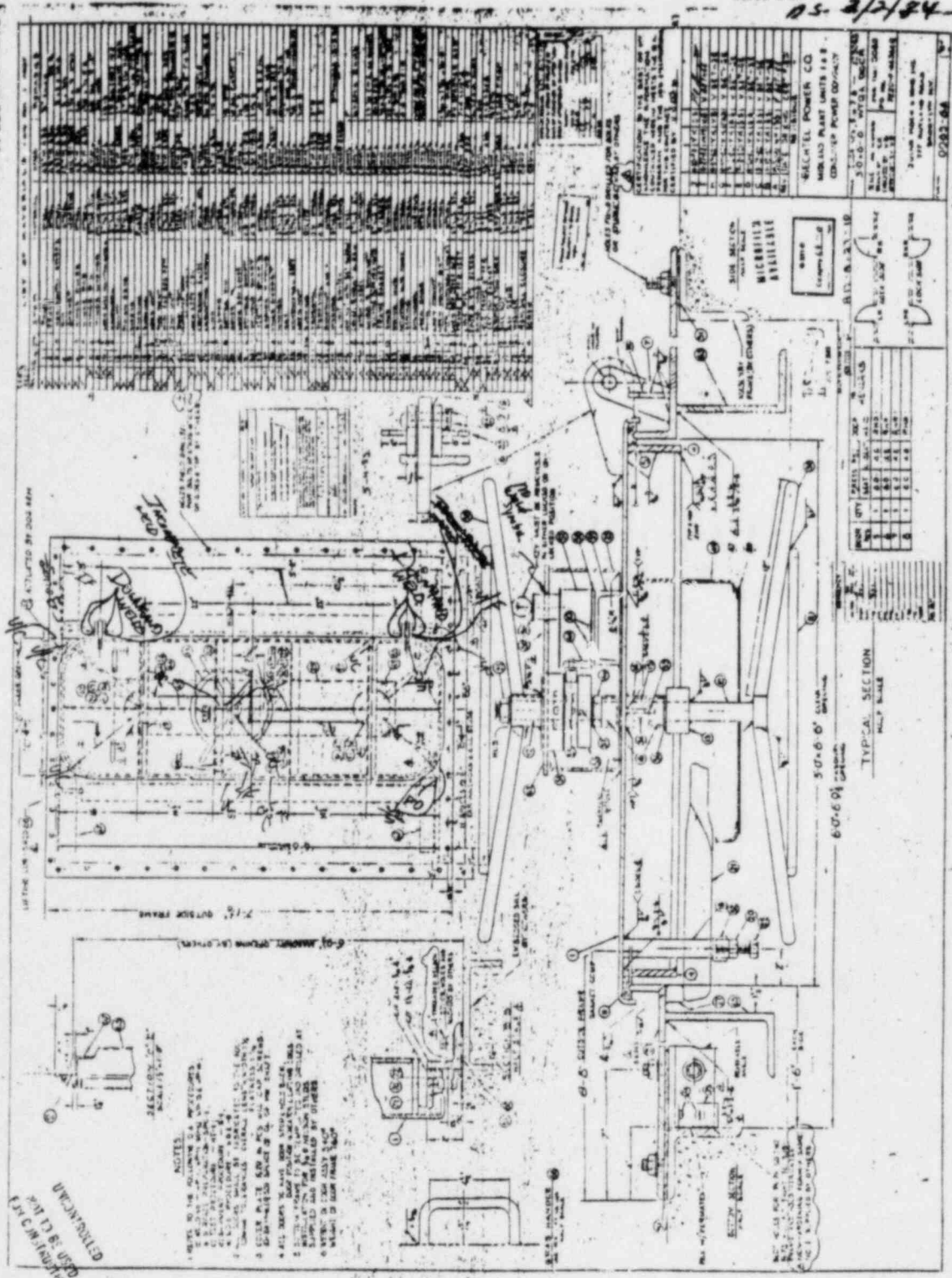
Door #33 ©



W/C = under cut  
 U/S = under size  
 L/P = lack of fusion

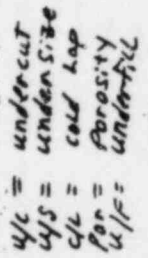
NRC-5000 Rev 1  
 05-2/2/84

Door #8



U/C = UNDERCUT  
 L/F = LACK OF FUSION  
 P.O. = POROSITY  
 I.F. = INCOMPLETE FUSION  
 U/F = UNDERFILL



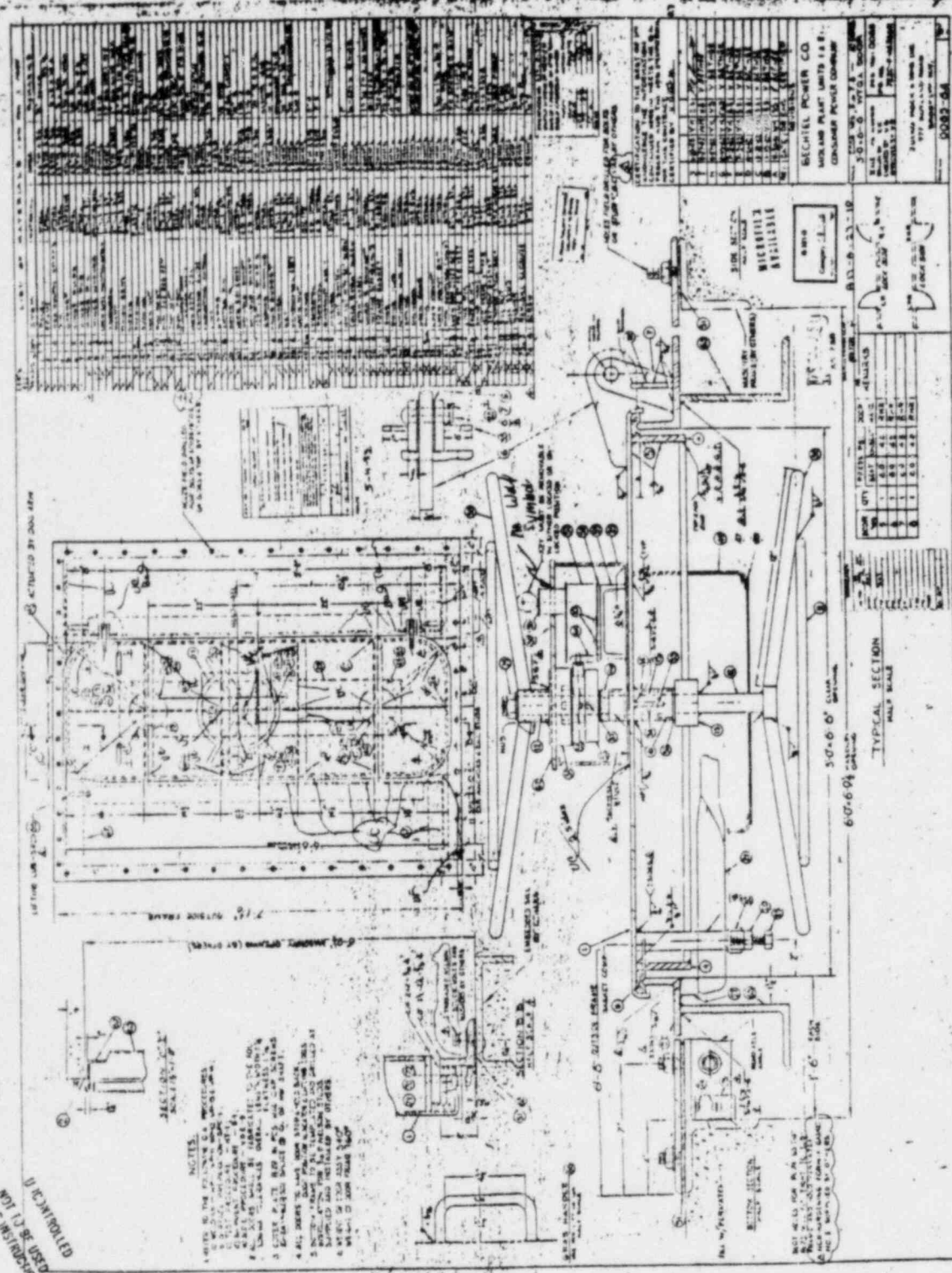




NCL 3-0000-1 Rev 1 0200  
Rev 1 0200  
Rev 1 0200

Door #7 (C)

UNCONTROLLED  
NOT TO BE USED  
FOR CONSTRUCTION



ITEM	QTY	DESCRIPTION
1	1	DOOR FRAME
2	1	DOOR GLASS
3	1	DOOR HANDLE
4	1	DOOR LOCK
5	1	DOOR STOP
6	1	DOOR SEAL
7	1	DOOR HINGE
8	1	DOOR LATCH
9	1	DOOR KNOB
10	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
11	1	DOOR FRAME
12	1	DOOR GLASS
13	1	DOOR HANDLE
14	1	DOOR LOCK
15	1	DOOR STOP
16	1	DOOR SEAL
17	1	DOOR HINGE
18	1	DOOR LATCH
19	1	DOOR KNOB
20	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
21	1	DOOR FRAME
22	1	DOOR GLASS
23	1	DOOR HANDLE
24	1	DOOR LOCK
25	1	DOOR STOP
26	1	DOOR SEAL
27	1	DOOR HINGE
28	1	DOOR LATCH
29	1	DOOR KNOB
30	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
31	1	DOOR FRAME
32	1	DOOR GLASS
33	1	DOOR HANDLE
34	1	DOOR LOCK
35	1	DOOR STOP
36	1	DOOR SEAL
37	1	DOOR HINGE
38	1	DOOR LATCH
39	1	DOOR KNOB
40	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
41	1	DOOR FRAME
42	1	DOOR GLASS
43	1	DOOR HANDLE
44	1	DOOR LOCK
45	1	DOOR STOP
46	1	DOOR SEAL
47	1	DOOR HINGE
48	1	DOOR LATCH
49	1	DOOR KNOB
50	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
51	1	DOOR FRAME
52	1	DOOR GLASS
53	1	DOOR HANDLE
54	1	DOOR LOCK
55	1	DOOR STOP
56	1	DOOR SEAL
57	1	DOOR HINGE
58	1	DOOR LATCH
59	1	DOOR KNOB
60	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
61	1	DOOR FRAME
62	1	DOOR GLASS
63	1	DOOR HANDLE
64	1	DOOR LOCK
65	1	DOOR STOP
66	1	DOOR SEAL
67	1	DOOR HINGE
68	1	DOOR LATCH
69	1	DOOR KNOB
70	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
71	1	DOOR FRAME
72	1	DOOR GLASS
73	1	DOOR HANDLE
74	1	DOOR LOCK
75	1	DOOR STOP
76	1	DOOR SEAL
77	1	DOOR HINGE
78	1	DOOR LATCH
79	1	DOOR KNOB
80	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
81	1	DOOR FRAME
82	1	DOOR GLASS
83	1	DOOR HANDLE
84	1	DOOR LOCK
85	1	DOOR STOP
86	1	DOOR SEAL
87	1	DOOR HINGE
88	1	DOOR LATCH
89	1	DOOR KNOB
90	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
91	1	DOOR FRAME
92	1	DOOR GLASS
93	1	DOOR HANDLE
94	1	DOOR LOCK
95	1	DOOR STOP
96	1	DOOR SEAL
97	1	DOOR HINGE
98	1	DOOR LATCH
99	1	DOOR KNOB
100	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
101	1	DOOR FRAME
102	1	DOOR GLASS
103	1	DOOR HANDLE
104	1	DOOR LOCK
105	1	DOOR STOP
106	1	DOOR SEAL
107	1	DOOR HINGE
108	1	DOOR LATCH
109	1	DOOR KNOB
110	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
111	1	DOOR FRAME
112	1	DOOR GLASS
113	1	DOOR HANDLE
114	1	DOOR LOCK
115	1	DOOR STOP
116	1	DOOR SEAL
117	1	DOOR HINGE
118	1	DOOR LATCH
119	1	DOOR KNOB
120	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
121	1	DOOR FRAME
122	1	DOOR GLASS
123	1	DOOR HANDLE
124	1	DOOR LOCK
125	1	DOOR STOP
126	1	DOOR SEAL
127	1	DOOR HINGE
128	1	DOOR LATCH
129	1	DOOR KNOB
130	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
131	1	DOOR FRAME
132	1	DOOR GLASS
133	1	DOOR HANDLE
134	1	DOOR LOCK
135	1	DOOR STOP
136	1	DOOR SEAL
137	1	DOOR HINGE
138	1	DOOR LATCH
139	1	DOOR KNOB
140	1	DOOR STRIKE

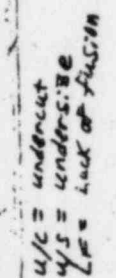
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142	1	DOOR GLASS
143	1	DOOR HANDLE
144	1	DOOR LOCK
145	1	DOOR STOP
146	1	DOOR SEAL
147	1	DOOR HINGE
148	1	DOOR LATCH
149	1	DOOR KNOB
150	1	DOOR STRIKE

ITEM	QTY	DESCRIPTION
151	1	DOOR FRAME
152	1	DOOR GLASS
153	1	DOOR HANDLE
154	1	DOOR LOCK
155	1	DOOR STOP
156	1	DOOR SEAL
157	1	DOOR HINGE
158	1	DOOR LATCH
159	1	DOOR KNOB
160	1	DOOR STRIKE

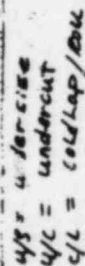
ITEM	QTY	DESCRIPTION
161	1	DOOR FRAME
162	1	DOOR GLASS
163	1	DOOR HANDLE
164	1	DOOR LOCK
165	1	DOOR STOP
166	1	DOOR SEAL
167	1	DOOR HINGE
168	1	DOOR LATCH
169	1	DOOR KNOB
170	1	DOOR STRIKE

W/C = under cut  
W/F = under fix

Door # 40 (C)

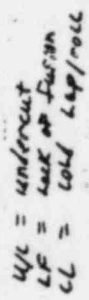


UNCONTROLLED  
NOT TO BE USED  
FOR CONSPIRING





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 Rev 1  
 8/2/84

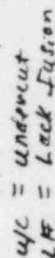


Door 18





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MIDLAND PROJECT  
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OVERSTRESS.

ALSO, BY REVIEWING THE VENDOR DESIGN CALCULATIONS,  
THE SEISMIC LOAD WAS FOUND TO BE INSIGNIFICANT COMPARED  
TO THE HYDROSTATIC PRESSURE.

~~MANUFACTURING~~ PROJECT ENGINEERING CONCLUDES THAT  
THE EXISTENCE OF THESE DEFICIENT WELDS WILL NOT  
AFFECT THE SAFETY OF THE DOORS AND THIS RECOMMENDS  
TO "USE AS IS"

JAM 4/27/84 P. Chen 4/27/84  
R. Chen for P. Rogan 4/27/84



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BLOCK 31a CONT'D.

PROJECT ENGINEERING DISPOSITION:

PROJECT ENGINEERING HAS EVALUATED THE NONCONFORMANCE CONCERNING DEFECTIVE WELDS ON THE REFERENCED WATERTIGHT DOORS AND FRAMES.

THE PRELIMINARY RESPONSE TO GAR RD-00027, CONCERNING THE DEFICIENCIES IN WATERTIGHT DOORS AND FRAMES, HAS BEEN REVIEWED BY PROJECT ENGINEERING. THE ATTACHED TRIP REPORT TO THIS GAR SHOWS THE RESULTS OF A DETAILED INSPECTION FOR TWO REPRESENTATIVE DOORS; DOOR AND FRAME NO. 5 AND FRAME NO. 34. THE WORST CONDITIONS DETECTED WERE UNDERCUTS OF  $\frac{1}{16}$ " x  $\frac{1}{4}$ " LONG. THE TOTAL LENGTHS OF WELD DEFICIENCIES FOUND FOR THE TWO DOORS WERE .3" OUT OF 722" OF WELDS INSPECTED.

~~\*CORROBORATING~~ A REVIEW OF CALCULATIONS 7220-A17A-12-7 FROM JULIUS MOCK & SONS, INC., SHOWS THAT THE MAJORITY OF THE CALCULATED WELD STRESSES ARE WELL BELOW THE ALLOWABLE STRESSES, WHICH WERE NOT INCREASED FOR ACCIDENT CONDITIONS. DRAWING 7220A-60 Sh. 2 ALLOWS A 50% INCREASE IN ALLOWABLE STRESSES FOR ACCIDENT LOADS WHICH WOULD GIVE A MINIMUM MARGIN OF SAFETY OF 33%. THE WELD DEFICIENCIES ARE WELL BELOW THIS MARGIN OF SAFETY AND THIS WILL NOT HAVE ANY IMPACT ON THE OPERATIONAL SAFETY ~~OF~~ OF THE DOORS.

FURTHERMORE, ALL THE DOOR AND FRAME ASSEMBLIES HAVE BEEN TESTED TO THE MAXIMUM REQUIRED DESIGN PRESSURES BASED ON ACCIDENT CONDITIONS. ALL THE ASSEMBLIES MET THE REQUIREMENTS WITH NO EVIDENCE OF STRUCTURAL





Consumers  
Power  
Company

# CONDITIONAL RELEASE

MIDLAND PROJECT  
QUALITY ASSURANCE DEPARTMENT

1. PAGE 1 OF 2

2. PROJECT:

MIDLAND JOB #7220

3. NCR

C01006

11. CONDITIONAL RELEASE NO:

C-01006-X01 34284

4. SPECIFIC ITEM(S) TO BE CONDITIONALLY RELEASED

NAME: JULIUS MOCK WATERTIGHT DOORS & FRAMES CONTRACT A17A

PART NO(S): SEE SHEET TWO

SERIAL NO(S): SEE SHEET TWO

QUANTITY: 31 EA SEE SHEET TWO

LOCATION: AUX BLD EL 668 THR 634

SEE SHEET TWO

12. FILE NO:

C-01006

13. DISTRIBUTION:

ORIGINAL

5. AUTHORIZED WORK OR USE: ALLOW REMOVAL OF COATINGS ON VENDOR WEIDS TO ENABLE A COMPLETE INSPECTION OF THE WEIDS PRIOR TO THE ARRIVAL OF THE JULIUS MOCK REPRESENTATIVE. THIS WILL INVOLVE THE UNPACKING OF THE DOORS IN WAREHOUSE 3. THIS WORK WILL NOT PROHIBIT OR MAKE THE NON CONFORMANCE MORE DIFFICULT TO REPAIR, REWORK, REPLACE OR EXAMINE, OR TO DETERMINE ITS ROOT CAUSE. THIS WORK WILL RENDER THE DEFICIENCIES MORE EASILY IDENTIFIABLE

6. LIMITATIONS ON CONDITIONAL RELEASE:

THE MATERIAL WILL NOT BE REMOVED FROM THE AREA & NO REWORK WILL BE PERFORMED.

7. JUSTIFICATION (GIVE COST SCHEDULE & SAFETY IMPLICATIONS IF THIS CR IS NOT AUTHORIZED)

THESE DOORS ARE A CRITICAL PART OF THE ORGC SECURITY SYSTEM SCHEDULED FOR TURN OVER 7/1/84. IF THIS REWORK IS NOT CLEARLY IDENTIFIED IT COULD IMPACT THE TURN OVER SCHEDULE FOR ORGC.

8. DATE OF EXPECTED CR CLOSURE:

3/26/84

9. REQUESTOR'S SIGNATURE/DATE:

Mike Cook 1/24/84

9A. PROJECT FIELD ENGINEER (BECHTEL ONLY)

GR Wick 1-26-84

9B. PQAE (BECHTEL ASME ONLY)

N/A 1/24/84

9C. ANI SIGNATURE/DATE (ASME)

N/A 1/24/84

10. PROJECT MANAGEMENT APPROVAL SIGNATURE/DATE:

RW Cook 1-26-84

14. MPQAD APPROVAL SIGNATURE/DATE:

1/26/84

15. CR TAGS APPLIED BY-SIGNATURE/DATE:

James Fisher 2-1-84

16. CR TAGS REMOVE/CR CLOSED - SIGNATURE/DATE:

HIGHLAND PROJECT  
QUALITY ASSURANCE  
DEPARTMENT

NONCONFORMANCE REPORT  
CONTINUATION SHEET

NCR NO.

C-0-1006

DATE ISSUED

REV

PAGE 2 OF 2

DOOR AND FRAME LOCATION

FRAME	EL	AREA	ROOM	DOOR	WAREHOUSE 3
5					X
6					X
7					X
8					X
210	575	340A	40	SAME	
205	"	540A	1	SAME	
14	584	120K	126	WHSF 3	
15	"	103A	130	" "	
18	"	102A	131	" "	
23	"	120D	118	" "	
24	"	120C	117	" "	
25	"	120A	111	" "	
26	"	120B	113	" "	
29	"	102A	116	" "	
31	"	120F	121	" "	
32	"	120G	122	" "	
33	"	120H	124	" "	
34	"	120J	125	" "	
35	599	130H	216	" "	
40	"	130J	217	" "	
43	"	130F	214	" "	
44	"	130G	215	" "	
45	"	130D	212	" "	
46	"	130E	213	" "	
53	614	103B	328	" "	
65	"	102B	329	" "	
77	"	210B	358	" "	
84	"	210E	361	" "	
88	"	210C	359	" "	
108	634	150L	420	" "	
109	"	150R	421	" "	

ORIGINAL



ENGINEERS  
POWER  
COMPANY

# ORIGINAL CONDITIONAL RELEASE

MIDLAND PROJECT  
QUALITY ASSURANCE DEPARTMENT

1. PAGE \_\_\_\_ OF \_\_\_\_

2. PROJECT:

7220

3. NCR

C-01006

11. CONDITIONAL RELEASE NO:

C-01006-02

4. SPECIFIC ITEM(S) TO BE CONDITIONALLY RELEASED

NAME: Watertight Frame # 23

PART NO(S): 0085-2 + 2A

SERIAL NO(S): N/A

QUANTITY: 1

LOCATION: Elev. 584' Rm. 118

12. FILE NO:

16.0/C-1006

13. DISTRIBUTION:

16.0/File

BT Foote (2 Copies)

MM Hanbury (TO)

BW Margaglio/DJones (QA)

WN McDougall (ASME)

RL Oliver

BMPalmer (Verification)

DF Ronk

5. AUTHORIZED WORK OR USE:

Cleaning of welds

6. LIMITATIONS ON CONDITIONAL RELEASE:

Removal of rust, paint and foreign material from welds

7. JUSTIFICATION (GIVE COST SCHEDULE & SAFETY IMPLICATIONS IF THIS CR IS NOT AUTHORIZED)

CAN NOT ADEQUATELY INSPECT WELDS.

8. DATE OF EXPECTED CR CLOSURE:

5-11-84

9. REQUESTOR'S SIGNATURE/DATE:

William E. Ganje 5/4/84

9A. PROJECT FIELD ENGINEER  
(BECHTEL ONLY)

*[Signature]* 5/4/84

9B. PQAE (BECHTEL ASME ONLY)

N/A

9C. ANI SIGNATURE/DATE (ASME)

N/A

10. PROJECT MANAGEMENT  
APPROVAL SIGNATURE/DATE:

*[Signature]* 5/4/84

14. HPQAD APPROVAL SIGNATURE/DATE:

*[Signature]* 5/4/84

15. CR TAGS APPLIED BY-  
SIGNATURE/DATE:

William E. Ganje 5/4/84

16. CR TAGS REMOVE/CR  
CLOSED - SIGNATURE/DATE:



PROJECT  
FIELD  
ENGINEER

# ORIGINAL CONDITIONAL RELEASE

KIRKLAND PROJECT  
QUALITY ASSURANCE DEPARTMENT

1. PAGE \_\_\_\_ OF \_\_\_\_

2. PROJECT:

7220

3. ICR

C-0100b

11. CONDITIONAL RELEASE NO:

C-01006-02

4. SPECIFIC ITEM(S) TO BE CONDITIONALLY RELEASED

NAME: Water tight Frame # 23

PART NO(S): 0085-2 + 2A

SERIAL NO(S): N/A

QUANTITY: 1

LOCATION: Elev. 584' Rm. 118

12. FILE NO:

16.0/C-1006

13. DISTRIBUTION:

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RL Oliver

BMPalmer (Verification)

DF Ronk

5. AUTHORIZED WORK OR USE:

Cleaning of welds

6. LIMITATIONS ON CONDITIONAL RELEASE:

Removal of rust, paint and foreign material from welds

7. JUSTIFICATION (GIVE COST SCHEDULE & SAFETY IMPLICATIONS IF THIS CR IS NOT AUTHORIZED)

CAN NOT ADEQUATELY INSPECT WELDS.

8. DATE OF EXPECTED CR CLOSURE:

5-11-84

9. REQUESTOR'S SIGNATURE/DATE:

William E. Ganke 5/4/84

9A. PROJECT FIELD ENGINEER  
(BECHTEL ONLY)

5/4/84

9B. PQAE (BECHTEL ASME ONLY)

N/A

9C. ASI SIGNATURE/DATE (ASME)

N/A

10. PROJECT MANAGEMENT  
APPROVAL SIGNATURE/DATE:

5/4/84

14. MPQAD APPROVAL SIGNATURE/DATE:

5/4/84

15. CR TAGS APPLIED BY-  
SIGNATURE/DATE:

William E. Ganke 5/4/84

16. CR TAGS REMOVE/CR  
CLOSED - SIGNATURE/DATE: