

DOCUMENTATION TRANSMITTAL

DmB

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SGA	File
ENF	

orig 3

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

Transmittal No: CIO-0044
Date: May 12, 1984

Attention: David Beauchamp

The documentation listed below ___ is provided herewith, X was previously provided on 5-11-84 ; as requested by David Beauchamp .

Documentation Description: Nonconformance Report - C-02834-V

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

Janne Kinn
Signature

8406050511 840512
PDR ADOCK 05000329
S PDR

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)
NIREichel, SMO (w/o)
RAWells, MPQAD (w/o)
CMThompson - File 24.2 (w/a, unless voluminous)

MI0384-0001A-QL06

IE01
MAY 30 1984 .1

MIDLAND PROJECT
QUALITY ASSURANCE
DEPARTMENT

ORIGINAL

NONCONFORMANCE REPORT

16 NCR NO.

C-02834-V

17 DATE ISSUED

4-16-84

18 REV

1

19

PAGE 1 OF 9

4/16/84

1 ITEM LOCATION

Unit #2, Aux. Bldg., Rm 118, 596' El., 5'5"N/6'14"W/7.4 Mod 1200

2 ITEM DRAWING/PART NO.

Dwg. C-855 rev. 22

3 ITEM PART NAME

Unit Coder 2VM54A

4 ITEM SERIAL NO.

N/A

5 ITEM DESCRIPTION

Welded Connections of Structural Supports

6 ITEM STARTUP SYSTEM NO.

Mod. 1200

7 REFERENCE DOCUMENT

PQCI C-210 rev. 23 AWS D1.1
PQCI CW-100 rev. 6 Spec. C-304 rev. 14

8 ASME A.N.I. REQUIRED

☐ YES ☒ NO

9 INSPECTION RECORD NO.

U-CW-100-10

LOG NO.

U154

REV NO.

N/A

10 RESPONSIBLE ORGANIZATION

Construction

11 NONCONFORMANCE DISCOVERED DURING:

☐ DESIGN

☐ RECEIVING

☐ CONST

☐ RELEASE FOR INSPECT

☒ POST INSPECT

☐ TURNOVER

☐ POST TURNOVER

☐ PRE-OP TEST

☐ FINAL TURNOVER

☐ OVERINSPECT

12 REQUIREMENT Dwg. C-855 rev. 22 Det. 2 Sec. B & Dwg. C-862 rev. 22 Det. 6 Show Required Weld Sizes
PQCI rev. 6 CW-100 para. 3.1.1 The minimum fillet weld shall be the size specified in the
Dwg., and shall not under-run the size by more than $\frac{1}{16}$ " for more than 10% of weld length.
3.1.2 A Maximum overrun for either or both fillet weld legs shall not exceed $+\frac{3}{16}$ " for
welds up to and including $\frac{3}{8}$ "...
3.1.9.4 Blemishes resulting from arc strikes are ground to a smooth contour...
3.1.12 Thorough fusion shall exist...
3.1.13 All craters are filled to the full cross section of the weld. 4/16/84 sec. 1. cont.

13 NONCONFORMANCE 1. Fillet weld sizes are not in accordance with the design requirements.

Item 2. Arc strikes are not ground smooth.

Item 3. Thorough fusion does not exist between weld and base metal.

Item 4. Craters are not filled to the full cross section of the weld.

Item 5. Final Configuration is not acceptable.

Item 6. Welder's Identifying Symbol Not Legible.

Item 7. Excessive leg size

14 NCR ORIGINATED BY (PERSON)

Mark L. Winkler

4/16/84
DATE

15 NCR ORIGINATED BY (DISCIPLINE)

MPQAD/Civil Struct.

See Attachments for Detail.

20 NUMBER OF HOLD TAGS (IF APPLIED)

1

21 LOCATION OF HOLD TAGS

596' El. 6' N/6' 15' W/7.4

22 POTENTIAL 50.55(e)

☐ YES

☒ NO

24 ACTION ITEM NO.

506664

26 ITEM PRIORITY CODE NO.

5

28 NCR REVIEWED BY:

William E. Jones

4/16/84

23 REPORTED TO MPQA MANAGER

DATE

N/A

25 DISCIPLINE:

5

27 TREND CODE

CC-40019 40005
4/16/84

DATE:

4/16/84

CONTINUED ON REVERSE

F-2M/LA (Rev 1)

29 CAUSE

30 PROCESS CORRECTIVE ACTION

☐ YES☐ NO

QAR NO. _____

31 RECOMMENDED DISPOSITION

☐ REWORK☐ SCRAP/REJECT☐ REPAIR☐ USE AS IS

32 CONDITIONAL RELEASE

☐ YES☐ NO

31A ADDITIONAL INFORMATION

33 DISTRIBUTION FOR ACTION

34 DISPOSITION CONCURRENCE

PROJECT FIELD ENGINEER DATE

MPQAD CONCURRENCE DATE

PFQCE (ASME) DATE

PQAE (ASME) DATE

LEAD DESIGN ORG DATE

CP Co SMO (for turned over systems) DATE

A.N.I. (ASME) DATE

35 DISPOSITION ACTION TAKEN

36 METHOD OF DISPOSITION ACTION VERIFICATION

RESULT OF DISPOSITION ACTION VERIFICATION

☐ ACCEPTABLE☐ UNACCEPTABLEIF UNACCEPTABLE, REFERENCE
SUPERCEDING NCR NUMBER _____

37 NCR CLOSED BY

MPQAD DATE

A.N.I. (ASME) DATE

ORIGINAL

NONCONFORMANCE REPORT

CONTINUATION SHEET

NCR NO. C-02834-V

DATE ISSUED 4-16-84

REV 01

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4/16/84

Block 13¹² Cont. PQCI C-210 rev.13 para. 3.2.4 Final configuration is acceptable.

PQCI CW-1.00 rev.6 para 3.1.15 Welder's Identifying symbol

4/16/84

4/16/84

See below

Block 12 Change A

Item #1 Spec. C-304 para. 6.2.1.1 Minimum fillet weld size shall be the size specified on the Dwg. ... (Dwg C-855 rev.22 Oct. 2 Sec. B & Dwg. C-862 rev.22 Oct. 6)

Item #2 AWS D1.1 para 4.4 Blemishes resulting from arc strikes are ground to a smooth contour...

Item #3 Spec. C-304 para. 6.2.4 Thorough fusion shall exist...

Item #4 AWS D1.1 para. 8.15.1.3 All craters are filled to the full cross section of the weld.

Item #5 Dwg. C-855 rev.22 Final Configuration

Item #6 PQCI CW-1.00 rev.6 para. 3.1.15 Welder's Identifying Symbol.

Item #7 Spec. C-304 6.2.1b Maximum overrun for either or both fillet weld legs shall not exceed $\pm 3/16$ "...

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MKW
4/10/84

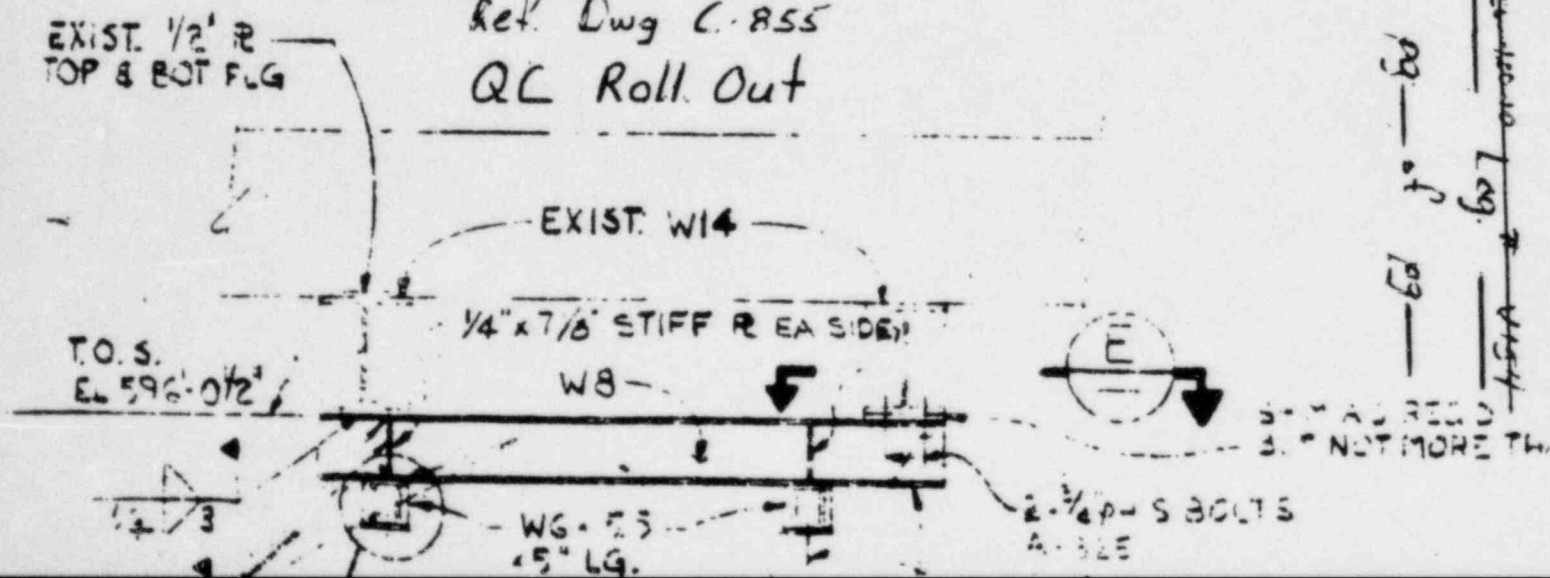


DETAIL (2)

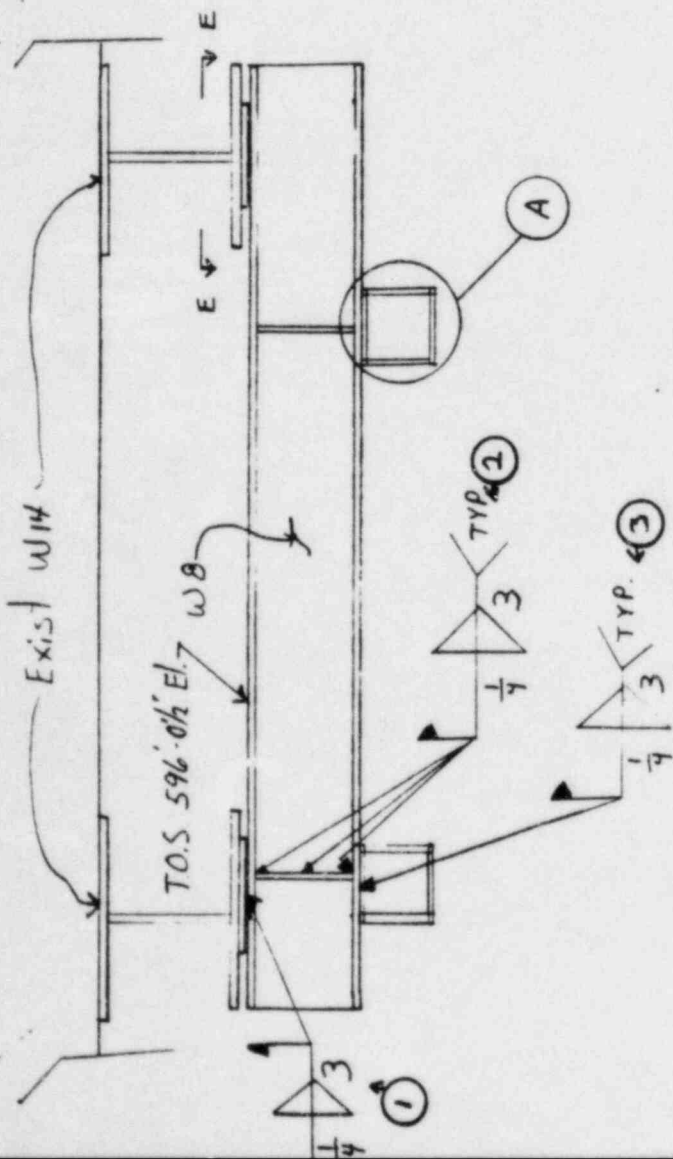
MLW
4/12/84

QCTK 10-10-10 Lag.

109-50-109

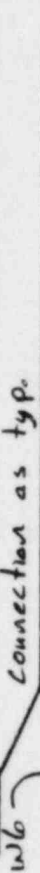


pg $\frac{45}{\text{new}}$ of pg 2



ABC,D Plan Locations
1,2,3,4,5 Individual Welds

N.S. Near Side (Looking North)
F.S. Far Side (Looking South)



Detail A
(Ref. Dwg. C-862)

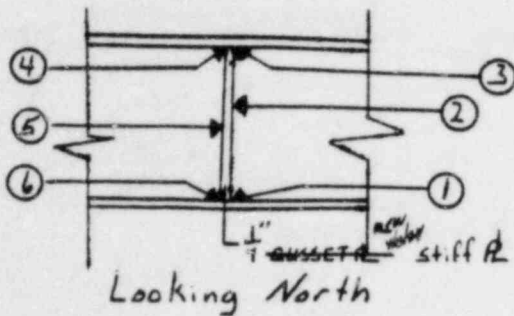
QC Roll out NO SCALE
Structural Supports for Unit Cooler 2UM54A
Ref. Dwg. C-855

ORIGINAL

ORIGINAL

2NS (TYP)

Attachment to NCR # C-02834-V
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msw 4/14/04



Notes: Undersize = 1 leg $\frac{3}{16}$ "
Insufficient Throat = $< \frac{1}{4} \geq \frac{3}{16}$ " *
* Fillet Gage Size
* Gouges in weld metal apparently caused by grinding.

Weld C2NS

2) $5 \frac{7}{8}$ " length

5) $5 \frac{3}{4}$ " length msw 4/14/04

Weld B2NS

1) Gouge in weld metal (G.W.M.) *
 $2 \frac{1}{4}$ " length $\frac{3}{32}$ to $\frac{1}{8}$ " Deep

2) $5 \frac{7}{8}$ " length
G.W.M. $4 \frac{3}{8}$ " length $\frac{3}{32}$ " Deep

4) G.W.M. $2 \frac{3}{8}$ " length $\frac{3}{32}$ " Deep

5) $5 \frac{7}{8}$ " Length
G.W.M. 4" length $\frac{1}{8}$ " Deep

6) G.W.M. $2 \frac{3}{8}$ " length $\frac{5}{32}$ " Deep

Item #1

Weld A2NS

1) Insufficient Throat $\frac{1}{2}$ " \approx

2) $5 \frac{7}{8}$ " length
Insufficient Throat & Undersize 100%

3) Insufficient Throat 50% \approx
Undersize 100%

4) Undersize 100%

5) Undersize & Insufficient Throat 100%

6) Undersize 100%
Insufficient Throat 50% \approx

Item #1

Weld O2NS

1) Undersize 25% \approx Insufficient Throat 80% \approx

2) Undersize & Insufficient Throat 100%

3) Insufficient Throat 50% \approx

4) Undersize 100% Insufficient Throat 25% \approx

5) Undersize 100% Insufficient Throat 10% \approx

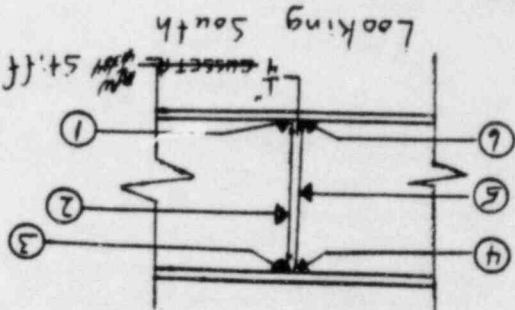
6) Undersize 100% Insufficient Throat 50% \approx

Item #1

ORIGINAL

Attachment to NCR # C-02834-V

2 FS (TYP)



Weld A2FS

1) Under size & Insufficient Throat 90% ≈

2) 5/2" in length

Under size 90% ≈ Insufficient Throat 1" ≈

3) Under size 60% ≈ Insufficient Throat 1" ≈

4) Under size 25% ≈ Insufficient Throat 1/2" ≈

5) Under size 90% ≈ Insufficient Throat 75% ≈
Length 5 1/2"

6) Under size & Insufficient Throat 50% ≈

Item #1

Item #1 & 4

1) Under size & Insufficient Throat 100% ≈

2) 5 9/16" length, Under size 100% ≈

4) Crater Not filled to full cross section of weld

5) Length 5 1/8" Insufficient Throat & Under size 25% ≈

6) Insufficient Throat & Under size 90% ≈

4) + 3) Base metal seam runs up to the toe of each weld.

Weld B2FS

2) 5 7/8" length
5) 5 1/8" length

Weld C2FS

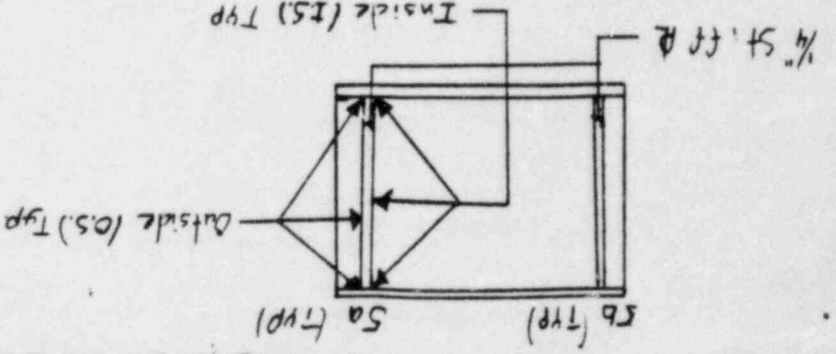
Weld
4/14/84

Notes: Under size = 1 leg 5/16"
Insufficient Throat = 1/4" - 3/8"
* Fillet Gage & size

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Dug L-855 re 22 calls for these stiff Rs to be on the South side of the Wlx 15.85

The opposite exists in the field.



Item #1

O.S. Undersize & Insufficient Throat 100%
I.S. Undersize 80% = Insufficient Throat 25%

Weld A5a

Item #1

O.S. Undersize & Insufficient Throat 100%
I.S. Undersize 100% Insufficient Throat 10%

Weld A5b

Item #1 & 3

O.S. Undersize 25% = Insufficient Throat 25%
I.S. Undersize & Insufficient Throat 40%

Weld D5a

Lack of Fusion & Slag Included 1/2" length
Bottom Corner at web & stiff R

Item #1

O.S. Undersize 100% Insufficient Throat 95%
I.S. Undersize & Insufficient Throat 50%

Weld D5b

Item #1

O.S. Undersize 100% Insufficient Throat 40%
I.S. Undersize 100% Insufficient Throat 50%

Weld B5a

Item #1

O.S. Undersize & Insufficient Throat 100%
I.S. Undersize 80%

Weld B5b

Item #1

O.S. Undersize & Insufficient Throat 100%
I.S. Undersize 100% Insufficient Throat 10%

Weld C5a

Item #1

O.S. Undersize 90%
I.S. Undersize & Insufficient Throat 80%

Weld C5b

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Attachment to NCR # C-02834-V
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ORIGINAL

Weld A3

Item #1

N.S. 5" length Excessive Convexity $\frac{1}{2}"$ *

F.S. $4\frac{7}{8}"$ length Insufficient Throat $\frac{1}{2}"$ $\frac{1}{2} \times \frac{1}{2} \times 10\% \approx$

Weld B3

Item #1

msw 4/14/04 #7

N.S. 5" length

1 leg $\frac{1}{2}"$ Excessive Convexity $\frac{7}{16}" - \frac{1}{2}"$ *

* Fillet Gage Size

F.S. $4\frac{3}{4}"$ length

Weld C3

Item #1 #4

N.S. $4\frac{7}{8}"$ length

F.S. Crater not filled to full cross section of weld

Under size 25%

5" length

Weld D3

Item #2 #6

N.S. Arc strike not ground smooth

F.S. $4\frac{7}{8}"$ length

Arc Strike not ground smooth

Welder ID Not Legible

Weld D1

N.S. $5\frac{7}{8}"$ length

F.S. $5\frac{7}{8}"$ length

Weld E1

msw 4/14/04