

50-329

50-330

DMB

DOCUMENTATION TRANSMITTAL

PRINCIPAL STAFF		
RA	has	DRP
D/RA		DE
A/RA		DRMSP
RC		DRMA
PAO		SCS
SGA		ML
ENF		File

orig 3

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

Transmittal No: CIO-0066  
Date: June 6, 1984

Attention: Ralph Butler

The documentation listed below \_\_\_ is provided herewith, X was previously provided on 6-6-84 ; as requested by Ralph Butler .

Documentation Description: Nonconformance Report - C-03736

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

Joanne Kinne  
Signature

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

8406150054 840606  
PDR ADOCK 05000329  
S PDR

JUN 11 1984

LEO/

MIDLAND PROJECT  
QUALITY ASSURANCE  
DEPARTMENT

NONCONFORMANCE REPORT

**ORIGINAL**

16 NCR NO.

C-03736 SU

17 DATE ISSUED

5-12-84

18 REV

0

19

PAGE 1 OF 6

1 ITEM LOCATION

UNIT # 2, AUX. Bldg, EL 5B4, Rm 11B, 11'-6" T<sub>o</sub> 15'-6" W/2.4, 13'-6" N/G

2 ITEM DRAWING/PART NO.

7220-A17A-14/A

3 ITEM PART NAME

(Door #23, WATER TIGHT) WELDS

4 ITEM SERIAL NO.

N/A

5 ITEM DESCRIPTION

WELDS ON Door #23, See ATTACH. #1

6 ITEM STARTUP SYSTEM NO.

Module # 120D

7 REFERENCE DOCUMENT ACT. 3.1.7, 3.1.2, 2.1.22, 2.3  
PQCI CW-1.00 AWS D1.1, G-27 GWS - STR

8 ASME A.N.I. REQUIRED

☐ YES ☒ NO

9 INSPECTION RECORD NO.

CW-100-747

LOG NO.

216412

REV NO.

6

10 RESPONSIBLE ORGANIZATION

CONSTRUCTION

11 NONCONFORMANCE DISCOVERED DURING:

☐ DESIGN

☐ RECEIVING

☐ CONST

☐ RELEASE FOR INSPECT

☒ POST INSPECT SU ☐ TURNOVER

☐ POST TURNOVER

☐ PRE-OP  
TEST

☐ FINAL  
TURNOVER

☐ OVERINSPECT

12 REQUIREMENT

(1) AWS D1.1 Paragraph 3.2.1: Surfaces and edges to be welded smooth, uniform and free of defects.

(2) GWS STR 5.1: Preheat temperature shall be in accordance with general preheating requirements.

(3) AWS D1.1 Section 5: Joint fit up conforms to the prequalified joint detail.

GWS STR 4.1.3.1: The parts to be joined by fillet welds shall be brought into close contact as possible, if gap is 1/16" or greater both legs of fillet weld will be increased by the amount of separation.

GWS STR: Verify that tack welds that are to be incorporated into final weld meet requirements of final weld.

CONTINUED

13 NONCONFORMANCE

The above requirements are listed in PQCI CW-1.00 with hold points to be inspected. The welds on the above listed IR have been made previous to inspection and the condition is indeterminate, on the following:

(1) Preparation of Base Metal

(2) Preheat

(3) Fitup

14 NCR ORIGINATED BY (PERSON)

Jim Hellett

5/12/84  
DATE

15 NCR ORIGINATED BY (DISCIPLINE)

GC Civil

20 NUMBER OF HOLD TAGS (IF APPLIED)

1

21 LOCATION OF HOLD TAGS

Door #23 Frame

22 POTENTIAL SO.55(a)

☐ YES

☒ NO

24 ACTION ITEM NO.

507917

25 ITEM PRIORITY CODE NO.

2

26 NCR REVIEWED BY:

William E. Damp

23 REPORTED TO MPQA MANAGER

DATE

N/A

25 DISCIPLINE:

S

27 TREND CODE

GG-20001 GG10001  
GG-30004 GG50008

DATE:

5/12/84

CONTINUED ON REVERSE

F-2M/LA (Rev 1)

29 CAUSE

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

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 ☐ UNACCEPTABLE

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

37 NCR CLOSED BY

MPQAD DATE

A.N.I. (ASME) DATE

ORIGINAL

NONCONFORMANCE REPORT

CONTINUATION SHEET

NCR NO.

C-03736

DATE ISSUED

5-12-84

REV

0

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Block 12 Continued -

(4) Drawg. 7220-A17A-14-8 specifies A intermittent  $3/16"$  Fillet weld with 2" Length AND 6" Pitch.

ANS. A 2.4-79 SECTION 4.6.1 STATES THAT THE SYMBOL INDICATES THAT INCREMENTS SHALL BE LOCATED AT THE ENDS OF THE dimensioned Length.

(5) MAX. OVERRUN FOR FILLET WELD LEGS SHALL NOT EXCEED  $+3/16"$  FOR WELDS UP TO AND INCLUDING  $3/8"$ . Fillet welds larger than this requires FE. APPROVAL prior TO FINAL ACCEPTANCE. Spec. C-304 6.2.1

(6) ADDITIONAL WELDS NOT SHOWN ON DRAWING REQUIRE Field Engineering APPROVAL prior TO FINAL ACCEPTANCE. Spec C-304 6.2.7

Block 13 continued:

(4) The intermittent Fillet welds ( $3/16"$  - 2" Long + 6" Pitch) connecting Door Frame To Embedded Angle DOES NOT HAVE INCREMENTS AT THE ENDS. See ATTACHMENT #1. This <sup>APPLIES</sup> ~~APPLIES~~ TO THE VERTICAL ENDS OF THE FRAME ONLY.

(5) The welds identified with a \* symbol ON ATTACHMENT 1 ARE THOSE WITH WELD SIZES IN EXCESS OF  $+3/16"$ . THE AVG. ACTUAL SIZE IS  $7/16"$  FOR ENTIRE WELD. WELDS #3 oversize AND #4. (See ATTACH 1)

(6) ADDITIONAL WELDS INDICATED ON ATTACHED SKETCH SECTION "A-A" <sup>ARE</sup> ~~NOT~~ SHOWN ON DRAWINGS.

NOTE:  $1/4"$  ground OFF OF WELD #7 (Length), These welds <sup>CONNECT</sup> ~~WALL~~ Embedded Angle Frame To Embedded Floor Angle Frame.



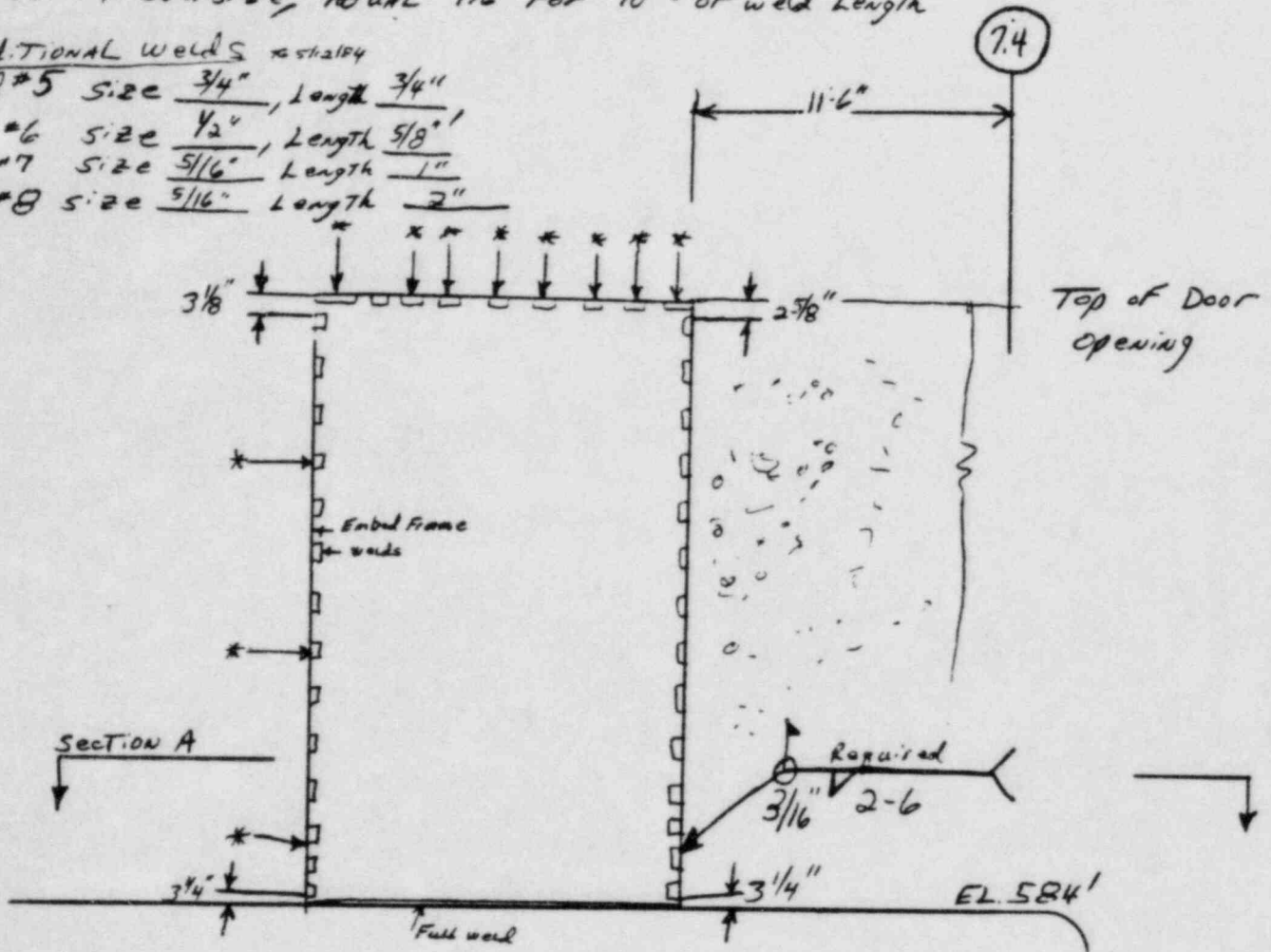
## ATTACHMENT #1

### NON-CONFORMANCES

- ① The symbol \* indicates (Oversize welds, #1) to shop
- ② Weld #3 oversize, ACTUAL  $7/16"$  For 10% of weld Length  
Weld #4 oversize, ACTUAL  $7/16"$  For 10% of weld Length

### Additional welds to shop

- ③ Weld #5 size  $3/4"$ , Length  $3/4"$   
Weld #6 size  $1/2"$ , Length  $5/8"$   
Weld #7 size  $5/16"$ , Length  $1"$   
Weld #8 size  $5/16"$ , Length  $2"$

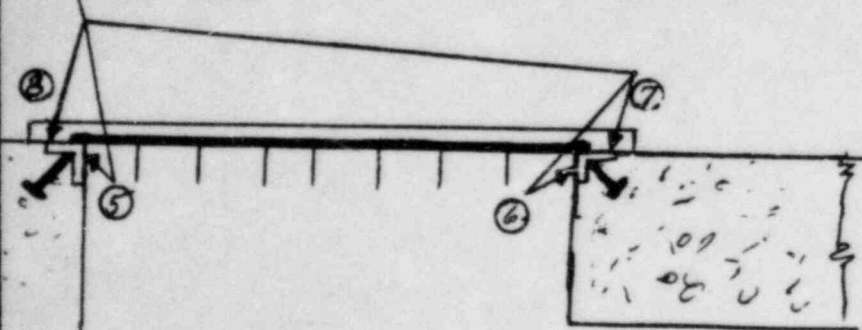


Elevation View (Looking North)

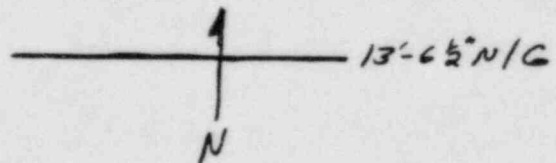
Watertight Door #23

13'-6" N/G, Aux. Bldg.

Additional welds

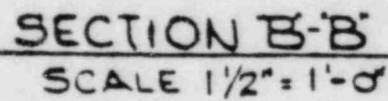



Section A



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65




  
3 SIDES

# ORIGINAL

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NCR # C-03736

ROFILM  
ILABLE

PANEL - 1/4" THK.  
ASTM A36

LUG WELD 

1. REFERENCE  
FOLLOW  
PROC.

a) WELD  
WP-1,  
WP-1.

b) SURF  
SPC:

C-TEST

-d) SHIP  
B-1

e) N.D. 1  
N.D. 2

2. WEIGHT  
WEIGHT

- OVAL  
 HOLD IN  
 PLACE.

- SAFE CORNER

FIELD  
FIELD  
B  
OTHERS

△△ TYPE  
EACH END

FIELD WELD  
BY OTHERS

WALLNEY FRAMES  
BY OTHERS

APR

7220-~~777~~-14-8

**CERTIFICATION: TO THE KNOWLEDGE THE INFORMATION CONTAINED HEREIN IS A PROGRAM AND THE TOOL FOR THIS CONTRACT.**

SECTION "Y-Y"  
HALF SCALE

# WORKPRINT

VERIFICATION DATE 1-31-84

RECIPIENT ORGANIZATION 309

36  
RECEIVED  
JUN 6 1983  
CONTROL

JUN 6 1983

JUN 6 1964  
QUALITY CONTROL  
BECHTEL JOB 7220

BECHTEL POWE

MIDLAND PLANT UNIT  
CONSUMER POWER CO.

1-31-74 RW  
CONTINUED