

166

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50-445-02-2
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September 27, 1984

UNITED STATES OF AMERICA
NUCLEAR REGULATORY COMMISSION

'84 OCT -1 AIO:57

BEFORE THE ATOMIC SAFETY AND LICENSING BOARD

In the Matter of)	
)	
TEXAS UTILITIES GENERATING)	
COMPANY, et al.)	Docket Nos. 50-445-2
)	and 50-446-2
(Comanche Peak Steam Electric)	
Station, Units 1 and 2))	

CASE's Evidence Of A Quality Control Breakdown

Ms. Sue Ann Neumeyer testified that on March 3, 1983 she was instructed to "sign off" on approximately 140 travelers which were missing signatures. (See CASE's Preliminary Proposed Findings of Fact (PPFF) Nos. 1 - 20) She did so, under protest, noting with an asterisk and explanation what her signature on certain lines did and did not mean. As a conscientious quality control inspector she was deeply concerned about the implications and impropriety of the task put before her. Applicant's explanation, offered through C. Thomas Brandt, is that Ms. Neumeyer's concerns were without foundation -- even if she had been pressured into signing the missing hold points. (See prefiled testimony of C.T. Brandt, dated August 16, 1984.

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DS03

Applicant's argument is without foundation. After the production of the travelers for Unit 2 Refueling Building there is no question that Ms. Neumeyer had every reason to be apprehensive about the condition of the liner plates and the specific assignment she was given by her supervisor.

Months before Ms. Neumeyer's testimony in July 1984 on this incident in the Atomic Safety and Licensing Board hearings on harassment and intimidation she reported the information to the Nuclear Regulatory Commission's Office of Investigation (OI). OI investigators apparently never reviewed the stainless steel liner plate travelers which were the subject of her concern, neither did the Technical Review Team (TRT).

During the September 1984 hearings on this issue Applicant produced approximately 1300 travelers, including some of those signed off by Ms. Neumeyer and another Quality Control Inspector Fred Evans on March 3, 1983.

A review of the travelers demonstrates that at least as to the fabrication and installation of the stainless steel liner plates there has been a complete quality control breakdown. We find no evidence that the breakdown is limited to the Unit 2 refueling cavity, since the construction and quality procedures control apply to Unit 1, Unit 2, the transfer canal and Refueling Building.

In fact there is increasing evidence that the problems identified below regarding Unit 2 are equally applicable to Unit 1. (See Attachment 1, Interview of Avril Dillingham by the Office of Investigations (OI), August 24, 1983; Attachment 2,

Handwritten memorandum of James Cole and Larry Wilkerson, dated August 13, 1982, which appear as Attachment "H" to Brown & Root's internal investigation of complaints raised by Mr. Dillingham; and also Staff Exhibit 120 regarding a 1979 IE inspection into allegations by former welders of problems with the fuel pool, etc.)

This evidence also indicates that both the NRC and Applicant have been aware of the significant problems regarding the construction, inspection, and documentation of the liner plates in both units since the beginning of work on this project.

Finally, CASE asserts that neither the Applicant's explanation nor their resolution of this problem are credible.

In particular, our preliminary research into the technical merits reveals that the vacuum box test and penetrant test are unacceptable substitutes for insuring that the weld was clean -- that is, free from foreign materials. These welds must last the lifetime of the reactor and the damage caused by impurities in a weld cannot be detected by vacuum box, hydrostatic or penetrant test. The impurities may not manifest themselves for months or years, but when the impurities "eat their way out" of unclean welds it is likely that the impurity will extend to the liner plate also.

The importance of the welds in the refueling cavities cannot be underestimated. On August 24, 1984 IE Bulletin No. 84-03 was issued regarding the refueling cavity water seal. Its purpose was to

(1) notify addressees of an incident in which the refueling cavity water seal failed and rapidly drained the refueling cavity, and (2) request certain actions to assure that fuel uncovering during refueling remains an unlikely event.

Although the incident involved the failure of the refueling cavity water seal it nonetheless draws attention to the dangers which could result from water seal failures.

No fuel was being transferred at the time of this seal failure. If, however, fuel had been in transfer at the time, it could have been partially or completely uncovered with possible high radiation levels, fuel cladding failure and release of radioactivity. In addition, if the fuel transfer tube had been open, the spent fuel pool could have drained to a level which would have uncovered the top of the fuel.

The liner plates are also susceptible to being hit or jostled by the fuel as it moves through the canal, and refueling cavity and into the spent fuel pool. Because of this it is important that the structural integrity of the welds be adequate. Further, the NRC requires that the fuel pool and other cavities be seismically qualified, and therefore dictate that all quality assurance requirements of Appendix B to 10 C.F.R. Part 50 be applied to these structures and components.^{1/}

1. Violations of Federal Regulations

Applicant violated at a minimum of three specific criterion of 10 C.F.R. Appendix B in its failure to adequately control the work, inspections, and documentation relating to the stainless steel liner plates.

^{1/} NRC Regulatory Guide 1.29, Revision 3, September 1978.

10 C.F.R. 50 Appendix B - Criteria V, Criteria VI and
Criteria VIII states:

Criteria V: Instructions, Procedures, and Drawings.
Instructions, procedures, or drawings shall include appropriate quantitative or acceptance criteria for determining that important activities have been satisfactorily accomplished.

Criteria VI: Document Control.
These measures shall assure that documents, including changes, are reviewed for adequacy and approved for release by authorized personnel and are distributed to and used at the location where the prescribed activity is performed.

Criteria VIII: Identification and control of Materials, Parts and Components.
These measures shall assure that identification of the item is maintained by heat number, part number, serial number, or other appropriate means, either on the item or on records traceable to the item as required throughout fabrication, erection, installation, and use of the item.

a. The failure to use the correct S/S Liner traveler testified to by Brandt was a violation of Criteria V, VI, and VIII.

b. The lack of sufficient documentation violates Criteria VI.

c. The lack of QC verification and supporting documentation violates Criteria V, VI, VIII, and includes all the categories.

d. The failure to include all supporting documentation WMRS and WFMLs in the welding package is a violation of Criteria VIII that requires identification and traceability of materials used, and to prevent the use of incorrect or defective material, parts, and components.

e. There is no adequate traceability for any of the welding packages reviewed.

2. Violations of CPSES Procedures

Applicant disregarded the clear instructions contained in its own procedures for the conduct of inspection on the liner plates.

a. From at least 11/29/77 until 1/4/79 Applicant used the wrong traveler form (admitted by Brandt), failed to enter NDE chits on the traveler each day when used and failed to put the chits in the QA vault daily as required by CP-QCI-2.11-1 Rev. 0, 1 & 2, Section 3.1.1 (note) and used a chit for fit-up and cleanliness when no chit for that inspection was authorized by the procedures in effect for that period (see CP-QCI-2.11-1 & 35-1195-CCP-8).

b. No QC procedure published since 1/4/79 authorizes the use of NDE chits to record fit-up and cleanliness inspections having been performed. Procedures require that sign-off for all inspections included on the eight line traveler be on the authorized eight-line traveler (see e.g. QI-QP-11.14-6 (Rev. 1) Section 3.8) although this was not followed in many instances and even today unauthorized and uncontrolled chits are being used to record inspections.

c. With adoption of QI-QAP-11.1-4 in 12/26/79 Applicant had no QC authorized traveler form for stainless steel liner inspections and no chit forms for any inspection

since this procedure deleted any reference to 35-1195-CCP-38 and does not include any traveler or chit forms.

d. As of March 26, 1982 and per QI-QP-11.14-6 (Rev. 0-6), Section 3.5 (in Rev. 0) the issuance and distribution of inspection travelers were to be governed by 35-1195-CCP-38, which contains no instructions on issuance or distribution of travelers (see Section 3.4.2. (p. 5 of 18)). In addition the March 26, 1982 instruction for inspections is woefully inadequate compared to the level of detail and guidance on the conduct of the inspection contained in its predecessors and successors.

e. QI-QP-11.14-6 (Rev. 4 & 5) does not contain any traveler form at all although it is allegedly included as an attachment. See pp. 3 of 6 - 6 of 6. This condition continued from June 17, 1983 until January 10, 1984 (Rev. 6).

f. All forms authorized and/or used for inspection of stainless steel liners and all instructions required a fit up and cleanliness inspection for all welds. The NCR dispositioned the inspection deficiency only as to cleanliness and not as to fit-up. Thus the NCR does not fully address the entire problem.

g. QI-QP-11.14-6 Rev. 1 through 6 requires QC Inspections to be documented on the S/S Inspection Travelers, and that NDE performed for holdpoints not included on the S/S Liner Inspection Travelers is to be documented on NDE sheets.

Prior to this procedure CP-QCI-2.11-1 required QC verification to be documented on the traveler, and the test results for VT, PT and VB test were to be documented on S/S Liner NDE reports.

Supporting documentation showing the results of VT, PT and VB test are missing from over 50 percent of the S/S Liner Travelers. (They are too numerous to list, but see travelers 2A, 221 and 589 for examples.)

3. Specific Categories of Discrepancies in the Stainless Steel Liner Plate Documentation

a. Category One

The five line form (hereafter referred to as Case Form A (CF-A),^{2/} an example is attached as Attachment 3) was signed in numerous different ways. These differing approaches included double signatures, dates different for the signatures, different explanations for what the signatures meant, and single signatures with no explanation of what inspection the single signature denotes. (Examples of four traveler packages are included for ease of explanation only, Nos. 52, 15, 118, 1091)

^{2/} The first form (Case Form A) is a construction form which is designated as Figure 3 first appearing in Interim Change Notice 2 to Construction Procedure 35-1195-CCP-38, Rev. 2, issued in August 1978. Prior to the issuance of the form the QC hold points were designated on Page 5A, Section 3.4.1, "QC Hold Points" in Rev. 2 of the same procedure issued December 8, 1977.

Case Form B is the form designated in Quality Instruction CP-QCI-11-1, Attachment 4A.

Case Form C is the eight-line form first appearing in Interim Change Notice 3 to Construction Procedure 35-1195-CCP-38, Rev. 2, issued in August 1978.

Case Form D is the eight-line form appearing as Attachment 1 to Rev. 0 of QI-QP 11.14-6, March 26, 1982.

Examples of this can be found in 15, 110, 118(incl.), 6, 7, 8, 36, 84, 130, 142.

As a result of this discrepancy it is impossible, on the face of the document, to determine what inspection the signature (or signatures) in line one on Form A is supposed to indicate was performed.

According to CP quality control procedures (QCI 2.11-1), in effect from December 1977 through January 1979 (incorporating the time period of Construction Procedure 35-1195-CCP-38 Rev. 2), the quality control inspectors were supposed to be inspecting the work done on the liner plates and documenting the inspections on Stainless Steel Liner Inspection Traveler NDE Report (Attachment A to QCI 2.11-1, hereinafter referred to as Case Form B, incorporated as Attachment 5).

The QCI required a five step, two point inspection of fit-up and cleanliness as follows:

1. Fitup and Cleanliness Inspection

- a. Verify that the fit-up gap between plates or plates to angle or plates to inserts, etc. is within a minimum of three-sixteenths inch (3/16") and a maximum of three-eighths inch (3/8") or as otherwise specified on fabrication drawings.
- b. Verify that the plates, angles and/or inserts to be welded have been mechanically cleaned a minimum of one inch (1") back from the weld prep and that a minimum of three inches (3") has been degreased.
- c. Verify that the piece being fitted into place is the correct piece and that it conforms to applicable drawings.

* * *

4. Fit-Up and Cleanliness Verification After Concrete Placement
 - a. Verify that the fit-up gap between liner material has been maintained within a minimum of three-sixteenths inch ($3/16"$) and a maximum of three-eighths inch ($3/8"$).
 - b. Verify that the linear material to be seam welded has been mechanically cleaned a minimum of one inch (1") and degreased a minimum of three inches from the weld prep.

* * *

As a result of the discrepancy between the spaces provided on Case Form A and the requirements of the quality control instructions, there is no assurance, based on whatever Case Form A indicates, that the inspections required by the QC instructions were ever performed.

d. Category Two

Welds were signed off as completed without QC verification for Step 5, which requires Seam Weld Fit-up and Cleanliness verification. The traveler (Case Form A) shows that welds were done for Step 5 by indicating "SAT", but no QC verification or signature is shown. These weld travelers indicate the original Fit-up and Cleanliness was done in 1979 and welding resumed in 1983 without verification and preparation required by procedure.

Examples of this can be found in 15, 52, 118 (see also TR. 16,748 and 16-751-752).

This is a violation of Criterion V, VI, and VIII of 10 C.F.R. Appendix B (infra). It is also a violation of CPSES QC procedure 2.11-1, Section 3.1.1.(4) and (5).

c. Category Three

Not all travelers have attached chits which are alleged to verify that the QC inspections were performed, although there are signatures on line one of Form A which indicate QC has performed an inspection on that weld.

Examples of this can be found in 7, 19, 81, 877, 878, 879 (see also TR. 16,748).

Even if one would accept the argument of the Applicant that inspections are verified on construction chits (Figure 3, Rev. 2 (CCP 35-1195-CCP 38, Dec. 8, 1977)), the failure of the inclusion of the chit is a violation of CPSES QC procedure 2.11.1, Section 3.1.1 (note) which required that NDE Reports (although not the same chit used by QC) be forwarded to the vault daily as "status indicators".

d. Category Four

Almost all of the chits reviewed have the explanation of the inspection allegedly performed written on "the chit" (Figure 3, Rev. 2, 35-1195-CCP-38, December 8, 1977) in one of two handwritings.

Examples are incorporated as Attachment 6; tallies for weld numbers 1-175 appear at TR. 16,751.

The "comments" section on the chits occasionally does have what appear to be original comments on them. (See TR. 16,751 for numbered examples)

Ms. Sue Ann Neumeyer testified that the explanation was not on the chit on March 3, 1983. (TR. 59,773) The absence of that

comment at that time would be consistent with the prescribed purpose of that chit in CPSEC 35-1195-CCP-38, Rev. 2, December 8, 1977, Section 3.4.2 which states:

The form shown in Figure 3 shall be used in the above noted hold points as notification to QC to perform inspection.

The use of this form to verify the completion of an inspection is a violation of Criterion V, VI and VIII of 10 C.F.R. Appendix B, as well as a violation of CPSES QCI 2.11.1.

e. Category Five

Inconsistency of the use of Case Form A or Form C to document QC inspections from 1977-1982.

Case Form C, an eight-line traveler issued by craft in Interim Change Notice 3 to 35-1195-CCP-38, Rev. 2 was apparently also used by QC inspectors during the 1978-1979 to 1982 time frame. The use of this form also violated CPSES QC instruction. In numerous cases there are no craft NDT chits attached to these forms at all.

Examples of the use of the eight-line Form C can be found in 2A, 15, 52, 118, 1091(incl.), 205.

As with Category Numbers 1-4 the use of this form violates Criterion V, VI and VIII of 10 C.F.R. Appendix B.

f. Category Six

The documentation provided is not complete. That is, the "traveler packages" do not contain all documentation which is required by regulation and procedure to substantiate that work

was done as prescribed, with correct materials, by certified welders, and inspected by qualified inspectors. There are numerous instances where traveler packages either do not contain weld filler material logs (WFMLs) at all, or penetrant test verification reports, or no weld material records (WMRs).

Examples of those are found in 877, 878, 879 (see also TR. 16,752-753).

This is a violation of Criterion V, VI and VIII of 10 C.F.R. Appendix B.

It also violates both site quality control procedures and the Applicant's explanation.

g. Category Seven

A review of the weld filler material logs indicate some instances where inspections were performed on a certain hold point prior to the issuance of the weld rod which would precede the making of the weld.

Examples of this include 2A, 15, 34, 52(incl.), 61, 62, 110, 118.

This is a violation of both 10 C.F.R. Appendix B and of all relevant CPSES quality control procedures.

h. Category Eight

Signatures are often missing from lines on the travelers (all Forms) which indicate "SAT". The "SAT" seems to indicate the hold point has been complied with but there are no signatures, therefore it is impossible to accept that the

inspection was performed, and totally impossible to determine who performed the inspection or test. The result is that those welds must be considered indeterminate.

Examples of this can be found in 15, 52(incl.), 115, also 126, 137 - Lines 7 and 8 on the Form C/D with "SAT" but no signatures, 62, 81, 205, 225 - Line 5 says SAT for the VT inspection but no signature. (see also Category One)

i. Category Nine

Jimmie Duncan, Jim Cole and Jack Hawford's signatures appear frequently through groups of hundreds of the travelers as the sole QC inspector on this project, as well as the weld rod issues.

It appears incredulous that either Mr. Duncan or Mr. Cole could have actually performed the large measure of inspections they have verified, or that Mr. Hawford could have issued thousands of controlled weld rods in a single day.

Further, if their work was a document review and correction there is no explanation on the face of the documents or in any of the supporting documentation which would suggest a legitimate explanation for the bulk work performed by Mr. Duncan or Mr. Cole.

Further, neither Mr. Cole nor Mr. Duncan's name appears on the ASME QC inspectors list raising the inference that the work, whatever it was, is totally rejectable since the liner plates were designated as safety-related and therefore required at least the original work to be performed by qualified ASME inspectors.

Finally, we understand that Mr. Cole was terminated for falsification of documentation. If that is correct, and we have a good faith belief that it is, all of Mr. Cole's work on these travelers is invalidated.

Traveler numbers 400-499, 500-599, 600-699, 700-799, 800-899 should be reviewed in their entirety.

4. Failure to Properly Disposition NCRs Regarding Discrepancies With the Stainless Steel Liner Plates

Applicant has failed to adequately address the indeterminate status of the affected welds on the stainless steel liner plates, even though the condition has been identified at least four separate times since late March 1983.

a. NCR M83-00795 3/

This NCR identifies that the quality of the forty-eight waterside welds in Refueling Building #2 are indeterminate because the Fitup and Cleanliness inspections cannot be verified as being performed.

The NCR does not identify the discrepancy as a generic problem, which it was. Nor does the disposition require that the review of welds be expanded to determine the root cause of the problem, or include engineering evaluation of the requirements for the potential for rust-through during the lifetime of the weld if the weld could not have passed cleanliness.

3/ Also Brandt Exhibits 18 and 19 , another revision of this NCR dated in August 1984 is attached with Attachment 4. It is unclear why the revised NCR (Brandt 19) was again revised in August 1984.

b. A review of the Stainless Steel Liner Travelers disclosed that an NCR has recently been written against welds that had been signed off years ago as "late entry" using old NDE chits as verification that Step 1 had been completed for the required Fit-up/Cleanliness inspection of the inside (waterside) welds. The NCR stated that the use of these old NDE chits was not sufficient to verify QC inspection, making the condition of the welds indeterminate.

Yet, the disposition of the NCR stated only that the welds are seam welds utilized to provide leak tightness of the liner, and that their acceptability would be based on the outcome of Vacuum Box and Hydrostatic Test. (NCR M83-0079, dated 3/17/84, Attachment 4)

c. Another NCR was written that also applies. This NCR states that Step 5 (inside Fit-up and Cleanliness) of these welds lacks QC verification, again leaving acceptability of the welds indeterminate until they are Vacuum Box Tested. (NCR M83-01000, Attachment 4)

d. NCR M84-00669 Rev. 1

On June 11, 1984, during another document review of the stainless steel liner welds "it was noted that step 7 on Form D had not been performed as required." Yet, the next step was signed as complete. The disposition again was to perform the vacuum box test, although curiously the disposition says to "reestablish" the hold point for that test. Also the two travelers for weld number 1091 reveal several unsettling discrepancies.

First, the traveler (a Form D) does contain signatures of lines one, seven and eight. Those signatures make it appear as if the inspections were performed in the proper chronological order -- that is there appears to be no basis for this NCR. Yet there is also a traveler (Form C) with no signatures or dates which contains the explanation by asterisk that "This traveler originated to satisfy the requirements of NCR m84-00669." Since the NCR wasn't written until June of this year the new attached traveler form must have been included in the package after June 1984, after the original traveler had already been placed in the permanent plant record vault on January 13, 1982. The discrepancy, whatever it was, was not discovered until a June 1984 document review.

e. NCR #200087-200088, NCR #84-200018

As late as August 1984 numerous problems were being discovered on these welds. A document review on Field Weld #52 discovered that (1) welding has resumed in 1984 while the cleanliness requirement was ignored (NCR #200087); (2) that the backing slip had a gap behind it (NCR #200088); and (3) that the backing slip was ground through exposing concrete from 5 on FW53 (NCR #84-200018, Rev.1).

The September 5, 1984 disposition does not address the reason the cleanliness issue was ignored or the extent of the problem, but only requires a PT test for the particular weld in question (#52).

The travelers in this package, Form A reveals no signature on line one, although the WMR log indicates the first fit-up was done during this time period and the chit indicates "First fitup and cleanliness" done September 13, 1978, but includes a comment, without signature of date, that on 7/18/79 cleanliness was verified "where accessable." Form D contains no signatures, and Form C contains two signatures on line one with two dates.

5. Quality Control Breakdown in Construction
Inspection and Documentation

One thing is undeniably clear about this incident. Ms. Sue Ann Neumeyer's fears about not being involved in highly irregular and possibly illegal activity were well grounded. It appears from a review of the documents, the NCRs and their individual resolutions, the internal Brown & Root investigations of welder complaints and the Staff's review of Brown & Root explanations that since the welding and inspection on the liner plates began there have been serious problems with construction, inspection, quality control procedures and documentation.

More significantly, in each case the Applicant either deliberately or negligently failed to recognize the seriousness and extent of the problem. Instead Applicant engaged in, and continues to engage in, "damage control" and cover-up of this quality control breakdown.

The seriousness of the delinquent and callous manner in which this incident has been handled cannot be explained away by Applicant.

CASE believes that it is not mere coincidence that Applicant has refused to provide the remainder of the Neumeyer-Evans travelers. Neumeyer testified she and Evans signed off documentation from the Unit I fuel pool and transfer canal. Obviously Applicant is continuing its attempts to delude the public and the NRC by creating the false impression that the quality control breakdown was limited to only the Unit 2 refueling building. Yet, the testimony of employees since 1977 is to the contrary. In the face of the indeterminate and potentially dangerous situation which would be created by fuel loading in Unit 1 Applicant continues to disregard its responsibilities toward both the public and the Nuclear Regulatory Commission. This attitude is illustrative of this Applicant's gross disrespect for the regulations which could have and should have prevented this situation from ever existing.

Ironically, on the eve of fuel load, Applicant is discovering that the unheeded claims and warnings of both construction workers and quality control inspectors were indeed like canaries in the coal mine.

Respectfully submitted,

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cc: Service List



UNITED STATES

NUCLEAR REGULATORY COMMISSION
OFFICE OF INVESTIGATIONS FIELD OFFICE, REGION IV

Attachment 1

611 RYAN PLAZA DRIVE, SUITE 1000
ARLINGTON, TEXAS 76011

DATE: March 7, 1984

REPORT OF INVESTIGATION

'84 OCT -1 AIO:57

TITLE: COMANCHE PEAK STEAM ELECTRIC STATION:
ALLEGED INTIMIDATION OF QC PERSONNEL

SUPPLEMENTAL NO. DN 50-445/50-446

CASE NUMBER: 4-84-006

CONTROL OFFICE: OI FIELD OFFICE: REGION IV STATUS: CLOSED

PERIOD OF INVESTIGATION: August 3, 1983 - October 27, 1983

REPORTING INVESTIGATOR: H. Brooks Griffin
H. Brooks Griffin, Investigator
Office of Investigations Field Office, Region IV

PARTICIPATING PERSONNEL: Richard K. Herr, Director
Office of Investigations Field Office, Region IV

Wendel E. Frost, Investigator
Office of Investigations Field Office, Region IV

REVIEWED BY: Richard K. Herr
Richard K. Herr, Director
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William J. Ward, Director
Division of Field Operations
Office of Investigations

Roger Fortuna
Roger Fortuna, Deputy Director
Office of Investigations

APPROVED BY: Ben B. Hayes
Ben B. Hayes, Director
Office of Investigations

FUEL BUILDING

AFCO DWG. TRAVELERS

A 100 R	101
78	118
64	132
55	139
47	147
42A	156
25A	172
A 20 R	A 180 R
16A	188
3A	193
15A	300
24A	287
A - 32 R	268
47A	247
63	225
70	223
81	A - 216 R
97	211
A - 98 R	A - 209 R
100	203
200	201
183	216
A 171 R	231
157	239
141	261
124	266
109	298
102	299

255

251

238

A - 232 R

'84 OCT -1 AIC:57

OFFICE OF SECRETARY
ACCOMMODATING & SERVICE
BRANCH

I have examined
the travelers on this
page and found them
all to be complete &
correct & all signatures
to be accurate. No
discrepancy exists.

James Cole 8-13-82
"Jim"

Travelers

199	122
198	120
176	116
173	114
168	110
167	109
165	104
162	101
155	93
142	91
141	90
139	90J
133	89
126	80
123	78
72	70
64	55

53J

53

46

32

23

These ARE UNIT I
Travelers. Drawing WRB10559

ABOVE REFERENCED STAINLESS STEEL LIVER
TRAVELERS WERE REVIEWED FOR UNSIGNED
HOLDPOINTS + ACCURACY OF SIGNATURES.
TO THE BEST OF MY KNOWLEDGE, NO
DISCREPANCIES WERE FOUND.

Sam Wilburn

8-13-81

DOCKETED
USMRC

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FIGURE 3

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DOCKETING & SERVICE

FIGURE 3

B&R STAINLESS STEEL LINER INSPECTION TRAVELER

WELD NO.

PROJECT: CPSES JOB NO.: 35-1195 UNIT PAGE OF

DRAWING NO.

POOL

METAL TYPE

MTL. THICKNESS

PC. TO PC.

☐ PLATE TO PLATE

☐ INSERT TO PLATE

☐ ANGLE TO PLATE

☐ OTHER

WELDER
SYMBOL

WMR NO.

WELD
PROCED.

HOLD
POINT

1. Fit up and cleanliness of above:

RESULTS

INSPECTOR SIGNATURE

DATE

2. V.T. of backing strip tack/fillet welds:

RESULTS

INSPECTOR SIGNATURE

DATE

3. Cleanliness of channel, liner, and backing strip:

RESULTS

INSPECTOR SIGNATURE

DATE

4. Final V.T. of channel fillet weld:

RESULTS

INSPECTOR SIGNATURE

DATE

5. Final V.T. of inside weld:

RESULTS

INSPECTOR SIGNATURE

DATE

Completion of weld inspection.

RESULTS

INSPECTOR SIGNATURE

DATE

ARG	POOL	MIL TYPE	MIL. THICKNESS	CASE Form B
ELD/ITEM NO.	PC. TO PC.	-- Plate to Plate -- Insert to Plate -- Angle to Plate		
WMK NO.				
WELD PROCEDURE				
WELDER SYMBOL				
STAGE OF MANUFACTURE				

DESCRIPTION(s) and INSPECTION REMARK(s)	RESULTS	INSPECTOR SIGNATURE	DATE
1. Fit up of Liner Plate to plate, angle, insert Cleanliness of liner and backing			
2a. V. T. of backing strip tack/fillet welds			
2b. cleanliness of channel, liner and backing strip			
3. Final V. T. on Channel Welds			
4. Liner Fit-up Verification Cleanliness Verification			
5a. Final V. T.			

Acceptance Std.
Gibbs & Hill 2323-SS-18

5b. Penetrant Mfg. Magnaflux	Spotcheck	Batch	Time
Cleaner Mfg. Magnaflux	Spotcheck	Batch	
Developer Mfg. Magnaflux	Spotcheck	Batch	Developing Time
NDE Procedure 300-NB-5250 Attach. 6B	Surface	As Welded	Ground Other
Final P. T.			

5c. Vacuum Box by	Gasket Type	Solution Type
Pretest Cleaning	Pressure	Temperature
Solution Application Method	Post Test Cleaning	NDE Procedure 603
Gauge Serial Number	Pressure Differential Maintained for	Sec. Min.
Final V. B.		

N/A - Not Applicable

Satisfactory _____ Unsatisfactory _____ INSPECTOR _____ DATE _____ CERT. LEVEL _____

FIGURE 3

Browning-Pool, Inc.

B&R Stainless Steel Liner Inspection Traveler				WELD NO.
PROJECT: CPSES JOB NO: 35-1195 UNIT PAGE OF				
Drawing No.	Pool	Metal Type	MEL. THK.	PC. to PC.
<input type="checkbox"/> Plate to Plate	<input type="checkbox"/> Insert to Plate	<input type="checkbox"/> Angle to Plate	<input type="checkbox"/> Other	
Welder Symbol	W.M.R. No.	Weld Proced.	Hold Point	
				1. Fit up and Cleanliness of Above: Results Inspector Signature Date
				2. V.T. of Backing Strip Tack/Fillet Welds: Results Inspector Signature Date
				3. Cleanliness of Channel, Liner, and B. Strip: Results Inspector Signature Date
				4. Final V.T. of Channel Fillet Weld: Results Inspector Signature Date
				5. Inside Fit Up and Cleanliness: Results Inspector Signature Date
				6. V.T. of Fillet Prior to Binding: Results Inspector Signature Date
				7. Final V.T. of Side Weld: Results Inspector Signature Date
				8. Completion of Weld Inspection: (NDE P200) Results Inspector Signature Date



Results Inspector Signature Date

DOCKETED
USNRC

WELD NO.

B&R Stainless Steel Liner Inspection Traveler

PROJECT: CPSES JOB NO: 35-1195 UNIT 2 PAGE 1 OF 3

BB2401A

Drawing No.

React. Liner 2

Pool

Stainless Steel

Metal Type

3/16"

Mtl. Thk.

Top Angle to R H2O

PC. to PC.

☐ Plate to Plate ☐ Insert to Plate ☒ Angle to Plate ☐ Other

Welder Symbol	W.M.R. No.	Weld Proced.	Hold Point
BEN	A162855	88023	1
BDA	A162881	88023	2
BEN	A162911	88023	2
AXK	A162999	88023	2
BCC	D-021	88023	2
BEN	D-027	88023	2
BEN	D-035	88023	2
BCC	D-043	88023	1.5
BEN	D-065	88023	1.5
CCG	B-183	88025	1.5
CCG	B-195	88025	1.5
CCG	B-204	88025	1.5

1. Fit up and Cleanliness of Above:

Reviewed by: D.D. [Signature] Date: 12-30-81
 Results: Don R. [Signature] Inspector Signature Date: 7-12-79

2. V.T. of Backing Strip Tack/Fillet Welds:

Reviewed by: Don R. [Signature] Date: 7-16-79
 Results: Don R. [Signature] Inspector Signature Date: 7-16-79

3. Cleanliness of Channel, Liner, and B. Strip:

Results: NA Inspector Signature: NA Date: NA

4. Final V.T. of Channel Fillet Weld:

Results: NA Inspector Signature: NA Date: NA

5. Inside Fit Up and Cleanliness:

Results: NA Inspector Signature: NA Date: NA

6. V.T. of Fillet Prior to Grinding:

Results: NA Inspector Signature: NA Date: NA

7. Final V.T. of Inside Weld:

Results: SAT Inspector Signature: [Signature] Date: [Date]

8. Completion of Weld Inspection: (

Results: [Signature] Inspector Signature: [Signature]

B&R STAINLESS STEEL LINER INSPECTION TRAVELER

PROJECT: CPSES JOB NO.: 35-1195 UNIT #2 PAGE 7 OF 3

2401A Reactor liner #2 stainless steel 3/16 H2O to Angle
 Drawing No. POOL METAL TYPE MIN. THK. PC. to PC.
☐ PLATE TO PLATE ☐ INSERT TO PLATE ☒ ~~ANGLE TO PLATE~~ ☐ OTHER

[illegible]

- DATE _____

- DATE _____

- DATE _____

- DATE _____

- DATE _____

Completion of weld inspection:

DATE _____

CLIPPING verified where ACCESSABLE
MAY 7-18-74

QI-QP-11.14-6 REV.

GF

TOF ANGLE to H2O
PC. to PC.

Other

1. Fit up and Cleanliness of Above

Results	Inspector Signature	Date
---------	---------------------	------

2. V.T. of Backing Strip Tack/Fillet Welds:

Results	Inspector Signature	Date
---------	---------------------	------

3. Cleanliness of Channel, Liner, and B. Strip:

Results	Inspector Signature	Date
---------	---------------------	------

4. Final V.T. of Channel Fillet Weld:

Results	Inspector Signature	Date
---------	---------------------	------

5. Seam Weld Fit Up and Cleanliness:

Results	Inspector Signature	Date
---------	---------------------	------

6. Final V.T. of Welds for Surface Preps.

Results	Inspector Signature	Date
---------	---------------------	------

7. Final P.T. and Vacuum Box of Seams
(See Weld Inspection Sheet)

Results	Inspector Signature	Date
---------	---------------------	------

8. Completion of Weld Inspection: QI-QP-11.14-6

Inspector Signature Date

52
WELD NO.

B&R Stainless Steel Liner Inspection Traveler

Weld Inspection Sheet

Page ____ of ____

Acceptance Std.
Gibbs & Hill 2323-SS-18

7a. Penetrant Mfg. Magnaflux-Spotcheck _____

Cleaner Mfg. Magnaflux-Spotcheck _____

Developer Mfg. Magnaflux-Spotcheck _____

NDE Procedure

Final P.T.

Level II

RESULTS

INSPECTOR SIGN.

DATE

7b. Vacuum Box

GASKET TYPE

SOLUTION TYPE

_____ by _____

Pretest Cleaning _____ Pressure _____ Temperature _____ NDE Procedure _____

Solution Application Method _____ Post Test Cleaning _____

Gauge Serial Number _____ Pressure Differential
Maintained for _____ Sec. _____ Min.

Final V.B. _____

N/A - Not Applicable

Satisfactory _____ Unsatisfactory _____
Level II Inspector _____ Date _____

FOR INFORMATION ONLY

NON DESTRUCTIVE TEST INSPECTION R EST		FOREMAN <u>Faulstich</u>		TIME/DATE <u>35 12/30/81</u>	
WELDOR: <u>2/12</u>					
DRAWING # <u>BB 2401A</u>					
INSP. REQ.	CLEAN VISUAL	<input checked="" type="checkbox"/>	FIT-UP L.P.		FIELD WELD # <u>52</u> V.B.
	FINAL				WFML :
COMMENTS:					
INSPECTOR : <u>(Signature)</u> ACCEPT: <input checked="" type="checkbox"/> DATE: <u>12/30/81</u>					

TOP INFORMATION ONLY

NON DESI. JIVE TEST
INSPECTION REQUEST

FOREMAN

TIME

DATE 9/1-1/12

WELDER: Dee Below

DRAWING # 2401A G.L. P#2

INSP.

CLEAN ☐

FIT-UP ☐

FIELD WELD JT. # 152

REQ.

VISUAL ☐

L.P. ☐

V.B. ☐

FINAL ☐

COMMENTS:

1 up &

NR:

A017182

MR

and of

NR:

A017210

ARD

16 angle

INSPECTOR: LORR. Vort

ACCEPT: ☒

DATE: 7-13-71

NON DESTRUCTIVE TEST
INSPECTION REQUEST

FOREMAN

TIME DATE
9/15/78

WELDER: Don Bulow #2

DRAWING: 2401A SS P#2

INSF. REQ.	CLEAN <input type="checkbox"/>	FIT-UP <input type="checkbox"/>	FIELD WELD JT. <input type="checkbox"/>	52
	VISUAL <input type="checkbox"/>	L.P. <input type="checkbox"/>	V.B.	
	FINAL <input type="checkbox"/>			


WNR: A017182 APR
A017210 ARD

COMMENTS:
Just fit up &
first time of
condemned
Plate to angle

INSPECTOR: Don Bulow

ACCEPT: ☒

DATE: 9-13-78

BCP OS 

FW # 52

~~SECRET~~ B-183

CC Serial No.

Drawing No.

1412 5.

[illegible]

FOR INFORMATION ONLY

COMANCHE PEAK STEAM ELECTRIC STATION

INSPECTION REPORT

SHEET 1 OF 1
NO. 20021079

ITEM DESCRIPTION 1. <i>Area cleaned and backing strip located in proper location</i>		IDENTIFICATION NO. 2. <i>FD52/BB2401A</i>		SYSTEM, STRUCTURE DESIGNATION 3. <i>11</i>	
SPEC. NO. 4. <i>CS-18</i>		REV. 5. <i>0</i>		REF. Q.C. DOC. & REV. & CHANGE NO. 6. <i>RT-OP-11.4-6/1</i>	
MEASURE OR TEST EQUIP. IDENT. NO. 7. <i>N/A</i>					
<input type="checkbox"/> IN PROCESS INSPECTION		<input type="checkbox"/> PRE INSTALLATION VERIFICATION		<input type="checkbox"/> INSTALLATION INSPECTION	
<input checked="" type="checkbox"/> FINAL INSPECTION		<input type="checkbox"/> PRE-TEST INSPECTION			
INSR. RESULTS					
<input checked="" type="checkbox"/> INSPECTION COMPLETED, ALL APPLICABLE ITEMS SATISFACTORY					
<input type="checkbox"/> INSPECTION COMPLETED, UNSATISFACTORY ITEMS LISTED BELOW					
QC INSPECTOR <i>Lyndon</i> DATE <i>8/14/84</i>					
10					
ITEM NO. 11		INSPECTION ATTRIBUTES		12	
				13	
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REMARKS (DWGS, SPECS, ETC.)

FOR INFORMATION

RELATED NCR NO. *194-200018* 15

L.R. CLOSED ☐ 16

DATE *8/14/84* 17

SIGNATURE *Lyndon* 18

QC INSPECTOR 19

81/01 8/84

UNIT	STRUCTURE SYSTEM	ITEM/COMPONENT	TAG/ID NUMBER	LOCATION OR ELEVATION	RIR NO
2	MANCHE PEAK	FW-52	BB2401H	Ex. RD #2 FC19	NA

NONCONFORMING CONDITION

FW 52 had the Fit up/Cleanliness (Block #1) signed off SAT on both 7/12/79 and 12/30/81. ON 8/17/84 welding resumed on this weld AND the Cleanliness was ignored. Procedure Requires 4" ON EACH SIDE of Weld to be Degreased & Cleaned AND this was NOT DONE Prior to Welding

(SEE ATTACHED SKETCH FOR AREAS WELDED ON 8/17/84)

1 HOLD TAG APPLIED

REFERENCE DOCUMENT: QI-QP 11.14-6 REV 6 PARA 3.42

REPORTED BY: Lou Tessier Bill Wright L.C. Randall DATE: 8/21/84

QE REVIEW/APPROVAL:	<u>D.T. Wright</u>	DATE:	<u>8/23/84</u>
ACTION ADDRESSEE	<u>Bill Wright</u>	DEPARTMENT	

DISPOSITION: REWORK _____ REPAIR _____ USE AS IS ☒ SCRAP _____

O.C. is to perform a P.T. examination of the affected weld area and if sat. the weld may be used as is. The cognizant craftsman shall also be instructed to the requirements of holdpoints and document.

ENG. REVIEW/APPROVAL	<u>B. Wright</u>	DATE:	<u>9/15/84</u>
QE REVIEW APPROVAL:	<u>D.T. Wright</u>	DATE:	<u>9/15/84</u>
DISPOSITION VERIFICATION & CLOSURE:		DATE:	<u>1/1</u>

COMMENTS:

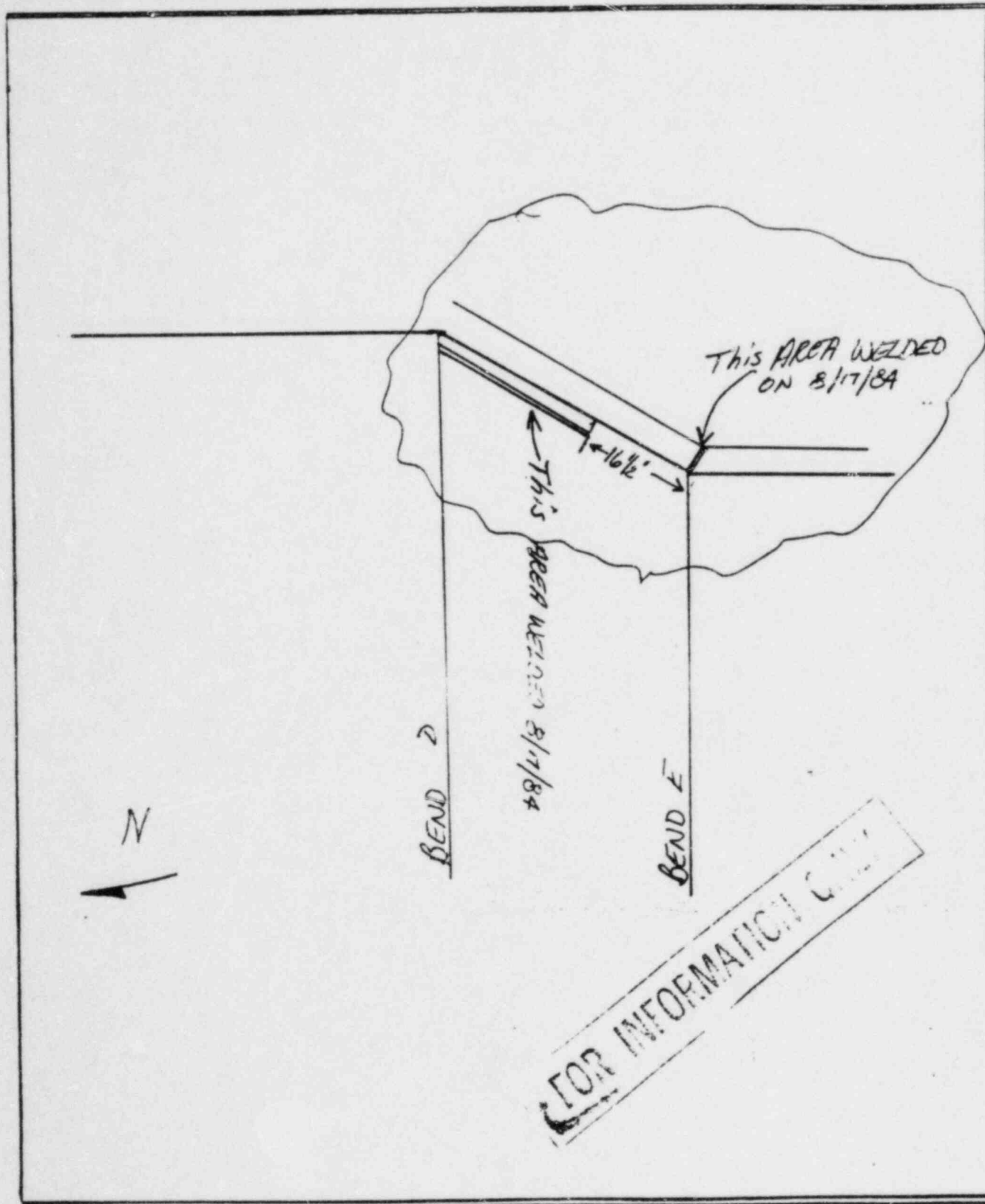
COMANCHE PEAK STEAM ELECTRIC STATION
GENERATING CO.

COMANCHE PEAK STEAM ELECTRIC STATION

NONCONFORMANCE REPORT (NCR)

(Continuation Sheet)

Sheet 2 of 2



UNIT	STRUCTURE/SYSTEM	ITEM/COMPONENT	TAG/ID NUMBER	LOCATION OR ELEVATION	REF. NO.
2	Reactor Vessel	W-52	BB2401A	6' 10" - 7' 0"	

NONCONFORMING CONDITION

During A Visual Insp. I found A $3\frac{1}{4} \times \frac{1}{8}$ " gap Between the backing Strip behind FW-52 and the backing Strip on the $3 \times 3 \times \frac{1}{4}$ " Angle ABOVE (SAME FW) this weld.

(SEE ATTACHED SKETCH FOR DETAILS)

1 Hold TAG APPLIED

CCP-38

REFERENCE DOCUMENT: Q1 QP 11.14-6 REV 6 PARA 34.2

REPORTED BY: Lou Tessier *[Signature]* RBH *[Signature]* C.C. *[Signature]* DATE: 8/22/84

QE REVIEW/APPROVAL: D.T. *[Signature]* DATE: 8/23/84
ACTION ADDRESSEE: Bill Wright DEPARTMENT

DISPOSITION: REWORK _____ REPAIR _____ USE AS IS ☒ SCRAP _____

- There is no requirement that backing strips be continuous therefore, if there is no evidence of discontinuity the weld may be used as is.

ENG. REVIEW/APPROVAL: B. Wright DATE: 9/15/84

QE REVIEW APPROVAL: D.T. *[Signature]* DATE: 9/15/84

DISPOSITION VERIFICATION & CLOSURE: DATE: 1/1

COMMENTS:

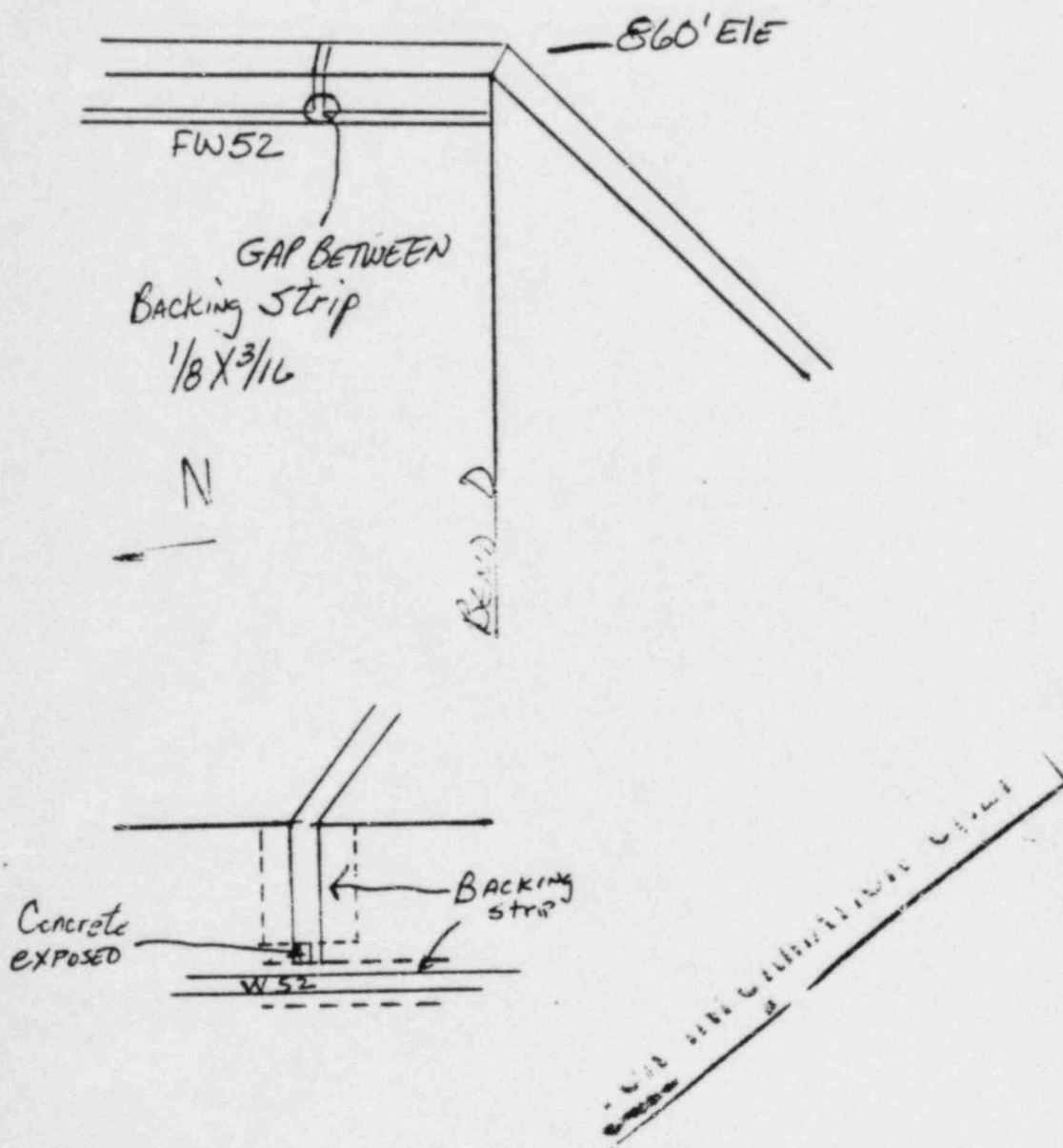
FOR INFORMATION ONLY

REPORTING PERSONNEL

QE

ACTION ADDRESSEE

QE



STRUCTURE SYSTEM	ITEM COMPONENT	TAG ID NUMBER	LOCATION OR ELEVATION	RIP NO
2 Reactor Ch. ty	Weld 52 S.S. Liner	EGC RB 2	NA	

NONCONFORMING CONDITION

The Backing Strip was ground thru exposing Concrete for APPROX. 5" on W#52

REFERENCE DOCUMENT: QI-QP11.14-6 REV 6 PARA 3.1.4.5

REPORTED BY: L TESSIER DATE: 8/14/84

QE REVIEW/APPROVAL: [Signature] DATE: 8/14/84

ACTION ADDRESSEE DEPARTMENT

DISPOSITION: REWORK _____ REPAIR _____ USE AS IS ☒ SCRAP _____

NOT A NONCONFORMING CONDITION
CLEANING OF WELD GROOVE AREA BY CHIPPING AND BRUSHING.
BACKING STRIP WAS FOUND TO BE IN PLACE AS REQUIRED.

NOTE: THE EXPOSED CONCRETE AS REFERENCED
ABOVE WAS IN THE GROOVE ON TOP OF THE
BACKING STRIP.

ENG. REVIEW/APPROVAL DATE: 1/1

QE REVIEW APPROVAL: "VOID" Michael D. Warner DATE: 8/15/84

DISPOSITION VERIFICATION & CLOSURE: DATE: 1/1

COMMENTS:
RI ISSUED TO VOID NCR. SEE ATTACHED I.R. # 20021078
20021079

UNIT	STRUCTURE/SYSTEM	ITEM COMPONENT	TAG ID NUMBER	LOCATION OR ELEVATION	REF NO
2	S.S. Liner	Weld #52	Reactor 4th Fl. ABC FC19		
NONCONFORMING CONDITION					
The backing strip is removed by grinding, exposing the concrete for approx. 5" Long on weld #52.					
1) Hold TAG Applied					
REFERENCE DOCUMENT: <u>QI-QP11.14-6</u> REV <u>6</u> PARA <u>3.1.4.5</u>					
REPORTED BY: <u>L. Tessier / Jimmie Duncan / Bill Cooper</u>					DATE: <u>7/18/84</u>
QE REVIEW/APPROVAL: <u>D.T. Ott</u>					DATE: <u>7/19/84</u>
ACTION ADDRESSEE: <u>Bill Wright Hooton / TRIESTE</u>					DEPARTMENT: <u>Engineering</u>
DISPOSITION: REWORK <input checked="" type="checkbox"/> REPAIR <input type="checkbox"/> USE AS IS <input type="checkbox"/> SCRAP <input type="checkbox"/>					
Install new backing strip in the affected areas per sketches & procedure given on the attached sheets.					
Ray V. Deliaferre 8-2-84					
ENG REVIEW/APPROVAL: <u>James Halburn</u>					DATE: <u>8/2/84</u>
QE REVIEW APPROVAL: <u>Michael D. Wain</u>					DATE: <u>8/3/84</u>
DISPOSITION VERIFICATION & CLOSURE:					DATE: <u>1/1</u>
COMMENTS:					

REPORTING PERSONNEL

QE

ACTION ADDRESSEE

QE

FOR INFORMATION ONLY



Brown & Root, Inc.

INSPECTION REPORT

PAGE 1 OF 1

PLANT CODE	SYSTEM CODE	COMPONENT CODE
1-4	5-10	11-16

TAG/SPIN/IDENT NO						DRAWING SPECIFICATION NO		SERIAL NO	
A	B	C	D	E	F	G	(Units)	H	(Units)
							17-55		

PURCHASE ORDER NUMBER	VEND CODE
56-89	70-73

MRR NUMBER	R R NUMBER	VENDOR'S HEAT/LOT/BATCH NO.	COUNT	UNITS	PURCHS OR NO.	RLS/HOLD NO.	CODE	INPUT DATE
74-75	80-81	86-85		QUANTITY			STATUS	
			98-105		106-111	112-121		122-127

PURPOSE AND TYPE OF INSPECTION/SURVEILLANCE: *To verify WMR and WFMLP issued to field weld #52 - (BB 2401A).*

RESULTS OF INSPECTION / SURVEILLANCE: *After replacement of top angle, the packing strip was welded completely to prevent concrete from getting into seam. The following WMR and WFMLP were used for this purpose:*

	A162911	BEN	
WMR -	A162999	AXK	✓
WFMLP -	D-021	BCC	✓
	D-027	BEN	✓
	D-035	BEN	✓
	D-043	BCC	✓
	D-065	BEN	✓
WMR	A162760	AXK	✓
WMR	A162999	AXK	✓

NCR NO. *N/A*

Robert F. Kanne
QC ENGINEER/INSPECTOR

DATE

6/24/82 RFK
6-24-82

TEXAS UTILITIES SERVICES INC.
COMANCHE PEAK S.E.S.

Agent For

DALLAS POWER & LIGHT COMPANY
TEXAS ELECTRIC SERVICE COMPANY
TEXAS POWER & LIGHT COMPANY

Filing Code

Sheet No

Of

G & H Job No

Cust. Appr. No

Subject

DISPOSITION [CONT'D]

Ref. Dwg./Spec. No

REWORK PROCEDURE

1. THIS PROCEDURE IS TO DESCRIBE THE ACTIVITIES NECESSARY TO REPLACE THE BACKING STRIP WHICH WAS REMOVED BY GRINDING.
2. THE BACKING STRIP(S) INSTALLED PER THIS PROCEDURE MAY BUTT UP AGAINST EXISTING BACKING STRIP(S) THAT THE Q.C. INSPECTOR HAS DEEMED ACCEPTABLE. IT IS NOT NECESSARY TO WELD THE 2 SECTIONS OF BACKING STRIP TOGETHER, HOWEVER CRAFT MAY TACKWELD THE 2 SECTIONS TOGETHER TO EXPEDITE INSTALLATION.
3. REPLACEMENT BACKING BAR INSTALLED PER THIS PROCEDURE IS TO BE 1/8" MIN. THICKNESS X LENGTH REQ'D. IT IS TO BE STAINLESS STEEL.
4. IN THE AREAS DOCUMENTED BY PG. 1 OF THIS NCR THAT NEED A BACKING BAR, THE CRAFT IS TO REMOVE EXISTING CONCRETE AND MISC. WELD FILLER MAT'L IN EXACTLY THE SAME SHAPE AS THE NEW BACKING BAR. GRINDING, CHIPPING, AND DRILLING ARE ALL ACCEPTABLE MEANS OF REMOVING EXISTING CONCRETE AND MISC. WELD FILLER MAT'L.
5. THE FINAL CONFIGURATION OF BACKING BAR RELATIVE TO THE ANGLE ARE TO BE AS SHOWN ON PG 2. VOIDS DEEPER THAN 1/16" ARE NOT PERMITTED UNDER THE BACKING BAR.
6. PG. 2 SHOWS ONLY THE CONFIGURATION OF NEW BACKING BAR. SUITABLE EXISTING BACKING BARS EXISTS IN SOME AREAS AND WILL NOT BE AS PICTURED ON PAGE 2. THIS IS ACCEPTABLE.
7. NEW BACKING STRIPS MAY BE TACKWELDED TO THE ANGLE TO EXPEDITE CONSTRUCTION.

S-I-S-T

CALC BY TALIAFERRO

CHK & APPR BY

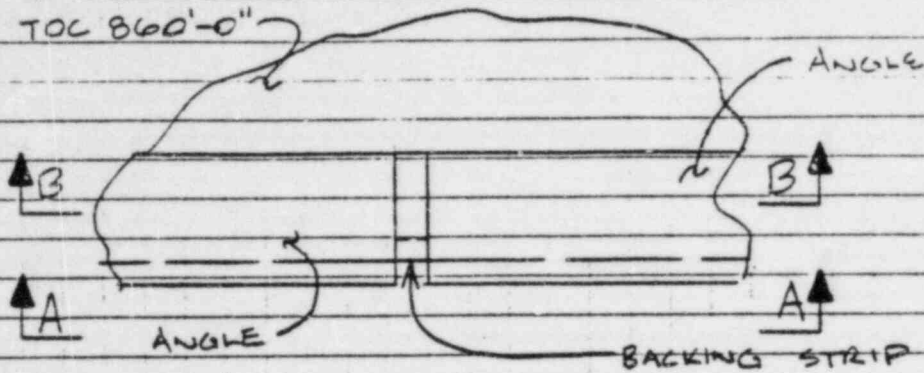
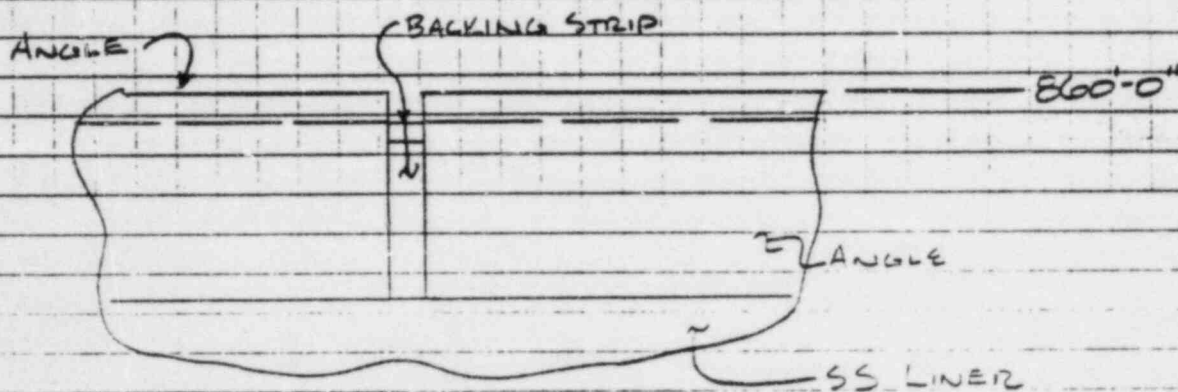
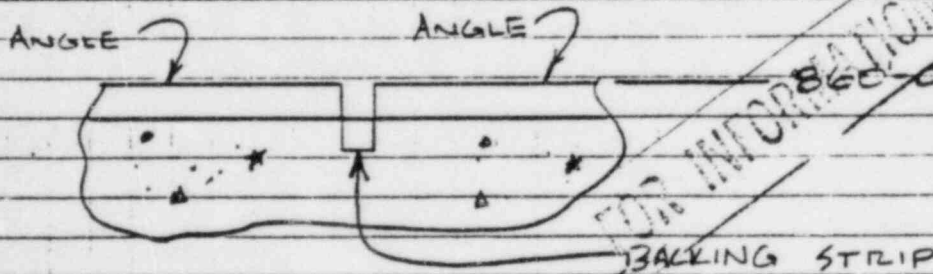
Subject DISPOSITION [CONT'D]

 ADJUST FOR
 DALLAS POWER & LIGHT COMPANY
 TEXAS ELECTRIC SERVICE COMPANY
 TEXAS POWER & LIGHT COMPANY

Sheet No. _____ Of _____

D & H Job No. _____

Ref. Dwg. Spec. No. _____

PLANSECT A-ASECT B-B

FOR INFORMATION ONLY

B&R Stainless Steel Liner Inspection Traveler

01-OP-11.14-6 REV.

PROJECT: CPSES

JOB NO: 35-1195

UNIT 2

PAGE _____ OF _____

OF _____

BB-2401-A
Drawing No.

Reactor Liner #2
Pool

STAINLESS STEEL
Metal Type

$$\frac{3}{712}$$

Mtl. Thick.

RB26 to RB27
PC. to PC.

PC. to PC.

☒

Plate to Plate



Insert to Plate

Angle to Plate

Other

[illegible]

1. Fit up and Cleanliness of Above

Results	Inspector Signature	Date
---------	---------------------	------

- ## 2. V.T. of Backing Strip Tack/Fillet Welds:

Results	Inspector Signature	Date
---------	---------------------	------

3. Cleanliness of Channel, Liner, and B. Strip:

Results	Inspector Signature	Date
---------	---------------------	------

4. Final V.T. of Channel Fillet Weld:

Results	Inspector Signature	Date
---------	---------------------	------

5. Seam Weld Fit Up and Cleanliness:

Results	Inspector Signature	Date
---------	---------------------	------

- #### 6. Final V.T. of Welds for Surface Preps.

Results	Inspector Signature	Date
---------	---------------------	------

7. Final P.T. and Vacuum Box of Seams
(See Weld Inspection Sheet)

Results	Inspector Signature	Date
---------	---------------------	------

8. Completion of Weld Inspection: QI-QP-11.14-6

Inspector Signature Date

FOR INFORMATION ONLY

15
WELD NO.

B&R Stainless Steel Liner Inspection Traveler

Weld Inspection Sheet

Page ____ of ____

Acceptance Std.
Gibbs & Hill 2323-SS-18

7a. Penetrant Mfg. Magnaflux-Spotcheck _____
Cleaner Mfg. Magnaflux-Spotcheck _____
Developer Mfg. Magnaflux-Spotcheck _____

NDE Procedure

Final P.T. Level II
RESULTS INSPECTOR SIGN. DATE

7b. Vacuum Box GASKET TYPE SOLUTION TYPE

_____ by _____

Pretest Cleaning _____ Pressure _____ Temperature _____ NDE Procedure _____

Solution Application Method _____ Post test Cleaning _____

Gauge Serial Number _____ Pressure Differential
Maintained for _____ Sec. _____ Min.

Final V.B. _____

N/A - Not Applicable

Satisfactory _____ Unsatisfactory _____
Level II Inspector _____ Date _____

FOR INFORMATION ONLY

WILLIAMS DEPT.

Drawing No. 135 240/A

WELD FILLER MATERIAL LOG Weld No.

Weld No. N/A

D-1240

[illegible]

FOR INFORMATION ONLY

WILLIAM H. DEPT.

Drawing No. BB 2401.4

D-1224

WELD FILLER MATERIAL LOG

Weld No. 1115

[illegible]

FOR INFORMATION ONLY

NON DESTRUCTIVE TEST
INSPECTION REQUEST

FORMAN

TIME

DATE

WELDER:

WESLEY T. ...

DRAWING #

2401 H

K 712

DISP.
REQ.

CLEAN ☐

FIT-UP ☐

FIELD WELD JT. #

15

VISUAL ☐

L.P. ☐

V.B. ☐

FINAL ☐

COMMENTS:

First Fit up!

indivisual
Plate to Plate

WMR:

4007107 AFG

INSPECTOR:

Phil Lane

ACCEPT: ☒

DATE:

8-2-14

FOR INFORMATION ONLY

NON DESTRUCTIVE TEST INSPECTION REQUEST		FOREMAN	TIME	DATE
				8/31/78
WELDER: <u>McMaster AFG</u>				
DRAWING # <u>2401 A BBO</u>				
<u>RA2</u>				
INSP. REQ.	CLEAN <input type="checkbox"/>	FIT-UP <input type="checkbox"/>	FIELD WELD JT. # <u>15</u>	
	VISUAL <input type="checkbox"/>	L.P. <input type="checkbox"/>	V.B. _____	
	FINAL <input type="checkbox"/>			
COMMENTS: <u>First Fit up &</u>				
<u>Cleanliness of</u>				
<u>Plate to Plate</u>				
WWR: <u>A008107 AFG</u>				
INSPECTOR: <u>Phil Davis</u> ACCEPT: <input checked="" type="checkbox"/> DATE: <u>8-31-78</u>				

118

WELD NO.

PROJECT: CPSES JOB NO.: 35-1195 UNIT *React. 2* PAGE / OF *2*

BB 2401A

Drawing No.

Reaction Times #2

POOL

Stainless Steel

METAL TYPE

3/16

MTL. THK.

~~6.4.11 RAGT to RE 23~~

PC. to PC.

PLATE TO PLATE ☐ INSERT TO PLATE ☒ ANGLE TO PLATE ☒ OTHER R D25 TO LA39

[illegible]

1. Fit up and cleanliness of above:

SAT.
RESULTS

N. D. Shrivastava
INSPECTOR SIGNATURE

2-3-82
DATE

2. V.T. of backing strip tack/fillet welds:

SAT
RESULTS

James Wilhelm
INSPECTOR SIGNATURE

8-11-78
DATE

3. Cleanliness of channel, liner, and backing strip:

SAI
RESULTS

James Williams
INSPECTOR SIGNATURE

8-11-78
DATE

4. Final V.T. of channel fillet weld:

SAT
RESULTS

Inspector Signature

8-11-78
DATE

5. Final V.T. of inside weld:

SAT.
RESULTS

INSPECTOR SIGNATURE

DATE _____

Completion of weld inspection:

RESULTS

INSPECTOR SIGNATURE

DATE _____

SCP QS

FILE B- 398

20 Jan 1964. N/A

Drawing No. BB 2401A

22 JUL 1964 14:00 MP-110

6-20-04

[illegible]

FOR INFORMATION ONLY

NO DESTRUCTIVE ST
IN ACTION REQUEST

FOREMAN

8-10-78

WELDER: OWENS ARN

DRAWING # B.B. 2401 A

Reactor #2

INSP. REQ.	CLEAN <input type="checkbox"/>	FIT-UP <input type="checkbox"/>	FIELD WELD JT. # <u>118</u>
	VISUAL <input type="checkbox"/>	L.P.C. <input type="checkbox"/>	V.B. <input type="checkbox"/>
	FINAL <input type="checkbox"/>		

COMMENTS:

Fit up &
Cleanliness

WNR: A007517 ARN

INSPECTOR: S.M.M. Co. ACCEPT: ☒ DATE: 8-10-78

NON DESTRUCTIVE TEST
INSPECTION REQUEST

FOREMAN

Franklin

TIME/DATE

1-22-82

WELDOR:

N/A

DRAWING #

BB2401A

INSP.
REQ.

CLEAN
VISUAL
FINAL

☒

FIT-UP
L.P.

FIELD WELD # *118*
V.B.

WFML :

COMMENTS:

Copy

INSPECTOR :

[Signature]

ACCEPT:

☒

DATE:

1-22-82

FOR INFORMATION ONLY

NON DESTRUCTIVE TEST
INSPECTION REPORT

FOREMAN

TIME/DATE

Fewles

7-22-82

WELDOR:

N/A

DRAWING #

BB2461A

INSP.
REQ.

CLEAN
VISUAL
FINAL

☒

FIT-UP
L.P.

FIELD WELD #
V.B.

1/8

COMMENTS:

WFML:

INSPECTOR:

[Signature]

ACCEPT:

[Signature]

DATE:

7-22-82

FOR INFORMATION ONLY

PROJECT: CPSES JOB NO: 35-1195 UNIT 2 PAGE OF

Other A37 to D25

Inspector Signature Date

B&R Stainless Steel Liner Inspection Traveler

Weld Inspection Sheet

Page ____ of ____

Acceptance Std.
Gibbs & Hill 2323-SS-18

7a. Penetrant Mfg. Magnaflux-Spotcheck _____

Cleaner Mfg. Magnaflux-Spotcheck _____

Developer Mfg. Magnaflux-Spotcheck _____

NDE Procedure

Final P.T.

Level II

RESULTS

INSPECTOR SIGN.

DATE

7b. Vacuum Box

GASKET TYPE

SOLUTION TYPE

_____ by _____

Pretest Cleaning _____ Pressure _____ Temperature _____ NDE Procedure _____

Solution Application Method _____ Post Test Cleaning _____

Gauge Serial Number _____ Pressure Differential
Maintained for _____ Sec. _____ Min.

Final V.B. _____

N/A - Not Applicable

Satisfactory _____ Unsatisfactory _____
Level II
Inspector _____ Date _____

FOR INFORMATION ONLY

WELD NO.

1091

B&R Stainless Steel Liner Inspection Traveler

Weld Inspection Sheet

Page ____ of ____

Acceptance Std.
Gibbs & Hill 2323-SS-18

7a. Penetrant Mfg. Magnaflux-Spotcheck _____

Cleaner Mfg. Magnaflux-Spotcheck _____

Developer Mfg. Magnaflux-Spotcheck _____

NDE Procedure

Final P.T.

Level II

RESULTS

INSPECTOR SIGN.

DATE

7b. Vacuum Box

GASKET TYPE

SOLUTION TYPE

_____ by _____

Pretest Cleaning _____ Pressure _____ Temperature _____ NDE Procedure _____

Solution Application Method _____ Post Test Cleaning _____

Gauge Serial Number _____ Pressure Differential
Maintained for _____ Sec. _____ Min.

Final V.B. _____

N/A - Not Applicable

Satisfactory _____ Unsatisfactory _____
Level II
Inspector _____ Date _____

WELD NO.

1091

QI-QP-11.14-6 REV.

PROJECT: CPSES JOB NO: 35-1195 UNIT 2 PAGE OF

BB-2401-A	Reactor Liner#2	STAINLESS STEEL	1/4" TO 1/4"	E4 TO G4
Drawing No.	Pool	Metal Type	Mtl. Thck.	PC. to PC.

☐ Plate to Plate ☐ Insert to Plate ☐ Angle to Plate Other ANGLE TO ANGLE

[illegible]

- | Results | Inspector Signature | Date |
|---------|---------------------|------|
|---------|---------------------|------|

- ## 2. V.T. of Backing Strip Tack/Fillet Welds:

Results	Inspector Signature	Date
---------	---------------------	------

- ### 3. Cleanliness of Channel, Liner, and B. Strip:

Results	Inspector Signature	Date
---------	---------------------	------

4. Final V.T. of Channel Fillet Weld:

Results	Inspector Signature	Date
---------	---------------------	------

5. Seam Weld Fit Up and Cleanliness:

Results	Inspector Signature	Date
---------	---------------------	------

- ## 6. Final V.T. of Welds for Surface Preps.

Results	Inspector Signature	Date
---------	---------------------	------

7. Final P.T. and Vacuum Box of Seams
(See Weld Inspection Sheet)

Results	Inspector Signature	Date
---------	---------------------	------

8. Completion of Weld Inspection: QI-QP-11.14-6

Inspector Signature Date

* THIS TRAVELER ORIGINATED TO
 GETISEN REQUIREMENTS OF A P.R. MAIL-00669

WORK INFORMATION ONLY

PEAK STEAM ELECTRIC STATION
PERFORMANCE REPORT (NCR)

NCR No.
M-84-00669

UNIT	STRUCTURE/SYSTEM	ITEM/COMPONENT	TAG/ID NUMBER	LOCATION OR ELEVATION	RIR NO.
2	Reactor Cavity	Welds SS. Liner	BB-2401 A	860' RB#2 A.19	N/A

NONCONFORMING CONDITION

REPORTING PERSONNEL

During Document Review of the welds on splices on angles on the lower section of Liner it was noted that the Vacuum Box Space had been N/A'ed AND the Completion of Weld Inspection had been signed off as complete. A portion of these welds are pressure boundaries AND ARE Required to have Vacuum Box Performed. The following welds ARE Affected by this Document: W-1087, 1088, 1089, 1090, 1091, 1092, 1144 and 1145
1 Hold Tag APPLIED

REFERENCE DOCUMENT: QI-OP 11.14-6 REV 6 PARA 3.4.4

REPORTED BY: Louis Tessier DATE: 2/27/84

QE

QE REVIEW/ APPROVAL: [Signature] DATE: 2/27/84
ACTION ADDRESSEE: Kissinger DEPARTMENT

ACTION ADDRESSEE

DISPOSITION: REWORK XXX REPAIR _____ USE AS IS _____ SCRAP _____

The holdpoint for performing vacuum box inspection shall be reinstated and the vacuum box shall be performed by QC.

ENG. REVIEW/ APPROVAL: D. Patankar / B. Wright DATE: 4/18/84

QE REVIEW APPROVAL: D. T. Oth DATE: 4/19/84

DISPOSITION VERIFICATION & CLOSURE: DATE: 1/1

COMMENTS: RA Issued to delete w#1145

FOR INFORMATION ONLY

GENERATING CO.

PEAK STEAM ELECTRIC STATION
PERFORMANCE REPORT (NCR)

NCR No.

1184-00669 Δ

UNIT	STRUCTURE/SYSTEM	ITEM/COMPONENT	TAG/ID NUMBER	LOCATION OR ELEVATION	RIR NO.
2	Reactor Cavity	Welds S.S. Liner	BB2401A	860' RB2 AC 19	N/A

NONCONFORMING CONDITION

During Document Review of traveler on S.S. Liner welds, it was noted that Step 7 had not been Performed as required AND Step 8 was signed as Complete. These welds are pressure boundaries and require Vacuum Box Testing.

The following welds are affected by this NCR: W-1057, 1088, 1089, 1090, 1091, 1092 and 1144. The traveler # & Weld # ARE the same.

one hold tag Applied

REFERENCE DOCUMENT:

QI-OP 1114-6

REV

6

PARA

3.4.4

REPORTED BY:

Lou Tessier / JIMMIE DUNCAN

DATE:

6/11/84

QE REVIEW/APPROVAL:

Bill Peterson

DATE:

6/11/84

ACTION ADDRESSEE

DEPARTMENT

DISPOSITION:

REWORK



REPAIR

USE AS IS

SCRAP

THE HOLDPOINT FOR PERFORMING VACUUM BOX TEST SHALL BE RE-ESTABLISHED AND THE VACUUM BOX TEST PERFORMED BY QC.

ENG. REVIEW/APPROVAL

Kary Maedgen

DATE:

8/3/84

QE REVIEW APPROVAL:

D.T. Oxt

DATE:

8/7/84

DISPOSITION VERIFICATION & CLOSURE:

DATE:

1/1

COMMENTS:

Δ Issued to delete W#1145

FOR INFORMATION ONLY

Page 2 of 2

1091
Weld No.

Acceptance Std.
Gibbs & Hill 2323-SS-18

Sb. Penetrant Mfg. Magnaflux-Spotcheck

Cleaner Mfg. Magnaflux-Spotcheck

Developer Mfg. Magnaflux-Spotcheck

NDE Procedure

9I-GAP 10.2-1 REV. Q

Final P.T.

Level II

RESULTS

INSPECTOR SIGN.

DATE

Sc. Vacuum Box

GASKET TYPE

SOLUTION TYPE

Pretest Cleaning _____ by _____ Pressure _____ Temperature _____ NDE Procedure

Solution Application Method _____ Post Test Cleaning _____

Gauge Serial Number _____ Pressure Differential _____
Maintained for _____ Sec. _____ Min.

Final V.B.

N/A - Not Applicable

Satisfactory _____

Unsatisfactory _____

Level II

Inspector ☒

Date

2/13/81

Будет ли это?

PERM. PLT. RECORD

RTN	L	FILE LOC	172.93.7
SUBFILE LOC.		A 1091	

1091

WELD NO.

582 Stainless Steel Liner Inspection Traveler

PROJECT: CPSES JOB NO: 35-1195 UNIT 2 PAGE 1 OF 2

WRB-10559/BB-2401A REACTOR LINER #2 STAINLESS STEEL 1/4" to 1/4" *see below
Drawing No. Pool Metal Type Mtl. Thk. PC. to PC.
☐ Plate to Plate ☐ Insert to Plate ☐ Angle to Plate ☒ Other < to <

Welder Symbol	WFLAL No.	Weld Proced.	Hold Point
------------------	--------------	-----------------	---------------

AGE	D-5 687.	88025	1,7
-----	----------	-------	-----

1. Fit up and Cleanliness of Above:

Sgt. James G. Cobb 2/12/81
Results Inspector Signature Date

2. V.T. of Backing Strip Tack/Fillet Welds:

N/A N/A N/A
Res(1) S Inspector Signature Date

3. Cleanliness of Channel, Liner, and U. Strip:

N/A N/A N/A
Results Inspector Signature Date

4. Final V.T. of Channel Fillet Weld:

N/A N/A N/A
Results Inspector Signature Date

5. Inside Fit Up and Cleanliness:

N/A N/A N/A
Results Inspector Signature Date

6. V.T. of Fillet Prior to Grinding:

N/A N/A N/A
Results Inspector Signature Date

7. Final V.T. of Inside Weld:

Lat. James W. Cobb 2/13/81
Results Inspector Signature Date

* splice in embed L
LWC 3/6/81

8. Completion of Weld Inspection: 91-QAP 10.2-7
Sgt. James W. CB 3/6/81 REV. 0
 Results: Inspector Signature Date

CASE Form E

35-1195-CCP-38, July 19, 1977
 REVISION 2, December 8, 1977
 PAGE 17 of 17

DOCKETED
 USNRC

*84 OCT -1 A10:57

OFFICE OF SECRETARY
 DOCKETING & SERVICE
 BRANCH

FIGURE 3

NONDESTRUCTIVE TEST INSPECTION REQUEST		FOREMAN	TIME	DATE
WELDER: _____				
DRAWING #: _____				
INSP. REQ.	CLEAN	FIT-UP	FIELD WELD JT. #	
	VISUAL	L.P.	V.B. _____	
	FINAL			
COMMENTS: _____				
WWR. _____				

INSPECTOR: _____ ACCEPT: _____ DATE: _____				



NON DESTRUCTIVE TEST
INSPECTION REQUEST

FOREMAN

TIME

DATE

9/13/78

WELDER:

See Below

DRAWING #

2401A BB R#2

INSP. REQ.	CLEAN <input type="checkbox"/>	FIT-UP <input type="checkbox"/>	FIELD WELD JT. #	52
	VISUAL <input type="checkbox"/>	L.P. <input type="checkbox"/>	V.B.	
	FINAL <input type="checkbox"/>			

COMMENTS:

Just fit up &
Cleanliness of
Plate to angle

WNR:

A017182 AARA017210 AED

INSPECTOR:

Don R. Vogt

ACCEPT:

☒DATE: 9-13-78DOCKETED
USNRC

'84 OCT -1 AIO:57

OFFICE OF BELMONT
DOCKETING & SERVICE
BRANCHNON DESTRUCTIVE TEST
INSPECTION REQUEST

FOREMAN

TIME

DATE

10-17-78

WELDER:

Justice AEU

DRAWING #

BB 2401A

INSP. REQ.	CLEAN <input type="checkbox"/>	FIT-UP <input type="checkbox"/>	FIELD WELD JT. #	235
	VISUAL <input type="checkbox"/>	L.P. <input type="checkbox"/>	V.B.	
	FINAL <input type="checkbox"/>			

COMMENTS:

Just fit up and
Cleanliness of Embed
to Plate

WNR:

A068850 AEU

INSPECTOR:

J.M. McCoy

ACCEPT:

☒

DATE:

10-18-78

DOCKETED
September 27, 1984

UNITED STATES OF AMERICA
NUCLEAR REGULATORY COMMISSION

'84 OCT -1 A10:57

BEFORE THE ATOMIC SAFETY AND LICENSING BOARD

OFFICE OF SECRETARY
SERVICE
BRANCH

In the Matter of)	
)	
TEXAS UTILITIES GENERATING)	
COMPANY, et al.)	Docket Nos. 50-445-2
)	and 50-446-2
(Comanche Peak Steam Electric)	
Station, Units 1 and 2))	

CERTIFICATE OF SERVICE

By my signature below, I hereby certify that true and correct copies of CASE's CASE's Evidence of a Quality Control Breakdown have been sent to the names listed below this 27th day of September, 1984, by: Express mail where indicated by *; Hand-delivery where indicated by **; and First Class Mail unless otherwise indicated.

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