



99901007

## THE PRESCON CORPORATION

July 23, 1985

Director Division  
Vendor and Technical Training Center Program  
E.W.W. 357 U.S. N.R.C.  
Washington, DC 20555

Attention: Mr. Brian K. Grimes

Subject: Nuclear Regulatory Commission Surveillance of  
The Prescon Corporation Quality Assurance  
Program and Procedures  
June 10, 11, and 12, 1985

Gentlemen:

Pursuant to your telephone request of July 18, 1985, the following findings and concerns have either been taken care of or will be accomplished by the dates shown.

- Item #1 A letter was sent on July 13, 1985, requesting actual mill CMTRS in relation to the washers supplied by National Flame and Forge. Actual CMTRS received July 11, 1985 and are now on file.
- Item #2 A letter amendment, dated June 13, 1985, has been issued to National Flame and Forge on Prescon P.O. #5394 covering the washers for STNP adding 10CFR50 and 10CFR21 as applicable to the original purchase order.
- Item #3 The correction to the misspelled word "respectfully" in the forward letter in the Dynamic Test Report has been taken care of by a memo to file number STP 502.4 on June 13, 1985.
- Item #4 The drawings in the shop and plant Q.C. office have been reviewed for correctness by Q.A. and stamped and dated June 13, 1985. Instructions have been issued that drawings made from sepias (tracings) shall be reviewed by Q.A. against the client approved drawings prior to issuance. Memo to log June 14, 1985.

8508010353 850723  
PDR QA999 EECPRESC  
99901007 PDR

IE:09  
11

- Item #5 The welders qualification procedures have been submitted to Bechtel Energy Corporation for approval. Reference transmittal #090, dated June 13, 1985.
- Item #6 The audit report form of vendors has been updated since the audit of National Flame and Forge in 1977 and is more detailed. It will be included in the Q.A. manual exhibit section upon revision of the manual. Reference item #10.
- Item #7 Physical audit of National Flame and Forge after the issuance of P.O. #5394.  
Chronological review was conducted with the following findings:
- a. Letter of January 27, 1977, B. Mabrito, Q.A., to E. Cutler, V.P. Nuclear Systems, shows NF&F added to approved vendor list (no physical audit report).
  - b. Approved vendor list, Rev. 4, lists NF&F dated January 27, 1977.
  - c. P.O. #5394 issued to NF&F, October 17, 1977.
  - d. Physical audit conducted December 9, 1977.  
Three open items on audit report dated December 9, 1977; item #10, 13, and 16. Since joining The Prescon Corporation QA/QC department in June of 1979 and having reviewed past inspection receiving records of washers, making several trips to NF&F manufacturing and observing their operations, I can justify making late date entries and signing these three items on the audit report of December 9, 1977.  
Corrective action taken to Item #7:
1. Reword sections 4.2 and 7.1 of Q.A. manual to read purchase orders will not be issued prior to the audit approval of the vendor.
  2. Instructions have been given to those individuals qualified to conduct vendor audits that all item blocks will be completed or identified as not applicable (N/A).
- Item #8 Procedures for Implementation of 10CFR21.  
Correction action:  
Appropriate procedures will be adopted to insure compliance with the Part 21. Upon completion, they will be posted at areas within the manufacturing and office of The Prescon Corporation. Effective date, August 22, 1985.

NRC  
July 23, 1985  
Page 3

Item #9 Shop Personnel and Management Training

Corrective action:

A program outlining this program will be instituted. Input from Shop Manager and Director of Engineering will be required. Files will be kept on each individual reflecting this training. Paragraph 2.6, Page 8 of the Q.A. Program will be added to cover this requirement, August 22, 1985.

Item #10 Corrections and/or Additions to Q.A. Manual, Rev. #9.

Pg. 10, Sect. 4.2, Pg. 13, Sect. 7.1, Ref. Item #7  
Pg. 16, Correct spelling in subject block to read "processes".

Pg. 26, Sect. 18.0, Change "compliance" to read "adequacy".

Pg. 26, Sect 18.1, Add "and/or independent service organization" for auditing.

Pg. 31, Insert new purchase order requisition form.

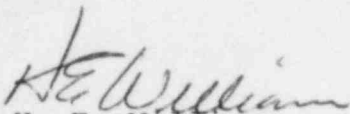
Pg. 36, Insert new vendor audit check list.

Effective date, August 22, 1985.

As no formal surveillance data report has been issued on these findings and concerns, these ten items have been taken from the general notes taken by The Prescon Corporation during June 10 thru 12, 1985.

Yours truly,

THE PRESCON CORPORATION



H. E. Williams  
Quality Assurance Manager

HEW/kf

cc: J. Oiknine, President  
K. R. Naidu, U.S. N.R.C.  
J. Kelly, Q.C.  
File-S1175

enclosures (7)

Freyssinet

## THE PRESCON CORPORATION

*Note: See Attached  
Response Letter.*

June 13, 1985

National Flame and Forge  
330 W. 25th  
P. O. Box 7358  
Houston, Texas 77008

Attention: Mr. W. E. Pielop III

Subject: Prescon P. O. No. 5394

Dear Bill,

We have just recently been audited by the NRC. One of their concerns was that we did not have copies of Cabot Mills Certification on the raw material in our file.

We assume that the chemical, physical properties, and heat treatment were all done by Cabot. We have attached a list of your D.M. no. and heat no. involved. We would very much appreciate it if you can supply us copies of Cabot's CMTR on these heats for insertion into our files.

Yours truly,

THE PRESCON CORPORATION

*Howard E. Williams*  
Howard E. Williams  
Q. A. Manager

HEW/kf

cc: J. Oiknine  
J. Kelly

**FOR INFORMATION ONLY**

National  
Flame &  
Forge, Inc.

RECEIVED  
JUL 11 1985  
PRESCON CORP.

Item #1

879177

(10) J.O.

July 3, 1985

Mr. Howard Williams  
Q. A. Manager  
The Prescon Corporation  
P O. Box 20800  
San Antonio, Texas 78220-0800

Dear Howard:

I have enclosed copies of Cabots mill certs that you requested. You requested certs from heat H-945 under DM#33500. Our records indicate that H-945 was not shipped under the referenced DM. I have instead enclosed the mill cert for heat H-941 which was shipped under DM#33500.

I hope that these certs will satisfy your needs.

Sincerely,

*Bill Pielop III*

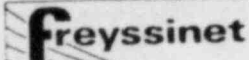
W. E. (Bill) Pielop, III  
Vice President, Engineering

WEP, III/tmm

Encl.

FOR INFORMATION ONLY



The logo for Freyssinet, featuring the company name in a bold, sans-serif font within a rectangular border.

# THE PRESCON CORPORATION

June 13, 1985

National Flame and Forge  
P.O. Box 7358  
Houston, Texas 77008

Attention: Mr. W. E. Pielop III

Subject: The Prescon Corporation Amendment to P.O. 5394

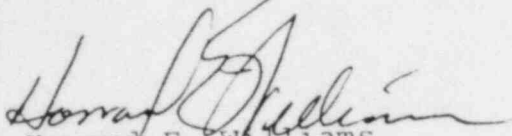
Dear Bill,

This amendment is issued to add the following requirements omitted upon issuance of the above purchase order. Please attach to your copy.

10CFR50 and 10CFR21 are applicable to the above mentioned purchase order.

Yours truly,

THE PRESCON CORPORATION

A handwritten signature in dark ink, appearing to read "Howard E. Williams".

Howard E. Williams  
Quality Assurance Manager

HEW/kf

cc: J. Oiknine  
J. Kelly  
D. Lester

FOR INFORMATION ONLY

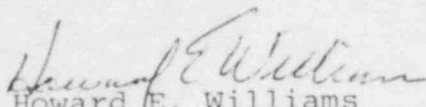


NW  
Item #3

MEMORANDUM \_\_\_\_\_ THE PRESCON CORPORATION

DATE: June 13, 1985  
TO: Dynamic Test File - STP 502.4  
FROM: H. E. Williams  
SUBJECT: NRC Audit, June 10-12, 1985

A review of test results indicated that in the cover letter dated February 1, 1978, the last word in the 2nd paragraph is incorrectly spelled. Respectfully should be respectively. I have lined through, dated, initialed, and corrected same this date.

  
Howard E. Williams  
Quality Assurance Manager

HEW/kf

cc: J. Oiknine

FOR INFORMATION ONLY

Item #4

MEMORANDUM

THE PRESCON CORPORATION

DATE: June 14, 1985  
TO: Engineering Controlled Drawing Log  
FROM: H. E. Williams  
SUBJECT: Release of Drawings

Effective this date, copies of drawings made for issuance to Production or Quality Control will be reviewed for correctness as to drawing number, latest revision, and QA/QC review stamp and signature.

*HE Williams*  
H. E. Williams  
Q. A. Manager

HEW/kf

cc: J. Oiknine  
T. Su  
J. Kelly  
File-S1175

FOR INFORMATION ONLY



Item #5

THE PRESCON CORPORATION

1338 north w. w. white road, p.o. box 20800  
san antonio, texas 78220-0800  
telephone: (512) 662-8500 telex: 767-550

TRANSMITTAL FORM NO: 48A

Page 1 of 1

TO: Bechtel Energy Corporation  
P. O. Box 2166  
Houston, Texas  
Zip 77252-2166

Number 090  
Date June 13, 1985  
Our File No. S1175  
Reply Requested ... Yes X No     

ATTN: Mr. Bruce Bitner

SUBJECT/PROJECT STNP  
Contract No. 14926-C-0067

Transmitted herewith are the following:

Originals	_____	Prints	_____
Calculations	_____	Literature	_____
Letter Copies	_____	Materials	_____
Xerox Copies	<u>X</u>	Work/Shop Order	_____
Sepias	_____	Data	_____
Specs	_____		
Other	_____		

FOR:

Approval	<u>X</u>	Handling	_____
Completion	_____	Reference	_____
Correction	_____	Relay to Others	_____
Comments	_____	Your Information	_____
Construction	_____	Your File	_____
Fabrication	_____	Other	_____
Final Approval	_____		

Transmitted by way of:

Your Messenger	_____	Parcel Post	_____
Our Messenger	_____	Air Freight	_____
Special Delivery	_____	Truck	_____
Regular Mail	<u>X</u>	Rail	_____
Federal Express	_____	UPS	_____
Express Mail	_____		
Telecopy	_____		

Handle by July 13, 1985 date  
Please sign & return one copy to:  
H. E. Williams, Q.A. Mgr.  
Received by \_\_\_\_\_  
Date \_\_\_\_\_

No. of Copies	Reference No.	Revision No.	Description
<u>1</u>	<u>Lab No. 7.6-8163</u>	<u>N/A</u>	<u>Welding Procedure</u>
	<u>File No. 1208</u>		<u>Qualification &amp; Operator</u>
			<u>Performance Qualification</u>

FOR INFORMATION ONLY

Remarks

A NRC concern - no Bechtel approval. This was overlooked by Prescon in reviewing the data returned by Bechtel on pkg. 645 14926-0067-01060-APR. NRC found all procedures in regards to welding satisfactory. Note-replace cover sheet.

Copies to : (itemize)

File - S1175

Log

J. Smith

THE PRESCON CORPORATION

From: QA/QC

To:

H. E. Williams  
H. E. Williams  
Q. A. Manager

225a-11 79

ITEM #6

AUDIT CHECKLIST

PAGE \_\_\_\_ OF \_\_\_\_

ORGANIZATION /  
ACTIVITY AUDITED

DATE (S)  
OF AUDIT

AUDIT REPORT NO.

REV.

REFERENCE DOCUMENT

AUDIT SUBJECT

LEAD AUDITOR  
AUDITOR

REFERENCE DOCUMENT  
PARAGRAPH

AUDIT ELEMENT DESCRIPTION

FINDINGS

STATUS

FOR INFORMATION ONLY

S - SATISFACTORY, CLOSED OUT  
U - UNSATISFACTORY  
O - OPEN ITEMS, CORRECTIVE ACTION REQUIRED  
F - FOLLOWUP NEXT AUDIT  
N/A - NOT APPLICABLE

EXAMPLE : S  
EXAMPLE : U, O

PRESCON CORPORATION

1406 NORTH W.W. WHITE ROAD

P.O. BOX 20800

SAN ANTONIO, TEXAS 78220-0800

List ~~Enough~~ Performance - ~~is~~  
is supplemental for information purposes only.

PRESCON VENDOR QUALITY AUDIT CHECKLIST

Name: NATIONAL FLAME & FORGE, Inc

Location: 330 West 25<sup>th</sup> Street

Houston, TX 77008

MAN. INTERVIEW WITH NF&F: Mr. Faircloth: (713) 869-5724

1. ORGANIZATION

Richard T. Faircloth  
Name of QA/QC Dept Manager

QC Manager  
Title

W. E. Pieper III  
QA/QC Dept Manager Reports to

V.P. - Engineering  
Title

Number of Personnel in QA/QC Dept

13

Number of Quality Control Inspectors

8

2. QUALITY ASSURANCE PROGRAM

Acceptable (A)  
Adverse to Quality (Q)  
Not Applicable (N/A)      Remarks

QA/QC Program documented  
by written manual.

A

Date QA/QC Program initiated.

A

1/3/77

Quality Control checks receive  
proper documentation.

A

QA/QC Program periodically  
reviewed.

A

QA/QC Dept authorized to stop work.

A

QA Personnel certificates of  
qualification maintained.

N/A

3. DESIGN CONTROL

Prescon Specifications/Drawings  
reviewed by persons other than  
original design team.

N/A

Procedure changes reviewed by  
Engineering Management.

N/A

FOR INFORMATION ONLY

Test program performed to insure quality production for Prescon.

N/A

4. PROCUREMENT DOCUMENT CONTROL

Procedures established for review of purchase orders by Quality Assurance dept.

A

5. INSTRUCTIONS, PROCEDURES & DRAWINGS

Shop Manual(s) clearly written and adhered to.

A

Shop Personnel knowledgeable in their assignments.

A

6. DOCUMENT CONTROL

Prescon specifications/instructions maintained in central plant location.

A

7. CONTROL OF PURCHASED MATERIAL, EQUIPMENT AND SERVICES

Approved Vendor Listing available.

A

*checked by B. Mason 10-12/9/77*

Checks/investigations made of suppliers/vendors.

A

QA/QC Dept checks supplies upon arrival (initial inspection).

A

QA/QC Dept examines shipping documents for inclusion of Prescon specifications.

A

Suitable storage area available for unacceptable incoming material.

A

8. IDENTIFICATION AND CONTROL OF MATERIALS, PARTS AND COMPONENTS

Materials marked clearly for identification throughout entire production process.

A

CONFIDENTIAL INFORMATION ONLY

Measuring/test equipment should include date of calibration, identification of calibrator and next cal-due date.

A

Every Time gauge is used it is calibrated!

QA/QC Dept maintains detailed information on measuring/test equipment.

A

Provisions for calibration and adjustment at perscribed intervals.

A

SEE ABOVE

### 13. HANDLING, STORAGE AND SHIPPING

General level of plant housekeeping.

A

LDE.  
7/22/85  
HEW  
GAMM

Orderly, Clean.  
Items in Proper order

Age, general condition and quality level of production equipment.

A

Plant built in 1980 -  
newer buildings present.  
Equipment well maintained.

Safety hazards apparent/serious accidents in past 12 months.

A

NONE

### 14. INSPECTION, TEST AND OPERATING STATUS

Status board or flow sheet of inspection/testing to indicate progress.

N/A

check point operation  
reports from each operation

### 15. NONCONFORMING MATERIALS, PARTS OR COMPONENTS

Nonconforming materials properly marked, identified and controlled.

A

Policy for review of nonconforming items to determine destination.

A

MATERIAL REVIEW BOARD

### 16. CORRECTIVE ACTION

Conditions adverse to quality production are isolated and immediate corrective action taken.

A

LDE  
7/24/85  
HEW  
GAMM

Parts Tagged & Segregated  
Scrap/Reas Separate from  
Re-work Areas.

FOR INFORMATION ONLY

## 17. QUALITY ASSURANCE RECORDS

Full records of past QA/QC Programs, including project date, observations, results and acceptability.

A

Working on them first  
program - effective date  
listed above

## 18. AUDITS

Date and investigating organization of last QA/QC audit.

A

Southeast Fabricating 1/77  
Gray Tool Co 9/77

Last internal audit of QA/QC Dept and results.

A7/12/77

Planned and periodic internal audit program in effect.

A

every 6 months

## 19. OBSERVATIONS

(To include remarks on any variables that might affect the quality/workmanship Prescon expects from this vendor/supplier).

1. Approximately 200 total employees, down from a higher figure in 1974.
2. Inspected in-process work on Prescon STD Washers specifically checked PC #356 and PC #357 in process. National Flame & Forge is getting 34 to 35 washer blanks per heat. Saw cutting, with each piece individually marked with a PC # and a sequence number (starting at #1 with each <sup>new</sup> PC #) with a marker. Stamped in letters/numbers will be done later.
3. Excellent machine shop capabilities available at National Flame & Forge.

FOR INFORMATION ONLY

Bruce E. Melville  
Auditor

12/9/77  
Date





MEMORANDUM

The attached Prescon Vendor Quality Audit Checklist

has been reviewed by Bruce E. Maltbie / QA manager

signature / title

on 12/13/77.

date

Indicate:

Approval

/ Disapproval

If approved, add company to Prescon's Approved Vendors' List.

FOR INFORMATION ONLY

ITEM #7

MEMORANDUM \_\_\_\_\_ The Prescon Corporation  
January 27, 1977

TO: Earl Cutler  
Vice President, Nuclear Systems

FROM: Bruce Mabrito  
Quality Assurance

SUBJECT: Additions to Prescon's Approved Vendor List

FOR INFORMATION ONLY

The following four (4) firms have been added to Prescon's Approved Vendor List: Alamo Welding Supply; National Forge, Inc.; Norcath Company; and Trinity Testing Laboratories.

Justification and qualification of these four firms to the Approved Vendor List is listed below:

Alamo Welding Supply Company  
1735 South Alamo  
San Antonio, Texas 78204

Alamo Welding Supply has been in business since 1937 in San Antonio, and is a supplier of Industrial Gases, weld filler material, welding equipment and safety equipment. Personnel at Alamo Welding Supply were helpful in sorting out welding equipment problems in early 1976 in preparation of qualifying Prescon welders prior to South Texas Project production. Prescon Central Division utilized Alamo Welding Supply from 1969 to 1970 and received satisfactory service. Since February, 1976, Central Division Welding Annex has received Alamo Welding Supply services and the foreman of that facility is satisfied with their performance. Alamo Welding supplies material and services from the following major U.S. manufacturers: Linde; Miller; McKay; Oxweld; Purox; Prest-o-Lite; Puritan-Bennet; Stooddy; and Med-Gas. From past and recent performance, Alamo Welding Supply is added to Prescon's Approved Vendor List.

National Flame & Forge, Inc.  
330 West 25th Street (P.O. Box 7385)  
Houston, Texas 77008

National Flame & Forge, Inc. was founded in 1940 and their quality levels meet ASTM, ASME and military specifications. Forged washer blanks for tendons have been previously supplied to Prescon by National Forge for projects and they have been prompt with delivery of Certified Mill Test Report information, delivering the document with the shipment. Their paperwork is clear and concise and the forgings meet Prescon's Purchase Order requirements.

January 27, 1977

Generally, the forgings arrive banded to a pallet which helps control large numbers of washer blanks in Prescon's facility. From National Flame & Forge, Inc. past performance, they are included in Prescon's Approved Vendor List.

Norcath Company  
15613 East San Pedro  
Gardena, California 90248

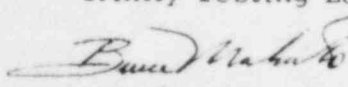
Prescon has, since 1954, purchased equipment from William S. Pine in Los Angeles, California. They have supplied rams of all capacities to Prescon for 20 years and their performance has been satisfactory. The Templeton, Kenly Company terminated the William S. Pine operations effective 1976, but Mr. Norm Soukup founded his own company by the name of "Norcath." Since Soukup was part of the William S. Pine operation for many years, he is continuing to sell and service equipment under a new name only. There is a close working relationship between Prescon Equipment Department and Norcath, and Norcath has supplied equipment which is satisfactory. With Prescon's experience with Mr. Soukup and now Norcath, they qualify for the Approved Vendor's List.

Also note on the Approved Vendor List that Templeton, Kenly and Company's address has changed to:

2525 Gardner Road  
Broadview, Illinois 60153

Trinity Testing Laboratories  
810 South Padre Island Drive  
Corpus Christi, Texas 78415

Trinity Testing Laboratories has performed testing operations on Prescon products since 1960 and for various nuclear projects has performed Weld Procedure Qualification Test and Welder Qualification Tests. In 1976 and 1977, Trinity Testing Laboratories has performed Radiographic examination of large castings for a major bridge project. Trinity Testing has been consulted on matters of weld procedures by Prescon Corporation and is recognized as a respected laboratory in Radiographic and destructive testing field. Through their past performance with Prescon Corporation, Trinity Testing Laboratories is placed on our Approved Vendor List.

  
BEM/ced

Reviewed by Vice President

Date

2/1/77

# APPROVED VENDORS LIST

## THE PRESCON CORPORATION SOUTH TEXAS PROJECT

Page 1 of 2

VENDOR	MATERIAL
Armco Steel Corporation P. O. Box 1382 Kansas City, Missouri 64141	Wire
Armco Steel Corporation P. O. Box 3351 Houston, Texas 77001	Steel plate
Aztec Manufacturing Company P. O. Box 23176 East Houston Station Houston, Texas 77028	Galvanizing
Cabot Corporation P. O. Box 1101 Pampa, Texas 79065	Steel forgings Metal products
Corpus Christi Gasket & Packing Company P. O. Box 4074 Corpus Christi, Texas 78408	Grease cap gaskets
Earle M. Jorgensen Company P. O. Box 1421 Houston, Texas 77001	Washer blanks, steel plate and forgings
Puralloy, Inc. 907 Roosevelt Avenue San Antonio, Texas 78207	Transition cones
Joseph T. Ryerson, Inc. P. O. Box 10006 Charlotte, North Carolina 28237	Grease cap materials Washer Blanks
Armco Steel Corporation P. O. Box 600 Middletown, Ohio 45043	Trumpets

Revision 4

Date 1/27/77

Reviewed by Bruce M. Smith

APPROVED VENDORS LIST

THE PRESCON CORPORATION  
SOUTH TEXAS PROJECT

Page 2 of 2

VENDOR	MATERIAL
Valmont Industries, Inc. Valley, Nebraska 68064	6" Trumpet extension Metal Products
Viscosity Oil Company 3200 South Western Avenue Chicago, Illinois 60608	Corrosion protection material
Templeton Kenly & Company 2525 Gardnes Road Broadview, Illinois 60153	Jacking equipment
Alamo Welding Supply Company 1735 South Alamo San Antonio, TX 78204	Welding Equipment Welding Material
National Flame & Forge, Inc. 330 West 25th Street (P.O. Box 7385) Houston, TX 77008	Forgings
Norcath Company 15613 East San Pedro Gardena, CA 90248	Rams Pull Rods, Bushings, etc.
Trinity Testing Laboratories 810 South Padre Island Drive Corpus Christi, TX 78415	Radiographic Testing General NDE, Welder Qualifications

Revision 4

Date 11/27/77

Reviewed by Bruce M. Smith