

ENCLOSURE 1

NOTICE OF VIOLATION

Tennessee Valley Authority
Browns Ferry

Docket Nos. 50-259 and 50-296
License Nos. DPR-33 and DPR-68

The following violation was identified during an inspection conducted on April 22 - 26, 1985. The Severity Level was assigned in accordance with the NRC Enforcement Policy (10 CFR Part 2, Appendix C).

10 CFR 50, Appendix B, Criterion V, requires that activities affecting quality shall be prescribed by documented instructions, procedures, or drawings and shall be accomplished in accordance with these instructions, procedures and drawings.

Browns Ferry Instruction BF MAI-23 contains the following requirements: Paragraph 6.1.1 requires that manufacturer's recommended installation procedures shall be followed. Paragraph 6.1.6 requires that all threaded fasteners shall be provided with locking devices. Paragraph 6.4.2 requires that component standard supports shall be within the range of support adjustment and that full thread engagement of all parts must be maintained. Paragraph 7.3 requires that for new supports, the Quality Control (QC) inspector shall verify that the general configuration is correct. Paragraph 7.4 requires that the craft foremen and QC inspector shall verify that all threaded connections are installed snug plus 1/4 turn with full thread engagement and locking devices.

Contrary to the above, activities affecting quality were not being accomplished in accordance with documented procedures and drawings in that a field inspection of seven QC accepted pipe supports revealed five supports with deviations from the documented requirements. As a result, these supports may not be able to perform their intended function as required by the design. These five supports are identified below:

1. Unit 1, residual heat removal (RHR) support No. R-108, Rev. 1, snubber bolt connections were loose. The pipe clamp was installed with single nut instead of double nuts specified by the manufacturer's instructions.
2. Unit 1, core spray support No. H-83, Rev. 1, configuration was incorrect in that a bolt connection was used instead of a pin connection specified by the drawing. A lack of thread engagement for three bolts that were used for the pipe clamp installation was noted.
3. Unit 3, RHR support No. R-62, Rev. 2, drawing called for a 5/16" all around weld was not achievable, actual weld was 1/4" on two sides. A lack of thread engagement for four double nuts that were used for U-bolt installation was noted.

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4. Unit 3, RHR support No. R-11, Rev. 3, the lock nut was loose for the strut installation.
5. Unit 3, RHR support No. R-105, Rev. 2, a 3/16" fillet weld was missing at two weld attachments. The pipe clamp was installed with a single nut without any locking devices. The manufacturer's instructions require double nut installation.

This is a Severity Level IV violation (Supplement I).

Pursuant to 10 CFR 2.201, you are required to submit to this office within 30 days of the date of this Notice, a written statement or explanation in reply, including: (1) admission or denial of the alleged violation; (2) the reasons for the violation if admitted; (3) the corrective steps which have been taken and the results achieved; (4) corrective steps which will be taken to avoid further violations; and (5) the date when full compliance will be achieved.

Security or safeguards information should be submitted as an enclosure to facilitate withholding it from public disclosure as required by 10 CFR 2.790(d) or 10 CFR 73.21.

Date: MAY 14 1985