



UNITED STATES  
NUCLEAR REGULATORY COMMISSION  
WASHINGTON, D. C. 20555

JAN 08 1993

Docket No. 99901258

Mr. B. J. Gruner, Vice President  
Ram Forge & Steel, Inc.  
P.O. Box 592  
Navasota, Texas 77868

Dear Mr. Gruner:

SUBJECT: NOTICE OF VIOLATION AND NOTICE OF NONCONFORMANCE (NRC INSPECTION  
REPORT NO. 99901258/92-01)

This letter addresses the inspection of your facility at Navasota, Texas conducted by Messrs. L. L. Campbell, C. K. Battige, and D. G. Naujock of this office on November 17 through 20, 1992, and the discussions of their findings with you and members of your staff at the conclusion of the inspection. The performance based inspection was conducted to evaluate Ram Forge & Steel, Inc.'s (Ram Forge's) quality program and its implementation in selected areas such as (1) purchased material and services and control of sub-suppliers, (2) control of work and special processes, (3) inspections and tests, and (4) Ram Forge's material certification program.

Areas examined during the U.S. Nuclear Regulatory Commission (NRC) inspection and the inspectors' findings are discussed in the enclosed report. This inspection consisted of an examination of procedures and representative records, interviews with personnel, and observations by the inspectors.

Based on the results of this inspection, certain of your activities appear to be in violation of NRC requirements, as specified in the enclosed Notice of Violation. The violation identified that Ram Forge's procedures did not address the requirements of Section 21.21, "Notification," of Title 10 of the Code of Federal Regulations (10 CFR) as revised and effective on October 29, 1991 (e.g. the 60 day period for evaluating potential defects and failures or filing an interim report was not addressed). Also, the inspection team identified the failure of Ram Forge to invoke the requirements of Section 21.31, "Procurement Documents," of 10 CFR on its purchase order issued to a supplier of safety-related calibration services.

You are required to respond to this letter and should follow the instructions specified in the enclosed Notice of Violation when preparing your response. In your response, you should document the specific actions taken and any additional actions you plan to prevent recurrence. After reviewing your response to this Notice, including your proposed corrective actions and the results of future inspections, the NRC will determine whether further NRC enforcement action is necessary to ensure compliance with NRC regulatory requirements.

In addition, during the inspection it was found that the implementation of your quality assurance (QA) program failed to meet certain NRC requirements. The

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Mr. B. J. Gruner

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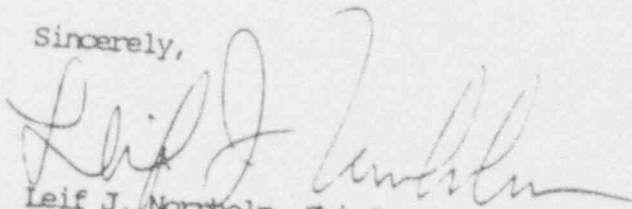
inspection identified that because Ram Forge failed to follow the requirements of its Quality Control Manual, shop orders and drawings for the fabrication of a 12 inch, safety-related elbow, for use in the River Bend Station's reactor feedwater piping contained insufficient requirements to ensure that minimum wall thickness was maintained. The specific findings and references to the pertinent requirements are identified in the enclosed Notice of Nonconformance and Inspection Report.

Please provide us within 30 days from the date of this letter a written statement in accordance with the instructions specified in the enclosed Notice of Nonconformance. We will consider extending the response time if you can show good cause for us to do so.

The responses requested by this letter and the enclosed Notices are not subject to the clearance procedures of the Office of Management and Budget as required by the Paperwork Reduction Act of 1980, Public Law No. 96-511. In accordance with 10 CFR 2.790 of the NRC's "Rules of Practice," a copy of this letter and its enclosures will be placed in the NRC Public Document Room.

If you have any questions concerning this inspection, we will be pleased to discuss them with you.

Sincerely,



Leif J. Norrholm, Chief  
Vendor Inspection Branch  
Division of Reactor Inspection  
and Licensee Performance  
Office of Nuclear Reactor Regulation

Enclosures:

1. Notice of Violation
2. Notice of Nonconformance
3. Inspection Report No. 99901258/92-01

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\*See previous concurrence

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COPY OF DOC	YES NO	YES NO	YES NO	YES NO	YES NO	YES NO

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