

## NOTICE OF NONCONFORMANCE

Ram Forge & Steel, Inc.  
Navasota, Texas

Docket No.: 99901258/92-01

Based on the results of an NRC inspection conducted on November 17 through 20, 1992, it appears that certain of your activities were not conducted in accordance with NRC requirements.

Criterion V, "Instructions, Procedures, and Drawings," of Appendix B to Title 10 of the Code of Federal Regulations (10 CFR) Part 50 requires, in part, that activities affecting quality be accomplished in accordance with instructions, procedures, or drawings.

Section 16, "Preparation of Drawing and Release For Machinery," of the Ram Forge Quality Control (QC) Manual, Revision 5, dated March 18, 1988, requires, in part, that special requirements and notes be added to drawings to assure that all of the customer's requirements are strictly adhered to throughout the production process. Section 20, "Forging," of the Ram Forge QC Manual requires, in part, that forge orders are checked for completeness and compliance with the customer's purchase order and the American Society of Mechanical Engineers (ASME) code.

NB-2121, "Permitted Material Specifications," NB-2548, "Elimination of Surface Defects," NB-2700, "Dimensional Standards," and NB-4214, "Minimum Thickness of Fabricated Material," of the ASME Section III Code, 1986 Edition, requires, in part by reference, that the thickness of fabricated forgings meet Code minimum design wall thickness requirements.

Section 12, "Finish," of ASME Section II Material Specification SA-234, "Specification for Piping Fittings of Wrought Carbon Steel and Alloy for Moderate and Elevated Temperatures," 1986 Edition, requires, in part, that following the removal of imperfections by grinding or machining the remaining wall thickness shall not be less than 87 1/2 percent of the nominal wall thickness.

Contrary to the above, Ram Forge shop orders and drawings for an ASME Section III, Class 1, 12 inch carbon steel elbow, SA-234 schedule 80 material, fabricated to the requirements of Connex Pipe Systems, Inc.'s Purchase Order No. E8634-2, dated February 13, 1992, for use in the River Bend Station's reactor feedwater system, failed to contain sufficient requirements to ensure that the required 87 1/2 percent of nominal wall thickness was present in the forged elbow (99901258/92-01-03).

Please provide a written statement or explanation to the U.S. Nuclear Regulatory Commission, ATTN: Document Control Desk, Washington, D.C. 20555, with a copy to the Chief, Vendor Inspection Branch, Division of Reactor Inspection and Licensee Performance, Office of Nuclear Reactor Regulation, within 30 days of the date of the letter transmitting this Notice of Nonconformance. This reply should be clearly marked as a "Reply to a Notice of Nonconformance" and should include for

each nonconformance: (1) a description of steps that have been or will be taken to correct these items; (2) a description of steps that have been or will be taken to prevent recurrence; and (3) the dates your corrective actions and preventive measures were or will be completed.

Dated at Rockville, Maryland  
this 8<sup>th</sup> day of January 1993.