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D. VERRELLI
RP



June 5, 1985

Docket No. 50-348
Docket No. 50-364

Mr. D. M. Verrelli
U. S. Nuclear Regulatory Commission
Region II
101 Marietta Street, N.W.
Suite 3100
Atlanta, GA 30323

SUBJECT: J. M. Farley Nuclear Plant NRC Inspection of
April 16 - 19, 1985

RE: Report Numbers 50-348/85-22
50-364/85-22

Dear Mr. Verrelli:

This letter refers to the violation cited in the subject inspection report which states:

"The following violation was identified during an inspection conducted on April 16 - 19, 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, as implemented by paragraph 17.2.5 of the Final Safety Analysis Report (FSAR), requires, in part, that activities affecting quality shall be prescribed by documented instructions, procedures, and drawings and shall be accomplished in accordance with these instructions, procedures and drawings. Paragraph 7.1 of Procedure ISI-47, the applicable ultrasonic testing (UT) procedure for inservice inspection of steam generator feedwater nozzle to shell weld 1-8, requires that the weld and heat affected zones be inspected using a straight beam examination. Procedure FNP-1-STP-157.0, the applicable procedure delineating the inservice inspection plan, requires that steam generator transition cone to lower shell weld 1-4 be UT inspected from 284.0 inches to 292.5 inches circumferentially using the feedwater nozzle as datum.

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Contrary to the above, on April 17, 1985, activities affecting quality were not accomplished in accordance with prescribed procedures in that:

1. For weld 1-8, only the edge of the weld on the shell side was being examined. The majority of the weld and the nozzle side heat affected zone were not being examined.
2. For weld 1-4, the area of weld examined was mislocated by approximately 15 inches circumferentially.

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

Admission or Denial

The above violation occurred as described in the subject report.

Reason for Violation

The above violation was caused by personnel error in that the examiner failed to inspect the welds properly. Although properly qualified, this is attributed to the fact that the examiner was relatively inexperienced.

Corrective Action Taken and Results Achieved

All areas inspected by the examiner were re-inspected and found to be satisfactory. In addition, the individual was not allowed to perform any more independent inspections as a Level II examiner during the remainder of the inspection program.

Corrective Steps Taken to Avoid Further Violations

The contractor supplying the Inservice program examiners will be instructed to provide closer supervision when utilizing relatively inexperienced examiners. Also, FNP-1-STP-157.0 and FNP-2-STP-157.0 "Inservice Inspection of Class 1 and 2 Systems and Components" will be revised to require personnel monitoring nondestructive examinations to stop work when warranted.

Date of Full Compliance

May 30, 1985.

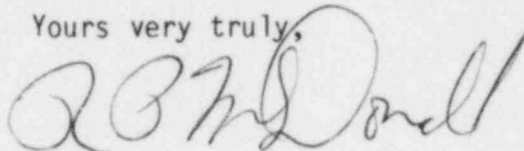
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Affirmation

I affirm that this response is true and complete to the best of my knowledge, information and belief.

The information contained in this letter is not considered to be of a proprietary nature.

Yours very truly,

A handwritten signature in cursive script, appearing to read "R. P. McDonald". The signature is written in dark ink and is positioned above the printed name.

R. P. McDonald

RPM:sam/F2