

U. S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT
REGION IV

Report No. STN 50-482/81-05

Docket No. STN 50-482

Category A2

Licensee: Kansas Gas and Electric Company
P. O. Box 208
Wichita, Kansas 67201

Facility Name: Wolf Creek, Unit No. 1

Inspection at: Wolf Creek Site, Coffey County, Burlington, Kansas

Inspection conducted: March 23-27, 1981

Inspectors:

[Signature]
L. E. Martin, Reactor Inspector, Project Section 3
(Paragraphs 1, 2, 3, 7, 8 and 9)

4/21/81
Date

[Signature]
L. D. Gilbert, Reactor Inspector, Engineering and
Materials Section (Paragraphs 4, 5 and 6)

4/21/81
Date

Approved by:

[Signature]
W. A. Crossman, Chief, Project Section 3

4/21/81
Date

[Signature]
R. E. Hall, Acting Chief, Engineering and Materials
Section

4/24/81
Date

Inspection Summary

Inspection on March 23-27, 1981 (Report No. STN 50-482/81-05)

Areas Inspected: Licensee action on previous inspection findings; site tour; observation of work and review of records for welding of Reactor Coolant Pressure Boundary and other safety-related piping; review of records and installation of electrical equipment. The inspection involved 66 inspector-hours on site by two NRC inspectors.

Results: One deviation was identified in the area of review of records and installation of electrical equipment (Deviation - 4160 Volt Switchgear Specification Color Code Identification - Paragraph 7.b)

DETAILS

1. Persons ContactedPrincipal Licensee Personnel

- *D. W. Prigel, QA Manager, Site
- *G. W. Reeves, QA Engineer
- *J. L. Stokes, Construction Project Support Supervisor
- *N. L. Hill, Startup Manager
- R. G. Haines, QA Engineer

Daniel International Personnel

- *L. F. Warrick, Project Manager
- *N. J. Criss, Audit/Procedure Coordinator
- R. Schofield, Project Welding Engineer
- B. Newton, Welding Engineer
- D. Dennison, QC Manager
- C. Hopkins, Traveler Supervisor
- J. T. Goodwin, Asst. Project Electrical Engineer

Other Personnel

- D. E. Kent, Senior Welding Engineer, Westinghouse Electric Corporation

*Denotes those present at the exit interview.

The NRC inspectors also interviewed other contractor personnel during the course of the inspection.

2. Licensee Action on Previous Inspection Findings

(Open) Infraction (50-482/80-11): Failure to specify appropriate acceptance criteria. The NRC inspector reviewed Welding Procedure Techniques N-1-1-BA-1 Revision 6, N-1-1-BA-5 Revision 4, and N-1-8-BA-24 Revision 1 and found the acceptance criteria for weld reinforcement to now be consistent with that specified in paragraph NE-4426 of ASME B&PV Code, Section III-1974 Edition through Summer 1975 Addenda. The welding procedure techniques for fabricating component supports are being reviewed by Daniel International for appropriate weld reinforcement requirements to preclude a similar problem when inspecting component supports to paragraph NF-4426 of the above Code.

This item will remain open pending completion of the review and corrective action.

(Open) Unresolved Item (50-482/80-20): Qualification of procedures for welding P Number 8 base material to A Number 8 weld material used as base material. The NRC inspector reviewed the revision issued by the Daniel International Corporate Office to Welding Procedure CWP 507, Revision 26, which clarifies that the procedure is consistently qualified with ASME Code Case 212 for Welding P Number 8 base material to A Number 8 weld material used as base material.

Since the corporate revision to the procedure had not been incorporated into the site procedure, this item will remain open pending revision of site Procedure CWP 507.

(Open) Unresolved Item (50-482/80-05): Concrete expansion anchors. During this inspection the NRC inspector called Mr. Mel Johnson of KG&E Engineering to determine the status of the qualification of the repair procedure for concrete expansion anchors. Mr. Johnson said that Bechtel has advised him that the necessary information is in typing and should be available soon. This item will remain open pending review of the Bechtel data substantiating that the repair methods meet the requirements for loading, plus safety factor of the original design.

(Closed) Infraction (50-482/80-15): Failure to provide appropriate procedures for II/I Cable Raceway. The NRC inspector reviewed the list of II/I cable trays and the status of the inspection of this tray. The list of II/I tray was compared to drawing EOR 1321, Revision 14; EOR 1323, Revision 5; and EOR 3511, Revision 12 to determine the accuracy of the list. The NRC inspector also reviewed inspection reports for 15 randomly selected II/I Raceways. The requirements for the installation and inspection of II/I are appropriately addressed in Procedures WP-X-300, WP-X-302 and QCP-X-300, as documented in NRC Inspection Report STN 50-482/80-24, and the procedures have been implemented. This item is considered closed.

3. Follow Up on Licensee Identified Problems

a. Auxiliary Panels and Main Control Board Welding - 50.55(e), SNUPPS Construction Deficiency

The NRC inspector discussed the status of this item with the licensee representative and examined several areas of concern in Auxiliary Panels and Main Control Board. This deficiency is generic to Wolf Creek and Callaway. The Panel Fabricator, Comsip Customline Corporation has built and seismically tested a prototype panel that will be utilized as a comparative standard for the panel welding at both Wolf Creek and Callaway. Bechtel letter BLSE 9034 of December 24, 1980, indicates that the seismic testing of the panel has been accomplished by Action Laboratory, but the final test report is not available. Comsip is now at Callaway doing the comparative evaluation. The final response for this item is now scheduled for July 1, 1981. This item will remain open.

- b. G.E. HFA Relay-GE Part 21, SNUPPS 50.55(e),
NRC IE Information Notice 81-01

Daniel has identified 48 suspect HFA relays used in Class IE applications in equipment that is on site. Bechtel is still in the process of reviewing the design to identify any other HFA relays used in other equipment. The licensee has committed to replacing all GE HFA relays both in Class IE and Non-Class IE applications. This item will remain open pending completion of the Bechtel review.

- c. Damaged Motor Control Center (MCC) - Potential 50-55(e)

The NRC inspector reviewed Deficiency Report (DR) 1SD 5356E. MCC 1N603 was damaged while moving. A possible cause was identified with the hydraulic system on the fork lift. The fork lift was subsequently repaired. The MCC was returned to the manufacturer on December 17, 1980 for repair. The licensee letter of January 30, 1981 stated that this was not considered reportable under the requirements of 50.55(e). This item is considered closed.

- d. NEMA 3 Size Starters - Gould Part 21, NRC IE Circular 79-23

The NRC inspector reviewed Nonconformance Reports (NCR) 1SN1274E, 1SN1275E, 1NN1373ER, and 1NN1426ER. The NCRs identified 70 size 3 starters that might require replacement. Gould subsequently identified three more starters for a total of 73. Gould letter of March 10, 1980 to Bechtel stated that a total of 74 starter contact carrier replacement kits had been installed at Wolf Creek. This item will remain open until the licensee can determine exactly how many kits were replaced.

- e. Internal Color Coding (G.E. SWGR) - Potential 50.55(e)

The NRC inspector discussed the status of this item with the licensee representative. The licensee letter of June 6, 1980 stated that this item was not considered reportable under the requirements of 50.55(e). The reportability of this item is considered closed; however, the review of the specification (Specification No. 10466-E-009) has indicated an apparent Deviation as discussed in paragraph 7.b of this report.

4. Site Tour

The NRC inspectors inspected the Reactor Building, Auxiliary Building and Control Building to observe construction activities in progress and house-keeping practices.

No violations or deviations were identified.

5. Reactor Coolant Pressure Boundary Piping

The NRC inspector observed the welding of a field weld in the Loop 4 cross-over pipe identified as weld F408 on Drawing I-Loop 4 (Q) in the Reactor Coolant Pressure Boundary piping system. The weld was being machine welded using the gas tungsten-arc welding process in accordance with welding Technique NM-8-B-1, Revision 4.

In the areas inspected, no discrepancies were noted concerning traveler documentation, welder qualification, procedure compliance and material control.

No violations or deviations were identified

6. Other Safety-Related Piping

The NRC inspector observed welding activities on the following five field welds: Weld F005R-1 on Drawing I-M03BM01(Q) in the Steam Generator Blow-down piping system; Weld F038 on Drawing I-M03AE04(Q) in the Feedwater piping system; Weld F026A on Drawing I-M03EM01(Q) in the High Pressure Coolant Injection piping system; and Welds F040 and F051 on Drawing I-M03EJ02(Q) in the Residual Heat Removal piping system. In the areas inspected, no discrepancies were noted concerning traveler documentation, welder qualification, procedure compliance and material control.

The NRC inspector reviewed the supporting procedure qualification test reports, PQT 149 and 324, for Welding Technique N-1-3-BA-22, Revision 3, which was used for welding Welds F005R-1 and F038 above. The procedure qualification, in the areas reviewed, was consistent with requirements of Bechtel Specification 10466-M-204(Q) and ASME B&PV Code, Section III NC, and Section IX 1974 Edition through Summer 1975 Addenda.

No violations or deviations were identified.

7. Electrical Equipment and Components

- a. The NRC inspector reviewed the initial charging procedures and charge records for the Class IE Batteries NK-11, NK-12, NK-13 and NK-14. The initial charge was accomplished by KG&E personnel.

The NRC inspector reviewed the following documents:

Calibration Data Sheets For Battery Charges NK-21, NK-22, NK-23, and NK-24

Procedure SU8-003, "Special Electrical Procedure -.6 months. Initial Storage Charge Performed To Maintain Battery Warranty"

Pre-charge and Post-charge Data Sheets For Batteries NK-11, NK-12, NK-13 and NK-14

The NRC inspector inspected the battery rooms and the general installation and condition of batteries NK-11, NK-12, NK-13 and NK-14. During the inspection the NRC inspector observed that there were no cell spacers installed between the cells on any of the four Class IE Batteries. The NRC inspector found that the manufacturers Installation Drawings E-050-0006-02 and E-050-0009-02 show the cell spacers as Bill of Material Mark Number 14. However, the Gould Instruction book for battery installation does not reference the cell spacers and the cell spacers were not received on site. These cell spacers are generally utilized as a method of providing a degree of seismic restraint. IEEE 484, 1975, requires seismic restraint of the individual cells. Daniel's Assistant Project Electrical Engineer initiated a Request for Clarification of Information, RCI No. 7158, for Bechtel to determine if the cell spacers are required or the method of restraint to be utilized is in lieu of the cell spacers. This is an unresolved item.

- b. The NRC inspector reviewed Bechtel Specification 10466-E-009 for the Class IE 4160 Switchgear during closeout of potential 50.55(e) item in paragraph 3.e of this report. The NRC inspector found that Appendix A of this specification specifies a different color coding for redundant separation groups than that specified in the Final Safety Analysis Report (FSAR).

The Wolf Creek FSAR section 7.1.2.8 identifies the color coding for the separation groups as follows:

| | |
|---------------------|---------|
| Separation Group 1: | Red |
| Separation Group 2: | White |
| Separation Group 3: | Blue |
| Separation Group 4: | Yellow |
| Nonsafety | : Black |

Section 7.1.2.3 further states, "Within the control panel, where more than one separation group is present, wiring is identified by separation group. . . ."

Section 8.3.1.3 states, "Within control panels where more than one separation group is present, wiring is identified by separation group designation. . . ."

Section 8.3.1.3 further states, "In cases where the majority. . . is primarily one separation group, standard color wire and/or sleeves for the majority separation group is used. The remaining wiring is identified, using the appropriate color."

Bechtel Specification 10466-E-009 Appendix 7, Revision 6, paragraph 5.2.2 states, "Wiring of the various separation groups within the

switchgear shall be identified (color-coded) in accordance with the following:

- Separation Group 1: Red
- Separation Group 2: White
- Separation Group 3: Blue
- Separation Group 4: Green

This is an apparent deviation to the FSAR commitments.

8. Unresolved Items

Unresolved items are matters about which more information is required in order to ascertain whether they are acceptable items, items of noncompliance, or deviations. One unresolved item disclosed during the inspection is discussed in paragraph 7a.

9. Exit Interview

The NRC inspectors met with licensee representatives (denoted in paragraph 1) and the NRC Resident Reactor Inspector, T. E. Vandel, on March 26, 1981, and summarized the scope and findings of the inspection. No additional findings resulted from inspection activities continued on March 27, 1981.

FORM NRC 788
FEBRUARY 1978
(MC 0538)

UNITED STATES NUCLEAR REGULATORY COMMISSION
INSPECTION & ENFORCEMENT - STATISTICAL DATA

| | | | | | |
|---|--|---|--|--|--|
| FACILITY NAME: <u>Walters, H. & Co.</u> | | INSPECTOR(S): <u>L. G. 16 21</u> | | PRINCIPAL INSPECTOR: <u>TEVARD</u> | |
| LICENSEE/VEI DOOR: <u>Kent's Gas & Electric Co.</u> | | REVIEWER: <u>WACross</u> | | | |
| TRANS-ACTION TYPE 1 CHECK ONE: <input type="checkbox"/> Direct <input checked="" type="checkbox"/> Report <input type="checkbox"/> Monthly | 00. KEY NUMBER <u>05000482</u> OR LICENSE NO. (BY PRODUCT) <u>2</u> | (A) REPORT NO. <u>8105</u> | DATES INQ/INVEST/INSP FROM <u>032381</u> TO <u>032781</u> | | REGION CONDUCTING ACTIVITY <u>4</u> |
| INSPECTION PERFORMED BY: 1 <input checked="" type="checkbox"/> REGIONAL OFFICE STAFF 2 <input type="checkbox"/> RESIDENT INSPECTOR 3 <input type="checkbox"/> PERFORMANCE APPRAISAL TEAM | | | | | |
| TYPE OF ACTIVITY CONDUCTED (CHECK ONE BOX ONLY) | | | | | |
| 13-34 02 <input checked="" type="checkbox"/> SAFETY 03 <input type="checkbox"/> INCIDENT 04 <input type="checkbox"/> ENFORCEMENT | | 05 <input type="checkbox"/> MANAGEMENT AUDIT 06 <input type="checkbox"/> MANAGEMENT VISIT 07 <input type="checkbox"/> SPECIAL 08 <input type="checkbox"/> VENDOR | | 09 <input type="checkbox"/> MATL. ACCT. 10 <input type="checkbox"/> PLANT SEC. 11 <input type="checkbox"/> INVENT. VERIF. 12 <input type="checkbox"/> SHIPMENT/EXPORT 13 <input type="checkbox"/> IMPORT 14 <input type="checkbox"/> INQUIRY 15 <input type="checkbox"/> INVESTIGATION 16 <input type="checkbox"/> INVEST. ALSO CHECK BLOCK 51 | |
| INSPECTION OR INVESTIGATION WARNING: 1 <input type="checkbox"/> ANNOUNCED 2 <input checked="" type="checkbox"/> UNANNOUNCED | | | | | |
| INSPECTION SHIFT: 1 <input checked="" type="checkbox"/> DAY SHIFT 2 <input type="checkbox"/> OFF-SHIFT 3 <input type="checkbox"/> WEEKEND/HOLIDAY | | | | | |
| INSPECTION/INVESTIGATION NOTIFICATION (CHECK ONE BOX ONLY) | | | | | |
| 1 <input type="checkbox"/> 591 2 <input checked="" type="checkbox"/> REGIONAL OFFICE LETTER 3 <input type="checkbox"/> REFERRED TO HQS FOR ACTION 4 <input type="checkbox"/> REGION LETTER & HQS FOR ACTION | | | | | |
| INSPECTION/INVESTIGATION FINDINGS (CHECK ONE BOX ONLY) | | | | | |
| 1 <input type="checkbox"/> CLEAR 2 <input type="checkbox"/> NONCOMPLIANCE 3 <input checked="" type="checkbox"/> DEVIATION 4 <input type="checkbox"/> NONCOMPLIANCE & DEVIATION | | | | | |
| ENFORCEMENT CONFERENCE HELD: 1 <input type="checkbox"/> 39 | | | | | |
| M NUMBER OF NONCOMPLIANCE ITEMS IN LETTER TO LICENSEE: <u>00</u> N NUMBER OF DEVIATION ITEMS IN LETTER TO LICENSEE: <u>00</u> O NUMBER OF LICENSEE EVENTS: <u>44 45</u> NOTE: CHANGE MUST BE SUBMITTED ON 786 WHENEVER PREVIOUSLY CITED ITEM OF NONCOMPLIANCE IS OFFICIALLY DELETED FROM THE RECORD. | | | | | |
| P 48 INSPECTION FEE: 1 <input type="checkbox"/> NON-ROUTINE/VENDOR (No Fee) 2 <input type="checkbox"/> ROUTINE (No Fee) 3 <input type="checkbox"/> ROUTINE (Fee) 4 <input type="checkbox"/> ROUTINE (Fee Reduced) | | | | | |
| Q 47 CONTENTS 2.7900 INFORMATION: <input type="checkbox"/> YES | | | | | |
| REGIONAL OFFICE LETTER OR REPORT TRANSMITTAL DATE FOR INSPECTION OR INVESTIGATION | | | | | |
| 591 OR LETTER ISSUED TO LICENSEE <u>042781</u> M M D D Y Y | | REPORT SENT TO HQS FOR ACTION <u>54 59</u> M M D D Y Y | | IMMEDIATE ACTION LETTER <u>60 65</u> M M D D Y Y | |
| SUBJECT OF INVESTIGATION (CHECK ONE BOX ONLY) 66-67 | | | | | |
| TYPE A 01 <input type="checkbox"/> INTERNAL OVEREXPOSURE 02 <input type="checkbox"/> EXTERNAL OVEREXPOSURE 03 <input type="checkbox"/> RELEASE TO UNREST. AREA 04 <input type="checkbox"/> LOSS OF FACILITY 05 <input type="checkbox"/> PROPERTY DAMAGE | | TYPE B 06 <input type="checkbox"/> 07 <input type="checkbox"/> 08 <input type="checkbox"/> 09 <input type="checkbox"/> 10 <input type="checkbox"/> | | 10 CFR 20.405 11 <input type="checkbox"/> INT. OVEREXPOSURE 12 <input type="checkbox"/> EXT. OVEREXPOSURE 13 <input type="checkbox"/> EXCESS RAD. LEVELS 14 <input type="checkbox"/> EXCESS CONC. LEVELS 15 <input type="checkbox"/> CRITICALITY 16 <input type="checkbox"/> LOSS/THEFT 17 <input type="checkbox"/> MUF 18 <input type="checkbox"/> TRANSPORTATION 19 <input type="checkbox"/> CONTAM/LEAKING SOURCE 20 <input type="checkbox"/> ENVIRONMENTAL EVENT | |
| MISC. 21 <input type="checkbox"/> EQUIP. FAILURE 22 <input type="checkbox"/> ALLEGATION/COMPLAINT 23 <input type="checkbox"/> PUBLIC INTEREST 24 <input type="checkbox"/> SABOTAGE 25 <input type="checkbox"/> ABNORMAL OCCUR. 26 <input type="checkbox"/> OTHER | | | | | |
| HEADQUARTERS ENTRIES | | | | | |
| Y HQS ACTION ON INSP/INVEST REFERRED BY REGION: (See Reference List for Code) | | 70 <u>75</u> M M D D Y Y | | NOTE: BLOCKS K TO N MUST BE VERIFIED BY IE HQS WHENEVER ENTRIES ARE MADE IN BLOCKS T, U AND V | |
| U DATE HQS ENFORCEMENT LETTER, NOTICE, ORDER ISSUED: | | 76 <u>77 80</u> M M Y Y | | | |
| V CIVIL PENALTY ISSUED: 1 <input type="checkbox"/> | | | | | |
| W DATE 786 ENTERED INTO COMPUTER FILE (MO/YR): | | | | AITS REFERENCE | |

USNRC -- INSPECTION & ENFORCEMENT STATISTICAL DATA

NOTE: % COMPLETE AND STATUS:
 LEAVE BLANK FOR MC 02, 03 & 04
 PROCEDURES AND 30 702, 30 703 &
 30 800

NOTE: STATUS CODING:
 BLANK TO REMAIN OPEN
 C CLOSED
 L REOPEN & LEAVE OPEN
 P REOPEN THIS TRANSACTION
 (ONLY)

NOTE: MODULE REQUIRING
 FOLLOWUP
 USE ONLY WHEN MODULE
 INSPECTED IS 92 7010

| MODULE TRACKING INFORMATION | | | | | | | | | | NONCOMPLIANCE | | | | | | | | | | | | | |
|-----------------------------|------|------|-------|-------------|----|---------------------|--------|--------|-------|---------------------|------|------|-------|------|-------|------|-------|------|-------|------|-------|------|-------|
| MODULE NO INSP | | | | DIRECT INSP | | % COM PLETE TO DATE | | STATUS | | MODULE REQ FOLLOWUP | | | | N/C | | N/C | | N/C | | N/C | | N/C | |
| PHASE | CHAP | PROG | LEVEL | MANUAL | NO | EXPEND | MANUAL | NO | LEVEL | PHASE | CHAP | PROG | LEVEL | CODE | SEE V | CODE | SEE V | CODE | SEE V | CODE | SEE V | CODE | SEE V |
| 0 | 2 | 30 | 703B | | | 2 | | | | | | | | | | | | | | | | | |
| 1 | 292 | 702B | | | | 12 | | | | | | | | | | | | | | | | | |
| 2 | 292 | 706B | | | | 8 | | | | | | | | | | | | | | | | | |
| 3 | 255 | 173B | | | | 4 | | | | | | | | | | | | | | | | | |
| 4 | 255 | 103B | | | | 20 | | | | | | | | | | | | | | | | | |
| 5 | 251 | 053B | | | | 2 | | | | | | | | | | | | | | | | | |
| 6 | 251 | 055B | | | | 2 | | | | | | | | | | | | | | | | | |
| 7 | 292 | 701L | | | | 16 | | | | | | | | | | | | | | | | | |
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LINE COLUMN NUMBER SHOWN IN BOTTOM LINE



UNITED STATES
NUCLEAR REGULATORY COMMISSION
REGION IV
611 RYAN PLAZA DRIVE, SUITE 1000
ARLINGTON, TEXAS 76011

January 24, 1978

In Reply Refer To:

RIV

Docket No. STN 50-482/Rpt. 78-01

Kansas Gas and Electric Company
ATTN: Mr. G. L. Koester
Vice President Operations
Post Office Box 208
Wichita, Kansas 67201

Gentlemen:

This refers to the inspection conducted by Mr. C. R. Oberg and other members of the NRC staff during the period January 4-6, 1978, of activities authorized by NRC Construction Permit No. CPPR-147 for Wolf Creek, Unit No. 1, and to the discussion of our findings with Mr. J. O. Arterburn and other members of your staff at the conclusion of the inspection.

Areas examined during the inspection and our findings are discussed in the enclosed inspection report. Within these areas, the inspection consisted of selective examination of procedures and representative records, interviews with personnel, and observations by the inspector.

During the inspection, it was found that certain activities under your license appear to be in noncompliance with Appendix B to 10 CFR 50 of the NRC Regulations, "Quality Assurance Criteria for Nuclear Power Plants." The items of noncompliance and references to the pertinent requirements are identified in the enclosed Notice of Violation.

One new unresolved item is identified in paragraph 9 of the enclosed report.

This notice is sent to you pursuant to the provisions of Section 2.201 of the NRC's "Rules of Practice," Part 2, Title 10, Code of Federal Regulations. Section 2.201 requires you to submit to this office, within 30 days of your receipt of this notice, a written statement or explanation in reply including:

- (1) corrective steps which have been taken by you, and the results achieved;
- (2) corrective steps which will be taken to avoid further noncompliance; and
- (3) the date when full compliance will be achieved.

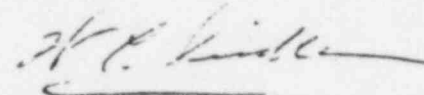
~~8412200215-PDR~~
ZPP

January 24, 1978

In accordance with Section 2.790 of the NRC's "Rules of Practice," Part 2, Title 10, Code of Federal Regulations, a copy of this letter and the enclosed inspection report will be placed in the NRC's Public Document Room. If this report contains any information that you believe to be proprietary, it is necessary that you submit a written application to this office, within 20 days of the date of this letter, requesting that such information be withheld from public disclosure. The application must include a full statement of the reasons why it is claimed that the information is proprietary. The application should be prepared so that any proprietary information identified is contained in an enclosure to the application, since the application without the enclosure will also be placed in the Public Document Room. If we do not hear from you in this regard within the specified period, the report will be placed in the Public Document Room.

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

Sincerely,



W. C. Seidle, Chief
Reactor Construction and
Engineering Support Branch

Enclosure:

1. Appendix A, Notice of Violation
2. IE Inspection Report No. STN 50-482/78-01

Appendix A

NOTICE OF VIOLATION

Based on the results of the NRC inspection conducted on January 4-6, 1978, it appears that certain of your activities were not conducted in full compliance with conditions of your NRC Construction Permit No. CPPR-147 as indicated below:

1. 10 CFR Part 50, Appendix B, Criterion V requires that activities affecting quality shall be prescribed by documented instructions, procedures, or drawings of a type appropriate to the circumstances and shall be accomplished in accordance with these instructions, procedures, or drawings.

Bechtel specification No. 10466-C115 requires Cadweld splices to be tested on a frequency so that one production splice be tested out of the first ten production splices, and that one production and three sister splices be tested out of the next ninety splices.

Contrary to the above, on or about September 20, 1977, the ninety splices tested beyond the original ten splices for splicer ID No. "N," failed to include a production splice. This splice was part of the containment base mat.

This is an infraction.

2. 10 CFR Part 50, Appendix B, Criterion VI requires that measures shall assure that documents are reviewed for adequacy by authorized personnel.

SNUPPS QA manual, Section 17 B.1.6, Document Control, requires that documents, such as instructions and drawings shall be reviewed, prior to release, to assure that quality requirements are sufficiently, clearly and accurately stated.

Contrary to the above, drawings for the Reactor Base Mat, Drawings FD-C Cadweld 58, Rev. 0, and FD-C Cadweld 71, Rev. 0, were released to document control without the required review and approval.

This is an infraction.

8412200220
PDR LP

U. S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT

REGION IV

Report No. STN 50-482/78-01

Docket No. STN 50-482

Category A2

Licensee: Kansas Gas and Electric Company
Post Office Box 208
Wichita, Kansas 67201

Facility Name: Wolf Creek, Unit No. 1 (SNUPPS)

Inspection at: Wolf Creek Site, Burlington, Coffey County, Kansas

Inspection conducted: January 4-6, 1978

Inspector:

for W. A. Crossman
C. R. Oberg, Reactor Inspector, Projects Section
(Paragraphs 1, 2, 3, 4, 5, 10 & 11)

1/19/78
Date

L. D. Gilbert
L. D. Gilbert, Reactor Inspector, Engineering Support
Section (Paragraphs 6 & 7)

1/19/78
Date

for W. A. Crossman
T. L. Elsasser, Reactor Inspector, Region I
(Paragraph 8)

1/19/78
Date

for W. A. Crossman
J. C. Mattia, Reactor Inspector, Region I
(Paragraph 9)

1/19/78
Date

Approved:

W. A. Crossman
W. A. Crossman, Chief, Projects Section

1/19/78
Date

R. E. Hall
R. E. Hall, Chief, Engineering Support Section

1/19/78
Date

~~8412200232~~
PDR 147P

Inspection Summary:

Inspection on January 4-6, 1978 (Report No. STN 50-482/78-01)

Areas Inspected: Internal audit reports; observation of containment base mat; review of quality records pertaining to the base mat concrete placement; review of Essential Service Water pipe welding records; observation of containment liner welding; review of QA procedures relating to safety related structures and supports; observation of work and review of quality records pertaining to the Auxiliary Building structural steel. The inspection involved seventy-eight inspector-hours on site by four NRC inspectors.

Results: Of the eight areas inspected, no apparent items of noncompliance were identified in seven areas; two items of noncompliance were identified in one area (infraction - failure to follow testing frequency for production Cadwelds, paragraph 4; infraction - failure to review as-built drawings, paragraph 5).

DETAILS

1. Persons Contacted

Principal Licensee Personnel

- *J. O. Arterburn, Superintendent of Nuclear Development
- *M. E. Clark, Manager, Quality Assurance, Site

Daniel International

- *W. E. Hitt, Project Manager
- *C. T. Kinney, Construction Manager
- R. N. Key, Civil QC Supervisor
- *D. L. Jones, QC Manager
- *A. S. Harper, Engineering Manager
- *C. L. Phillips, Project Civil Engineer
- *G. W. Reeves, QA Engineer
- D. J. Dennison, Assistant QC Manager
- C. A. Sturgill, Acting Lead QC Mechanical/Welding Engineer
- S. O. Tackett, QC Mechanical/Welding Engineer
- J. A. Roach, Project Welding Engineer
- I. Hussain, QA Manager
- E. Dixon, Services QC Engineer
- S. A. Johnson, Civil QC Inspector
- J. C. Aldridge, Lead QC Receiving Inspector
- S. Bender, QC Inspector

SNUPPS

- R. D. Brown, Site Representative

Chicago Bridge & Iron

- W. F. Hiser, Project Welding and QA Supervisor
- C. L. Richards, Project Superintendent
- L. W. Brook, Welding Inspector

The inspector also interviewed several other licensee and construction employees during the course of the inspection. They included members of the Document Control Section, QC inspectors and general office personnel.

*denotes those attending the exit interview.

2. Site Tour

The inspector walked through the various areas of the site to observe the construction activities in progress, to inspect the base mat placement subsequent to removal of the forms, to review the welding of the containment liner plate, and to check the general state of housekeeping during construction.

No items of noncompliance or deviations were identified.

3. Licensee Internal Audits

The inspector reviewed the following audit reports issued by Daniel:

Quality Assurance Report No. 26, 11/3/77

Quality Assurance Report No. 27, 12/8/77

Quality Assurance Report No. 28, 01/4/78

The inspector determined that Daniel International had conducted audits in the following areas related to base mat placement:

Concrete Pre-placement

Mechanical Splicing of Reinforcing Steel

Reinforcing Steel Placement

Civil Testing Lab Procedure (Destructive)

Concrete Placement

Concrete Batch Plant Qualification

Concrete Mixing and Delivery

Storage of Concrete Materials

Post Placement of Concrete

No items of noncompliance or deviations were identified.

4. Review of Quality Records for Containment Base Mat Placement

The inspector reviewed the records associated with the concrete placement for the reactor base mat (Placement No. OC221507). The inspector examined the records for conformance to established procedures and determined that they reflect work actually accomplished. Specifically, the following records were examined:

- a. Preplacement Checklists.
- b. Delivery and Placement records including delivery of specified mix, batch (trip) tickets, records of required tests taken and placement inspection records.
- c. Curing records - the records reviewed included concrete temperature, ambient temperature, duration of curing, and post placement inspection report.
- d. Rebar Splicing - records reviewed included:
 - (1) Individual Cadweld splicer logs (September - November, 1977)
 - (2) Daily Cadweld Inspection Reports (August - December, 1977)
 - (3) Cadweld Test Report No. 1-31
 - (4) As-built drawings of Cadweld splices and rebar placement (see paragraph 5)
 - (5) Audits of Mechanical Splicing of Reinforcing Steel (QAR #26) (see paragraph 3)

The inspector also reviewed Deficiency Reports (DR) and Nonconformance Reports (NCR) relating to concrete placement as listed:

DR

C-00302, 297 and 288

NCR

1-00102, 103, 114 and 116-120

Specification No. 10466-C115, paragraph 7.2.1 requires Cadweld splices to be tested with a specific frequency. While reviewing the records for individual (team) splicer ID "N", the inspector observed that a horizontal sister splice (NH-135-S) had been tested in lieu of a required production splice.

This is considered an item of noncompliance.

5. As-Built Drawings for Cadweld Location

The inspector reviewed the as-built drawings which locate and identify original and replacement splices for those production splices removed for destructive testing. On drawings FD-C Cadweld 58, Rev. 0 and FD-C Cadweld 71, Rev. 0, it was noted that the Cadweld locations were not drawn in accordance with the location information supplied by QC (Daily Cadweld Reports). The same condition existed on all similar drawings. A review of the following Daniel Procedures was then made:

AP-III-02, Rev. 0 (9/13/76) As-Built Drawings

QCP-I-05, Rev. 1 (8/22/77) QC Processing of QA Records

QCP-IV-102, Rev. 1 (9/1/77) Mechanical Splicing of Reinforcing Steel

WP-IV-102, Rev. 1 (10/20/77) Mechanical Splicing of Reinforcing Steel

Section 17 B.1.6, Document Control, of the SNUPPS PSAR assigns responsibilities for the implementation of measures to control the review and approval of quality documents, including drawings.

The inspector concluded that the requirements of the above procedures did not provide for a quality review of Cadweld splice as-built drawings. This item was discussed with the licensee and his representatives.

This is considered an item of noncompliance.

6. Essential Service Water Piping

The inspector reviewed the quality records for weld No. F-074 of the Essential Service Water piping system identified on Daniel drawing No. 206. The open root, butt joint was welded by Daniel using a combination of the gas tungsten-arc and shielded metal-arc welding processes with E70S-2 and E7018 welding material. The completed weld was magnetic particle inspected, by a Peabody certified Level III MT inspector, to the requirements of ASME B&PV Code, 1974 edition ND 5000.

No items of noncompliance or deviations were identified.

7. Containment Liner

The inspector observed the work accomplished by Chicago Bridge and Iron (CB&I) in fabricating the reactor containment liner floor. The liner plate butt joints were welded with E6010 for the root pass and E7018 for the remainder, using General Weld procedure GWPS-SMA, Rev. 1 and weld procedure specification E7018/74-3750/59, Rev. 2. Welders were identified as qualified for the welding process, electrode and position

used for welding the liner floor. Fabrication of the liner by CB&I was found to be in accordance with Bechtel Technical Specification No. 10466-C151(Q), Rev. 10.

No items of noncompliance or deviations were identified.

E. Review of Quality Assurance Implementing Procedures for Safety Related Structures and Supports

The inspector determined that appropriate and adequate procedures are included or referenced in the QA manual to assure that the following activities are controlled and performed according to NRC requirements and PSAP commitments:

- Procedures which identify where witnessing or inspecting is required during the erection of structural steel.
- Procedures for receiving inspection.
- Procedures for storage, protection, issue, identification and records of materials and components used for safety related structures.
- Procedure for QC inspection of installation of structures and supports.

The following specification, work procedure (WP), quality control procedures (QCPs) and Administrative procedures (APs) were reviewed by the inspector:

- Bechtel Specification No. 10466-C122(Q), Rev. 7, 9/9/77
- Daniel Work Procedures
 - WP-I-01, Rev. 3, 8/8/77
 - WP-IV-III, Rev. 0, 11/7/77
- Daniel Quality Control Procedures
 - QCP-I-01, Rev. 1, 3/28/77
 - QCP-IV-III, Rev. 0, 11/16/77
- Daniel Administrative Procedures
 - AP-VI-02, Rev. 2, 9/29/77

No items of noncompliance or deviations were identified.

9. Observation of Work and Review of Quality Related Records, Auxiliary Building Steel

The inspector verified that provisions of the Bechtel specification and the Daniel procedures referenced in paragraph 8 were being met in the following areas:

a. Storage

The inspector observed that the storage of several QC accepted structural beams (K 6710, 609-B1-124, 621-B1-123, 506-B7-101) for the Auxiliary Building was satisfactory. During this inspection, the inspector noted that the beams covered by deficiency report CR-141, 8/19/77, were segregated by the use of a rope-flag system. Further inspection revealed that several of the beams identified on the applicable tag were not inside the roped off area. Although the segregation of non-acceptable material was satisfactory, i.e., no green "acceptance" marking, the rope barricade had not been extended to define the full limit of the hold area. The licensee agreed to instruct QC personnel in the proper use of the rope barricade.

This item is considered unresolved and will be reviewed during a subsequent inspection.

b. Receipt Inspection

The inspector verified that the acceptable stored beams identified in paragraph a. above were properly inspected upon receipt at the site. For those and the following additional beams:

K 6711

50-B2-351

56-B1-361

114-B3

103-CA-NA

The documentation, as applicable, was reviewed:

Material Receiving Reports (7702, 5997, 4047, 3159, 3320)

Receiving Quality Control Inspection Reports

Material Test Reports

Nondestructive Examination Reports

No items of noncompliance or deviations were identified.

c. Observation of Completed Work

The inspector observed bolted connections for Auxiliary Building beam K 6710 114-B3 and column 103 C4 NA. The inspector verified that the bolts, nuts and load indicating washers were of the proper type. Final torquing and QC inspection had not been completed. The inspector verified the components were in the proper location per American Bridge drawing K 6710 E101, Rev. 1. The inspector also reviewed the QC inspector's records for inspections performed to date concerning erection of structural steel. The records adequately reflected the status of work and completed QC inspections.

No items of noncompliance or deviations were identified.

d. Qualification of QC Inspectors

The inspector reviewed the qualification records of a sample of civil QC inspectors to verify that qualification was in accordance with the provisions of ANSI N45.2.6 and Daniel procedure AP-VI-01, Rev. 1, 4/12/77. The inspector reviewed the qualification records for:

One QC Civil Inspector ^{1/}

The QC Civil Field Supervisor

No items of noncompliance or deviations were identified.

e. Deficiency Reports

Deficiency reports pertaining to Auxiliary Building structural steel were reviewed by the inspector. The inspector ascertained that the records are legible, complete, retrievable and that corrective action had been specified. The following reports were reviewed:

Deficiency Report CR-047

Deficiency Report CR-141

No items of noncompliance or deviations were identified.

^{1/} Identification of the QC Civil Inspector is maintained in the Regional Office files.

10. Unresolved Items

Unresolved items are matters about which more information is required in order to ascertain whether they are acceptable items, items of noncompliance, or deviations. An unresolved item disclosed during the inspection is discussed in paragraph 9.

11. Exit Interview

The inspector met with the licensee representatives (denoted in paragraph 1) at the conclusion of the inspection on January 6, 1978. The inspector summarized the scope of the inspection and the findings. The licensee representative acknowledged the noncompliances identified by the inspector and stated that steps would be taken to correct the situation.

UNITED STATES NUCLEAR REGULATORY COMMISSION
INSPECTION & ENFORCEMENT - STATISTICAL DATA

| | | | | | | | | | |
|---|---|---|--|-------------------------------------|---|---|---|---|--|
| FACILITY NAME: Wolf Creek, Unit No. 1 | | INSPECTOR: CROBERG | | PRINCIPAL INSPECTOR: CROBERG | | | | | |
| LICENSEE/VENDOR: Kansas Gas & Electric Co. | | INSPECTOR: 20610101 | | REVIEWER: WACrossman | | | | | |
| TRANS-ACTION TYPE 1 <input checked="" type="checkbox"/> CHECK ONE 2 <input type="checkbox"/> OTHER | DOCKET NUMBER 2 9 05000482 | | (A) REPORT NUMBER 15 18 7801 | | DATES INTO INVEST/INSP FROM 19 24 (C) 010478 M M D D Y Y TO 25 30 (D) 010678 M M D D Y Y | | | | |
| | OR LICENSE NO. (BY PRODUCT) 2 14 <div style="border: 1px solid black; width: 100px; height: 15px;"></div> | | | | REGION CONDUCTING ACTIVITY (E) 31 4 | | | | |
| INSPECTION PERFORMED BY: 32 <input checked="" type="checkbox"/> REGIONAL OFFICE STAFF <input type="checkbox"/> RESIDENT INSPECTOR | | | | | | | | | |
| 3 <input type="checkbox"/> PERFORMANCE APPRAISAL TEAM | | | | | | | | | |
| TYPE OF ACTIVITY CONDUCTED (CHECK ONE BOX ONLY) 33-34 | | | | | | | | | |
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| N NUMBER OF DEVIATION ITEMS IN LETTER TO LICENSEE: 42 43 <div style="border: 1px solid black; width: 40px; text-align: center;">00</div> | | | | | | | | | |
| O NUMBER OF LICENSEE IDENTIFIED ITEMS: 44 45 <div style="border: 1px solid black; width: 40px; text-align: center;">00</div> | | | | | | | | | |
| P NUMBER OF LICENSEE EVENTS: 46 47 <div style="border: 1px solid black; width: 40px; text-align: center;">00</div> | | | | | | | | | |
| REGIONAL OFFICE LETTER OR REPORT TRANSMITTAL DATE FOR INSPECTION OR INVESTIGATION | | | | | | | | | |
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| SUBJECT OF INVESTIGATION (CHECK ONE BOX ONLY) 66-67 | | | | | | | | | |
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| U CIVIL PENALTY ISSUED 76 <input type="checkbox"/> | | | | | | | | | |
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NOTE: BLOCKS K TO U MUST BE VERIFIED BY IE HOS WHENEVER ENTRIES ARE MADE IN BLOCKS S, T AND U

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REFERENCE

Wolf Creek STN 50-482/78-01

USNRC - INSPECTION & ENFORCEMENT STATISTICAL DATA

(NOTE: % COMPLETE AND STATUS:
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PROCEDURES AND 30 702, 30 703 &
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NOTE: STATUS CODING:
BLANK - TO REMAIN OPEN
C- CLOSED
L- REOPEN & LEAVE OPEN
R- REOPEN THIS TRANSACTION
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NOTE: MODULE REQUIRING FOLLOWUP:
USE ONLY WHEN MODULE INSPECTED IS 92-7018.

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☐ CONTINUES ON SUBSEQUENT SHEET

UNITED STATES NUCLEAR REGULATORY COMMISSION
INSPECTION & ENFORCEMENT-STATISTICAL DATA SUPPLEMENT

GENERAL INSTRUCTIONS: BLOCK A MUST BE CHECKED TO SHOW TYPE OF INFORMATION CONTAINED ON THE FORM. ONE FORM IS TO BE COMPLETED FOR EACH:
(A) ITEM OF NONCOMPLIANCE CITED.
(B) ITEM OF NONCOMPLIANCE NOT CITED, AND,
(C) DEVIATION CITED IN ENFORCEMENT CORRESPONDENCE

DOCKET NUMBER STN 50-482

OR LICENSE NUMBER _____ REPORT NUMBER 78-01

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| 1 | A-TYPE OF FINDINGS (CHECK ONE BOX ONLY) | | B-SPECIFIC N/C CODE OR DEVIATION | | CAUSE | PROCEDURE | SEVERITY | FUNCTIONAL AREA | |
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| 20 | I | <input checked="" type="checkbox"/> INSPECTOR | 21 P <input type="checkbox"/> HAD POTENTIAL TO RESULT IN ACTUAL OCCURRENCE | | | | | | |
| | D | <input type="checkbox"/> OTHER | N <input checked="" type="checkbox"/> DID NOT HAVE POTENTIAL TO RESULT IN ACTUAL OCCURRENCE | | | | | | |
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| 22 | S | <input type="checkbox"/> CHECK BOX IF EXEMPT INFORMATION IS INCLUDED IN TEXT BELOW, PER 10 CFR 2.790 | 23 25 | | | | | | |
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| | | | H-NONCOMPLIANCE REPETITIVE OCCURRENCE (IF FIRST OCCURRENCE ENTER "1") | | | | | | |
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| 1 | Contrary to 10 CFR 50, Appendix B, Criterion VI and SNUPPS QA manual, (1) | | | | | | | | |
| | Section 17.B.1.6, as-built drawings for the location of Cadweld splices (2) | | | | | | | | |
| | were not reviewed for accuracy of information. (3) | | | | | | | | |
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UNITED STATES NUCLEAR REGULATORY COMMISSION
INSPECTION & ENFORCEMENT—STATISTICAL DATA SUPPLEMENT

GENERAL INSTRUCTIONS: BLOCK A MUST BE CHECKED TO SHOW TYPE OF INFORMATION
CONTAINED ON THE FORM. ONE FORM IS TO BE COMPLETED FOR EACH
(A) ITEM OF NONCOMPLIANCE CITED.
(B) ITEM OF NONCOMPLIANCE NOT CITED, AND,
(C) DEVIATION CITED IN ENFORCEMENT CORRESPONDENCE.

DOCKET NUMBER STN 50-482

OR LICENSE NUMBER _____ REPORT NUMBER 78-01

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| <div>1</div> <div>S</div> | A—TYPE OF FINDINGS (CHECK ONE BOX ONLY) A <input checked="" type="checkbox"/> NONCOMPLIANCE 2 B <input type="checkbox"/> LICENSEE IDENTIFIED ITEMS C <input type="checkbox"/> DEVIATION | B—SPECIFIC N/C CODE OR DEVIATION 3 7 E E B 8 9 10 11 12 P B 2 C—MODULE NUMBER 13 19 2 4 7 0 5 5 B |
| | D—HOW ITEM IDENTIFIED (CHECK ONE BOX ONLY) L <input type="checkbox"/> LICENSEE 20 I <input checked="" type="checkbox"/> INSPECTOR Q <input type="checkbox"/> OTHER | E—CONSEQUENCES (CHECK ONE BOX ONLY) A <input type="checkbox"/> CAUSE OR CONSTITUTED ACTUAL OCCURRENCE 21 P <input type="checkbox"/> HAD POTENTIAL TO RESULT IN ACTUAL OCCURRENCE N <input checked="" type="checkbox"/> DID NOT HAVE POTENTIAL TO RESULT IN ACTUAL OCCURRENCE |
| F—EXEMPT INFORMATION 22 S <input type="checkbox"/> CHECK BOX IF EXEMPT INFORMATION IS INCLUDED IN TEXT BELOW, PER 10 CFR 2.790 | | G—ADDITIONAL UNITS (ENTER "N" IN FIRST BOX FOLLOWED BY OTHER UNIT NUMBERS) 23 26 H—NONCOMPLIANCE REPETITIVE OCCURRENCE (IF FIRST OCCURRENCE ENTER "1") 27 |
| I—TEXT (ENTER UP TO 2400 CHARACTERS FOR EACH ITEM). IF THE TEXT OF THE NONCOMPLIANCE OR DEVIATION EXCEEDS THIS NUMBER, IT WILL BE NECESSARY TO PARAPHRASE) | | |
| <div>1</div> <div>Contrary to 10 CFR 50, Appendix B, Criterion V and specification</div> <div>10466-C115, the frequency for testing of production Cadwelds was not</div> <div>followed.</div> <div>(1)</div> <div>(2)</div> <div>(3)</div> <div>(4)</div> <div>(5)</div> <div>(6)</div> <div>(7)</div> <div>(8)</div> <div>(9)</div> <div>(10)</div> <div>(11)</div> <div>(12)</div> <div>(13)</div> <div>(14)</div> <div>(15)</div> <div>(16)</div> <div>(17)</div> <div>(18)</div> <div>(19)</div> <div>(20)</div> <div>(21)</div> <div>(22)</div> <div>(23)</div> <div>(24)</div> <div>(25)</div> <div>(26)</div> <div>(27)</div> <div>(28)</div> <div>(29)</div> <div>(30)</div> <div>(31)</div> <div>(32)</div> <div>(33)</div> <div>(34)</div> <div>(35)</div> <div>(36)</div> <div>(37)</div> <div>(38)</div> <div>(39)</div> <div>(40)</div> <div>(41)</div> <div>(42)</div> <div>(43)</div> <div>(44)</div> <div>(45)</div> <div>(46)</div> <div>(47)</div> <div>(48)</div> | | |
| <div>E E N D</div> <div>NOTE: DATA ENTRY CLERK—THE LAST LINE ENTERED MUST CONTAIN THIS INFORMATION</div> <div>1 5</div> <div>(OVER)</div> | | |



UNITED STATES
NUCLEAR REGULATORY COMMISSION
REGION IV
611 RYAN PLAZA DRIVE, SUITE 1000
ARLINGTON, TEXAS 76012

ENCLOSURE 2

February 26, 1980

In Reply Refer To:

RIV

Docket No. STN 50-482/Rpt. 80-03

Kansas Gas and Electric Company
ATTN: Mr. G. L. Koester
Vice President Operations
Post Office Box 208
Wichita, Kansas 67201

Gentlemen:

This refers to the inspection conducted by Messrs. L. E. Martin and L. D. Gilbert of our staff during the period February 11-14, 1980, of activities authorized by NRC Construction Permit No. CPPR-147 for Wolf Creek, Unit No. 1, and to the discussion of our findings with Mr. M. E. Clark and other members of your staff at the conclusion of the inspection.

Areas examined during the inspection and our findings are discussed in the enclosed inspection report. Within these areas, the inspection consisted of selective examination of procedures and representative records, interviews with personnel, and observations by the inspectors.

Within the scope of the inspection, no items of noncompliance were identified.

We have also examined actions you have taken with regard to a previously identified inspection finding. The status of this item is identified in paragraph 2 of the enclosed report.

In accordance with Section 2.790 of the NRC's "Rules of Practice," Part 2, Title 10, Code of Federal Regulations, a copy of this letter and the enclosed inspection report will be placed in the NRC's Public Document Room. If the report contains any information that you believe to be proprietary, it is necessary that you submit a written application to this office, within 20 days of the date of this letter, requesting that such information be withheld from public disclosure. The application must include a full statement of the reasons why it is claimed that the information is proprietary. The application should be prepared so that any proprietary information identified is contained in an enclosure to the application, since the application without the enclosure will also be placed in the Public Document Room. If we do not hear from you in this regard within the specified period, the report will be placed in the Public Document Room.

~~8005280075~~
PDR 2A

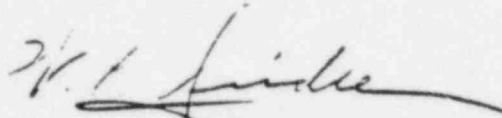
Kansas Gas and Electric
Company

-2-

February 26, 1980

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

Sincerely,



W. C. Seidle, Chief
Reactor Construction and
Engineering Support Branch

Enclosure:

IE Inspection Report No. STN 50-482/80-03

U. S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT

REGION IV

Report No. STN 50-482/80-03

Docket No. STN 50-482

Category A2

Licensee: Kansas Gas and Electric Company
P. O. Box 208
Wichita, Kansas 67201

Facility Name: Wolf Creek, Unit No. 1

Inspection at: Wolf Creek Site, Coffey County, Burlington, Kansas

Inspection conducted: February 11-14, 1980

Inspectors:

W. A. Crossman
for L. E. Martin, Reactor Inspector, Projects Section
(Paragraphs 1, 2, 3, 5 & 6)

2/25/80
Date

L. D. Gilbert
L. D. Gilbert, Reactor Inspector, Engineering Support
Section (Paragraph 4)

2/25/80
Date

Reviewed:

W. A. Crossman
for C. R. Oberg, Reactor Inspector, Projects Section

2/25/80
Date

Approved:

W. A. Crossman
W. A. Crossman, Chief, Projects Section

2/25/80
Date

R. E. Hall
R. E. Hall, Chief, Engineering Support Section

2/25/80
Date

~~8005280087~~
PDR app

Inspection Summary:

Inspection on February 11-14, 1980 (Report No. STN 50-482/80-03)

Areas Inspected: Licensee action on a previously identified item of noncompliance; safety-related piping; review of records and observation of work for safety-related steel supports; and site tour. The inspection involved forty-eight inspector-hours on site by two NRC inspectors.

Results: No items of noncompliance or deviations were identified.

DETAILS

1. Persons Contacted

Principal Licensee Personnel

- *M. E. Clark, Manager, Quality Assurance, Site
- *D. W. Prigel, Assistant Manager, Quality Assurance, Site
- *S. J. Walmsley, QA Technician
- *G. L. Fouts, Construction Manager, Site

Daniel International

- *W. E. Hitt, Project Manager
- *R. D. Scott, Construction Manager
- *V. J. Turner, Project Quality Assurance Manager
- *D. L. Jones, Quality Control Manager
- *D. J. Dennison, Assistant QC Manager
- B. G. Bullard, Project Welding Engineer
- *T. R. Barber, Assistant Welding Engineer
- P. C. Schaffer, Supervisor-Mechanical Welding QC
- G. Martin, General Foreman, Welder Qualification
- D. C. Bondurant, Mechanical Engineer
- D. J. Harris, Area Civil Engineer

Others

- *R. D. Brown, Site Representative, SNUPPS
- *W. R. Seiple, Resident Geotech, Dames & Moore
- *E. Glasbergen, Site Manager, Westinghouse

The IE inspectors also interviewed other licensee and contractor personnel including members of the QA/QC and engineering staffs.

*Denotes those attending the exit interview.

2. Licensee Action on Previous Inspection Finding

(Closed) Item of Noncompliance (STN 50-482/79-17): Failure to Follow Procedures for Blasting Operations. The IE inspector reviewed the Dames & Moore records for the blasting performed on September 15, 1979, and the subsequent Daniel approved qualifications of Mr. R. D. Blake. Clarkson Blasting Procedure (B-1), Revision 2 now includes the Daniel approved blasting specialist's qualifications as an enclosure and requires the blasting specialist's name to appear on the cover sheet of the blasting plan.

This item is considered closed.

3. Site Tour

The IE inspectors made a tour of the Reactor Building, Auxiliary Building, and other general plant areas to observe construction activities in progress and to inspect housekeeping.

The IE inspectors advised the licensee representative of two areas (one inside containment around the base of the accumulators and one area in the cable spread room) which needed attention with regard to housekeeping. These two areas were cleaned the next morning.

No items of noncompliance or deviations were identified.

4. Safety-Related Piping

The IE inspector observed the various phases of welding safety-related piping which included fit-up of an insert ring for field weld F-001 on the Containment Spray System drawing I-M03EN02(Q); automatic gas tungsten-arc welding of field weld F-049 on the Boron Refueling Water Storage System drawing I-M03BN01(Q); gas tungsten-arc welding of shop weld W-823 on the Chemical and Volume Control System drawing P-M03BG09(Q); and tack welding of shop weld W-501 on the Chemical and Volume Control System drawing P-M03BG15(Q). In the areas inspected, no discrepancies from the requirements of welding procedure CWP-507 were noted.

The automatic gas tungsten-arc welding procedure specification NM-8-8-B-2 for stainless steel pipe and supporting procedure qualification test reports PQT-109, 111 and 180 were reviewed by the IE inspector. In the areas reviewed, no discrepancies from the requirements of ASME B&PV Code, Section III or IX, 1974 Edition through Summer 1975 Addenda were noted.

Welding filler materials were observed to be controlled and stored as required by procedure CWP-503. The traceability and certification of three filler material heat numbers used for welding safety-related piping were confirmed by the IE inspector to be in compliance with procedure CWP-503. The heat numbers checked were 462570, 464176 and C3547R308.

Three welders were observed taking performance qualification tests. The pipe position, material and welding processes being used were consistent with the requirements specified in welder qualification procedure CWP-502 for qualifying to ASME Code, Section IX.

No items of noncompliance or deviations were identified.

5. Safety-Related Steel Supports

a. Records Review

The IE inspector reviewed the following procedures, drawings, travelers and records for compliance with FSAR, 10 CFR 50 Appendix B and manufacturer's instructions for the installation of the below indicated steel supports.

QCP-I-01, Rev. 8, "Receipt Storage & Preservation of Safety-Related Material"

AP-VI-08, Rev. 6, "Identification & Status of Material, Parts, & Components"

AP-IV-02, Rev. 2, "Nonconformance Control and Reporting"

QCP-IV-509, Rev. 1, "Inspection of Stud Welding"

CWP-509, Rev. 1, "Stud Welding"

MRR 9198 (P.O. 10466 C 134A) Steam Generator Anchor Bolts

MRR 30576 (P.O. 546 CVW 263752) Steam Generator Base Assemblies

MRR 31507 (P.O. 546 CVW 263752) Steam Generator Vertical Column

Dwg. M-717-008, Rev. 6

Dwg. M-717-002, Rev. 6

Dwg. M-717-007, Rev. 5

Dwg. M-717-003, Rev. 7

Traveler I-FBB01-VC, Rev. 1 for Reactor Coolant Pumps A-D Vertical Supports

Traveler I-PBB01-TR, Rev. 0 for Reactor Coolant Pumps A-D Tie-Rod Supports

Traveler I-EBB01-VC, Rev. 2 for Steam Generator Vertical Supports

Traveler I-TBB03, Rev. 0 for Pressurizer to Pressurizer Base Attachment

NCR 1SN 1485 MR

NCR 1SN 0898 M

NCR 1SN 1727 M

NCR 2SN 00915 M (Callaway)

Request for Storage-In-Place (SIP) 1485

KG&E QA Surveillance Report S05 of April 21, 1978

No items of non-compliance or deviations were identified.

b. Observation of Work

The IE inspector observed the in-process work and status of vertical supports for all four steam generators, all four reactor coolant pumps, and the pressurizer lower support. All four reactor coolant pump casings are in-place on the vertical supports, and three steam generators are in-place. The IE inspector observed the assembling of two of the vertical columns for the fourth steam generator and inspected two vertical columns to determine that the correct parts were used in assembly and properly documented as required by the associated traveler. During the assembly of one of the steam generator vertical assemblies, the craft experienced considerable alignment difficulties. In the process of assembling the upper forging to the vertical column, the bearing was displaced approximately one inch from center as the pin was driven through. The Westinghouse Site Manager advised the IE inspector that this was not a significant problem. The IE inspector reviewed an NCR 2SN 00915 M from the Callaway project where the same situation had previously been experienced. The bearing was subsequently centered in the vertical column.

The IE inspector observed the status of the setting of the pressurizer. During this observation and review, the IE inspector noticed that the heat numbers for the shims between the pressurizer support skirt and the support had not been recorded. The pressurizer is just sitting on the support; the leveling and torquing has not been done. These shims can easily be removed to facilitate recording the numbers as required by the traveler. The licensee representative stated that this will be accomplished prior to torquing the hold-down bolts.

Also during the observation of the status of the pressurizer, the Mechanical Engineer who was accompanying the IE inspector noticed some cracked tack welds on a ring inside the pressurizer support skirt. Subsequent discussions with the Westinghouse Site Manager indicated that this ring and the associated welds were used only for sealing the pressurizer during shipping and storage. The Daniel engineer initiated NCR 1SN 1727 M to insure follow up and disposition of the cracked tack welds.

No items of noncompliance or deviations were identified.

6. Exit Interview

The IE inspectors met with licensee representatives (denoted in paragraph 1) at the conclusion of the inspection on February 14, 1980. The IE inspectors summarized the scope and findings of the inspection.

UNITED STATES NUCLEAR REGULATORY COMMISSION
INSPECTION & ENFORCEMENT - STATISTICAL DATA


| | | | | | | | |
|---|--|--|---|-------------------------------|--|-----------------------------------|--|
| MC 05351 | | FACILITY NAME <u>Wolf Creek, Unit No. 1</u> | | INSPECTOR(S) <u>LE Martin</u> | | PRINCIPAL INSPECTOR <u>ROBERT</u> | |
| LICENSEE/VENDOR <u>Kansas Gas & Electric Co.</u> | | REVIEWER <u>WACrossman</u> | | | | | |
| TRANS-ACTION TYPE 1 (CHECK ONE) <input type="checkbox"/> Delete <input checked="" type="checkbox"/> Insert <input type="checkbox"/> Modify | DOCKET NUMBER <div>2 8</div> <div>0 5 0 0 0 4 8 2</div> | (A) REPORT NO. <div>(B)</div> <div>15 18</div> <div>8 0 0 3</div> | DATES INQ/INVEST/INSP FROM <div>(C) 19 24</div> <div>0 2 1 1 8 0</div> <div>M M D D - Y Y</div> | | REGION CONDUCTING ACTIVITY <div>(E) 31</div> <div>4</div> | | |
| | OR LICENSE NO. (BY PRODUCT) <div>2 14</div> <div></div> | TO <div>(D) 25 30</div> <div>0 2 1 4 8 0</div> <div>M M D D Y Y</div> | | | | | |
| INSPECTION PERFORMED BY <div>32</div> <div>1 <input checked="" type="checkbox"/> REGIONAL OFFICE STAFF 2 <input type="checkbox"/> RESIDENT INSPECTOR</div> <div>3 <input type="checkbox"/> PERFORMANCE APPRAISAL TEAM</div> | | | | | | | |
| TYPE OF ACTIVITY CONDUCTED (CHECK ONE BOX ONLY) <div>33-34</div> <div>INSPECTION OTHER</div> <div>02 <input checked="" type="checkbox"/> SAFETY 05 <input type="checkbox"/> MANAGEMENT AUDIT 08 <input type="checkbox"/> MATL. ACCT. 13 <input type="checkbox"/> IMPORT 14 <input type="checkbox"/> INQUIRY</div> <div>03 <input type="checkbox"/> INCIDENT 06 <input type="checkbox"/> MANAGEMENT VISIT 10 <input type="checkbox"/> PLANT SEC. 15 <input type="checkbox"/> INVESTIGATION</div> <div>04 <input type="checkbox"/> ENFORCEMENT 07 <input type="checkbox"/> SPECIAL 11 <input type="checkbox"/> INVENT. VERIF. (IF INVENT. ALSO CHECK BLOCK 5)</div> <div>08 <input type="checkbox"/> VENDOR 12 <input type="checkbox"/> SHIPMENT/EXPORT</div> | | | | | | | |
| H INSPECTION OR INVESTIGATION WARNING 1 <input type="checkbox"/> ANNOUNCED 2 <input checked="" type="checkbox"/> UNANNOUNCED | | | | | | | |
| I INSPECTION SHIFT 1 <input checked="" type="checkbox"/> DAY SHIFT 2 <input type="checkbox"/> OFF-SHIFT 3 <input type="checkbox"/> WEEKEND/HOLIDAY | | | | | | | |
| J INSPECTION/INVESTIGATION NOTIFICATION (CHECK ONE BOX ONLY) <div>37</div> <div>1 <input type="checkbox"/> 591 2 <input checked="" type="checkbox"/> REGIONAL OFFICE LETTER 3 <input type="checkbox"/> REFERRED TO HQS FOR ACTION 4 <input type="checkbox"/> REGION LETTER & HQS FOR ACTION</div> | | | | | | | |
| K INSPECTION/INVESTIGATION FINDINGS (CHECK ONE BOX ONLY) <div>38</div> <div>1 <input type="checkbox"/> CLEAR 2 <input type="checkbox"/> NONCOMPLIANCE 3 <input type="checkbox"/> DEVIATION 4 <input type="checkbox"/> NONCOMPLIANCE & DEVIATION</div> | | | | | | | |
| L ENFORCEMENT CONFERENCE HELD: 1 <input type="checkbox"/> 39 | | | | | | | |
| M NUMBER OF NONCOMPLIANCE ITEMS IN LETTER TO LICENSEE: <div>40 41</div> <div>0 0</div> NOTE: CHANGE MUST BE SUBMITTED ON 766 WHENEVER PREVIOUSLY CITED ITEM OF NONCOMPLIANCE IS OFFICIALLY DELETED FROM THE RECORD. | | | | | | | |
| N NUMBER OF DEVIATION ITEMS IN LETTER TO LICENSEE: <div>42 43</div> <div>0 0</div> | | | | | | | |
| O NUMBER OF LICENSEE EVENTS <div>44 45</div> <div></div> | | | | | | | |
| P 46 INSPECTION FEE <div>1 <input type="checkbox"/> NON-ROUTINE/VENDOR (No Fee) 2 <input type="checkbox"/> ROUTINE (No Fee) 3 <input type="checkbox"/> ROUTINE (Fee) 4 <input type="checkbox"/> ROUTINE (Fee Reduced)</div> | | | | | | | |
| Q 47 CONTENTS 2.790D INFORMATION <input type="checkbox"/> S' YES | | | | | | | |
| REGIONAL OFFICE LETTER OR REPORT TRANSMITTAL DATE FOR INSPECTION OR INVESTIGATION | | | | | | | |
| R 591 OR LETTER ISSUED TO LICENSEE REPORT SENT TO HQS FOR ACTION IMMEDIATE ACTION LETTER <div>48 52</div> <div>54 59</div> <div>60 65</div> <div>0 2 2 1 8 2</div> <div></div> <div></div> <div>M M D D Y Y</div> <div>M M D D Y Y</div> <div>M M D D Y Y</div> | | | | | | | |
| S SUBJECT OF INVESTIGATION (CHECK ONE BOX ONLY) 66-67 <div>TYPE A 10 CFR 20.403 TYPE B 10 CFR 20.405 MISC.</div> <div>01 <input type="checkbox"/> INTERNAL OVEREXPOSURE 06 <input type="checkbox"/> 11 <input type="checkbox"/> INT. OVEREXPOSURE 15 <input type="checkbox"/> CRITICALITY 21 <input type="checkbox"/> EQUIP. FAILURE</div> <div>02 <input type="checkbox"/> EXTERNAL OVEREXPOSURE 07 <input type="checkbox"/> 12 <input type="checkbox"/> EXT. OVEREXPOSURE 16 <input type="checkbox"/> LOSS/THEFT 22 <input type="checkbox"/> ALLEGATION/COMPLAINT</div> <div>03 <input type="checkbox"/> RELEASE TO UNREST. AREA 08 <input type="checkbox"/> 13 <input type="checkbox"/> EXCESS RAD. LEVELS 17 <input type="checkbox"/> MUF 23 <input type="checkbox"/> PUBLIC INTEREST</div> <div>04 <input type="checkbox"/> LOSS OF FACILITY 09 <input type="checkbox"/> 14 <input type="checkbox"/> EXCESS CONC. LEVELS 18 <input type="checkbox"/> TRANSPORTATION 24 <input type="checkbox"/> SABOTAGE</div> <div>05 <input type="checkbox"/> PROPERTY DAMAGE 10 <input type="checkbox"/> 19 <input type="checkbox"/> CONTAM/LEAKING SOURCE 25 <input type="checkbox"/> ABNORMAL OCCUR.</div> <div>20 <input type="checkbox"/> ENVIRONMENTAL EVENT 26 <input type="checkbox"/> OTHER</div> | | | | | | | |
| T HEADQUARTERS ENTRIES <div>68 69</div> <div>HQS ACTION ON INSP/INVEST REFERRED BY REGION: (See Reference List for Code)</div> | | | | | | | |
| U DATE HQS ENFORCEMENT LETTER, NOTICE, ORDER ISSUED: <div>70 75</div> <div></div> <div>M M D D Y Y</div> | | | | | | | |
| V CIVIL PENALTY ISSUED <div>76</div> <div></div> | | | | | | | |
| W DATE 766 ENTERED INTO COMPUTER FILE (MO/YR): <div>77 80</div> <div></div> <div>M M Y Y</div> | | | | | | | |
| <div>NOTE: BLOCKS K TO N MUST BE VERIFIED BY IE: HQS WHENEVER ENTRIES ARE MADE IN BLOCKS T, U AND V</div> <div>AITs REFERENCE</div> | | | | | | | |

NOTE: % COMPLETE AND STATUS:
(LEAVE BLANK FOR MC 92, 93 & 94
PROCEDURES AND 30-702, 30-703 &
30-800

(NOTE: STATUS CODING;)
(BLANK - TO REMAIN OPEN)
(C - CLOSED)
(L - REOPEN & LEAVE OPEN)
(P - REOPEN THIS TRANSACTION)
(ONLY)

NOTE: MODULE REQUIRING FOLLOWUP:
USE ONLY WHEN MODULE INSPECTED IS 92 701B.

[illegible]

 CONTINUES ON SUBSEQUENT SHEET

NOTE: MODULE REQUIRING FOLLOWUP:
USE ONLY WHEN MODULE INSPECTED IS 92 7018.

NOTE: STATUS CODING;

NOTE: % COMPLETE AND STATUS:
LEAVE BLANK FOR MC 92, 93 & 94
PROCEDURES AND 30 702, 30 703 &

BLANK - TO REMAIN OPEN
C - CLOSED
L - REOPEN & LEAVE OPEN
P - REOPEN THIS TRANSACTION ONLY

DN STN 50-482/80-03

[illegible]

LINE COLUMN NUMBER SHOWN IN BOTTOM LINE

CONTINUES ON SUBSEQUENT SHEET

UNITED STATES
NUCLEAR REGULATORY COMMISSIONREGION IV
611 RYAN PLAZA DRIVE, SUITE 1000
ARLINGTON, TEXAS 76012

June 17, 1980

In Reply Refer To:

RIV

Docket No. STN 50-482/Rpt. 80-11

Kansas Gas and Electric Company
ATTN: Mr. Glenn L. Koester
Vice President-Operations
Post Office Box 208
Wichita, Kansas 67201

Gentlemen:

This refers to the inspection conducted by Messrs. L. E. Martin and L. D. Gilbert of our staff during the period May 27-30, 1980, of activities authorized by NRC Construction Permit No. CPPR-147 for Wolf Creek, Unit No. 1, and to the discussion of our findings with Mr. M. E. Clark and other members of your staff at the conclusion of the inspection.

Areas examined during the inspection and our findings are discussed in the enclosed inspection report. Within these areas, the inspection consisted of selective examination of procedures and representative records, interviews with personnel, and observations by the inspectors.

During the inspection, it was found that certain activities under your license appear to be in noncompliance with Appendix B to 10 CFR 50 of the NRC Regulations, "Quality Assurance Criteria for Nuclear Power Plants." The item of noncompliance and references to the pertinent requirements are identified in the enclosed Notice of Violation.

We have also examined actions you have taken with regard to previously identified inspection findings. The status of these items is identified in paragraph 2 of the enclosed report.

This notice is sent to you pursuant to the provisions of the Section 2.201 of the NRC's "Rules of Practice," Part 2, Title 10, Code of Federal Regulations. Section 2.201 requires you to submit to this office, within 30 days of your receipt of this notice, a written statement or explanation in reply including:

- (1) corrective steps which will be taken by you, and the results achieved;
- (2) corrective steps which will be taken to avoid further noncompliance; and
- (3) the date when full compliance will be achieved.

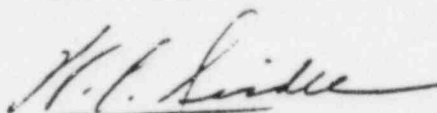
~~80-482-724~~
PDR 2 pp

June 17, 1980

In accordance with Section 2.790 of the NRC's "Rules of Practice," Part 2, Title 10, Code of Federal Regulations, a copy of this letter and the enclosed inspection report will be placed in the NRC's Public Document Room. If the report contains any information that you believe to be proprietary, it is necessary that you submit a written application to this office, within 20 days of the date of this letter, requesting that such information be withheld from public disclosure. The application must include a full statement of the reasons why it is claimed that the information is proprietary. The application should be prepared so that any proprietary information identified is contained in an enclosure to the application, since the application without the enclosure will also be placed in the Public Document Room. If we do not hear from you in this regard within the specified period, the report will be placed in the Public Document Room.

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

Sincerely,



W. C. Seidle, Chief
Reactor Construction and
Engineering Support Branch

Enclosures:

1. Appendix A, Notice of Violation
2. IE Inspection Report No. STN 50-482/80-11

Appendix A

NOTICE OF VIOLATION

Based on the results of the NRC inspection conducted on May 27-30, 1980, it appears that certain of your activities were not conducted in full compliance with the conditions of your NRC Construction Permit No. CPPR-147 as indicated below:

Failure to Specify Appropriate Acceptance Criteria

10 CFR Part 50, Appendix B, Criterion V requires that procedures shall include appropriate acceptance criteria for determining that important activities have been satisfactorily accomplished.

Bechtel Specification No. 10466-M-204 specifies in paragraph 5.6.1:

"Welds joining flued heads or closure plates and penetration sleeve shall be considered Class 2 or Class MC welds and shall be full penetration welds. The welds installing the fuel transfer tube and the stainless steel fuel transfer tube sleeve and the welds joining the weld neck flange to the electrical penetration sleeve shall be made in accordance with NE-4000 and examined per NE-5000."

Paragraph NE-4426 of NE-4000 specifies limits for the maximum reinforcement of butt welds.

Contrary to the above:

The IE inspector determined that the limits for maximum reinforcement of butt welds specified in Daniel welding technique sheets N-1-1-BA-1, Revision 4 for welding carbon steel and N-1-8-BA-24, Revision 0 for welding carbon steel to stainless steel and Daniel Quality Control Procedure, QCP-VII-200, Revision 5 for visual inspection are less restrictive than required in NE-4000, paragraph NE-4426 of ASME B&PV Code, Section III, 1974 Edition through Summer 1975 Addenda. For example, for a material thickness of one inch, NE-4426 limits the maximum reinforcement to 3/32 inch, whereas, the welding technique sheets and Quality Control procedure permit a maximum reinforcement of 3/16 inch.

This is an infraction.

~~5647280728~~
PDR LP

U. S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT

REGION IV

Report No. STN 50-482/80-11

Docket No. STN 50-482

Category A2

Licensee: Kansas Gas and Electric Company
P. O. Box 208
Wichita, Kansas 67201

Facility Name: Wolf Creek, Unit No. 1

Inspection at: Wolf Creek Site, Coffey County, Burlington, Kansas

Inspection conducted: May 27-30, 1980

Inspectors:

W. A. Crossman
jo L. E. Martin, Reactor Inspector, Projects Section
(Paragraphs 1, 2, 3, 6, 7 & 8)

6/13/80
Date

R. E. Hall
jo L. D. Gilbert, Reactor Inspector, Engineering
Support Section (Paragraphs 4 & 5)

6/13/80
Date

Reviewed:

W. A. Crossman
jo C. R. Oberg, Reactor Inspector, Projects Section

6/13/80
Date

Approved:

W. A. Crossman
jo W. A. Crossman, Chief, Projects Section

6/13/80
Date

R. E. Hall
R. E. Hall, Chief, Engineering Support Section

6/13/80
Date

~~6647284734~~
PDR 722

Inspection Summary:

Inspection on May 27-30, 1980, (Report No. STN 50-482/80-11)

Areas Inspected: Licensee action on previous inspection findings; safety-related pipe welding; containment penetration welding; electrical raceway and equipment installation; and IE follow up on licensee identified deficiencies. The inspection involved forty-eight inspector-hours by two NRC inspectors.

Results: Of the five areas inspected, one item of noncompliance was identified in one area (infraction - failure to specify appropriate acceptance criteria - paragraph 5).

DETAILS

1. Persons Contacted

Principal Licensee Personnel

- *M. E. Clark, QA Manager Site
- D. W. Prigel, QA Engineer
- G. W. Reeves, QA Engineer
- *D. G. Plasce, QA Technical Auditor
- *J. L. Stokes, Assistant Construction Manager

Daniel International (Daniel) Personnel

- *T. Damashek, QC Engineer, Civil
- *C. E. Hackney, QA Engineer, Welding
- M. Dugan, Electrical QC Inspector
- D. C. McBee, Welding General Foreman
- C. Light, Pipe Department General Foreman
- M. G. Wiggins, Pipefitter Foreman
- B. G. Bullard, Project Welding Engineer
- D. J. Dennison, Assistant QC Manager

SNUPPS

R. D. Brown, Site Representative

Kansas Electric Power Cooperative

A. Mee, Engineer

*Denotes those present at the exit interview

The IE inspectors also interviewed other licensee and contractor personnel during the course of the inspection.

2. Licensee Action on Previous Inspection Findings

(Closed) Infraction (50-482/80-05): Failure to Provide Appropriate and Prompt Corrective Action. The reactor vessel internals have been relocated to in-place storage inside containment and the reactor head has been relocated to a new sheet metal storage building in an area that is not susceptible to flooding. These actions should preclude water ingress into the storage areas for these components.

This item is considered closed.

(Open) Unresolved Item (50-482/80-05): Concrete Expansion Anchors. Daniel had initiated a Request for Clarification of Information (RCI No. 7153) to determine if there were criteria for the minimum distance that a replacement anchor can be located from an abandoned anchor. The response on the RCI from Bechtel Site Liaison Engineer stated that there were no criteria.

The IE inspector asked the responsible individual if this statement meant that there was not a requirement for criteria or if he could not find the criteria. The individual stated that he was not able to identify or locate any criteria for the minimum spacing from abandoned anchors.

This item will remain open until Bechtel can furnish data substantiating that the repair and installation methods that have been used for concrete expansion anchors meet the requirements for loading plus safety factor of the original design.

(Open) Unresolved Item (50-482/79-07): II/I Problem with Electrical Procedures. Interim Change (ICP) No. 156 to QCP-X-302 now includes within its scope II/I and indicates that the inspection requirements are the same as Class IE. The craft procedures are now undergoing revision to include the II/I requirements.

This item will remain open pending revision of all pertinent procedures.

3. Site Tour

The IE inspectors walked through the Reactor Building, Auxiliary Building, Control Building, and various outside storage areas to observe construction activities in progress and housekeeping practices.

No items of noncompliance or deviations were identified.

4. Safety-Related Piping

The IE inspector observed welding of safety-related piping in the following systems:

a. Boron Refueling Water Steam (Drawing I-M-03BN01(Q))

| <u>Field Weld</u> | <u>Activity</u> |
|-------------------|------------------------------------|
| F 40 | Fit Up Inspection and Root Welding |
| FW 901 | Interpass Temperature Monitoring |
| F 014 | Fill Welding |
| F 016R-2 | Final Visual Inspection |

b. Chemical and Volume Control System (Drawing I-M-03BG01(Q))

| <u>Field Weld</u> | <u>Activity</u> |
|-------------------|--|
| F 025 | Fit Up Inspection, Root and Fill Welding |
| F 022 | Final Visual Inspection |

In the areas inspected, no discrepancies from the requirements of welding procedure CWP-507 and visual inspection procedure QCP-VII-200 were noted.

Welding filler materials were observed to be controlled and traceable to certified material test reports as required by the procedure for Control of Welding Consumables (CWP-503). The Material Receiving Reports (MRR) for the following filler material heat numbers were inspected:

| <u>Heat Number</u> | <u>MRR Number</u> |
|--------------------|-------------------|
| 7D21B Mix12 | 3435 |
| 411J4141 | 41727 |
| 462571 | 30669 |

No items of noncompliance or deviations were identified.

5. Penetration Assemblies

The IE inspector observed welding being accomplished on Field Weld FW 537 using the Gas Tungsten-Arc Welding process and welding procedure technique sheet N-1-1-BA-1, Revision 4. FW 537 is identified on sheet D-2 of Drawing C-OL-2916(Q)01 as a Class MC butt welding in penetration E-283 with Bechtel Specification 10466-M-204 as the control document. Specification 10466-M-204, paragraph 5.6.1 specifies requirements for making penetration welds in accordance with NE-4000, Class MC. In addition to technique sheet N-1-1-BA-1; technique sheet N-1-8-BA-24, Revision 0, a procedure specifically issued for welding carbon steel to stainless steel for NE-4000 applications; and QCP-VII-200, Revision 5, the visual inspection procedures were selectively reviewed for compliance with NE-4000.

The IE inspector determined that these procedures are not in compliance with NE-4000, in that the limits for maximum reinforcement of butt welds specified in N-1-1-BA-1, N-1-8-BA-24 and QCP-VII-200 are less restrictive than required in NE-4000, paragraph NE-4426 of ASME Code, Section III, 1974 Edition through Summer 1975 Addenda. For example, NE-4426 limits maximum reinforcement to 3/32 inch for a material thickness of one inch, whereas, the welding technique sheets and Quality Control procedure permit a maximum reinforcement of 3/16 inch for a material thickness of one inch. For all nominal material thicknesses greater than 1/8 inch, the procedural allowance is greater than the allowance permitted by NE-4426.

This is an apparent item of noncompliance with Criterion V of 10 CFR 50, Appendix B, in that these procedures did not specify appropriate acceptance criteria.

6. Electrical Systems and Components

The IE inspector observed the partial installation of one 480 volt motor control center (NG02A) and one cable tray support (331-08). Neither installation was complete, but the IE inspector inspected the partial installation for compliance with the following engineering and construction documents:

480 Volt MCC NG021

Manufacturer's I.B. 10466-E-018-0190-06

Bechtel Specification 10466-E-018

Daniel Work Assignment WA-EI-331-03

Design Change Notice DCN C-003-Rev. 8

Deficiency Report DR 1SD3516EW

Bechtel Drawing EOR3311, Rev. 14

Bechtel Drawing C-OC331, Rev. 9

Bechtel Drawing E-018-0043-04

Cable Tray Support 331-08

Bechtel Drawing EOR-3311, Rev. 14

Bechtel Drawing C-0401(Q), Rev. 8

Bechtel Drawing C-0402(Q), Rev. 7

Bechtel Drawing C-0403(Q), Rev. 9

Bechtel Drawing C-0404(Q), Rev. 9

Daniel Field Sketch FSK-E-331, Rev. 11

Daniel Work Assignment WA-EI-331-01

QC Raceway Support Checklists Dated

April 9, April 5, March 1, and March 8, 1979 for support
0331-08

The IE inspector also reviewed the certification records for two Level II and one Level I Electrical QC inspectors for compliance with ANSI N45.2.6.

No items of noncompliance or deviations were identified.

7. Follow Up on Licensee Identified Deficiencies

The IE inspector discussed the potential 50.55(e) item concerning Rockbestos cable jacket extrusion defects reported to NRC on April 3, 1980, and KG&E's letter of May 8, 1980, informing the NRC, that based on testing by Rockbestos, that the jacket defects do not constitute a 10 CFR 50.55(e) deficiency. The Rockbestos testing, according to KG&E, shows that the cable still meets the specification requirements and the original IEEE-323 test requirements.

The test documentation was not available on site, but KG&E advised the IE inspector that it would be on site for review during a subsequent inspection.

The IE inspector observed the termination problems with Bunker-Ramo electrical penetrations. The licensee had identified improper crimps on lugs, undersized lugs, and improper insulation stripping. Bunker-Ramo representatives were on site to determine corrective actions. This problem was reported to NRC on May 19, 1980, and was KG&E's response to investigating a SNUPPS 50.55(e) of March 14, 1980, at Callaway.

These items will remain open until the licensee submits his report as required by 10 CFR 50.55(e).

8. Exit Interview

The IE inspectors met with licensee representatives (denoted in paragraph 1) at the conclusion of the inspection on May 30, 1980. The IE inspector summarized the scope and findings of the inspection. The item of noncompliance was acknowledged by the licensee representatives.



UNITED STATES
NUCLEAR REGULATORY COMMISSION

REGION IV
611 RYAN PLAZA DRIVE, SUITE 1000
ARLINGTON, TEXAS 76011

October 23, 1980

In Reply Refer To:

RIV

Docket No. STN 50-482/Rpt. 80-20

Kansas Gas and Electric Company
Attn: Mr. Glenn L. Koester
Vice President-Nuclear
Post Office Box 208
Wichita, Kansas 67201

Gentlemen:

This refers to the inspection conducted by Mr. L. D. Gilbert of our staff during the period October 7-10, 1980, of activities authorized by NRC Construction Permit No. CPPR-147 for Wolf Creek, Unit No. 1, and to the discussion of our findings with Mr. D. W. Prigel and other members of your staff at the conclusion of the inspection.

Areas examined during the inspection and our findings are discussed in the enclosed inspection report. Within these areas, the inspection consisted of selective examination of procedures and representative records, interviews with personnel, and observations by the inspector.

Within the scope of the inspection, no items of noncompliance were identified.

One new unresolved item is identified in paragraph 3.a of the enclosed report.

In accordance with Section 2.790 of the NRC's "Rules of Practice," Part 2, Title 10, Code of Federal Regulations, a copy of this letter and the enclosed inspection report will be placed in the NRC's Public Document Room. If the report contains any information that you believe to be proprietary, it is necessary that you submit a written application to this office, within 20 days of the date of this letter, requesting that such information be withheld from public disclosure. The application must include a full statement of the reasons why it is claimed that the information is proprietary. The application should be prepared so that any proprietary information identified is contained in an enclosure to the application, since the application without the enclosure will also be placed in the Public Document Room. If we do not hear from you in this regard within the specified period, the report will be placed in the Public Document Room.

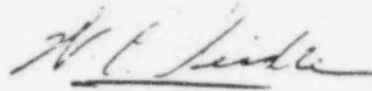
~~6012424757~~

PDR 2pp

October 23, 1980

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

Sincerely,



W. C. Seidle, Chief
Reactor Construction and
Engineering Support Branch

Enclosure:

IE Inspection Report No. STN 50-482/80-20

U. S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT

REGION IV

Report No. STN 50-482/80-20

Docket No. STN 50-482

Category A2

Licensee: Kansas Gas and Electric Company
P. O. Box 208
Wichita, Kansas 67201

Facility Name: Wolf Creek, Unit No. 1

Inspection at: Wolf Creek Site, Coffey County, Burlington, Kansas

Inspection conducted: October 7-10, 1980

Inspector: *L. D. Gilbert*
L. D. Gilbert, Reactor Inspector, Engineering Support
Section

10/22/80
Date

Approved: *W. A. Crossman*
W. A. Crossman, Chief, Projects Section

10/22/80
Date

R. E. Hall
R. E. Hall, Chief, Engineering Support Section

10/22/80
Date

Inspection Summary:

Inspection on October 7-10, 1980 (Report No. STN 50-482/80-20)

Areas Inspected: Routine, unannounced inspection of construction activities including site tour and observation of work and review of records for welding of Reactor Coolant Pressure Boundary piping. The inspection involved seventeen inspector-hours by one NRC inspector.

Results: No items of noncompliance or deviations were identified.

~~STN 50-482/80-20~~
PDR 6pp

DETAILS

1. Persons Contacted

Principal Licensee Personnel

- *D. W. Prigel, Assistant QA Manager
- *G. W. Reeves, QA Engineer
- *C. A. Snyder, Construction
- *J. Stokes, Construction

Daniel International (Daniel) Personnel

- *C. Phillips, Engineering Manager
- *R. Schofield, Welding Engineer
- *W. E. Hitt, Project Manager
- *R. Scott, Construction Manager
- *C. R. Patterson, QA Engineer
- *N. Criss, Audit Response Coordinator
- *M. D. Pfeifer, QC Engineer
- D. Dennison, Assistant QC Manager
- C. Chavis, QC Senior Receiving Inspector

*Denotes those present at the exit interview.

The IE inspector also interviewed other contractor personnel during the course of the inspection.

2. Site Tour

The IE inspector walked through the Reactor Building to observe construction activities in progress and housekeeping practices.

No items of noncompliance or deviations were identified.

3. Reactor Coolant Pressure Boundary Piping

a. Review of Procedures

The IE inspector reviewed the Daniel Procedure for welding stainless steel, Procedure CWP 507, Revision 10, which included the Welding Technique Sheet (WTS) being used for machine welding the Reactor Coolant Loop piping, WTS NM-8-8-B-1, Revision 4 and its supporting procedure qualification tests, PQT-111 and PQT-180.

In the areas reviewed, no discrepancies with the requirements of the ASME Code Section III-NB or Section IX 1974 edition including Summer 1975 addenda were noted.

During the inspection, it was noted that CWP 507 and WTS NM-8-8-B-1 were being used for welding base material specification SA 351 Grade CF8A (P No. 8) to base material consisting of Type 308L filler metal (A No. 8) buttered onto base material specification SA 216 Grade WCC (P No. 1), when neither material is listed in Table I of CWP 507 for determining the type of filler metal to be used for welding the combination, e.g., field weld F 304 on Drawing I-Loop 3(Q). Since the ASME Code is not clear concerning the qualification of procedures for welding P No. 8 material to A No. 8 material, this item shall be considered unresolved pending a revision of the procedure as supported by a code clarification.

b. Observation of Welding Activities

The IE inspector observed activities associated with fit up, welding and inspection of six field welds in the Reactor Coolant Loop piping. The field welds and the activities observed were as follows:

| <u>Field Welds</u> | <u>Drawing</u> | <u>Activity</u> |
|--------------------|----------------|-----------------|
| F 205 | I-Loop 2 (Q) | Fit Up |
| F 405 | I-Loop 4 (Q) | Fit Up |
| F 304 | I-Loop 3 (Q) | Welding |
| F 404 | I-Loop 4 (Q) | Welding |
| F 201 | I-Loop 2 (Q) | Repair Welding |
| F 402 | I-Loop 4 (Q) | ISI Weld Prep. |

During the inspection, field welds F 304 and F 404 were in the process of being machine welded using the gas tungsten-arc process in accordance with WTS NM-8-8-B-1. The filler metal observed being used for welding was type ER 308 identified as Heat No. 464176 for field weld F 304 and Heat No. 464802 for field weld F 404.

The repair welding of field weld F 201 was observed being accomplished using filler metal type ER 308 (Heats No. C3547R308 and D3547R308) and the gas tungsten-arc process in accordance with WTS N-8-8-B-8.

In the areas inspected, no discrepancies were noted concerning traveler documentation, welder qualification, procedure compliance and material control and certification.

No items of noncompliance or deviations were identified.

4. Unresolved Items

Unresolved items are matters about which more information is required in order to ascertain whether they are acceptable items, items of non-compliance, or deviations. One unresolved item related to procedure qualification is discussed in paragraph 3a.

5. Exit Interview

The IE inspector met with licensee representatives (denoted in paragraph 1) on October 10, 1980, and summarized the purpose, scope and findings of the inspection.

UNITED STATES NUCLEAR REGULATORY COMMISSION
INSPECTION & ENFORCEMENT - STATISTICAL DATA

| | | | | | | | |
|--|--|---|---|---|--|--|--|
| FACILITY NAME <u>Wolf Creek, Unit 1</u> | | INSPECTOR(S) <u>LD Gilbert</u> | | PRINCIPAL INSPECTOR <u>TE Vander</u> | | | |
| LICENSEE/VENDOR <u>Kansas Gas & Electric</u> | | REVIEWER <u>WACrossman</u> | | | | | |
| TRANS-ACTION TYPE 1 CHECK ONE: <input checked="" type="checkbox"/> SAFETY <input type="checkbox"/> INCIDENT <input type="checkbox"/> ENFORCEMENT | DOCKET NUMBER 2 9 <u>05000482</u> | REPORT NO. (8) 15 18 <u>8020</u> | DATES INQ/INVEST/INSP FROM 19 24 (C) <u>1007810</u> M M O O Y Y TO 25 30 (D) <u>1010810</u> M M O O Y Y | | REGION CONDUCTING ACTIVITY (E) 31 <u>4</u> | | |
| | OR LICENSE NO. (BY PRODUCT) 2 14 <u> </u> | | | | | | |
| INSPECTION PERFORMED BY: 1 <input checked="" type="checkbox"/> REGIONAL OFFICE STAFF 3 <input type="checkbox"/> RESIDENT INSPECTOR 2 <input type="checkbox"/> PERFORMANCE APPRAISAL TEAM | | | | | | | |
| TYPE OF ACTIVITY CONDUCTED (CHECK ONE BOX ONLY) 33-34 | | | | | | | |
| G <input checked="" type="checkbox"/> SAFETY 02 <input type="checkbox"/> SAFETY 03 <input type="checkbox"/> INCIDENT 04 <input type="checkbox"/> ENFORCEMENT | | INSPECTION 05 <input type="checkbox"/> MANAGEMENT AUDIT 06 <input type="checkbox"/> MANAGEMENT VISIT 07 <input type="checkbox"/> SPECIAL 08 <input type="checkbox"/> VENDOR | | OTHER 13 <input type="checkbox"/> IMPORT 14 <input type="checkbox"/> INQUIRY 15 <input type="checkbox"/> INVESTIGATION 16 <input type="checkbox"/> INVEST. ALSO CHECK BLOCK 51 | | | |
| H <u>INSPECTION OR INVESTIGATION WARNING</u> 1 <input type="checkbox"/> ANNOUNCED 2 <input checked="" type="checkbox"/> UNANNOUNCED | | | | | | | |
| I <u>INSPECTION SHIFT</u> 1 <input checked="" type="checkbox"/> DAY SHIFT 2 <input type="checkbox"/> OFF-SHIFT 3 <input type="checkbox"/> WEEKEND/HOLIDAY | | | | | | | |
| J <u>INSPECTION/INVESTIGATION NOTIFICATION (CHECK ONE BOX ONLY)</u> | | | | | | | |
| 1 <input type="checkbox"/> SBI 2 <input checked="" type="checkbox"/> REGIONAL OFFICE LETTER 3 <input type="checkbox"/> REFERRED TO HQS FOR ACTION 4 <input type="checkbox"/> REGION LETTER & HQS FOR ACTION | | | | | | | |
| K <u>INSPECTION/INVESTIGATION FINDINGS (CHECK ONE BOX ONLY)</u> | | | | | | | |
| 1 <input checked="" type="checkbox"/> CLEAR 2 <input type="checkbox"/> NONCOMPLIANCE 3 <input type="checkbox"/> DEVIATION 4 <input type="checkbox"/> NONCOMPLIANCE & DEVIATION | | | | | | | |
| L <u>ENFORCEMENT CONFERENCE HELD:</u> 1 <input type="checkbox"/> YES | | | | | | | |
| M NUMBER OF NONCOMPLIANCE ITEMS IN LETTER TO LICENSEE: | | 40 41 <u>00</u> | | NOTE: CHANGE MUST BE SUBMITTED ON 766 WHENEVER PREVIOUSLY CITED ITEM OF NONCOMPLIANCE IS OFFICIALLY DELETED FROM THE RECORD. | | | |
| N NUMBER OF DEVIATION ITEMS IN LETTER TO LICENSEE: | | 42 43 <u>00</u> | | | | | |
| O NUMBER OF LICENSEE EVENTS | | 44 45 <u> </u> | | | | | |
| P <u>46 INSPECTION FEE</u> 1 <input type="checkbox"/> NON-ROUTINE/VENDOR (No Fee) 2 <input type="checkbox"/> ROUTINE (No Fee) 3 <input type="checkbox"/> ROUTINE (Fee) 4 <input type="checkbox"/> ROUTINE (Fee Reduced) | | | | | | | |
| Q <u>47 CONTENTS 2.7600 INFORMATION</u> <input type="checkbox"/> YES | | | | | | | |
| R <u>REGIONAL OFFICE LETTER OR REPORT TRANSMITTAL DATE FOR INSPECTION OR INVESTIGATION</u> | | | | | | | |
| SBI OR LETTER ISSUED TO LICENSEE 48 49 <u>102380</u> M M O O Y Y | | REPORT SENT TO HQS FOR ACTION 54 59 <u> </u> M M O O Y Y | | IMMEDIATE ACTION LETTER 60 65 <u> </u> M M O O Y Y | | | |
| SUBJECT OF INVESTIGATION (CHECK ONE BOX ONLY) 66-67 | | | | | | | |
| TYPE A 10 CFR 20.403 | | TYPE B 10 CFR 20.405 | | MISC. | | | |
| 01 <input type="checkbox"/> INTERNAL OVEREXPOSURE 02 <input type="checkbox"/> EXTERNAL OVEREXPOSURE 03 <input type="checkbox"/> RELEASE TO UNREST. AREA 04 <input type="checkbox"/> LOSS OF FACILITY 05 <input type="checkbox"/> PROPERTY DAMAGE | | 06 <input type="checkbox"/> 07 <input type="checkbox"/> 08 <input type="checkbox"/> 09 <input type="checkbox"/> 10 <input type="checkbox"/> | | 11 <input type="checkbox"/> INT. OVEREXPOSURE 12 <input type="checkbox"/> EXT. OVEREXPOSURE 13 <input type="checkbox"/> EXCESS RAO. LEVELS 14 <input type="checkbox"/> EXCESS CONC. LEVELS 15 <input type="checkbox"/> CRITICALITY 16 <input type="checkbox"/> LOSS/THEFT 17 <input type="checkbox"/> MUF 18 <input type="checkbox"/> TRANSPORTATION 19 <input type="checkbox"/> CONTAM/LEAKING SOURCE 20 <input type="checkbox"/> ENVIRONMENTAL EVENT | | 21 <input type="checkbox"/> EQUIP. FAILURE 22 <input type="checkbox"/> ALLEGATION/COMPLAINT 23 <input type="checkbox"/> PUBLIC INTEREST 24 <input type="checkbox"/> SABOTAGE 25 <input type="checkbox"/> ABNORMAL OCCUR 26 <input type="checkbox"/> OTHER | |
| HEADQUARTERS ENTRIES | | | | | | | |
| T HQS ACTION ON INSP/INVEST REFERRED BY REGION: (See Reference List for Codes) | | 58 59 <u> </u> | | CLEAR NOTE: BLOCKS K TO N MUST BE VERIFIED BY 'E' HQS WHENEVER ENTRIES ARE MADE IN BLOCKS T U AND V AITS REFERENCE: | | | |
| U DATE HQS ENFORCEMENT LETTER, NOTICE, ORDER ISSUED: | | 70 75 <u> </u> M M O O Y Y | | | | | |
| V CIVIL PENALTY ISSUED: | | 77 80 <u> </u> M M Y Y | | | | | |
| W DATE 766 ENTERED INTO COMPUTER FILE (MM/YY): | | 87 90 <u> </u> M M Y Y | | | | | |

INSPECTION PLAN

IE Inspection Report No. STN 50-482/80-20

Licensee: Kansas Gas and Electric Company

Location: Wichita, Kansas

Facility: Wolf Creek, Unit No. 1

Type of Licensee: PWR, W, 1030 MWe (SNUPPS)

Type of Inspection: Routine, unannounced

Dates of Inspection: October 7-10, 1980

Dates of Previous Inspection: September 30 - October 2, 1980

Inspectors: LD Gilbert

SCOPE OF INSPECTION

30703B
92706B
~~55171B~~
55171B
55173B

LD Gilbert
Reactor Inspector

9/26/80
Date

W. L. Linsman
Approved

9/26/80
Date

UNITED STATES
NUCLEAR REGULATORY COMMISSIONREGION IV
611 RYAN PLAZA DRIVE, SUITE 1000
ARLINGTON, TEXAS 76012

June 16, 1981

In Reply Refer To:

RIV

Docket STN 50-482/Rpt. 81-11

Kansas Gas and Electric Company
ATTN: Mr. Glenn L. Koester
Vice President - Nuclear
Post Office Box 208
Wichita, Kansas 67201

Gentlemen:

This refers to the inspection conducted by Mr. L. D. Gilbert of our staff during the period June 1-5, 1981, of activities authorized by NRC Construction Permit CPPR-147 for Wolf Creek, Unit 1, and to the discussion of our findings with Mr. D. W. Prigel and other members of your staff at the conclusion of the inspection.

Areas examined during the inspection and our findings are discussed in the enclosed inspection report. Within these areas, the inspection consisted of selective examination of procedures and representative records, interviews with personnel, and observations by the inspector.

Within the scope of the inspection, no violations or deviations were identified.

Two new unresolved items are identified in paragraphs 4 and 5 of the enclosed report.

We have also examined actions you have taken with regard to previously identified inspection findings. The status of these items is identified in paragraph 2 of the enclosed report.

In accordance with 10 CFR 2.790 of the Commission's regulations, a copy of this letter and the enclosed inspection report will be placed in the NRC's Public Document Room. If this report contains any information that you believe to be exempt from disclosure under 10 CFR 9.5(a)(4), it is necessary that you (a) notify this office by telephone within 10 days from the date of this letter of your intention to file a request for withholding; and (b) submit within 25 days from the date of this letter a written application to this office to withhold such information. If your receipt of this letter has been delayed such that less than seven days are available for your review, please notify this office promptly so that a new due date may be established.

~~8107090251~~
PDR LPP

June 16, 1981

Consistent with Section 2.790(b)(1), any such application must be accompanied by an affidavit executed by the owner of the information which identifies the document or part sought to be withheld, and which contains a full statement of the reasons on the basis which it is claimed that the information should be withheld from public disclosure. This section further requires the statement to address with specificity the considerations listed in 10 CFR 2.790(b)(4). The information sought to be withheld shall be incorporated as far as possible into a separate part of the affidavit. If we do not hear from you in this regard within the specified periods noted above, the report will be placed in the Public Document Room.

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

Sincerely,



W. C. Seidle, Chief
Engineering Inspection Branch

Enclosure:

IE Inspection Report STN 50-482/81-11

U.S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT

REGION IV

Report: STN 50-482/81-11

Docket: STN 50-482

Category A2

Licensee: Kansas Gas and Electric Company
Post Office Box 208
Wichita, Kansas 67201

Facility Name: Wolf Creek, Unit 1

Inspection at: Wolf Creek Site, Coffey County, Burlington, Kansas

Inspection Conducted: June 1-5, 1981

Inspector: *[Signature]*
L. D. Gilbert, Reactor Inspector, Engineering and Materials
Section

6/14/81
Date

Approved: *[Signature]*
R. E. Hall, Acting Chief, Engineering and Materials Section

6/14/81
Date

Inspection Summary:

Inspection During June 1-5, 1981 (Report STN 50-482/81-11)

Areas Inspected: Licensee action on previous inspection findings; site tour; and observation of work and review of records for welding of Reactor Coolant Pressure Boundary and other safety-related piping. The inspection involved 29 inspector-hours on site by one NRC inspector.

Results: In the areas inspected, no violations or deviations were identified.

~~8107490255~~
6 pp. 202

DETAILS

1. Persons Contacted

Principal Licensee Personnel

- *D. W. Prigel, QA Manager, Site
- *P. Burck, QA Engineer
- *C. Snyder, Construction Supervisor

Daniel International Personnel

- *L. Bryant, Project Quality Manager
- *D. Dennison, Project Quality Inspection Manager
- *R. Schofield, Project Welding Engineer
 - J. Doeblner, Pipe Superintendent Automatic Welding
 - R. Rigdon, QC Training Supervisor

The NRC inspector also interviewed other contractor personnel during the course of the inspection.

*Denotes those present at the exit interview.

2. Licensee Action on Previous Inspection Findings

(Closed) Infraction (STN 50-482/80-11): Failure to Specify Appropriate Acceptance Criteria. The NRC inspector reviewed ICP 313, Interim Change to Procedure CWP-506 for Welding Techniques N-1-1-B-1 and N-1-1-BA-1. It was determined that the acceptance criteria for weld reinforcement is now consistent with that specified in paragraph NF-4426 of ASME B&PV Code, Section III 1974 Edition through Summer 1975 Addenda for fabricating component supports.

This item is considered closed.

(Closed) Unresolved Item (STN 50-482/80-20): Qualification of Procedures for Welding P Number Base Material to A Number 8 Weld Material Used as Base Material. The NRC inspector reviewed Welding Procedure CWP 507, Revision 12 and determined that the procedure now includes Daniel International Corporate Office Revision 26 to the procedure.

This item is considered resolved.

(Closed) Violation (STN 50-482/81-04): Receiving inspections did not verify that required heat treatment information was specified on the certified material test reports for certain bolting materials. The NRC inspector reviewed the corrected copies of the certified material test reports which now include the required heat treatment information. The records documenting

the training of 18 QC services personnel to re-emphasize the importance of checking all chemical and physical properties on the material test reports were made available to the NRC inspector for review.

This item is considered closed.

3. Site Tour

The NRC inspector toured the Reactor Building and Auxiliary Building to observe construction activities in progress and housekeeping practices.

No violations or deviations were identified.

4. Reactor Coolant Pressure Boundary Piping

The NRC inspector observed welding activities and reviewed weld documentation on the following Reactor Coolant Pressure Boundary piping system field welds: Weld F104-R1 on Drawing I-LOOP 1(Q), Weld F206 on Drawing I-LOOP 2(Q), and Welds F306 and F308 on Drawing I-LOOP 3(Q). In the areas inspected, no discrepancies were noted concerning traveler documentation, welder qualification, procedure compliance, and material control.

While observing the welding of temporary attachments for fit up of Weld F308, the NRC inspector noted that the welding machine was grounded to the base plate of a Steam Generator vertical support column which had the potential to cause damage to the two bearings in the support column. The observation was reported to the Daniel International Project Quality Inspection Manager and Project Welding Engineer for resolution. A deficiency report, DR No. ISD 7059M, and interoffice communication, PWE No. 465, were issued to assess the potential damage and prevent recurrence.

This item is considered unresolved pending resolution of the above deficiency report.

5. Other Safety-Related Welding

The NRC inspector observed welding of the flued head to penetration sleeve, Weld F100 on Drawing I-MO3AB01(Q) in the Main Steam piping system. In the areas inspected, no discrepancies were noted concerning traveler documentation, welder qualification, procedure compliance, and material control.

The NRC inspector also discussed a 1980 ASME B&PV Code Committee interpretation with Daniel International and Kansas Gas and Electric personnel; Interpretation III-80-65 states that all new performance qualifications for welders shall be in accordance with the latest edition of Section IX. Daniel International takes the position that a 1976 ASME B&PV Committee Code interpretation permits new qualifications to be performed in accordance with the 1974 Edition through Summer 1975 Addenda of Section IX. Since the 1980 interpretation does not support the Daniel International position, this item is considered unresolved pending a clarification of the two interpretations.

6. Unresolved Items

Unresolved items are matters about which more information is required in order to ascertain whether they are acceptable items, violations, or deviations. Two unresolved items disclosed during the inspection are discussed in paragraphs 4 and 5.

7. Exit Interview

The NRC inspector met with licensee representatives (denoted in paragraph 1) on June 5, 1981, and summarized the scope and findings of the inspection.

| | | | | | | | | | | | | | | | | | |
|--|--|---|---|--|--|----------------------|---|--|---|-------|--|---|--|---|---|--|--|
| FACILITY NAME <u>Waffle Creek, Unit 1</u> | | INSPECTOR(S) <u>L.D. Gilbert</u> | | PRINCIPAL INSPECTOR <u>FEV</u> | | | | | | | | | | | | | |
| LICENSEE/VENDOR <u>Kansas Gas Electric</u> | | REVIEWER <u>RE 4/2/11</u> | | | | | | | | | | | | | | | |
| TRANS-ACTION TYPE 1 CHECK ONE! <input type="checkbox"/> Delete <input checked="" type="checkbox"/> Amend <input type="checkbox"/> Modify | DOCKET NUMBER 2 8 <u>05000482</u> | (A) REPORT NO. (B) 15 18 <u>8111</u> | DATES INQ/INVEST/INSP FROM 19 24 (C) <u>060181</u> M M D D Y Y TO 25 30 (D) <u>060581</u> M M D D Y Y | | REGION CONDUCTING ACTIVITY (E) 31 <u>4</u> | | | | | | | | | | | | |
| | OR LICENSE NO. (BY PRODUCT) 2 14 <u> </u> | | | | | | | | | | | | | | | | |
| | INSPECTION PERFORMED BY 32 1 <input checked="" type="checkbox"/> REGIONAL OFFICE STAFF 2 <input type="checkbox"/> RESIDENT INSPECTOR 3 <input type="checkbox"/> PERFORMANCE APPRAISAL TEAM | | | | | | | | | | | | | | | | |
| TYPE OF ACTIVITY CONDUCTED (CHECK ONE BOX ONLY) | | | | | | | | | | | | | | | | | |
| <table border="0" style="width:100%;"> <tr> <td colspan="2">33-34</td> <td colspan="2">INSPECTION</td> <td colspan="2">OTHER</td> </tr> <tr> <td>G</td> <td>02 <input checked="" type="checkbox"/> SAFETY 03 <input type="checkbox"/> INCIDENT 04 <input type="checkbox"/> ENFORCEMENT</td> <td>05 <input type="checkbox"/> MANAGEMENT AUDIT 06 <input type="checkbox"/> MANAGEMENT VISIT 07 <input type="checkbox"/> SPECIAL 08 <input type="checkbox"/> VENDOR</td> <td>09 <input type="checkbox"/> MATL ACCT 10 <input type="checkbox"/> PLANT SEC. 11 <input type="checkbox"/> INVENT. VERIF. 12 <input type="checkbox"/> SHIPMENT/EXPORT</td> <td>13 <input type="checkbox"/> IMPORT</td> <td>14 <input type="checkbox"/> INQUIRY 15 <input type="checkbox"/> INVESTIGATION 16 <input type="checkbox"/> INVEST. ALSO CHECK BLOCK S1</td> </tr> </table> | | | | | | 33-34 | | INSPECTION | | OTHER | | G | 02 <input checked="" type="checkbox"/> SAFETY 03 <input type="checkbox"/> INCIDENT 04 <input type="checkbox"/> ENFORCEMENT | 05 <input type="checkbox"/> MANAGEMENT AUDIT 06 <input type="checkbox"/> MANAGEMENT VISIT 07 <input type="checkbox"/> SPECIAL 08 <input type="checkbox"/> VENDOR | 09 <input type="checkbox"/> MATL ACCT 10 <input type="checkbox"/> PLANT SEC. 11 <input type="checkbox"/> INVENT. VERIF. 12 <input type="checkbox"/> SHIPMENT/EXPORT | 13 <input type="checkbox"/> IMPORT | 14 <input type="checkbox"/> INQUIRY 15 <input type="checkbox"/> INVESTIGATION 16 <input type="checkbox"/> INVEST. ALSO CHECK BLOCK S1 |
| 33-34 | | INSPECTION | | OTHER | | | | | | | | | | | | | |
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| H INSPECTION OR INVESTIGATION WARNING 1 <input type="checkbox"/> ANNOUNCED 2 <input checked="" type="checkbox"/> UNANNOUNCED | | | | | | | | | | | | | | | | | |
| I INSPECTION SHIFT 1 <input checked="" type="checkbox"/> DAY SHIFT 2 <input type="checkbox"/> OFF-SHIFT 3 <input type="checkbox"/> WEEKEND/HOLIDAY | | | | | | | | | | | | | | | | | |
| J INSPECTION/INVESTIGATION NOTIFICATION (CHECK ONE BOX ONLY) 1 <input type="checkbox"/> 591 2 <input checked="" type="checkbox"/> REGIONAL OFFICE LETTER 3 <input type="checkbox"/> REFERRED TO HQS FOR ACTION 4 <input type="checkbox"/> REGION LETTER & HQS FOR ACTION | | | | | | | | | | | | | | | | | |
| K INSPECTION/INVESTIGATION FINDINGS (CHECK ONE BOX ONLY) 1 <input checked="" type="checkbox"/> CLEAR 2 <input type="checkbox"/> NONCOMPLIANCE 3 <input type="checkbox"/> DEVIATION 4 <input type="checkbox"/> NONCOMPLIANCE & DEVIATION | | | | | | | | | | | | | | | | | |
| L ENFORCEMENT CONFERENCE HELD 1 <input type="checkbox"/> 39 | | | | | | | | | | | | | | | | | |
| M NUMBER OF NONCOMPLIANCE ITEMS IN LETTER TO LICENSEE: 40 41 <u>00</u> NOTE: CHANGE MUST BE SUBMITTED ON 766 WHENEVER PREVIOUSLY CITED ITEM OF NONCOMPLIANCE IS OFFICIALLY DELETED FROM THE RECORD. | | | | | | | | | | | | | | | | | |
| N NUMBER OF DEVIATION ITEMS IN LETTER TO LICENSEE: 42 43 <u>00</u> | | | | | | | | | | | | | | | | | |
| O NUMBER OF LICENSEE EVENTS 44 45 <u> </u> | | | | | | | | | | | | | | | | | |
| P 46 INSPECTION FEE 1 <input type="checkbox"/> NON-ROUTINE/VENDOR (No Fee) 2 <input type="checkbox"/> ROUTINE (No Fee) 3 <input type="checkbox"/> ROUTINE (Fee) 4 <input type="checkbox"/> ROUTINE (Fee Reduced) | | | | | | | | | | | | | | | | | |
| Q 47 CONTENTS 2.7900 INFORMATION <input type="checkbox"/> 'S' YES | | | | | | | | | | | | | | | | | |
| REGIONAL OFFICE LETTER OR REPORT TRANSMITTAL DATE FOR INSPECTION OR INVESTIGATION | | | | | | | | | | | | | | | | | |
| <table border="0" style="width:100%;"> <tr> <td>R</td> <td>591 OR LETTER ISSUED TO LICENSEE 48 53 <u>061611</u> M M D D Y Y</td> <td>REPORT SENT TO HQS FOR ACTION 54 59 <u> </u> M M D D Y Y</td> <td colspan="3">IMMEDIATE ACTION LETTER 60 DATE 65 <u> </u> M M D D Y Y</td> </tr> </table> | | | | | | R | 591 OR LETTER ISSUED TO LICENSEE 48 53 <u>061611</u> M M D D Y Y | REPORT SENT TO HQS FOR ACTION 54 59 <u> </u> M M D D Y Y | IMMEDIATE ACTION LETTER 60 DATE 65 <u> </u> M M D D Y Y | | | | | | | | |
| R | 591 OR LETTER ISSUED TO LICENSEE 48 53 <u>061611</u> M M D D Y Y | REPORT SENT TO HQS FOR ACTION 54 59 <u> </u> M M D D Y Y | IMMEDIATE ACTION LETTER 60 DATE 65 <u> </u> M M D D Y Y | | | | | | | | | | | | | | |
| SUBJECT OF INVESTIGATION (CHECK ONE BOX ONLY) 66-67 | | | | | | | | | | | | | | | | | |
| <table border="0" style="width:100%;"> <tr> <td colspan="2">TYPE A 10 CFR 20.403</td> <td colspan="2">TYPE B 10 CFR 20.405</td> <td colspan="2">MISC.</td> </tr> <tr> <td>S</td> <td>01 <input type="checkbox"/> INTERNAL OVEREXPOSURE 02 <input type="checkbox"/> EXTERNAL OVEREXPOSURE 03 <input type="checkbox"/> RELEASE TO UNREST. AREA 04 <input type="checkbox"/> LOSS OF FACILITY 05 <input type="checkbox"/> PROPERTY DAMAGE</td> <td>06 <input type="checkbox"/> 07 <input type="checkbox"/> 08 <input type="checkbox"/> 09 <input type="checkbox"/> 10 <input type="checkbox"/></td> <td>11 <input type="checkbox"/> INT. OVEREXPOSURE 12 <input type="checkbox"/> EXT. OVEREXPOSURE 13 <input type="checkbox"/> EXCESS RAD. LEVELS 14 <input type="checkbox"/> EXCESS CONC. LEVELS</td> <td>15 <input type="checkbox"/> CRITICALITY 16 <input type="checkbox"/> LOSS/THEFT 17 <input type="checkbox"/> MUF 18 <input type="checkbox"/> TRANSPORTATION 19 <input type="checkbox"/> CONTAM/LEAKING SOURCE 20 <input type="checkbox"/> ENVIRONMENTAL EVENT</td> <td>21 <input type="checkbox"/> EQUIP. FAILURE 22 <input type="checkbox"/> ALLEGATION/COMPLAINT 23 <input type="checkbox"/> PUBLIC INTEREST 24 <input type="checkbox"/> SABOTAGE 25 <input type="checkbox"/> ABNORMAL OCCUR 26 <input type="checkbox"/> OTHER</td> </tr> </table> | | | | | | TYPE A 10 CFR 20.403 | | TYPE B 10 CFR 20.405 | | MISC. | | S | 01 <input type="checkbox"/> INTERNAL OVEREXPOSURE 02 <input type="checkbox"/> EXTERNAL OVEREXPOSURE 03 <input type="checkbox"/> RELEASE TO UNREST. AREA 04 <input type="checkbox"/> LOSS OF FACILITY 05 <input type="checkbox"/> PROPERTY DAMAGE | 06 <input type="checkbox"/> 07 <input type="checkbox"/> 08 <input type="checkbox"/> 09 <input type="checkbox"/> 10 <input type="checkbox"/> | 11 <input type="checkbox"/> INT. OVEREXPOSURE 12 <input type="checkbox"/> EXT. OVEREXPOSURE 13 <input type="checkbox"/> EXCESS RAD. LEVELS 14 <input type="checkbox"/> EXCESS CONC. LEVELS | 15 <input type="checkbox"/> CRITICALITY 16 <input type="checkbox"/> LOSS/THEFT 17 <input type="checkbox"/> MUF 18 <input type="checkbox"/> TRANSPORTATION 19 <input type="checkbox"/> CONTAM/LEAKING SOURCE 20 <input type="checkbox"/> ENVIRONMENTAL EVENT | 21 <input type="checkbox"/> EQUIP. FAILURE 22 <input type="checkbox"/> ALLEGATION/COMPLAINT 23 <input type="checkbox"/> PUBLIC INTEREST 24 <input type="checkbox"/> SABOTAGE 25 <input type="checkbox"/> ABNORMAL OCCUR 26 <input type="checkbox"/> OTHER |
| TYPE A 10 CFR 20.403 | | TYPE B 10 CFR 20.405 | | MISC. | | | | | | | | | | | | | |
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| HEADQUARTERS ENTRIES | | | | | | | | | | | | | | | | | |
| T HQS ACTION ON INSP/INVEST REFERRED BY REGION (See Reference List for Code) 58 59 <u> </u> | | | | | | | | | | | | | | | | | |
| U DATE HQS ENFORCEMENT LETTER, NOTICE, ORDER ISSUED 70 75 <u> </u> M M D D Y Y | | | | | | | | | | | | | | | | | |
| V CIVIL PENALTY ISSUED 76 1 <input type="checkbox"/> | | | | | | | | | | | | | | | | | |
| W DATE 766 ENTERED INTO COMPUTER FILE (MO/YR) 77 80 <u> </u> M M Y Y | | | | | | | | | | | | | | | | | |
| NOTE: BLOCKS K TO N MUST BE VERIFIED BY IE HQS WHENEVER ENTRIES ARE MADE IN BLOCKS T, U AND V | | | | | | | | | | | | | | | | | |
| AITS REFERENCE | | | | | | | | | | | | | | | | | |

INSPECTION PLAN

IE Inspection Report No. STN 50-482/81-11
Licensee: Kansas Gas & Electric Company
Location: Wichita, Kansas
Facility: Wolf Creek, Unit 1
Type of Licensee: PWR, W, 1030 MWe (SNUPPS)
Type of Inspection: Routine, unannounced
Dates of Inspection: June 1-5, 1981
Dates of Previous Inspection:
Inspectors: LD Gilbert

SCOPE OF INSPECTION

30703B
92706B
92702B
~~5517XB~~
~~5518XB~~
55173B
55176B
55178B
55183B
55186B
92701B

LD Gilbert

Reactor Inspector

5/26/81

Date

Approved

U. T. ...

Date



UNITED STATES
NUCLEAR REGULATORY COMMISSION
REGION IV
611 RYAN PLAZA DRIVE, SUITE 1000
ARLINGTON, TEXAS 76011

April 29, 1982

Docket: STN 50-482/82-06

Kansas Gas and Electric Company
ATTN: Mr. Glenn L. Koester
Vice President - Nuclear
P. O. Box 208
Wichita, Kansas 67201

Gentlemen:

This refers to the inspection conducted by Mr. L. D. Gilbert of our staff during the period March 29 - April 2, 1982, of activities authorized by NRC Construction Permit CPPR-147 for Wolf Creek, Unit 1, and to the discussion of our findings with Mr. D. W. Prigel and other members of your staff at the conclusion of the inspection.

Areas examined during the inspection and our findings are discussed in the enclosed inspection report. Within these areas, the inspection consisted of selective examination of procedures and representative records, interviews with personnel, and observations by the inspector.

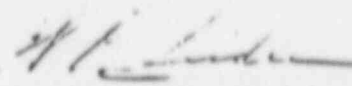
Within the scope of the inspection, no violations or deviations were identified.

One new unresolved item is identified in paragraph 3.a of the enclosed report.

In accordance with 10 CFR 2.790(a), a copy of this letter and the enclosure will be placed in the NRC Public Document Room unless you notify this office, by telephone, within 10 days of the date of this letter and submit written application to withhold information contained therein within 30 days of the date of this letter. Such application must be consistent with the requirements of 2.790(b)(1).

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

Sincerely,


W. C. Seidle, Chief
Reactor Project Branch 2

Enclosure:
Appendix - NRC Inspection Report STN 50-482/82-06

~~82482146469~~
PDR

APPENDIX

U. S. NUCLEAR REGULATORY COMMISSION
REGION IV

This Report Contains Results of an Investigation

Report: STN 50-482/82-06

Docket: STN 50-482

Category A2

Licensee: Kansas Gas and Electric Company
P. O. Box 208
Wichita, Kansas 67201

Facility Name: Wolf Creek, Unit 1

Inspection at: Wolf Creek Site, Coffey County, Burlington, Kansas

Inspection Conducted: March 29 - April 2, 1982

Inspector:

L. D. Gilbert

L. D. Gilbert, Reactor Inspector, Engineering Section

4/26/82
Date

Reviewed:

R. E. Hall

R. E. Hall, Chief, Reactor Project Section C

4/27/82
Date

Approved:

D. M. Hunnicutt

D. M. Hunnicutt, Chief, Engineering Section

4/27/82
Date

Inspection Summary

Inspection during March 29 - April 2, 1982 (Report STN 50-482/82-06)

Areas Inspected: Routine, unannounced inspection of construction activities including an allegation item and observation of work and review of records for welding and nondestructive examination (NDE) of Reactor Coolant Pressure Boundary piping. The inspection involved 30 inspector-hours onsite by one NRC inspector.

Results: No violations or deviations were identified. The allegation discussed in paragraph 2 was not substantiated.

8206140478
Epp PDR

DETAILS

1. Persons Contacted

Principal Licensee Personnel

- *D. W. Prigel, Manager QA, Site
- *G. W. Reeves, Assistant Manager QA, Site
- *O. L. Thero, Supervisor, QA Surveillance
- *C. E. Parry, Supervisor, QA Systems
- *D. A. Colwell, QA Technologist
- *J. L. Stokes, Project Support Supervisor

Other Personnel

- J. Johnson, Project Piping Engineer, Daniel International Corporation (Daniel)
- J. Linsome, Mechanical Superintendent, Daniel
- G. Robertson, NDE Level III, GEO Construction Testing

The NRC inspector also interviewed other licensee and contractor employees during the course of the inspection.

*Denotes those attending the exit interview.

2. Allegation Regarding Improper Welding Techniques

An allegation regarding improper welding techniques, received by the NRC Resident Reactor Inspector on March 4, 1982, was reviewed by the NRC inspector during the inspection. A welder claimed that while taking a test on Performance Test No. N-8-8-B-3 he was told to run the root pass and "wash" the remainder which he believed to be contrary to the procedure. He refused to complete the weld by "washing" and was fired. The welder also stated that he believed this practice was common onsite for weld-out of small bore extra strong pipe, but that it is not in accordance with the procedure.

The following information was obtained by the NRC inspector:

- Performance Test No. N-8-8-B-3 is specified in Daniel Procedure CWP-502, Revision 16 for qualification of welders. The test requires that a welder complete four consecutive open root butt joints consisting of 1/2-inch NPS pipe with a 0.294-inch nominal wall thickness in the "6G" position using the gas tungsten-arc welding process and type ER 308 filler metal.
- Instructions for welding stainless steel small bore extra strong pipe are contained in Daniel Procedure CWP-507, Revision 14 under Weld Procedure Specification (WPS) N-8-8 and Welding Technique (WT) N-8-8-B-3. Paragraph 4.18.4 of WPS N-8-8 specifies that a

minimum of three layers of weld metal shall be deposited for wall thicknesses 1/4-inch and greater. Therefore, at least three layers of weld metal should be used to complete the Performance Test No. N-8-8-B-3.

- The welder qualification supervisor informed the NRC inspector that he had been assigned the position on March 29, 1982, since the previous welder qualification supervisor terminated employment at the site on March 26, 1982.
- The NRC inspector interviewed all eight of the welders listed as currently qualified to WT N-8-8-B-3. Each of the eight welders stated to the NRC inspector that:
 - a. He had taken the Performance Test No. N-8-8-B-3, consisting of four consecutive test welds, which he completed using between four and seven layers of weld metal.
 - b. He had never been requested or instructed to weld the test weldments nor any production welds (1/4-inch or greater in wall thickness) using only two layers of weld metal (root pass and "wash" remainder).
 - c. He could not recall depositing less than four layers of weld metal on any safety-related weld having a pipe wall thickness of 1/4-inch or greater.

This allegation could not be substantiated and the NRC inspector indicated that he had no further questions regarding this matter.

3. Reactor Coolant Pressure Boundary Pipe Welding Activities

a. Observation of Work

The NRC inspector selected eleven completed welds in the Reactor Coolant Pressure Boundary piping to inspect the final weld surface. The following welds were inspected and found to be consistent with the ASME B&PV Code, Section III NB for weld reinforcement limitations, transition requirements between different wall thickness pipe, and weld quality.

| <u>Drawing</u> | <u>Weld</u> | <u>System</u> |
|----------------|-------------|------------------------------|
| I-M13BB02(Q) | F010 | Reactor Coolant |
| I-M13BB02(Q) | F017 | Reactor Coolant |
| I-M03BB14(Q) | F005 | Reactor Coolant |
| I-M03BB14(Q) | F004 | Reactor Coolant |
| I-M03EP02(Q) | F007 | Accumulator Safety Injection |

| <u>Drawing</u> | <u>Weld</u> | <u>System</u> |
|----------------|-------------|-----------------------------|
| I-M03HB24(Q) | F500 | Liquid Radwaste |
| I-M03BB05(Q) | F001 | Reactor Coolant |
| I-M03BG24(Q) | F552 | Chemical and Volume Control |
| I-M03BG24(Q) | F553A | Chemical and Volume Control |
| P-M03BB14(Q) | W534A | Reactor Coolant |
| P-M03BB15(Q) | W566 | Reactor Coolant |

The NRC inspector observed the following repair activities on the Reactor Coolant Pressure Boundary Class 1 piping:

- Cutting defective Weld F021 in Reactor Coolant System of Drawing I-M13BB04(Q) for rewelding.
- Excavation of a radiographic defect and liquid penetrant inspection of completed weld repair on Weld F304R-1 in Reactor Coolant System of Drawing I Loop 3(Q).
- Weld repair of counterbore on Weld F905A in Accumulator Safety Injection System of Drawing I-M03EJ04(Q) for violating minimum wall thickness requirements. The NRC inspector reviewed the Weld Repair Instruction WRI 2-FW905-1 and Weld Repair Procedure CWP-504, Revision 10 and requested that CWP-504 be clarified to comply with ASME Code Interpretation III-1-79-14, issued January 25, 1979, in that, weld buildup of pipe counterbores shall be treated as a weld repair of material under ASME B&PV Code, Section III NB/NC/ND-4214 and nondestructively examined accordingly.

This item is considered unresolved pending completion of actions required in KG&E Surveillance Report S-478 for clarification of CWP-504 and evaluation of past weld repairs to pipe inside diameter surfaces.

b. Review of Records

The NRC inspector selected five completed welds in the Reactor Coolant Pressure Boundary piping to review. The following weld records were reviewed for adequate weld and inspection history documentation:

| <u>Drawing</u> | <u>Weld</u> | <u>System</u> |
|----------------|-------------|-----------------|
| I-M13BB02(Q) | F010 | Reactor Coolant |
| I-M13BB02(Q) | F017 | Reactor Coolant |

| <u>Drawing</u> | <u>Weld</u> | <u>System</u> |
|----------------|-------------|-----------------------------|
| I-M03BB05(Q) | F001 | Reactor Coolant |
| I-M03BG24(Q) | FW552 | Chemical and Volume Control |
| I-M03BG24(Q) | FW553A | Chemical and Volume Control |

No violations or deviations were identified.

4. Reactor Coolant Pressure Boundary Piping NDE Activities

a. Observation of Work

The NRC inspector selected two welds in the Reactor Coolant piping system where the welding and surface preparation were complete and liquid penetrant examinations were in progress. The two welds inspected were Weld W534A of Drawing P-M03BB14(Q) and Weld W566 of Drawing P-M03BB15(Q). Each weld was liquid penetrant inspected consistent with the requirements of GEO Procedure IPPT-340, Revision 1701-3 for liquid penetrant examination techniques, materials, and acceptance criteria.

b. Review of Records

The NRC inspector selected six completed welds in the Reactor Coolant Pressure Boundary piping to review the NDE records covering evaluation of weld quality. The following NDE reports were reviewed:

| <u>NDE Report</u> | <u>Drawing</u> | <u>Weld</u> | <u>System</u> |
|-------------------|----------------|-------------|------------------------------|
| RT-7213 | I-M13BB02(Q) | F010 | Reactor Coolant |
| PT-4476 | I-M13BB02(Q) | F010 | Reactor Coolant |
| RT-7214 | I-M13BB02(Q) | F017 | Reactor Coolant |
| PT-4476 | I-M13BB02(Q) | F017 | Reactor Coolant |
| RT-6777 | I-M03BB05(Q) | F001 | Reactor Coolant |
| PT-4122 | I-M03BB05(Q) | F001 | Reactor Coolant |
| RT-5869 | I-M03EP02(Q) | F007 | Accumulator Safety Injection |
| PT-3288 | I-M03EP02(Q) | F007 | Accumulator Safety Injection |
| RT-69921 | I-M03BG24(Q) | FW552 | Chemical and Volume Control |

| <u>NDE Report</u> | <u>Drawing</u> | <u>Weld</u> | <u>System</u> |
|-------------------|----------------|-------------|-----------------------------|
| PT-69922 | I-M03BG24(Q) | FW552 | Chemical and Volume Control |
| RT-69929 | I-M03BG24(Q) | FW553A | Chemical and Volume Control |
| PT-69930 | I-M03BG24(Q) | FW553A | Chemical and Volume Control |

No violations or deviations were identified.

5. Unresolved Items

Unresolved items are matters about which more information is required in order to ascertain whether they are acceptable items, violations, or deviations. One unresolved item disclosed during the inspection is discussed in paragraph 3.a.

6. Exit Interview

The NRC inspector met with licensee representatives (denoted in paragraph 1) and T. E. Vandel (NRC Senior Resident Reactor Inspector) on April 2, 1982, and summarized the scope and findings of the inspection.

INSPECTOR'S REPORT

Office of Inspection and Enforcement

Gilbert, Leslie D
REVIEWER
D M HUNNICH

INSPECTORS L D Gilbert

| LICENSEE/VENDOR | TRANSACTION TYPE | DOCKET NO. (8 digits) OR LICENSE NO. (BY PRODUCT) (13 digits) | REPORT | | NEXT INSP. DATE | |
|----------------------------------|--|---|-------------|----------|-----------------|----|
| | | | NO | SEQ | MO | YR |
| <u>Kansas Gas & Electric</u> | <input checked="" type="checkbox"/> I - INSERT <input type="checkbox"/> M - MODIFY <input type="checkbox"/> D - DELETE <input type="checkbox"/> R - REPLACE | <u>05000482</u> | <u>8206</u> | <u>A</u> | | |
| | | | <u>B</u> | | | |
| | | | <u>C</u> | | | |
| | | | <u>D</u> | | | |

| PERIOD OF INVESTIGATION/INSPECTION | | | | | | INSPECTION PERFORMED BY | | ORGANIZATION CODE OF REGION/HQ CONDUCTING ACTIVITY (See 16MC 0535: Manpower Reporting - Weekly Manpower Reporting for code) | | |
|------------------------------------|-----------|-----------|-----------|-----------|-----------|---|--|---|----------|----------|
| FROM | | | TO | | | | | | | |
| MO | DAY | YR | MO | DAY | YR | | | REGION | DIVISION | BRANCH |
| <u>03</u> | <u>29</u> | <u>82</u> | <u>04</u> | <u>02</u> | <u>82</u> | | | <u>4</u> | <u>C</u> | <u>B</u> |
| | | | | | | <input checked="" type="checkbox"/> REGIONAL OFFICE STAFF <input type="checkbox"/> 2 - RESIDENT INSPECTOR <input type="checkbox"/> 3 - PERFORMANCE APPRAISAL TEAM | | | | |

| REGIONAL ACTION (Check one box only) | | TYPE OF ACTIVITY CONDUCTED (Check one box only) | | | | | |
|---|--|--|--|--|--|--|--|
| <input type="checkbox"/> 1 - NRC FORM 581 <input checked="" type="checkbox"/> 2 - REGIONAL OFFICE LETTER | | <input checked="" type="checkbox"/> 02 - SAFETY <input type="checkbox"/> 03 - INCIDENT <input type="checkbox"/> 04 - ENFORCEMENT <input type="checkbox"/> 05 - MGMT. AUDIT <input type="checkbox"/> 06 - MGMT. VISIT <input type="checkbox"/> 07 - SPECIAL <input type="checkbox"/> 08 - VENDOR <input type="checkbox"/> 09 - MAT. ACCT. <input type="checkbox"/> 10 - PLANT SEC. <input type="checkbox"/> 11 - INVENT. VER. <input type="checkbox"/> 12 - SHIPMENT/EXPORT <input type="checkbox"/> 13 - IMPORT <input type="checkbox"/> 14 - INQUIRY <input type="checkbox"/> 15 - INVESTIGATION | | | | | |

| INSPECTION INVESTIGATION FINDINGS (Check one box only) | | | | TOTAL NUMBER OF VIOLATIONS AND DEVIATIONS | | | | ENFORCEMENT CONFERENCE HELD | | | | REPORT CONTAIN 2790 INFORMATION | | | | LETTER OR REPORT TRANSMITTAL DATE | | | |
|--|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|-----------|-----------|--|
| A | B | C | D | A | B | C | D | A | B | C | D | A | B | C | D | MO | DAY | YR | |
| <input checked="" type="checkbox"/> | | | | <u>00</u> | | | | | | | | | | | | <u>03</u> | <u>29</u> | <u>82</u> | |
| <input type="checkbox"/> 1 - CLEAR <input type="checkbox"/> 2 - VIOLATION <input type="checkbox"/> 3 - DEVIATION <input type="checkbox"/> 4 - VIOLATION & DEVIATION | | | | | | | | <input type="checkbox"/> 1 - YES <input type="checkbox"/> 2 - NO | | | | <input type="checkbox"/> 1 - YES <input type="checkbox"/> 2 - NO | | | | <input type="checkbox"/> NRC FORM 581 OR REG LETTER ISSUED <input type="checkbox"/> REPORT SENT TO HQ FOR ACTION | | | |

| MODULE INFORMATION | | | | | | | | | | | | | | MODULE INFORMATION | | | | | | | | | | | | | | | | | | | |
|--------------------|-----------|-------|----------------|------------------|-------|------|----------|--|------------------------------|----------------------|-------|----------------|------------------|--------------------|------|-----------|----------|-------|----------------|------------------|-------|------|----------|--|------------------------------|--------|-------|----------------|------------------|-------|--|--|--|
| MODULE NUMBER INSP | | | | | | | | | | MODULE REQ. FOLLOWUP | | | | MODULE NUMBER INSP | | | | | | | | | | MODULE REQ. FOLLOWUP | | | | | | | | | |
| REC. ORG. | NUMBER | PHASE | MANUAL CHAPTER | PROCEDURE NUMBER | LEVEL | SEQ. | PRIORITY | DIRECT INSPEC. TIME EFFORT IN STAFF HOURS EXPENDED THIS INSPECTION | PERCENTAGE COMPLETED TO DATE | STATUS | PHASE | MANUAL CHAPTER | PROCEDURE NUMBER | LEVEL | TYPE | REC. ORG. | NUMBER | PHASE | MANUAL CHAPTER | PROCEDURE NUMBER | LEVEL | SEQ. | PRIORITY | DIRECT INSPEC. TIME EFFORT IN STAFF HOURS EXPENDED THIS INSPECTION | PERCENTAGE COMPLETED TO DATE | STATUS | PHASE | MANUAL CHAPTER | PROCEDURE NUMBER | LEVEL | | | |
| | 01230707 | B | 1 | 2 | | | | | | | | | | | | | 05255107 | H | B | 2 | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 08292706 | B | 1 | 2 | | | | | | | | | | | | | 04255107 | G | B | 2 | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| | 072551175 | B | 1 | 4 | 40 | | | | | | | | | | | | 07299101 | H | B | 3 | | | | | | | | | | | | | |
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| | 042551175 | B | 2 | 6 | 80 | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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INSPECTION PLAN

IE Inspection Report No. STN 50-482/82-06
Licensee: Kansas Gas & Electric Co.
Location: Wichita, Kansas
Facility: Wolf Creek, Unit 1
Type of Licensee: PWR, W, 1030 MWe (SNUPPS)
Type of Inspection: Routine, unannounced
Dates of Inspection: March 29 - April 2, 1982
Dates of Previous Inspection:
Inspectors: LD Gilbert

SCOPE OF INSPECTION

30703B
92706B
5517XB X = 5 & 8
55074B
55076B
99014B (Allegation ~~on weld rod control~~ regarding improper welding techniques)

Reactor Inspector

Date

[Signature]
Approved

3/23/82
Date

NOV 03 1982

Docket: STN 50-482/82-15

Kansas Gas and Electric Company
 ATTN: Mr. Glenn L. Koester
 Vice President - Nuclear
 P. O. Box 208
 Wichita, Kansas 67201

Gentlemen:

This refers to the inspection conducted by Mr. L. D. Gilbert of our staff during the period October 4-8, 1982, of activities authorized by NRC Construction Permit CPPR-147 for Wolf Creek, Unit 1, and to the discussion of our findings with Mr. D. W. Prigel and other members of your staff at the conclusion of the inspection.

Areas examined during the inspection and our findings are discussed in the enclosed inspection report. Within these areas, the inspection consisted of selective examination of procedures and representative records, interviews with personnel, and observations by the inspector.

Within the scope of the inspection, no violations or deviations were identified.

We have also examined action you have taken with regard to previously identified inspection findings. The status of these items is identified in paragraph 2 of the enclosed report.

In accordance with 10 CFR 2.790(a), a copy of this letter and the enclosure will be placed in the NRC Public Document Room unless you notify this office, by telephone, within 10 days of the date of this letter and submit written application to withhold information contained therein within 30 days of the date of this letter. Such application must be consistent with the requirements of 2.790(b)(1).

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

Sincerely,

W. C. Seidle, Chief
 Reactor Project Branch 2

Enclosure:

Appendix - NRC Inspection Report STN 50-482/82-15

| | | | | |
|---------------|---------------|----------------|--------------------|-------------------|
| ES <i>LD</i> | ES <i>DMH</i> | RPB2 <i>WC</i> | DRRP&EP <i>JEG</i> | RA-RIV <i>JTC</i> |
| LD Gilbert:gb | DMH Humicutt | WC Seidle | JEG Agard | JTC Collins |
| 11/1/82 | 11/2/82 | 11/2/82 | 11/2/82 | 11/3/82 |

531203046
POL 277

bcc to DMB: IE01

bcc to RIV:
RESIDENT INSEPECTOR
SECTION CHIEF
INFO SYSTEMS
RPB2
RIV FILE
KANSAS STATE DEPT. HEALTH
MYRON KARMAN, ELD, MNBB (2)
J. COLLINS
L. GILBERT
C. WISNER

APPENDIX

U. S. NUCLEAR REGULATORY COMMISSION
REGION IV

Report: STN 50-482/82-15

Docket: STN 50-482

Category A2

Licensee: Kansas Gas and Electric Company
P. O. Box 208
Wichita, Kansas 67201

Facility Name: Wolf Creek, Unit 1

Inspection at: Wolf Creek Site, Coffey County, Burlington, Kansas

Inspection Conducted: October 4-8, 1982

Inspector: L. D. Gilbert
L. D. Gilbert, Reactor Inspector, Engineering Section

11/2/82
Date

Reviewed: J. Hudson
for W. D. Johnson, Chief, Reactor Project Section C

11/2/82
Date

Approved: D. M. Hunnicutt
D. M. Hunnicutt, Chief, Engineering Section

11/2/82
Date

Inspection Summary

Inspection during October 4-8, 1982 (Report STN 50-482/82-15)

Areas Inspected: Routine, unannounced inspection of licensee action on previous inspection findings; site tour; observation of work and review of records for welding and nondestructive examination (NDE) of safety-related piping. The inspection involved 30 inspector-hours onsite by one NRC inspector.

Results: In the areas inspected, no violations or deviations were identified.

~~8512434458~~

8pp PDR

DETAILS1. Persons ContactedPrincipal Licensee Personnel

- *D. W. Prigel, Manager, QA Site
- *D. L. Donnoe, QA Technologist
- *O. L. Thero, Supervisor, QA Surveillance
- *C. E. Parry, Supervisor, QA Systems
- *D. A. Colwell, QA Technologist
- *R. W. Holloway, Project Construction Supervisor
- *J. Fletcher, Quality Control

Other Personnel

- *J. C. Grill, Project Piping Engineer, Daniel International Corporation (DIC)
- C. D. Mauldin, Project Quality Engineer, DIC
- G. Robertson, NDE Level III, GEO Construction Testing

The NRC inspector also interviewed other licensee and contractor employees during the course of the inspection.

*Denotes those attending the exit interview.

2. Licensee Action on Previous Inspection Findings

(Closed) Unresolved Item (8111-01): Grounding of welding machine to steam generator support base plate.

The NRC inspector reviewed the actions taken to resolve Deficiency Report No. ISD 7059M, which was issued to assess the potential damage resulting from grounding a welding machine to a steam generator support base plate while welding on the Reactor Coolant Loop piping. The deficiency report was upgraded to Nonconformance Report No. ISN 3302 MW and work instructions were issued to remove and inspect the steam generator support column for damage to the upper and lower pins and bearing surfaces. The visual inspection was performed and reported as acceptable.

This item is considered resolved.

3. Site Tour

The NRC inspector toured the reactor building and auxiliary building to observe construction in progress and to inspect housekeeping.

No violations or deviations were identified.

4. Safety-Related Pipe Welding and Nondestructive Examination

a. Observation of Welding Activities

The NRC inspector observed the welding and quality control activities associated with fabricating the following safety-related piping welds.

| <u>Weld</u> | <u>Control Drawing</u> | <u>System</u> | <u>Class</u> |
|-------------|------------------------|------------------------------|--------------|
| F-004 | IM13BB04(Q) | Reactor Coolant | 1 |
| FW-310 | IM03BG09(Q) | Chemical & Volume Control | 2 |
| FW-320A | IM03BG03(Q) | Chemical & Volume Control | 2 |
| FW-313 | IM03BG02(Q) | Chemical & Volume Control | 2 |
| F-002 | IM03BG16(Q) | Chemical & Volume Control | 3 |
| F-013 | IM03BG16(Q) | Chemical & Volume Control | 3 |
| FW-315 | IM03BG16(Q) | Chemical & Volume Control | 3 |
| FW-521 | IM03BG16(Q) | Chemical & Volume Control | 3 |
| F-034A | IM03BG03(Q) | Chemical & Volume Control | 2 |
| FW-596 | IM03EM03(Q) | High Pressure Core Injection | 2 |
| FW-654 | IM03EM03(Q) | High Pressure Core Injection | 2 |
| F-002 | IM03EJ05(Q) | Residual Heat Removal | 2 |
| F-001 | IM03EG01(Q) | Component Cooling Water | 3 |

In the areas inspected, the entries on the weld control record were consistent with the status of the welds, the filler materials were traceable to certified material test reports, and the welders were qualified to ASME B&PV Code Section IX.

b. Observation Of Nondestructive Examination Activities

The NRC inspector observed the liquid penetrant examination of the following completed welds:

| <u>Weld</u> | <u>Control Drawing</u> | <u>System</u> | <u>Class</u> |
|-------------|------------------------|------------------------------|--------------|
| FW-596 | IM03EM03(Q) | High Pressure Core Injection | 2 |
| FW-654 | IM03EM03(Q) | High Pressure Core Injection | 2 |
| FW-306 | IM03BM18(Q) | Steam Generator Blowdown | 2 |
| FW-301 | IM03BM20(Q) | Steam Generator Blowdown | 2 |
| FW-301 | IM03BM17(Q) | Steam Generator Blowdown | 2 |

The examinations were performed consistent with requirements of GEO Procedure IPPT-340, Revision 1701-0 for liquid penetrant examination techniques, materials, and acceptance criteria.

c. Observation of Completed Welds

The NRC inspector observed the weld surface condition of the following completed welds.

| Weld | Control Drawing | System | Class |
|--------|-----------------|------------------------------|-------|
| F-061 | IM13AE04(Q) | Feedwater | 2 |
| FW-302 | IM03EP01(Q) | Safety Injection | 1 |
| F-001 | IM03BB05(Q) | Reactor Coolant | 1 |
| F-009 | IM03EN03(Q) | Containment Spray | 2 |
| F-001A | IM13BB02(Q) | Reactor Coolant | 1 |
| F-005A | IM13BB02(Q) | Reactor Coolant | 1 |
| F-008 | IM13BB02(Q) | Reactor Coolant | 1 |
| FW-900 | IM13BB02(Q) | Reactor Coolant | 1 |
| F-004 | IM13BB04(Q) | Reactor Coolant | 1 |
| FW-503 | IM13BB04(Q) | Reactor Coolant | 2 |
| FW-904 | IM03EG24(Q) | Component Cooling Water | 3 |
| FW-905 | IM03EG24(Q) | Component Cooling Water | 3 |
| FW-906 | IM03EG24(Q) | Component Cooling Water | 3 |
| FW-907 | IM03EG24(Q) | Component Cooling Water | 3 |
| F-003 | IM03EJ05(Q) | Residual Heat Removal | 2 |
| F-004 | IM03EM03(Q) | High Pressure Core Injection | 2 |

In the areas inspected, no discrepancies with the requirements of ASME B&PV Code, Section III for completed welds were noted.

d. Review of Nonconformance Reports

The NRC inspector selected for review Nonconformance Report No. ISN5394 on improper radiographic examination by GEO and determined that the recommended disposition had been completed, cause of nonconformance had been established, and action to prevent recurrence had been taken.

e. Review of Records

The NRC inspector reviewed the weld history and nondestructive examination documentation related to the fabrication of the following 14 completed welds.

| Weld | Control Drawing | System | Class |
|--------|-----------------|-------------------|-------|
| F-001 | IM03BB05(Q) | Reactor Coolant | 1 |
| F-009 | IM03EN03(Q) | Containment Spray | 2 |
| F-001A | IM13BB02(Q) | Reactor Coolant | 1 |
| F-005A | IM13BB02(Q) | Reactor Coolant | 1 |
| F-008 | IM13BB02(Q) | Reactor Coolant | 1 |
| FW-900 | IM13BB02(Q) | Reactor Coolant | 1 |
| FW-503 | IM13BB04(Q) | Reactor Coolant | 2 |

| | | | |
|--------|-------------|-------------------------|---|
| FW-500 | IM13BB04(Q) | Reactor Coolant | 2 |
| FW-506 | IM13BB04(Q) | Reactor Coolant | 2 |
| FW-509 | IM13BB04(Q) | Reactor Coolant | 2 |
| FW-904 | IM03EG24(Q) | Component Cooling Water | 3 |
| FW-905 | IM03EG24(Q) | Component Cooling Water | 3 |
| FW-906 | IM03EG24(Q) | Component Cooling Water | 3 |
| FW-907 | IM03EG24(Q) | Component Cooling Water | 3 |

In the areas reviewed, the records indicated that specified inspections were completed; the records reflected adequate weld quality; and weld history records were adequate.

No violations or deviations were identified.

5. Exit Interview

The NRC inspector met with licensee representatives (denoted in paragraph 1) and T. E. Vandel (NRC Senior Resident Reactor Inspector) on October 8, 1982, and summarized the scope and findings of the inspection.

INSPECTOR'S REPORT
Office of Inspection and Enforcement

PRINCIPAL INSPECTOR (Name last first and middle initial)
Gilbert, Leslie F
REVIEWER
DM Hennick

| INSPECTORS | | | | |
|--|---|--|---|--|
| LICENSEE/VENDOR Kansas Gas & Electric Co. | TRANSACTION TYPE I - INSERT M - MODIFY D - DELETE R - REPLACE | DOCKET NO. (8 digits) OR LICENSE NO. (BY PRODUCT) (13 digits) 05000482 | REPORT NO SEQ MO YR B2/5 A B C D | NEXT INSP DATE |
| PERIOD OF INVESTIGATION / INSPECTION FROM TO MO DAY YR MO DAY YR 100482 100882 | INSPECTION PERFORMED BY 1 - REGIONAL OFFICE STAFF 2 - RESIDENT INSPECTOR 3 - PERFORMANCE APPRAISAL TEAM X | | ORGANIZATION CODE OF REGION/HQ CONDUCTING ACTIVITY (See E MC 0530 Mandpower Reporting Weekly Manpower Reporting for code) REGION DIVISION BRANCH 4 C B | |
| REGIONAL ACTION (Check one box only) 1 - NRC FORM 581 X 2 - REGIONAL OFFICE LETTER | TYPE OF ACTIVITY CONDUCTED (check one box only) 01 - SAFETY 02 - INCIDENT 03 - ENFORCEMENT 04 - MGMT AUDIT X 05 - MGMT VISIT 06 - SPECIAL 07 - VENDOR 08 - MAT ACCT 09 - PLANT SEC 10 - INVENT VER. 11 - SHIPMENT/EXPORT 12 - IMPORT 13 - INQUIRY 14 - INVESTIGATION | | | |
| INSPECTION/INVESTIGATION FINDINGS (Check one box only) A B C D X 1 - CLEAR 2 - VIOLATION 3 - DEVIATION 4 - VIOLATION & DEVIATION | TOTAL NUMBER OF VIOLATIONS AND DEVIATIONS A B C D 20 | ENFORCEMENT CONFERENCE HELD A B C D 1 - YES | REPORT CONTAIN 2790 INFORMATION A B C D 1 - YES | LETTER OR REPORT TRANSMITTAL DATE NRC FORM 581 OR REG LETTER ISSUED MO DAY YR 10 08 82 REPORT SENT TO HQ FOR ACTION MO DAY YR 10 08 82 |
| MODULE INFORMATION | | | | |
| REC ORD MODULE NUMBER INSP PHASE MANUAL CHAPTER PROCEDURE NUMBER LEVEL SEQ DIRECT INSPEC-TION EFFORT IN STAFF HOURS EXPENDED THIS INSPECTION PERCENTAGE COMPLETED TO DATE STATUS PHASE MANUAL CHAPTER PROCEDURE NUMBER LEVEL TYPE NUMBER PHASE MANUAL CHAPTER PROCEDURE NUMBER LEVEL DIRECT INSPEC-TION EFFORT IN STAFF HOURS EXPENDED THIS INSPECTION PERCENTAGE COMPLETED TO DATE STATUS PHASE MANUAL CHAPTER PROCEDURE NUMBER LEVEL | | | | |
| 230703B-1 2 255081B-3 1 PPC | | | | |
| 292706B-A 1 1 255083B-A 1 3 PPC | | | | |
| 292701B-A 1 1 255173B-A 2 1 BP | | | | |
| 255071B-A 3 1 PPC 255172B-A 2 1 60 | | | | |

INSPECTOR'S REPORT
Office of Inspection and Enforcement

REVIEWER

INSPECTORS

LICENSEE/VENDOR

TRANSACTION
TYPE

DOCKET NO. (8 digit) OR LICENSE
NO. (BY PRODUCT) (13 digit)

REPORT

NEXT INSP. DATE

NO

SEQ

MO

YR

I - INSERT

M - MODIFY

D - DELETE

R - REPLACE

PERIOD OF INVESTIGATION/INSPECTION

INSPECTION PERFORMED BY

ORGANIZATION CODE OF REGION/HQ CONDUCT-
ING ACTIVITY (See HMC 0530, Manpower Report-
ing - Weekly Manpower Reporting for code)

FROM

TO

1 - REGIONAL OFFICE STAFF

OTHER

2 - RESIDENT INSPECTOR

3 - PERFORMANCE APPRAISAL TEAM

REGION

DIVISION

BRANCH

MO

DAY

YR

MO

DAY

YR

REGIONAL ACTION
(Check one box only)

TYPE OF ACTIVITY CONDUCTED (Check one box only)

1 - NRC FORM 501

2 - REGIONAL OFFICE LETTER

02 - SAFETY

03 - INCIDENT

04 - ENFORCEMENT

05 - MGMT. AUDIT

06 - MGMT. VISIT

07 - SPECIAL

08 - VENDOR

09 - MAT. ACCT.

10 - PLANT SEC.

11 - INVENT. VER.

12 - SHIPMENT/EXPORT

13 - IMPORT

14 - INQUIRY

15 - INVESTIGATION

INSPECTION/INVESTIGATION FINDINGS
(Check one box only)

TOTAL NUMBER
OF VIOLATIONS AND
DEVIATIONS

ENFORCEMENT CONFERENCE
HELD

REPORT CONTAIN 2700
INFORMATION

LETTER OR REPORT TRANSMITTAL DATE

1 - CLEAR

2 - VIOLATION

3 - DEVIATION

4 - VIOLATION & DEVIATION

A B C D A B C D

1 - YES

A B C D

1 - YES

NRC FORM 501
OR REG.
LETTER ISSUED

REPORT SENT
TO HQ. FOR
ACTION

MO

DAY

YR

MO

DAY

YR

MODULE INFORMATION

MODULE INFORMATION

| REC ORD | MODULE NUMBER INSP. | | | | LEVEL | SEQ | PRIORITY | DIRECT INSPEC- TION EFFORT IN STAFF HOURS EXPENDED THIS INSPECTION | PERCENTAGE COMPLETED TO DATE | STATUS | MODULE REG. FOLLOWUP | | | | REC ORD | MODULE NUMBER INSP. | | | | LEVEL | SEQ | PRIORITY | DIRECT INSPEC- TION EFFORT IN STAFF HOURS EXPENDED THIS INSPECTION | PERCENTAGE COMPLETED TO DATE | STATUS | MODULE REG. FOLLOWUP | | | |
|------------|---------------------|--------|---------|-----------|-------|-----|----------|--|------------------------------------|--------|----------------------|--------|---------|-----------|------------|---------------------|--|--|--|-------|-----|----------|--|------------------------------------|--------|----------------------|--------|---------|-----------|
| | PHASE | MANUAL | CHAPTER | PROCEDURE | | | | | | | PHASE | MANUAL | CHAPTER | PROCEDURE | | | | | | | | | | | | PHASE | MANUAL | CHAPTER | PROCEDURE |
| 2551773 | B | | | | 3 | | 1 | 7.0 | | | | | | | 2551788 | B | | | | 3 | | 1 | 9.0 | | | | | | |
| 2551758 | B | | | | 2 | | 1 | 7.0 | | | | | | | 2551823 | B | | | | 3 | | 1 | 9.0 | | | | | | |
| 2551763 | B | | | | 2 | | 1 | 7.0 | | | | | | | 2551833 | B | | | | 3 | | 8 | 9.0 | | | | | | |
| 2551773 | B | | | | 2 | | 1 | 6.0 | | | | | | | 2551853 | B | | | | 3 | | 2 | 100 | | | | | | |

In Reply Refer To:
Docket: STN 50-482/83-12

AUG 26 1983

Kansas Gas and Electric Company
ATTN: Glenn L. Koester
Vice President - Nuclear
P.O. Box 208
Wichita, Kansas 67201

Gentlemen:

This refers to the independent measurements inspection conducted by Mr. H. W. Kerch and other members of the NRC, Region I office during the period June 6-17, 1983, of activities authorized by NRC Construction Permit CPPR-147, for the Wolf Creek Generating Station and to the discussion of our findings with Mr. E. W. Creel, and other members of your staff at the conclusion of the inspection.

Areas examined during the inspection included safety-related piping, structural, and support weldments. Within these areas, the inspection consisted of selective examination of procedures and representative records, interviews with personnel, and observations by the inspectors. These findings are documented in the enclosed inspection report.

During this inspection, it was found that certain of your activities were in violation of NRC requirements. Consequently, you are required to respond to these violations, in writing, in accordance with the provisions of Section 2.201 of the NRC's "Rules of Practice," Part 2, Title 10, Code of Federal Regulations. Your response should be based on the specifics contained in the Notice of Violation enclosed with this letter.

In accordance with 10 CFR 2.790(a), a copy of this letter and the enclosures will be placed in the NRC Public Document Room unless you notify this office, by telephone, within 10 days of the date of this letter, and submit written application to withhold information contained therein within 30 days of the date of this letter. Such application must be consistent with the requirements of 2.790(b)(1).

ES
LDGilbert:gb
8/-/83

ES
REHall
8/-/83

RPS-C
WDJohnson
8/25/83

RPBZ
WCSeidle
8/16/83

8349160279
PDR

Kansas Gas and Electric
Company

-2-

The response directed by this letter and the accompanying Notice is not subject to the clearance procedures of the Office of Management and Budget as required by the Paperwork Reduction Act of 1980, PL 96-511.

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

Sincerely,

Original Signed By
W. C. Seidle

W. C. Seidle, Chief
Reactor Project Branch 2

Enclosures:

1. Appendix A - Notice of Violation
2. Appendix B - NRC Inspection Report
50-482/83-12

bcc to DMB (IE01)

bcc distrib. by RIV:

| | |
|-----------------------------|-----------------------|
| RPB1 | Resident Inspector |
| RPB2 | Section Chief (RPS-C) |
| TPB | J. Gagliardo, DRRP&EP |
| J. Collins, RA | L. Gilbert |
| C. Wisner, PAO | T. Morton, DDE&TP, RI |
| MIS SYSTEM | T. Westerman |
| RIV File | |
| Myron Karman, ELD, MNBB (2) | |
| KANSAS STATE DEPT. HEALTH | |

NOTICE OF VIOLATION

Kansas Gas and Electric

Docket No. 50-482/83-12
License No. CPPR-147

As a result of the inspection conducted during the weeks of June 6 through June 17, 1983, and in accordance with the NRC Enforcement Policy (10 CFR 2, Appendix C), published in the Federal Register Notice (47 FR 9987) dated March 9, 1982, the following violations were identified:

- A. 10 CFR 50.55a(3) requires that reactor coolant pressure boundary piping meet the ASME III Boiler and Pressure Code. The ASME III Code directs that radiography be performed in accordance with the ASME V Code. The ASME V Code, Article 2, paragraph T-263.1, Placement of Penetrameters, requires that, where feasible, the penetrameter must be placed adjacent to the weld.

Contrary to the above, on or before June 6, 1983, Dravo Corporation Pipe radiograph 950-D, had penetrameter placed in the weld area at sectors 1-2 and 2-1.

This is a Severity Level V violation (Supplement II).

- B. 10 CFR 50.55(a) requires that reactor coolant pressure boundary piping meet the ASME III Boiler and Pressure Vessel Code. The ASME III Code, paragraph NB-5300, requires that unacceptable weld defects be removed or reduced to an acceptable limit. It further defines unacceptable discontinuities as any elongated indication exceeding specified lengths.

Contrary to the above, on or before June 6, 1983, the reactor coolant pressure boundary weld F-104, pipe line RC-06-BCR-29, was determined to have elongated indications which exceed the specified lengths which were erroneously accepted on Nonconformance Reports ISN3207MN and ISN2950M.

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

Pursuant to the provisions of 10 CFR 2.201, Kansas Gas and Electric is hereby required to submit to this office within thirty days of the date of the letter which transmitted this Notice, a written statement or explanation in reply, including: (1) the corrective steps which have been taken and the results achieved; (2) corrective steps which will be taken to avoid further violations; and (3) the date when full compliance will be achieved. Where good cause is shown, consideration will be given to extending this response time.

Dated: _____

AUG 26 1983

~~8309160725~~
PDR + P

U.S. NUCLEAR REGULATORY COMMISSION
REGION I

Report No. 50-482/83-12

Docket No. 50-482

License No. CPPR-147

Priority -

Category C

Licensee: Kansas Gas and Electric

P.O. Box 208

Wichita, Kansas 67201

Facility Name: Wolf Creek

Inspection At: Burlington, Kansas

Inspection Conducted: June 6 - 17, 1983

Inspectors: Harry W. Kerch
Harry W. Kerch

8/4/83
date signed

Richard H. Harris
Richard H. Harris

8/4/83
date signed

Randy M. Campbell
Randy M. Campbell

8/4/83
date signed

Approved by: Jacque Durr
Jacque Durr

8/6/83
date signed

Inspection Summary:

Inspection on June 6 - 17, 1983 (Report No. 50-482/83-12)

Areas Inspected: A routine, announced NRC independent measurements inspection was conducted at the utilities construction site using the NRC Mobile Nondestructive Examination (NDE) laboratory. Selected safety related piping, structural and support weldments fabricated to ASME Code, Section III, Classes 1, 2 and 3 and American Welding Society (AWS) Code D1.1 requirements were inspected. Three regional base inspection personnel assisted by two sub-contracted NDE personnel were utilized during this inspection. The inspection involved 437 onsite hours and 196 offsite hours.

Results: One violation was identified, radiographic penetrameters were stationed across the weld area possibly masking indications on the radiograph (482/83-12-01) and one violation was identified concerning an unacceptable linear indication (482/83-12-02).

~~830460293~~
12 PP PDR

Details

1.0 Persons Contacted

Kansas Gas and Electric

- * G. W. Reeves, Assistant Manager, QA
- * C. E. Parry, QA Systems Supervisor
- * E. W. Creel, Corporate QA Manager
- * W. M. Lindsey, QA Supervisor
- * T. Meyer, QC
- * H. K. Helwig, Supervisor, Project Field Engineers
- * J. G. Nelson, Project Quality Supervisor
- * J. Fletcher, LWQCE
- * W. M. Kemp, QA Auditor
- * D. A. Colwell, QA Technician

Westinghouse

- * R. Hopkins, Engineer
- * E. Glasbergen, Site Manager

Daniels Int. Construction

- * E. G. Stuart, Senior QA Engineer
- J. R. Cook, Project QA
- Keith Hollingsworth, Project Welding Engineer

G.E.O

- * G. P. Robertson

USNRC

- * W. Roberds, SRI
- * L. Gilbert, Inspector

* Denotes attendance at Exit Meeting on June 16, 1983

2.0 Independent Measurements - NRC Nondestructive Examination and Quality Records Review of Safety Related Systems

During the period of May 23 through June 3, 1983, quality records received from Wolf Creek Nuclear Power Plant were reviewed in the regional office for completeness and compliance to the licensee's FSAR commitment to applicable codes, standards and specifications.

Subsequently, an on-site independent verification inspection was conducted during the weeks of June 6 through June 17, 1983 using the NRC Mobile Non-destructive Examination (NDE) laboratory. This inspection was conducted by regional based personnel in conjunction with NRC sub-contract personnel.

The purpose of this examination was to verify the adequacy of the licensee's welding quality control program. This was accomplished by duplicating those examinations required of the licensee by the regulations and evaluating the results. In addition to the required examinations, several additional confirmatory examinations designed to verify conformance with material specifications were performed and compared to quality assurance records.

An NRC inspector made a random selection of welds. These were intended to provide a representative sample of piping systems, components, pipe size, materials, shop and field welds to AWS and ASME Class 1, 2 and 3 Codes. The items selected were previously accepted by the licensee based on vendor shop or onsite NDE records.

2.1 Material Traceability

Thirty-three document packages containing the following documents were reviewed:

- Material Certification, including weld wire
- NDE results
- Fabrication record - shop and field
- Drawings (Isometric)
- Physical properties
- Quality Procedures

These documents were verified to satisfy NRC requirements and licensee commitments to industry codes and standards.

Results: All areas examined were acceptable per applicable criteria.

2.2 Nondestructive Examination

Examinations were performed using NRC procedures with addenda written specifically for compliance to the Licensee's PSAR commitment to the ASME B&PV Code, for onsite fabrication. The intent was to duplicate to the extent practicable the techniques and methods of the original examinations.

The following examinations were performed:

Radiographic Examination - twenty-six welds were examined by radiography using an Iridium 192 source per NRC Independent Measurements Procedure, NDE-5, Revision 0, addenda WC-1.5-1. Welds examined were ASME Class 1, 2, and 3 carbon and stainless steel.

Results: One violation was identified 482/83-12-02 (see para. 3.0).

Magnetic Particle Examination - two safety related pipe weldments and structural supports were examined per NRC procedure NDE-6, Revision 0, and addendum WC-1-6-1. Samples included ASME and AWS Code welds.

Results: All areas examined were found acceptable per applicable procedures and acceptance criteria.

Liquid Penetrant Examination - eighteen safety related pipe weldments were examined per NRC procedure NDE-9, Revision 0, and addendum WC-1-9-1. Samples examined included ASME Class 1, 2, and 3 welds.

Results: All areas inspected were acceptable.

Visual Examination - thirty-one weldments and adjacent base material were visually inspected for weld reinforcement, overall workmanship and surface condition per NRC procedure NDE 14, Revision 0.

Results: All areas inspected were acceptable.

Ultrasonic Examination - twenty-four Hilti anchor bolts were inspected ultrasonically, for length only per NRC procedure NDE-18, Revision 0.

Results: All bolts examined were found acceptable per applicable criteria.

Thickness Measurement - six welds and adjacent pipe material were examined per NRC procedure NDE-11, Revision 0, using a NORTEC NDT thickness gauge. Minimum wall thickness was determined by using ASTM standard pipe sizes and nominal thickness chart.

Results: All areas examined were within tolerance requirements.

Ferrite Measurements - eight pipe welds were checked for delta ferrite content using a Type II Ferrite Indicator (Severn Gauge).

Results: All Measurements were within acceptable limits.

Hardness Measurements - seven welds were checked for hardness (base material adjacent to welds) using the Equo-tip hardness tester per NRC procedure NDE-12, Revision 0. Hardness numbers were converted to Brinnell values and the approximate tensile strengths were determined by use of conversion tables.

Results: All areas examined were within acceptable limits.

Alloy Analyzer - six pipe welds and adjacent base metals were examined using a Texas Nuclear Alloy Analyzer. A qualitative chemical analysis was made on four stainless steel 304 type and two stainless steel 316 type material.

Results: Areas examined were within $\pm 2\%$ of chemical analysis indicated on corresponding certified mill test reports.

Windsor Probe Test - three areas of concrete were tested to determine compressive strength using the Windsor probe test kit.

Results: All area tests were within acceptable limits.

Attachment: Attachment No. 1 is a tabulation of the specific items examined and results of tests.

3.0 Review of Licensee's Radiographs

A random selection of the licensee's safety related radiographs was reviewed to verify the adequacy of the radiographic program. Twenty-three radiographs that were previously accepted by the licensee were reviewed for technique, film quality, and weld integrity. The review disclosed that welds F-104-R1, F-305, and F-405-R2 were rejected by the licensee for incomplete fusion and elongated indications. The licensee issued Nonconformance Reports Nos. ISN3207MW, ISN3206, ISN3383, and ISN4873PW which were subsequently dispositioned by Westinghouse, the NSSS. Westinghouse accepted the welds based on in-process radiographs not final code radiographs.

Subsequently, the final radiography was performed and again rejected by the licensee's NDE personnel for lack of fusion and elongated indications. The final radiographic report referenced the above mentioned NCR's although the final film was not reviewed by the NSSS.

The NRC reviewed this final and in-process film and determined that the indications were, indeed, unacceptable and requested further examinations to be performed. In a telephone conversation with Messrs B. Russell and J. Fletcher, of the licensee's staff on July 22, 1983, it was stated that the indications in weld F-104, views 108-0 and 12-24 are code rejectable. The failure to properly disposition radiographic indications in reactor coolant pressure boundary welds is a violation of 10 CFR 50.55(a) (482/83-12-02).

Further, the review of reactor recirculation pipe welds F104 and F305 disclosed that the welds were rejected by licensee radiographic film reviewers for incomplete fusion. The rejection was documented on a nonconformance report (NCR) and subsequently accepted by other personnel as elongated slag inclusions. The appearance of incomplete fusion and elongated slag inclusions on a radiograph are distinctly different. The mischaracterization of these indications, by either party, is cause for concern. If the NDE film reviewers misread the film, then all film reviewed by him becomes suspect. If the disposition of the NCR is incorrect, then unacceptable defects exist in the welds.

4.0 Review of Vendor Radiographs

A review of vendor pipe radiographs was made during this inspection of ASME Class 1 weldments.

Three vendor radiographs were selected for review, one of which was unacceptable per ASME Code Section V, Paragraph T-263. Penetrators were placed on the weld in the area of interest possibly masking indications. The radiograph was identified as weld "D", line 88-BCA-6. A nonconformance (NCR ISN 11652PW) has been written by the licensee against the radiograph and dispositioned. The failure to place penetrators outside of the area of interest is a violation of 10 CFR 50.55(a) (482/83-12-01).

5.0 Review of Preservice Ultrasonic Examination

The inspector reviewed the ultrasonic preservice inspection (PSI) records on June 15, 1983 for compliance with 10 CFR 50.55(a) and the American Society of Mechanical Engineers (ASME) Boiler and Pressure Vessel Code requirements. Nuclear Energy Service is the site PSI subcontractor and started the PSI on May 23, 1983. Nondestructive examination (NDE) personnel qualification and certification records were reviewed and found to meet SNT-TC-1A and ASME code requirements. Liquid penetrant, magnetic particle and three ultrasonic testing procedures were reviewed and found to meet ASME code requirements. A review of the limited documentation of NDE results was performed and the results were considered acceptable.

No violations were identified.

6.0 Exit Interview

An exit interview was held on June 16, 1983, with members of the licensee's staff. The inspector summarized the purpose, scope and findings of this inspection.

| WELD NUMBER Line/ISO | CLASS | SIZE | DATA | THICK | M.T. | R.T. | U.T. | P.T. | HARDNESS | VISUAL | REMARKS |
|-------------------------|-------|------|------|-------|------|------|------|------|----------|--------|--------------------------------------|
| RC-88-BCA-6 SW-D | 1 | 6" | ACC. | N/A | N/A | ACC. | N/A | ACC. | N/A | ACC. | |
| RC-90-BCA-6 F006 | 1 | 6" | " | " | " | " | " | " | " | " | |
| RC-80-BCA-4 F001 | 1 | 4" | " | " | " | " | " | " | " | " | |
| RC-80-BCA-4 SW-C | 1 | 4" | " | " | " | " | " | " | " | " | |
| HP-BCA-6 F010 | 1 | 6" | " | ACC. | " | N/A | " | " | ACC. | " | |
| HP-BCA-6 SW-G | 1 | 6" | " | " | " | N/A | " | " | " | " | |
| MS-003-DBB-28 F047 | 2 | 28" | " | N/A | ACC. | " | " | N/A | N/A | " | |
| MS-003-DBB-28 SW-E | 2 | 28" | " | " | " | " | " | " | " | " | |
| RH-07-HCB-24 FW309 | 2 | 24" | " | " | N/A | ACC. | " | N/A | " | " | |
| RH-23-ECB-10 F035 | 2 | 10" | " | " | " | " | " | " | " | " | |
| RH-03-ECB-14 F005 | 2 | 14" | " | " | " | " | " | " | ACC. | " | FN-3.5 TO 7.5 |
| RH-04-HCB-14 F041 | 2 | 14" | " | " | " | " | " | " | " | " | FN-3.5 TO 7.5 ALLOY Analyzed - AC |
| CVC-028-ECB-3 FW309 | 2 | 3" | " | " | " | " | " | " | " | " | FN-7.5 ALLOY ANALYZED-ACC |
| CVC-028-ECB-3 F011-A | 2 | 3" | " | " | " | " | " | " | N/A | " | FN-3.5 TO 7.5 |

ADDITIONAL CONFORMATORY EXAMINATIONS

Kersch Harry W
REVIEWER
J. D. Durr

Richard H. Harris
Barry L. Campbell

| MODULE INFORMATION | | | | | | | | | | MODULE INFORMATION | | | | | | | | | |
|--------------------|-------|---------------------|---------|------------------|-------|----------|---|------------------------------|--------|--------------------|-------|---------------------|---------|------------------|-------|----------|---|------------------------------|--------|
| REC. ORD. | | MODULE NUMBER INSP. | | | | | MODULE REQ. FOLLOWUP | | | REC. ORD. | | MODULE NUMBER INSP. | | | | | MODULE REQ. FOLLOWUP | | |
| TYPE | PHASE | MANUAL | CHAPTER | PROCEDURE NUMBER | LEVEL | PRIORITY | DIRECT INSPEC. TIME EFFORT IN STAFF HOURS | PERCENTAGE COMPLETED TO DATE | STATUS | TYPE | PHASE | MANUAL | CHAPTER | PROCEDURE NUMBER | LEVEL | PRIORITY | DIRECT INSPEC. TIME EFFORT IN STAFF HOURS | PERCENTAGE COMPLETED TO DATE | STATUS |
| 05 | 2 | 310 | 710 | 3 | A | | 010.3 | | | 05 | 2 | 515 | 155 | 5 | A | | 110.2 | 430 | P |
| | | | | | B | | | | | | | | | | B | | | | |
| | | | | | C | | | | | | | | | | C | | | | |
| | | | | | D | | | | | | | | | | D | | | | |
| 06 | 2 | 515 | 0616 | 6 | A | | 115.1 | 110 | | 06 | 2 | 515 | 175 | 6 | A | | 110.5 | 520 | C |
| | | | | | B | | | | | | | | | | B | | | | |
| | | | | | C | | | | | | | | | | C | | | | |
| | | | | | D | | | | | | | | | | D | | | | |
| 07 | 2 | 515 | 076 | 6 | A | | 110.1 | 100 | P | 07 | 2 | 515 | 1815 | 6 | A | | 110.0 | 100 | P |
| | | | | | B | | | | | | | | | | B | | | | |
| | | | | | C | | | | | | | | | | C | | | | |
| | | | | | D | | | | | | | | | | D | | | | |
| 08 | 2 | 515 | 086 | 6 | A | | 110.0 | 100 | P | 08 | 2 | 517 | 1904 | 6 | A | | 121.0 | 100 | P |
| | | | | | B | | | | | | | | | | B | | | | |
| | | | | | C | | | | | | | | | | C | | | | |
| | | | | | D | | | | | | | | | | D | | | | |

* CIRCLE SEQUENCE IF VIOLATION OR DEVIATION

DOCKET NO. (8 digits) OR LICENSE
NO. (BY PRODUCT) (13 digits)

REPORT

MODIFICATION NUMBER

2 E

NO

SEQ

9505619

INSPECTOR'S REPORT

(Continuation)

Office of Inspection and Enforcement

05000482

8313

A

VIOLATION SEVERITY OR DEVIATION

SITE
RELATED

B

1 2 3 4 5 6

C

X

D

VIOLATION OR DEVIATION (Enter up to 2400 characters for each item. If the text exceeds this number, it will be necessary to paraphrase. Limit lines to 50 characters each.)

10 CFR 50.55a(3) requires that reactor coolant pressure boundary piping meet the ASME III Boiler and Pressure Code. The ASME III Code directs that radiography be performed in accordance with the ASME V Code. The ASME V Code, Article 2, paragraph T-263.1, Placement of Penetrameters, requires that, where feasible, the penetrometer must be placed adjacent to the weld.

Contrary to the above, on or before June 6, 1983, Dravo Corporation Pipe radiograph 950-D, had penetrometer placed in the weld area at sectors 1-2 and 2-1.

This is a Severity Level V violation (Supplement II).

DOCKET NO. (8 digits) OR LICENSE
 NO. (BY PRODUCT) (13 digits)

REPORT

MODULE NUMBER

DATE

INSPECTOR'S REPORT

(Continuation)

Office of Inspection and Enforcement

05000492

8313

957155B1

VIOLATION SEVERITY OR DEVIATION

SITE

1 2 3 4 5 6

RELATED

X

A C

X

B D

VIOLATION OR DEVIATION (Enter up to 2400 characters for each item. If the text exceeds this number, it will be necessary to paraphrase. Limit lines to 50 characters each.)

10 CFR.50.55(a) requires that reactor coolant pressure boundary piping meet the ASME III Boiler and Pressure Vessel Code. The ASME III Code, paragraph NB-5300, requires that unacceptable weld defects be removed or reduced to an acceptable limit. It further defines unacceptable discontinuities as any elongated indication exceeding specified lengths.

Contrary to the above, on or before June 6, 1983, the reactor coolant pressure boundary weld F-104, pipe line RC-06-BCR-29, was determined to have elongated indications which exceed the specified lengths which were erroneously accepted on Nonconformance Reports ISN3207MN and ISN2950M.

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

In Reply Refer To:
Docket: STN 50-482/83-15

JUN 30 1983

Kansas Gas and Electric Company
ATTN: Glenn L. Koester
Vice President - Nuclear
P.O. Box 208
Wichita, Kansas 67201

Gentlemen:

This refers to the inspection conducted by Mr. L. D. Gilbert of this office during the period June 6-9 and 14-16, 1983, of activities authorized by NRC Construction Permit CPPR-147, for Wolf Creek, Unit 1, and to the discussion of our findings with Mr. E. W. Creel, and other members of your staff at the conclusion of the inspection.

Areas examined during the inspection included: installation of safety-related piping and coordination of the NRC independent verification inspection program. Within these areas, the inspection consisted of selective examination of procedures and representative records, interviews with personnel, and observations by the inspector. These findings are documented in the enclosed inspection report.

Within the scope of the inspection, no violations or deviations were identified.

In accordance with 10 CFR 2.790(a), a copy of this letter and the enclosure will be placed in the NRC Public Document Room unless you notify this office, by telephone, within 10 days of the date of this letter, and submit written application to withhold information contained therein within 30 days of the date of this letter. Such application must be consistent with the requirements of 2.790(b)(1).

~~83-482-699~~
2PP PAR

ES *LB*
LDGilbert:gb
6/27/83

ES *DM*
DMHunnicut
6/27/83

RPB2 *X*
WCSeidle
6/27/83

DDRRP *EP*
JEGagliardo
6/27/83

Kansas Gas and Electric
Company

-2-

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

Sincerely,

"Original Signed by:
W. C. SEIDLE"

W. C. Seidle, Chief
Reactor Project Branch 2

Enclosure:
Appendix - NRC Inspection Report 50-482/83-15

bcc to DMB (IE01)

bcc distrib. by RIV:

| | |
|------|-----------------------|
| RPB1 | Resident Inspector |
| RPB2 | Section Chief (RPS-C) |
| TPB | L. Gilbert |

J. Collins, RA

C. Wisner, PAO

MIS SYSTEM

RIV File

Myron Karman, ELD, MNBB (2)

KANSAS STATE DEPT. HEALTH

APPENDIX

U. S. NUCLEAR REGULATORY COMMISSION
REGION IV

NRC Inspection Report: 50-482/83-15

Docket: 50-482

Category A2

Licensee: Kansas Gas and Electric Company
P. O. Box 208
Wichita, Kansas 67201

Facility Name: Wolf Creek, Unit 1

Inspection At: Wolf Creek Site, Coffey County, Burlington, Kansas

Inspection Conducted: June 6-9 and 14-16, 1983

Inspector:

L. D. Gilbert
L. D. Gilbert, Reactor Inspector, Engineering
Section

6/27/83
Date

Approved:

W. D. Johnson
W. D. Johnson, Chief, Reactor Project Section C

6/27/83
Date

D. M. Hunnicutt
D. M. Hunnicutt, Chief, Engineering Section

6/27/83
Date

Inspection Summary

Inspection Conducted June 6-9 and 14-16, 1983 (Report 50-482/83-15)

Areas Inspected: Routine unannounced inspection of activities including: observation of work and review of records for installation of safety-related piping and coordination of the NRC independent verification inspection program. The inspection involved 39 inspector-hours onsite by one NRC inspector.

Results: Within the areas inspected, no violations or deviations were identified.

~~8248090716~~

4 pp PDR

DETAILS1. Persons ContactedPrincipal Licensee Personnel

*E. W. Creel, Corporate QA Manager
 *C. E. Parry, QA Systems Supervisor
 *G. W. Reeves, Assistant Manager QA
 *W. M. Lindsay, QA Surveillance Supervisor
 *H. K. Helwig, Supervisor Project Field Engineering
 *J. V. Palermo, Assistant Construction Manager
 *J. G. Nelson, Project Quality Supervisor
 *W. M. Kemp, QA Auditor
 *D. A. Calwell, QA Technologist
 *J. Fletcher, Lead Welding QC Engineer
 *T. Meyer, Quality Control

Other Personnel

*E. Glasbergen, Site Manager, Westinghouse
 *R. Hopkins, Engineer, Westinghouse
 *G. P. Robertson, Project Manager, GEO
 *B. G. Stenett, Senior QA Engineer, Daniel International Corp. (DIC)
 K. Hollingsworth, Project Welding Engineer (DIC)

The NRC inspector also interviewed other licensee and contractor employees during the course of the inspection.

*Denotes those attending the exit interview.

2. Safety-Related Pipe Welding

The NRC inspector observed the welding and quality control activities associated with fabricating the following safety-related piping welds.

| <u>Weld</u> | <u>Control Drawing</u> | <u>System</u> | <u>Class</u> |
|-------------|------------------------|------------------------------|--------------|
| FW-308 | IM03BB15(Q) | Reactor Coolant | 1 |
| FW-506A | IM03EP02(Q) | Safety Injection | 1 |
| F-023A | IM03EJ04(Q) | Residual Heat Removal | 1 |
| F-024 | IM03EJ04(Q) | Residual Heat Removal | 1 |
| FW-571 | IM03EM05(Q) | High Pressure Core Injection | 2 |
| FW-500 | X-M06-EJ04-R009/232(Q) | Residual Heat Removal | 2 |
| FW-501 | X-M06-EJ04-R009/232(Q) | Residual Heat Removal | 2 |
| FW-502 | X-M06-EJ04-R009/232(Q) | Residual Heat Removal | 2 |
| FW-503 | X-M06-EJ04-R009/232(Q) | Residual Heat Removal | 2 |
| FW-504 | X-M06-EJ04-R009/232(Q) | Residual Heat Removal | 2 |
| FW-505 | X-M06-EJ04-R009/232(Q) | Residual Heat Removal | 2 |
| FW-506 | X-M06-EJ04-R009/232(Q) | Residual Heat Removal | 2 |
| FW-507 | X-M06-EJ04-R009/232(Q) | Residual Heat Removal | 2 |
| FW-500 | M08BG21-R501/242(Q) | Chemical & Volume Control | 2 |
| FW-029A | M13AE05(Q)-02 | Feedwater | 2 |

In the areas inspected, the entries on the weld control records were consistent with the status of the welds, the welding procedures were being followed, the welding filler materials were traceable to certified material test reports, and the welders were listed as qualified to ASME B&PV Code Section IX.

No violations or deviations were identified.

3. NRC Independent Verification Inspection Program

The NRC inspector coordinated the activities of the NRC, Region I, NDE inspection team on arrival at the site and provided additional information on the welds previously selected for the NRC independent verification inspection program. The results and findings of the NRC independent verification inspection program will be documented in NRC Inspection Report 50-482/83-12.

4. Exit Interview

The NRC inspector met with licensee representatives (denoted in paragraph 1) and H. W. Roberds, NRC Senior Resident Reactor Inspector, on June 16, 1983, and summarized the scope and findings of the inspection.

INSPECTOR'S REPORT
Office of Inspection and Enforcement

Gilbert, Leslie D

REVIEWER:

PECTORAL

| LICENSEE/VENDOR | TRANSACTION TYPE | DOCKET NO. (8 digits) OR LICENSE NO. (BY PRODUCT) (112 digits) | REPORT | | NEXT INSPECTION DATE | |
|--|---------------------|---|--------|------|----------------------|-----|
| | | | NO. | SEQ. | MO. | YR. |
| <i>Kansas Gas & Electric Company</i> | X I - INSERT | 05003482 | 8915 | A | | |
| | M - MODIFY | | | B | | |
| | D - DELETE | | | C | | |
| | R - REPLACE | | | D | | |

| PERIOD OF INVESTIGATION/INSPECTION | | | | | | | INSPECTION PERFORMED BY | | ORGANIZATION CODE OF REGION/HQ CONDUCTING ACTIVITY (See IEMC 0530 Manpower Reporting—Weekly Manpower Reporting for code) | | |
|------------------------------------|-----|-----|-----|-----|-----|--------------------------------|---------------------------|-------|--|----------|--------|
| FROM | | | TO | | | | 1 - REGIONAL OFFICE STAFF | OTHER | REGION | DIVISION | BRANCH |
| D. | DAY | YR. | MO. | DAY | YR. | 2 - RESIDENT INSPECTOR | | | | | |
| 7 | 16 | 83 | 06 | 17 | 83 | 3 - PERFORMANCE APPRAISAL TEAM | | | 4 | C | B |

| REGIONAL ACTION (Check one box only) | | TYPE OF ACTIVITY CONDUCTED (Check one box only) | | | |
|--|---|---|---|---|--|
| <input checked="" type="checkbox"/> 1 - NRC FORM 801 | <input checked="" type="checkbox"/> 02 - SAFETY | <input type="checkbox"/> 06 - MGMT. VISIT | <input type="checkbox"/> 10 - PLANT SEC. | <input type="checkbox"/> 14 - INQUIRY | |
| <input type="checkbox"/> 2 - REGIONAL OFFICE LETTER | <input type="checkbox"/> 03 - INCIDENT | <input type="checkbox"/> 07 - SPECIAL | <input type="checkbox"/> 11 - INVENT. VER. | <input type="checkbox"/> 15 - INVESTIGATION | |
| | <input type="checkbox"/> 04 - ENFORCEMENT | <input type="checkbox"/> 08 - VENDOR | <input type="checkbox"/> 12 - SHIPMENT/EXPORT | | |
| | <input type="checkbox"/> 05 - MGMT. AUDIT | <input type="checkbox"/> 09 - MAT. ACCT. | <input type="checkbox"/> 13 - IMPORT | | |

| INSPECTION INVESTIGATION FINDINGS (Check one box only) | | | | TOTAL NUMBER OF VIOLATIONS AND DEVIATIONS | | | | | | | | ENFORCEMENT CONFERENCE HELD | | | | | | | | REPORT CONTAIN 2790 INFORMATION | | | | LETTER OR REPORT TRANSMITTAL DATE | | | | | |
|---|---|---|---------------------------|---|---|---|---|---|---|---|---|-----------------------------|---|---|---|---|---------|-----|-----|---------------------------------|-----|-----|-----|-----------------------------------|--|--|--|--|--|
| B | C | D | | A | B | C | D | A | B | C | D | 1 - YES | A | B | C | D | 1 - YES | MO. | DAY | YR. | MO. | DAY | YR. | | | | | | |
| | | | 1 - CLEAR | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | 2 - VIOLATION | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | 3 - DEVIATION | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | 4 - VIOLATION & DEVIATION | | | | | | | | | | | | | | | | | | | | | | | | | | |

[illegible]

FEB 25 1985

In Reply Refer To:
Docket: STN 50-482/84-23

Kansas Gas and Electric Company
ATTN: Glenn L. Koester
Vice President - Nuclear
P. O. Box 208
Wichita, Kansas 67201

Gentlemen:

This refers to the inspection conducted by Mr. R. G. Taylor and other members of our staff during the period September 10 - December 14, 1984, of activities authorized by NRC Construction Permit CPPR-147 for Wolf Creek Generating Station, and to the discussion of our findings with Mr. R. M. Grant and other members of your staff at the conclusion of the inspection.

Areas examined during the inspection included review of procedures and records for installation of reactor coolant and other safety-related piping, review of quality records for installation of reactor vessel internals, comparison of as-built plant to FSAR description, followup on allegations, safety-related pipe supports/restraints, as-built piping systems and structures, onsite design activities, followup on construction deficiency reports, and licensee actions concerning NRC Vendor Program Branch inspection findings at Colt Industries. Within these areas, the inspection consisted of selective examination of procedures and representative records, interviews with personnel, and observations by the inspector. These findings are documented in the enclosed inspection report.

During this inspection, it was found that certain of your activities were in violation of NRC requirements. Consequently, you are required to respond to these violations, in writing, in accordance with the provisions of Section 2.201 of the NRC's "Rules of Practice," Part 2, Title 10, Code of Federal Regulations. Your response should be based on the specifics contained in the Notice of Violation enclosed with this letter.

During this inspection, it was found that certain of your activities appeared to deviate from accepted industry standards. This item and reference to the standards is identified in the enclosed Notice of Deviation. You are requested to respond to this deviation in writing. Your response should be based on the specifics contained in the Notice of Deviation enclosed with this letter.

RPB1/A
RG Taylor/jj
2/1/85

RPB1/A
IBarnes
2/1/85

RPB1/A
JPdaudon
1/1/85

RPB1
EHJohnson
1/85

C:WCTF
LEMartin
2/14/85

D:WCTF
RPDenise
2/18/85

8543010251

TEC1

We have also examined actions you have taken with regard to previously identified inspection findings. The status of these items is identified in paragraph 2 of the enclosed report.

The responses directed by this letter and the accompanying Notices are not subject to the clearance procedures of the Office of Management and Budget as required by the Paperwork Reduction Act of 1980, PL 96-511.

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

Sincerely,

Original Signed By:
Richard P. Denise

R. P. Denise, Director
Wolf Creek Task Force

Enclosures:

1. Appendix A - Notice of Violation
2. Appendix B - Notice of Deviation
3. Appendix C - NRC Inspection Report
50-482/84-23

cc w/enclosures:

Kansas Gas and Electric Company
ATTN: Gene P. Rathbun, Manager
of Licensing
P. O. Box 208
Wichita, Kansas 67201

Forrest Rhodes, Plant Superintendent
Wolf Creek Generating Station
P. O. Box 309
Burlington, Kansas 66839

bcc to DMB (IE01)

bcc distrib. by RIV:

*RPB1
✓*RPB2
*EP&RPB
*RIV File
Myron Karman, ELD, MNBB (2)
KANSAS STATE DEPT. HEALTH
*L. Ellershaw
P. O'Connor, NRR
*Resident Inspector
*Section Chief (RPB2/A)
R. Denise, DRS&P

K. Kneil, NRR
R. D. Martin, RA
C. Wisner, PAO
*MIS System
R. Walker, RII
*RSTS Operator
*I. Barnes, RPB1/A
*R. Taylor, RPB1/A

APPENDIX A

NOTICE OF VIOLATION

Kansas Gas and Electric Company
Wolf Creek Generating Station

Docket: 50-482
Permit: CPPR-147

Based on the results of an NRC inspection conducted during the period of September 10 - December 14, 1984, and in accordance with the NRC Enforcement Policy (10 CFR Part 2, Appendix C), 49 FR 8583, dated March 8, 1984, the following violations were identified:

1. Failure to Specify Appropriate Criteria in a Component Support Design Specification to Assure Compliance with Regulatory Guide 1.85

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

Appendix 3A of the SNUPPS Final Safety Analysis Report commits to compliance with the requirements of Regulatory Guide 1.85. The use of ASME Code Case 1644-7(N-71-7), "Additional Materials for Component Supports, Section III, Division 1, Subsection NF, Class 1, 2, and 3 and MC Component Supports," is conditionally accepted by Regulatory Guide 1.85. The stipulated conditions of acceptance are to either restrict the maximum measured ultimate tensile strength (UTS) of the component support material to 170 Ksi or, if it is desired to use material with up to 190 Ksi UTS, to specify impact testing of the material in the Design Specification. For the latter case, it is required to be demonstrated that (a) the impact test results for the material meet code requirements, and (b) the material is not subject to stress corrosion cracking by virtue of the fact that (1) a corrosive environment is not present and (2) the component containing the material has essentially no residual stresses or assembly stresses, and it does not experience frequent sustained loads in service.

Contrary to the above, SNUPPS Design Specification No. 10466-M-218A(Q), Revision 6 dated April 11, 1979, permitted the support manufacturer (i.e., Bergen Paterson) to utilize ASME Code Case 1644-7(N-71-7) for materials selection, without imposing the restrictions on use contained in Regulatory Guide 1.85.

This is a Severity Level IV Violation. (Supplement II) (482/8423-01)

2. Failure to Perform Nondestructive Examination of Component Support Field Welds in Accordance with Drawing Requirements

Criterion V of Appendix B to 10 CFR Part 50 requires that activities affecting quality shall be accomplished in accordance with appropriate instructions, procedures, or drawings.

~~482/8423-01~~
PDR 292

Daniel International (DIC) Drawing No. M06-EJ04-C021/231(Q), Revision 5, requires that nondestructive examination of welds be performed in accordance with Subsection NF, paragraph NF-5212 in Section III of the ASME Code. Paragraph NF-5212 requires that full fillet welds be examined by either the magnetic particle or liquid penetrant examination methods.

Contrary to the above, the field weld (i.e., Weld 1) in the EJ04-C021 component support, which was specified by the support manufacturer to be a full fillet weld, received only a visual examination and was not examined by either the magnetic particle or liquid penetrant methods.

This is a Severity Level V Violation. (Supplement II) (482/8423-01)

3. Failure to Follow Procedure with Respect to Handling of Potentially Reportable Nonconformances

Criterion V of Appendix B to 10 CFR Part 50 requires that activities affecting quality shall be accomplished in accordance with appropriate instructions, procedures, or drawings, and that these instructions, procedures, or drawings include acceptance criteria for determining that important activities have been accomplished.

Paragraph 15 of "Instructions For Completing Nonconformance Report (NCR)" in DIC Construction Procedure AP-VI-02 states, "Potential 50.55(e) or Part 21 - The Discipline Manager, after review of nonconformance, shall check the appropriate block. If the 'yes' block is indicated, refer to Paragraph 4.2.6 of this procedure for further action." Paragraph 4.2.6 states, "Evaluate NCR to determine if there is a potentially reportable nonconformance under the provisions of 10 CFR 50.55(e) or Part 21, and check the appropriate box. When it is determined that there is a potentially reportable nonconformance, immediately hand-carry a copy of the NCR to the KG&E Significant Deficiency Coordinator/Construction where a 'WCGS Request for Reportability Evaluation' shall be generated and further action taken,"

Contrary to the above, NCRs with the appropriate box checked off indicating potentially reportable conditions existed, were not immediately hand carried to KG&E's significant deficiency coordinator, as evidenced by the September 1984 date on the NCRs, and the DIC reportability evaluation dated December 1984.

This is a Severity Level IV Violation. (Supplement II). (482/8423-03)

Pursuant to the provisions of 10 CFR 2.201, Kansas Gas and Electric Company is hereby required to submit to this office, within 30 days of the date of this Notice, a written statement or explanation in reply, including: (1) the corrective steps which have been taken and the results achieved; (2) corrective steps which will be taken to avoid further violations; and (3) the date when full compliance will be achieved. Consideration may be given to extending your response time for good cause shown.

Dated: FEB 25 1985

APPENDIX B

NOTICE OF DEVIATION

Kansas Gas and Electric Company
Wolf Creek Generating Station

Docket: 50-482
Permit: CPPR-147

Based on the results of an NRC inspection conducted during the period of September 10 - December 14, 1984, and in accordance with NRC Enforcement Policy (10 CFR Part 2, Appendix C), 49 FR 8583, dated March 8, 1984, the following deviation was identified.

Failure of Procedure to Comply with Applicable ASME Code Requirements
for Magnetic Particle Examination

Paragraph T-734.2 in Article 7 of Section V of the ASME Code (1974 Edition through Summer 1975 Addenda) requires that a pole spacing of 3 to 6 inches be used for the yoke method of magnetic particle examination.

In deviation from the above, GEO Procedure No. 21.A.1; Revision 6, dated October 14, 1983, "Magnetic Particle Examination Dry Method," permitted a maximum pole spacing of 8 inches to be used for the yoke method.
(482/8423-04)

Kansas Gas and Electric Company is hereby requested to submit to this office, within 30 days of the date of this Notice of Deviation, a written statement or explanation in reply, including: (1) the corrective steps which have been taken and the results achieved; (2) corrective steps which will be taken to avoid further deviation from commitments made to the Commission; and (3) the date when full compliance will be achieved. Consideration may be given to extending your response time for good cause shown.

Dated: FEB 25 1985

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1p PDR

APPENDIX C

U. S. NUCLEAR REGULATORY COMMISSION
REGION IV

NRC Inspection Report: 50-482/84-23

Construction Permit: CPPR-147

Docket: 50-482

Licensee: Kansas Gas and Electric Company (KG&E)
P. O. Box 208
Wichita, Kansas 67201

Facility Name: Wolf Creek Generating Station (WCGS)

Inspection At: WCGS Site, Coffey County, Burlington, Kansas

Inspection Conducted: September 10 - December 14, 1984

Inspectors:

R. G. Taylor
R. G. Taylor, (Team Leader)
Wolf Creek Task Force

2/7/85
Date

L. E. Ellershaw
L. E. Ellershaw, Reactor Inspector
Wolf Creek Task Force

2/7/85
Date

R. P. Mullikin
R. P. Mullikin, Reactor Inspector
Wolf Creek Task Force

2/11/85
Date

D. E. Bess
D. E. Bess, Reactor Inspector
Wolf Creek Task Force

2/6/85
Date

L. D. Gilbert
L. D. Gilbert, Reactor Inspector
Wolf Creek Task Force

2/6/85
Date

~~85434-4262~~

PDR 29.2

I. Barnes

I. Barnes, Reactor Inspector
Wolf Creek Task Force

2/11/85
Date

for J.E. Martin
J. R. Boardman, Reactor Inspector
Wolf Creek Task Force

2/12/85
Date

W. R. Bennett
W. R. Bennett, Reactor Inspector
for Wolf Creek Task Force

2/4/85
Date

Approved: *J.E. Martin*
L. E. Martin, Chief, Wolf Creek Task Force

2/12/85
Date

Inspection Summary

Inspection Conducted September 10 - December 14, 1984 (Report 50-482/84-23)

Areas Inspected: Routine, announced inspection including licensee action on previous inspection findings, review of procedures for installation of reactor coolant and other safety-related piping, review of records for installation of reactor coolant and other safety-related piping, review of quality records for installation of reactor vessel internals, comparison of as-built plant to FSAR description, followup of allegations, safety-related pipe supports/restraints, as-built piping systems and structures, onsite design activities, followup on 10 CFR Part 50.55(e) construction deficiency reports, and licensee actions concerning NRC Vendor Program Branch inspection findings at Colt Industries. The inspection involved 677 inspector-hours by nine NRC inspectors.

Results: Within the 11 areas inspected, two violations and one deviation were identified in the review of safety-related pipe supports/restraints and one violation was identified in followup on 10 CFR part 50.55(e) construction deficiency reports.

DETAILS

1. Persons Contacted

Principal Licensee Employees

- *R. M. Grant, Director-Quality
- *P. Dyson, Field Engineering Supervisor
- *M. Johnson, Manager-Nuclear Plant Engineering
- *H. K. Chernoff, Licensing
- *K. Peterson, Licensing
- *W. M. Lindsay, Supervisor-Quality Systems

Bechtel Power Corporation

- *C. M. Herbst, Assistant Project Engineer
- *Z. Botros, Senior Supervisor

The NRC inspectors also interviewed other licensee, Daniel International (DIC) and Bechtel personnel.

*Denotes those attending the exit interviews.

2. Licensee Action on Previous Inspection Findings

(Closed) Unresolved Item (STN 50-482/8412-02): The acceptance criteria for welded connections in the II/I cable tray supports has been revised by the engineer's approval of nonconformance report (NCR) ISN20073EW. In essence, the engineer accepted revision allow welds to be 1/3 undersize or underlength. The combined percentage for welds exhibiting both deficiencies shall not exceed 33 1/3%. The NRC inspector has compared the revised criteria to a known worst case in a statistical sample and had no further questions.

This item is considered closed.

(Closed) Unresolved Item (STN 50-482/8219-02): This item addressed the same condition reported by the licensee as a 10 CFR 50.55(e) item identified as TE 53564-K88 which was reviewed and closed in Inspection Report No. 50-482/84-12, paragraph 4.

This item is considered closed.

(Closed) Open Item (STN 50-482/83-31): This item involved the need for a follow-up inspection to assure that the flexible conduit running to

This item is considered closed.

(Closed) Unresolved Item (STN 50-482/82-12): Projections in fuel storage envelopes in the spent fuel racks. Documentation indicates that a joint inspection by Westinghouse, SNUPPS and KG&E personnel determined that the projections satisfy the intent of specifications; i.e., not damage fuel during movement of the fuel. NRC Inspection Report No. 50-482/83-21 also documents a final postinstallation inspection of the racks which found them to be acceptable.

This item is considered closed.

(Closed) Unresolved Item (STN 50-482/8408-05): This item dealt with the change of category assignments on the turnover exception list without the startup engineer initialing that he made and approved the change. The turnover coordinator performed a general review of all turnover exception lists to determine proper item categorization. In addition, all startup engineers and supervisors were instructed to ensure that their final review checked for specific correct categorization of each item.

This item is considered closed.

(Closed) Unresolved Item (STN 50-482/8412-01): NCR 19197H has been fully dispositioned by DIC, Bechtel and KG&E. In summary, it appears that the involved three-part memo did provide instructions at variance with the engineering criteria. The memo had, however, very limited distribution and other inspectors involved in inspection of components to which the memo was applicable have certified that they do not have a copy of the memo. Based on many NRC inspections of the comparable components, there is no evidence that would appear to contradict the rationale provided in the NCR.

This item is considered closed.

(Closed) Open Item (STN 50-482/79-07): NRC Inspection Report No. STN 50-482/79-07 identified an open item concerning the establishment of procedures for the maintenance of General Electric 4160 volt circuit breakers (type 1200 and 2000 ampere with MC-13 mechanism magne-blast). Procedure No. MPE-E009-02, Revision 2, dated March 14, 1984, "Inspection and Testing of 13.8KV and 4.16KV Circuit Breakers," was written and approved. This procedure appears to resolve the concern. This item is considered closed.

(Closed) Open Item (STN 50-482/84-22, paragraph 5): Additional inspections of as-built Electrical Raceway: This item is considered closed based on inspection activities documented in NRC Inspection Report No. 50-482/84-51.

The NRC inspector reviewed licensee actions in accordance with licensee letter dated March 30, 1984, in response to NRC inspection report No. 50-482/83-36 and Notice of Violation dated February 14, 1984. The following paragraph numbers correspond to paragraph numbers in the KG&E letter:

- 1 Licensee response accepted. The revised FSAR was reviewed by the NRC inspector.
- 2 Licensee response was acceptable. The NRC inspector reviewed revised Procedure WP-IV-111, "Structural Steel and Pipe Whip Restraints," Revision 11, dated April 5, 1984, and QCP-IV-111, Revision 16, dated May 7, 1984, "Erection of Structural Steel and Pipe Whip Restraints."
- 4 Licensee response accepted. The NRC inspector reviewed procedure AP-VII-02, Revision 12, dated April 5, 1984, and found it to be acceptable.
- 5 The NRC inspector reviewed documentation on the use of unplated Load Indicating Washers (LIW's) with galvanized fasteners and found it to be acceptable.
- 6 The NRC inspector reviewed licensee controls on reuse of LIW's and found them acceptable.
- 7 Licensee response accepted relative to use of Load Indicating Washers under black (uncoated) bolt heads in bolted joints where the bolt is the turned element.
- 8 Licensee response accepted relative to prohibitions on reuse of A325 bolts.
- 9 Licensee response accepted relative to installation procedures to assume reuse of correct Load Indicating Washers.
- 10 Licensee response accepted. As stated in 2. above, Procedures WP-IV-111, Revision 11, and QCP-IV-111, Revision 16 were reviewed.

(Open) Unresolved Item (8336-06): Apparent lack of procedures for revision control of manufacturers instructions. The licensee presented the NRC inspector with existing procedures for revision control. These procedures appear adequate. The concern is with those procedures that were in effect during the entire construction phase. This item will remain open pending further review by the NRC inspector.

3. Review of Procedures for Installation of Reactor Coolant and Other Safety Related Piping

The NRC inspector reviewed the quality control and work procedures listed below pertaining to the range of installation activities for reactor coolant and other safety-related piping within the scope of the ASME Section III Code and FSAR commitments. This review, which is one of a series of such reviews, was undertaken at or near the end of all such construction activities to assure that the procedures, as revised during construction, continue to describe an acceptable program.

1. QCP-I-01, Revision 19, "Receiving, Storage and Preservation of Quality Related Materials and Items."
2. WP-VII-201, Revision 5, "Fabrication and Installation of Piping."
3. QCP-VII-200, Revision 20, "Inspection of Weld Process."
4. QCP-VII-201, Revision 14, "Inspection & Documentation of ASME Piping, Valves and Components."
5. WP-VII-203, "Revision 9, "Cleaning and Sealing Pipe."

No violations or deviations were identified.

4. Review of Records for Installation of Reactor Coolant and Other Safety-Related Piping

The NRC inspector reviewed four licensee audit reports pertaining to the subject activity area. Each report package contained a well defined statement of the objective of the audit which was further supported by a series of checklist type questions developed by the audit team leaders prior to the performance of the audits. Each audit folder contained well defined audit findings, corrective action statements and final resolutions.

- (a) TE 57061-K69: Covered pipe cutting and traceability transfer, bending, inspection of welding, verification of post-weld heat treatment, and welder identification.

- (b) TE 57061-K75: Drawing control in piping activities; control of Field Change Requests, NCRs and Design Change Notices; and accuracy of installation traveler record data.
- (c) TE 57061-K77: General practices for installation of piping 2" and over.
- (d) TE 57061-K112: Special process control (weld procedure and welder qualification).

The NRC inspector also reviewed the below listed NCRs pertaining to the subject activity area for legibility, adequacy of the definition of the nonconformance, appropriateness of the disposition of the nonconforming item(s) by engineering and reportability under 10 CFR 50.55(e).

- a) 1SN 5962 PW
- b) 1SN 5965 PW
- c) 1SN 5975 PW
- d) 1SN 4057 P
- e) 1SN 4074 P
- f) 1SN 4516 P
- g) 1SN 4574 P
- h) 1SN 4649 P
- i) 1SN 4623 P
- j) 1SN 5027 PW

No violations or deviations were identified.

5. Review of Quality Records for Installation of Reactor Vessel Internals

The NRC inspector reviewed the following traveler type records covering the installation, modification and repair of the reactor vessel internal core support structures. The travelers are detailed line-by-line instructions for both accomplishing the activity and for inspection thereof based upon vendor drawings and generalized instructions. The travelers were prepared by the vendor (Westinghouse) engineering personnel and the inspections were performed by Westinghouse QC personnel. Supplementing the travelers were detailed records of welds performed and the inspections thereof.

- (1) Traveler package G-SAP-WE-006, Revision 0 through 4, pertaining to the assembly and installation of the lower core support in accordance with Drawing 61214E55.
- (2) Traveler package G-SAP-WC-008 and Supplements B&E pertaining to assembly and installation of the upper support in accordance with Drawing 6121E72. Included within the review were

subpackages designated with a suffix "Q" which related to certain modification and repair activities.

No violations or deviations were identified.

6. Comparison of As-Built Plant to FSAR Description

The NRC inspectors reviewed four safety injection system drawings in order to:

- Verify that the latest revisions of the system field drawings are in agreement with FSAR piping and instrumentation diagrams (P&IDs).
- Verify by field observation that the component installations, including control and logic instrumentation, are as described in the FSAR.

a. Comparison of Field Drawings to FSAR P&IDs

The following Bechtel P&IDs were compared against corresponding FSAR drawings:

- Drawing M-02EP01 (Q), Revision 13, dated February 15, 1985, "Accumulator Safety Injection."
- Drawing M-12BB01 (Q), Revision 0, dated September 19, 1984, "Reactor Coolant System."
- Drawing M-12BN01 (Q), Revision 0, dated October 31, 1983, "Borated Refueling Water Storage System."
- Drawing M-02EM01 (Q), Revision 8, dated June 2, 1983, "High Pressure Coolant Injection System."

The NRC inspectors discovered no major discrepancies between field and FSAR drawings. However, several hand operated valves were shown as "locked closed" in the FSAR but not in the field drawings. The valves noted with this discrepancy are:

| | |
|------|------|
| V030 | V109 |
| V058 | V114 |
| V061 | V157 |
| V062 | V158 |
| V065 | V173 |
| V066 | V208 |
| V100 | V209 |
| V101 | V212 |
| V102 | V213 |
| V103 | V214 |
| V104 | V216 |

In addition, valve V029 on Accumulator Tank C was not identified by number in the FSAR.

The above discrepancies, although numerous, do not appear to raise any cause for concern. However, it is recommended that the licensee determine whether the valves in question are designed to be "locked closed" and that the as-built installation reflects the design.

There were no violations or deviations identified in this area.

b. Comparison of Field Drawings to the As-Built Plant

The NRC inspectors performed a walkdown of at least one safety train for each drawing listed in paragraph 6.a. The drawings were compared against the physical installation to assure that: 1) piping was installed as designed; 2) valves were identified and installed in the correct position; and 3) instrumentation transmitters and indicators were identified and installed per design.

During the inspection of piping and associated hardware for all four accumulator tanks the NRC inspectors noted that the nitrogen supply isolation valve (8875A) for tank A was installed in the opposite direction. The valve was identified to the licensee and it was removed and reinstalled in the correct position. An evaluation of the significance of this finding was performed by the NRC staff and it was determined that there would have been no impact on any safety function with the subject valve installed incorrectly. Thus, with this determination and the fact that no other hardware discrepancies were identified, this finding is considered an isolated case with no safety significance.

There were no violations or deviations identified in this area.

7. Followup on Allegations

A-84-A-58 (Closed): A person who identified himself as a former employee of the licensee contacted the NRC Region IV office relative to a concern that Code (ASME Section III) pressure boundary was being opened by CWP's (Construction Work Permits) without QC involvement and that he, the alleged, had been discharged because of his findings in the area. The NRC inspector found that the licensee had conducted a QA audit of "Startup" activities that identified the same problem. The audit was performed during the period of April and May 1984. The licensee QA organization issued a Quality Program Violation on June 1, 1984, on the matter. As a result of the violation, an administrative procedure was revised to

require the review, concurrence and observation by the appropriate QC unit in the activity. QA has verified that the change has been implemented as of July 16, 1984. The allegation has thus been substantiated: The NRC inspector would note that three licensee personnel were directly involved in the audit. The audit was concluded, documented and the Quality Program Violation issued by an employee still employed within the licensee's QA organization. It would appear that the alleged was not terminated by reason of involvement in the audit. The licensee informed the NRC inspector that one of the persons involved in the audit had been terminated because he had made an offer to provide illegal drugs to a licensee employee. The NRC inspector interviewed the latter employee who confirmed that the offer had been made and subsequently reported to the employee's supervision. The licensee management apparently believed the employee and discharged the alleged.

(Open) 4-84-A-102: Allegations were made to the NRC by two individuals in October 1984 concerning performance of the structural steel weld reinspection program at WCGS. NRC personnel were informed that welding inspectors had been instructed to visually inspect welds through paint in violation of the AWS D1.1-1975 Structural Welding Code. Written procedures were stated to have not been provided but welding inspectors were being required to mark inspection sheets as accept or reject. It was additionally identified that unacceptable and missing welds had been found by the reinspection program and one individual claimed to have been intimidated to produce results that would show welds were acceptable.

NRC Region IV staff were cognizant of structural steel weld discrepancies and reinspection of painted weld surfaces prior to receipt of the allegations, as a result of the NRC inspection activities in this area which are documented in NRC Inspection Report No. 50-482/84-22. Followup of these allegations was performed by NRC inspectors during October 16-19, 1984. One welding engineer and each welding inspector involved in the structural steel weld reinspection program were interviewed and a review was made of the reinspection records that had been generated prior to the NRC followup. It was ascertained from the interviews that the welding inspectors, who were all AWS Certified Welding Inspectors, were concerned about being able to fully evaluate painted weld surfaces to the visual inspection quality requirements of the AWS D1.1-1975 Structural Welding Code. Initial activities, which commenced in late September 1984, were established to have been performed under oral DIC Welding Engineering direction and without a written procedure. Document review showed that DIC had prepared written guidance on October 1, 1984, and KG&E had subsequently issued an inspection procedure dated October 6, 1984. Both of these documents identified that engineering evaluation of the inspection results would be made with the knowledge of paint and other foreign matter being present on most of the inspected welds. None of the welding inspectors indicated during interviews that they had ever been directed to improperly accept discrepant welds and review of the

reinspection records confirmed that discrepant conditions were being appropriately documented. The alleged intimidation was ascertained by interviews to relate to a disagreement concerning the need for and type of documentation to be made when conditions were judged to exist which affected performance of visual inspection of welds.

The Chief of the Wolf Creek Task Force and an NRC inspector interviewed the two individuals on October 3, 1984, and subsequently interviewed the associated supervisor and manager on October 4, 1984. Based on these discussions and review of the inspection records performed by the individuals, the allegations concerning intimidation or harassment were not substantiated.

The NRC inspectors determined that the only technical issue requiring additional review is the adequacy of data generated from inspection of painted weld surfaces. This subject will be addressed in a future inspection report after completion of review of the KG&E response to NRC Inspection Report No. 50-482/84-22.

8. Safety Related Pipe Supports/Restraints

a. Inspection of Pipe Supports/Restraints

The NRC inspectors selected the 21 pipe supports/restraints listed below for inspection of the installed support/restraint system. The supports or restraints were randomly selected from three piping systems; i.e., the residual heat removal (RHR) system, the high pressure coolant injection (HPCI) system, and the accumulator safety injection (ASI) system.

| <u>Drawing</u> | <u>Support/Restraint</u> | <u>System</u> |
|----------------|--------------------------|---------------|
| M-15EJ01(Q) | R006 | RHR |
| M-15EJ01(Q) | H006 | RHR |
| M-15EJ01(Q) | R019 | RHR |
| M-15EJ01(Q) | R016 | RHR |
| M-15EJ01(Q) | H001 | RHR |
| M-15EJ04(Q) | C021 | RHR |
| M-05EJ03(Q) | R015 | RHR |
| M-15EM03(Q) | R020 | HPCI |
| M-15EM03(Q) | C033 | HPCI |
| M-15EM03(Q) | C034 | HPCI |
| M-15EM03(Q) | R022 | HPCI |
| M-15EM03(Q) | R023 | HPCI |
| M-15EM01(Q) | C039 | HPCI |
| M-15EM01(Q) | R032 | HPCI |
| M-15EM01(Q) | R011 | HPCI |
| M-15EM01(Q) | C012 | HPCI |
| M-15EM01(Q) | C019 | HPCI |
| M-15EM05(Q) | R010 | HPCI |
| M-15EP01(Q) | H007 | ASI |
| M-15EP01(Q) | H008 | ASI |
| M-15EP01(Q) | C007 | ASI |

In the areas inspected, a limited number of anomalies were noted with respect to compliance of pipe supports restraints with the design drawing/specification requirements. Examples of observed conditions were a discrepant dimension on the EJ01/H006 restraint, excessive pin to pin dimension on the EJ01/R019 restraint, and incomplete welds on the base of the EJ01/H001 support. Each of the conditions noted by the NRC inspectors were ascertained to have been detected during Bechtel IE Bulletin 79-14 walkdown activities and had been subject to evaluation by Bechtel engineering. As a result of the foregoing, a review was performed of the SNUPPS IE Bulletin 79-14 Walkdown Procedure, Revision 7, and the SNUPPS Wolf Creek Generating Station IE Bulletin 79-14 Evaluation Procedure, Revision 1. A sample of walkdown findings was reviewed for various Bechtel categorizations of required actions and verifications made that required actions appeared to be appropriate and had been accomplished in accordance with procedure requirements.

Within this area of inspection, no violations or deviations were identified.

b. Review of Pipe Support/Restraint Installation Records

The NRC inspectors selected the six pipe support/restraint systems listed below for review of the installation records.

| <u>Drawing</u> | <u>Support/Restraint</u> | <u>System</u> |
|----------------|--------------------------|---------------|
| M-15EP02(Q) | C003 | ASI |
| M-15EM03(Q) | C034 | HPCI |
| M-15EM03(Q) | R022 | HPCI |
| M-15EM03(Q) | R020 | HPCI |
| M-15EM03(Q) | R023 | HPCI |
| M-15EJ04(Q) | C021 | RHR |

In the areas reviewed, the welding documentation was available for each weld identified on the support/restraint drawing. The welders were established to have been qualified for the procedures used and the welding material certification records were found to conform with welding procedure specification requirements for each of the welds reviewed.

During documentation review, it was noted that the SNUPPS design specification for Bergen Paterson ASME Section III Code pipe supports, 10466-M-218A(Q) Revision 6, permitted use of ASME Code Case 1644-7 for selection of alternate materials to those contained in the Appendices to the ASME Section III Code. Review of vendor Code Data Reports for Type 2540 mechanical snubber assemblies confirmed that the vendor had utilized Code Case 1644-7 for

manufacture of the assemblies. Code Case 1644-7 is conditionally accepted by Regulatory Guide 1.85, to which the SNUPPS FSAR commits to meet. The conditions established by the NRC staff for acceptance relate to the measured ultimate tensile strength (UTS) of an alternate component support material. Regulatory Guide 1.85 requires that either (1) the maximum measured UTS of the material be restricted to a maximum of 170 Ksi, or (2) impact tests should be required by the design specification for applications where it is desired to utilize material with up to 190 Ksi UTS. The SNUPPS design specification did not include the conditions of acceptance stipulated by Regulatory Guide 1.85.

This is a violation (482/8423-01).

Certificates of Compliance had been furnished by Bergen Paterson for the snubber assemblies reviewed by the NRC inspectors, which precluded identification of the Code Case 1644-7 materials that had been utilized in snubber manufacture. Material test data obtained by KG&E from Bergen Paterson, in response to a NRC request, showed that ASME SA 564 material from Code Case 1644-7 had been utilized for pins in the EJ04/C021 Type 2540 assembly reviewed. The material UTS for the specific pins reviewed was reported to be below 170 Ksi. Review of lower load capacity Bergen-Paterson snubber assemblies showed that ASTM A 574 capscrews had been utilized from Code Case 1644-7. This specification has a minimum material UTS of 170 Ksi. The sizes of capscrews used were, however, below the minimum for which the ASME Section III Code specifies impact test requirements. The adequacy of use of capscrews with greater than 170 Ksi measured UTS is considered an open item pending additional NRC review (482/8423-06).

Examination of documentation for the EJ04-C021 snubber assembly additionally showed that the snubber field weld (i.e., Weld 1) had only been inspected by visual examination. The Bergen Paterson Load Capacity Data Sheet for the Type 2540 snubber stipulates that this weld be a full fillet weld. The DIC fabrication drawing for this assembly required that welds be examined in accordance with the provisions of paragraph NF-5212 in Section III, Subsection NF of the ASME Code. Paragraph NF-5212 requires that full fillet welds be examined by either the magnetic particle or liquid penetrant examination methods.

This is a violation (482/8423-02)

Review of GEO Procedure No. 21.A.1, Revision 6, dated October 14, 1983, "Magnetic Particle Examination Dry Method," showed a yoke method pole spacing requirement of between 3 and 8 inches. The procedure indicated that it was in compliance with Section V of the ASME Code, 1974 Edition through the Summer 1975 Addenda.

Paragraph T-734.2 in Section V of the ASME Code (1974 Edition through the Summer 1975 Addenda) specifies, however, that a pole spacing of 3 to 6 inches be used for the yoke method of magnetic particle examination.

This is a deviation (482/8423-04).

9. As-Built Piping Systems and Structures

a. Piping Systems

The NRC inspectors selected portions of the seven Class 1 and Class 2 piping systems listed below to verify that the as-built design and construction drawings or specifications correctly reflected the as-built condition of the plant.

(1) Accumulator Safety Injection System, Class 2 Piping

Piping Drawing C-M-13EP02(Q)

- Line 04-ECB-10" from Accumulator Tank B to Weld F002
- Line 05-BCB-10" from Weld F002 to Weld FW 305

Support/Restraint Drawing M-15EP02(Q)

- Supports/Restraints C003, R006, R005, H003, R004, H002

(2) Chemical and Volume Control System, Class 2 Piping

Piping Drawing C-M-03BG02(Q), Class 2 Piping

- Line 149-BCB-4" from Centrifugal Charging Pump A to Weld F063
- Line 158-BCB-3" from Weld F063 to Weld F060A

Support/Restraint Drawing M-15BG02(Q)

- Supports/Restraints, R020, R019, R018, H010, H009, R001

(3) Containment Spray System, Class 2 Piping

Piping Drawing C-M-03EN01(Q)

- Line 01-HCB-14" from Weld F008 to Containment Spray Pump A
- Line 03-GCB-10" from Containment Spray Pump A to Weld FW 319
- Line 04-GCB-3" from Line 03-GCB-10" to Weld FW 343
- Line 58-GCB-3" from Line 04-GCB-3" to Weld F026

Support/Restraint Drawing M-15EN01(Q)

- Supports/Restraints R010, H005, R012, H004, C001, H003

(4) High Pressure Coolant Injection, Class 2 Piping

Piping Drawing I-M-03EM01(Q)

- Line 6-CCB-4" from Safety Injection Pump A to Weld F001
- Line 47-CCB-4" from Line 6-CCB-4" to Weld F010

Support/Restraint Drawing M-15EM01(Q)

- Supports/Restraints R013, C031, C030, R018, C013, C029, R017, R028, C041

(5) High Pressure Coolant Injection, Class 1 Piping

Piping Drawing C-M-03EM03(Q)

- Line BB-26-BCA-6" from Reactor Coolant Loop 2 Hot Leg to Weld F009
- Line 10-BCA-6" from Weld F009 to Weld EJ04-F014
- Line 09-BCA-2" from Line 10-BCA-6" to Weld FW 531

Support/Restraint Drawing M-15EM03(Q)

- Supports/Restraints H003, R004, R005, C057, C017, R009, C016

(6) Accumulator Safety Injection, Class 1 Piping

Piping Drawing C-M-03EP02(Q)

- Line BB-22-BCA-10" from Reactor Coolant Loop 2 Cold Leg to Weld F006
- Line 06-BCA-10" from Weld F006 to Weld F004

Support/Restraint Drawing M-15EP02(Q)

- Supports/Restraints R010, R009, H005, H004, R007

(7) Reactor Coolant System, Class 1 Piping

Piping Drawing PSI-M-03BB01(Q)

- Line BB-69-BCA-14" from Reactor Coolant Loop 4 Hot Leg to Pressurizer

Support/Restraint Drawing M-15BB01(Q)

- Supports/Restraints R001, H002, R002, H001, R003, R004

In the areas inspected, the as-built conditions of the piping and supports/restraints were consistent with the as-built drawings and specifications.

b. Structures

The NRC inspector selected 20 structural steel assemblies from bolted seismic Category I structures located in the auxiliary building and the control building for verification of actual installation against the latest approved design drawings. These particular assemblies were selected because they were at the opposite ends of welded connections which had been identified in NRC Inspection Report No. 50-482/84-22, and subsequent followup, as having significant defects; i.e., missing welds, cracked welds, undersized welds, and missing beam seats.

The inspected connections are identified as follows:

Control Building

| <u>Drawing No.</u> | <u>Beam Identity</u> | <u>Joint No.</u> |
|--------------------|----------------------|------------------|
| C-121-1484-05 | 95B5 | C36 |
| C-121-1484-05 | 99B2 | C52 |
| C-121-1484-05 | 99B2 | C53 |
| C-121-1484-05 | 99B3 | C54 |
| C-121-1484-05 | 99B4 | C55 |
| C-121-1484-05 | 99B5 | C40 |
| C-121-1484-05 | 99B6 | C42 |
| C-121-1484-05 | 99B10 | C37 |
| C-121-1484-05 | 41B4 | C13 |
| C-121-1411-02 | 41B4 | C14 |

Auxiliary Building

| <u>Drawing No.</u> | <u>Beam Identity</u> | <u>Joint No.</u> |
|--------------------|----------------------|------------------|
| C-121-0617-03 | 708B1 | A98 |
| C-121-1549-05 | 307B4 | A55 |
| C-121-0971-03 | 156B9 | A10 |
| C-121-0627-05 | 436B5 | A40 |
| C-121-0627-05 | 436B6 | A41 |
| C-121-0627-05 | 436B6 | A58 |
| C-121-0627-05 | 436B7 | A39 |
| C-121-0627-05 | 242B3 | A60 |
| C-121-0976-03 | 243B3 | A61 |
| C-121-0976-03 | 849B3 | A114 |
| C-121-1561-01 | | |

The above connections were inspected to assure conformance with the identified drawings and the following applicable construction and inspection procedures:

- DIC Procedure No. WP-IV-III, Revision 11, "Structural Steel and Pipe Whip Restraint Erection"

- DIC Procedure No. QCP-IV-III, Revision 11, "Structural Steel and Pipe Whip Restraint Inspection"
- Bechtel Specification No. 10466-C122(Q), "Specification for Erection of Structural Steel (SNUPPS)"
- Bechtel Specification No. 10466-C132(Q), "Specification for Erecting Miscellaneous Metal (SNUPPS)"
- AISC Specification for the "Design, Fabrication and Erection of Structural Steel for Buildings"
- AISC Specification for "Structural Joints Using ASTM A325 or A490 Bolts," approved May 8, 1974
- Drawing Nos. C-121-6003-04 and C-121-6004-03, which delineate joint assemblies showing the use of A325 and A490 bolts and placement of hardened load indicator washers

While the specified gap between the load indicator washers and bolt heads could not be readily ascertained due to the remnants of concrete and flame retarding materials that had to be removed for this inspection, the number, spacing, and placement of all bolts were as required by the applicable drawings and specifications. It was further observed that bolt identity was stamped on all bolt heads.

No violations or deviations were identified.

A concurrent NRC inspection has been performed at Bechtel's Gaithersburg, Maryland, engineering office to assure, with respect to the previously identified discrepant weld conditions, that the evaluations are being properly performed, reviewed, and approved, and that as-built changes on the design/construction drawings correctly reflect the as-built conditions. The results of this inspection effort will be addressed in a NRC followup inspection report.

10. Onsite Design Activities

The NRC inspector reviewed 17 documentation packages (travelers) pertaining to pipe supports to assure that onsite design activity, including controls for engineering and construction initiated field changes, was conducted in compliance with the technical and quality assurance requirements stipulated in the applicable procedures.

The reviewed procedures included:

- a. DIC Procedure No. WP-VII-209, "Preparation and Processing of Travelers"

- b. DIC Procedure No. AP-III-04, "Field Change Request (FCR), Construction Variance Request (CVR), Middle Third Deviation Notice (MTDN), and Middle Deviation Notice (MDN)"
- c. KG&E Procedure No. KI-1030.2, "Controlling and Releasing Design Document Change Notice"
- d. DIC Procedure No. AP-IX-03, "Document Control"
- e. DIC Procedure No. AP-III-05, "Field Prepared Drawings"
- f. DIC Procedure No. AP-III-06, "Field Prepared Specifications"
- g. Bechtel Procedure No. EDPI 4.46-01, "Project Engineering Drawings"

The procedures were reviewed to assure that control of the following elements was addressed:

- a. Design input
- b. Drawings
- c. Interface between cognizant design organizations
- d. Design review, approval, and verification
- e. Specifications
- f. Nonconformances and corrective actions
- g. Field change (FCRs)
- h. As-built drawings
- i. Quality assurance
- j. Engineering change notice (ECN)
- k. Design change notice (DCN)

The travelers pertained to the following pipe supports:

EM05-P004/231; AB05-H002/442;
AE01-H015/422; EJ01-H006; EP01-C007;
EP01-R009; EP01-R017; EP01-H007;
EJ01-H006; EJ01-R006; EJ01-R016;
EM02-H007; EM03-R020; EM03-C034;
EM03-R023; EM03-R022; EP02-C003;

and included the traveler index, bill of material, installation drawing, weld control record (if applicable), quality inspection checklist, and a NCR (if applicable).

The traveler indexes were compared against the referenced drawings and specifications, and then compared against the Document Record and Status Cards, to verify that the latest applicable revisions had actually been used. The drawings were reviewed to assure that the applicable ECNs/FCRs had been incorporated; and if not, that they were included in the

travelers. Verification was made by reviewing the Master File DCN/ECN-FCR Status Cards.

Identified NCRs were reviewed to assure that they had been reviewed, dispositioned, approved, and that the dispositions had been implemented and verified.

An attempt was made to assure that NCRs with a disposition of "use-as-is" had been correctly incorporated into as-built drawings. However, it was established that Bechtel has until 90 days after fuel load to review the drawings and NCRs to assure reconciliation with actual as-built conditions. The specific as-built drawing criteria are included in Attachment 2 to Bechtel's letter No. BLSE 13166 dated January 19, 1984.

There were no violations or deviations identified.

However, due to the 90 days after fuel load commitment with respect to reconciliation of design drawings and actual as-built conditions, this item shall remain open. (482/8423-05).

11. Followup on 10 CFR Part 50.55(e) Construction Deficiency Reports (CDRs)

- a. On December 12, 1984, KG&E notified NRC Region IV of a potential CDR pertaining to pipe supports which, after final inspection had been tampered with by insulation contractors during insulation installation. The NRC inspector reviewed the available, pertinent documentation. It was determined that DIC generated approximately 31 NCRs, the first one being dated June 1, 1984, dealing with pipe supports which had been partially disassembled to facilitate the installation of insulation. However, the first 6 NCRs, dated through July 27, 1984, caused KG&E to issue Corrective Action Request (CAR) No. 14 on July 31, 1984.

Four of the NCRs were silent and two were checked off "No" with respect to identifying that a potential 10 CFR Part 50.55(e) condition existed.

CAR 14, with respect to reportability to NRC, stated, "Under Evaluation 7/30/84." The evaluation was to be based on a DIC reinspection of the pipe supports which were within the insulation contractors' scope of work. DIC was directed to identify all rejectable conditions on NCRs. As a result of the reinspection effort, another 25 NCRs were generated, of which 16 dated between September 4 and September 20, 1984, identified that a potential 10 CFR Part 50.55(e) condition existed.

KG&E closed out CAR No. 14 on December 11, 1984, based on verification that DIC had performed and documented the required

reinspections, closed out all applicable NCRs, and that the insulation contractors had revised their installation procedures and retrained their personnel.

10 CFR Part 50.55(e) requires the holder of a construction permit to notify the NRC of each reportable deficiency within 24 hours. DIC Procedure AP-VI-02 requires, upon determination that a potentially reportable condition exists, immediate notification to KG&E by hand carrying a copy of the NCR to the KG&E deficiency coordinator.

Formal notification to KG&E by DIC of a significant deficiency occurred on December 11, 1984, when DIC completed the Wolf Creek Generating Station Request for Reportability Evaluation form.

Therefore, KG&E could not have made the required notification within 24 hours of the significant deficiency first being identified.

This is a failure to execute the required reporting of a significant deficiency and is a violation of Criterion V of Appendix B to 10 CFR Part 50. (482/8423-03)

- b. (Closed) TE 53564-K68 - Potentially compromised Level II welding inspector examinations: It was discovered in July 1982 that a Level II welding inspector examination could potentially have been in inspectors' possession since March 30, 1981. A new examination was immediately developed and given to the welding inspectors at WCGS. Three of the inspectors failed the new examination. Two of these three were given retraining and subsequently met the recertification requirements. The remaining individual terminated employment prior to being recertified. Fourteen other welding inspectors, who had been certified in the time period in question, were no longer employed at WCGS at the time of discovery of the potentially compromised examination. A sampling program was initiated to reinspect work previously accepted by the 14 former employees and the 3 who had failed the new examination. The results of the reinspections indicated that all but one of the individuals had performed acceptable inspections. Administrative actions were taken to identify during document review those inspections performed by this individual, in order that the work could be reinspected for acceptability.

This item is considered closed.

12. Licensee Actions Concerning NRC Vendor Program Branch Inspection Findings at Colt Industries

The NRC inspector reviewed KG&E actions taken as a result of QA deficiencies identified by the NRC Vendor Program Branch during an

inspection on March 26-30, 1984, at the Fairbanks Morse Engine Division of Colt Industries. Certain of the deficiencies were written in regard to QA records and documentation pertaining to diesel generators furnished by this vendor to WCGS. An audit was performed by Bechtel personnel on October 30-31, 1984, at the Fairbanks Morse Engine Division of Colt Industries, which addressed the vendor actions and response to the NRC inspection findings. The NRC inspector concluded from review of the audit report that KG&E had verified that appropriate actions had been taken by the vendor to resolve the NRC inspection findings.

No violations or deviations were identified.

13. Management Interview

The NRC personnel met with the licensee and Bechtel personnel noted in paragraph 1 on November 30 and again on December 14, 1984 to provide summary information on the overall scope of the inspection and the findings resulting therefrom. The licensee and engineering personnel acknowledged their understanding of the findings.

U.S. NUCLEAR REGULATORY COMMISSION

PRINCIPAL INSPECTOR NAME (Last, first, and middle initial)

REVIEWER

INSPECTOR'S REPORT
Office of Inspection and Enforcement

LICENSEE/VENDOR

TRANSACTION
TYPEDOCKET NO. (8 digits) OR LICENSE
NO. (BY PRODUCT) (12 digits)

REPORT

NEXT INSP. DATE

NO

SEQ

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I - INSERT
M - MODIFY
D - DELETE
R - REPLACE

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PERIOD OF INVESTIGATION/INSPECTION

INSPECTION PERFORMED BY

ORGANIZATION CODE OF REGION/HQ CONDUCT-
ING ACTIVITY (See ISMA: 0530 Manpower Report-
ing Weekly Manpower Reporting for code)

REGION

DIVISION

BRANCH

FROM TO

1 - REGIONAL OFFICE STAFF

OTHER

2 - RESIDENT INSPECTOR

3 - PERFORMANCE APPRAISAL TEAM

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REGIONAL ACTION
(Check one box only)

TYPE OF ACTIVITY CONDUCTED (Check one box only)

02 - SAFETY

06 - MGMT. VISIT

10 - PLANT SEC.

14 - INQUIRY

03 - INCIDENT

07 - SPECIAL

11 - INVENT. VER.

15 - INVESTIGATION

04 - ENFORCEMENT

08 - VENDOR

12 - SHIPMENT/EXPORT

05 - MGMT. AUDIT

09 - MAT. ACCT.

13 - IMPORT

1 - NRC FORM 581

2 - REGIONAL OFFICE LETTER

INSPECTION/INVESTIGATION FINDINGS
(Check one box only)TOTAL NUMBER
OF VIOLATIONS AND
DEVIATIONSENFORCEMENT CONFERENCE
HELDREPORT CONTAIN 2790
INFORMATION

LETTER OR REPORT TRANSMITTAL DATE

NRC FORM 581
OR REG.
LETTER IS ISSUEDREPORT SENT
TO HQ FOR
ACTION

1 - CLEAR

2 - VIOLATION

3 - DEVIATION

4 - VIOLATION & DEVIATION

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1 - YES

A B C D

1 - YES

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MODULE INFORMATION

MODULE INFORMATION

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REVIEWER

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INSPECTOR'S REPORT
Office of Inspection and Enforcement

REVIEWER

TO: James L. Eberhart, R. Mulliken
James L. Eberhart, R. Mulliken

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|--|--|---|-------------|------|-----|-----|
| LICENSEE/VENDOR <u>625 Elect. Co.</u> | TRANSACTION TYPE | DOCKET NO. (8 digits) OR LICENSE NO. (BY PRODUCT) (13 digits) | REPORT NO. | SEQ. | MO. | YR. |
| | <input checked="" type="checkbox"/> I - INSERT | <u>05000482</u> | <u>8423</u> | A | | |
| | <input type="checkbox"/> M - MODIFY | | | B | | |
| | <input type="checkbox"/> D - DELETE | | | C | | |
| | <input type="checkbox"/> R - REPLACE | | | D | | |
| | 1 | 2 | 14 | 15 | 16 | |

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| PERIOD OF INVESTIGATION/INSPECTION | INSPECTION PERFORMED BY | ORGANIZATION CODE (IF REGION HQ CONDUCTING ACTIVITY (See IEMC 0530 "Manpower Reporting - Weekly Manpower Reporting" for code)) |
| FROM: MO <u>29</u> DAY <u>10</u> YR <u>84</u> TO: MO <u>12</u> DAY <u>14</u> YR <u>84</u> | <input checked="" type="checkbox"/> 1 - REGIONAL OFFICE STAFF <input type="checkbox"/> 2 - RESIDENT INSPECTOR <input type="checkbox"/> 3 - PERFORMANCE APPRAISAL TEAM OTHER | REGION <u>4</u> DIVISION <u>2</u> BRANCH <u>3</u> |

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| REGIONAL ACTION (Check one box only) | TYPE OF ACTIVITY CONDUCTED (Check one box only) | 14 - INQUIRY 15 - INVESTIGATION |
| <input type="checkbox"/> 1 - NRC FORM 561 <input checked="" type="checkbox"/> 2 - REGIONAL OFFICE LETTER | <input checked="" type="checkbox"/> 02 - SAFETY <input type="checkbox"/> 03 - INCIDENT <input type="checkbox"/> 04 - ENFORCEMENT <input type="checkbox"/> 05 - MGMT. AUDIT <input type="checkbox"/> 06 - MGMT. VISIT <input type="checkbox"/> 07 - SPECIAL <input type="checkbox"/> 08 - VENDOR <input type="checkbox"/> 09 - MAT. ACCT. <input type="checkbox"/> 10 - PLANT SEC. <input type="checkbox"/> 11 - INVENT. VER. <input type="checkbox"/> 12 - SHIPMENT/EXPORT <input type="checkbox"/> 13 - IMPORT | |

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|---|---|-----------------------------|---------------------------------|---|
| INSPECTION/INVESTIGATION FINDINGS (Check one box only) | TOTAL NUMBER OF VIOLATIONS AND DEVIATIONS | ENFORCEMENT CONFERENCE HELD | REPORT CONTAIN 2790 INFORMATION | LETTER OF REPORT TRANSMITTAL DATE |
| <input type="checkbox"/> 1 - CLEAR <input type="checkbox"/> 2 - VIOLATION <input type="checkbox"/> 3 - DEVIATION <input checked="" type="checkbox"/> 4 - VIOLATION & DEVIATION | A B C D <u>0 4</u> | A B C D <u>1 - YES</u> | A B C D <u>1 - YES</u> | NRC FORM 561 OR REG LETTER ISSUED MO <u>2</u> DAY <u>5</u> YR <u>85</u> REPORT SENT TO HQ FOR ACTION MO <u></u> DAY <u></u> YR <u></u> |

| MODULE INFORMATION | | | | | | | | | | | | | | MODULE INFORMATION | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| TYPE | NUMBER | PHASE | MANUAL CHAPTER | PROCEDURE NUMBER | | | | | LEVEL | PHASE | MANUAL CHAPTER | PROCEDURE NUMBER | | LEVEL | TYPE | NUMBER | PHASE | MANUAL CHAPTER | | | | | PROCEDURE NUMBER | LEVEL | PHASE | MANUAL CHAPTER | PROCEDURE NUMBER | LEVEL | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| B | 249051B | | | | A | 0.12 | 100 | C | | | | | B | 249065B | | | | | A | 0.02 | 100 | C | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | </ |

INSPECTOR'S REPORT
Office of Inspection and Enforcement

REVIEWER

| LICENSEE/VENDOR | TRANSACTION TYPE I - INSERT M - MODIFY D - DELETE R - REPLACE | DOCKET NO. (8 digits) OR LICENSE NO. (BY PRODUCT) (112 digits) | REPORT | | NEXT INSP. DATE | |
|-----------------|---|--|--------|-----|-----------------|----|
| | | | NO | SEQ | MO | YR |
| | | 05000482 | 0423 | A | | |
| | | | (cont) | B | | |
| | | | | C | | |
| | | | | D | | |
| | | | 14 | 15 | 16 | |

| PERIOD OF INVESTIGATION / INSPECTION | | | | | | INSPECTION PERFORMED BY | | | | | | ORGANIZATION CODE OF REGION / HQ CONDUCTING ACTIVITY (See ILMC 0530: Manpower Reporting - Weekly Manpower Reporting for code) | | | | | |
|--------------------------------------|-----|----|----|-----|----|--------------------------------|--|--|-------|--|--|---|--|----------|--|--------|--|
| FROM | | | TO | | | 1 - REGIONAL OFFICE STAFF | | | OTHER | | | REGION | | DIVISION | | BRANCH | |
| MO | DAY | YR | MO | DAY | YR | 2 - RESIDENT INSPECTOR | | | | | | | | | | | |
| | | | | | | 3 - PERFORMANCE APPRAISAL TEAM | | | | | | | | | | | |
| 0 | | | 25 | 25 | 31 | | | | 32 | | | 33 | | 34 | | 35 | |

| REGIONAL ACTION (Check one box only) | | TYPE OF ACTIVITY CONDUCTED (Check one box only) | | 14 - INQUIRY | |
|--------------------------------------|--|---|------------------|----------------------|--------------------|
| 1 - NRC FORM 501 | | 02 - SAFETY | 06 - MGMT. VISIT | 10 - PLANT SEC. | |
| 2 - REGIONAL OFFICE LETTER | | 03 - INCIDENT | 07 - SPECIAL | 11 - INVENT. VER. | 15 - INVESTIGATION |
| | | 04 - ENFORCEMENT | 08 - VENDOR | 12 - SHIPMENT/EXPORT | |
| | | 05 - MGMT. AUDIT | 09 - MAT. ACCT. | 13 - IMPORT | |
| 36 | | 37-38 | | | |

| INSPECTION INVESTIGATION FINDINGS (Check one box only) | | | | TOTAL NUMBER OF VIOLATIONS AND DEVIATIONS | | | | ENFORCEMENT CONFERENCE HELD | | | | REPORT CONTAIN 2790 INFORMATION | | | | LETTER OF REPORT TRANSMITTAL DATE | | | | | | | |
|--|---|---|---|---|---|---|---|-----------------------------|---|---|---|---------------------------------|---|---|---|---------------------------------------|-----|------------------------------|----|-----|----|----|--|
| A | B | C | D | | | | | | | | | | | | | NRC FORM 501 OR REG. LETTER IS ISSUED | | REPORT SENT TO HQ FOR ACTION | | | | | |
| 1 - CLEAR | | | | A | B | C | D | A | B | C | D | A | B | C | D | MO | DAY | YR | MO | DAY | YR | | |
| 2 - VIOLATION | | | | | | | | | | | | | | | | | | | | | | | |
| 3 - DEVIATION | | | | | | | | | | | | | | | | | | | | | | | |
| 4 - VIOLATION & DEVIATION | | | | | | | | | | | | | | | | | | | | | | | |
| 39 | | | | 40-43 | | | | 42 | | | | 43 | | | | 44 | | 45 | | 50 | | 55 | |

| MODULE INFORMATION | | | | | | | | | | MODULE INFORMATION | | | | | | | | | | | | | |
|--------------------|--------|---------|-----------|-------|----------------------|---|------------------------------|--------|-------|--------------------|---------|-----------|-------|----------|---|------------------------------|--------|--------|--------|---------|-----------|-------|----------|
| MODULE NUMBER INSP | | | | | MODULE REG. FOLLOWUP | | | | | MODULE NUMBER INSP | | | | | MODULE REG. FOLLOWUP | | | | | | | | |
| PHASE | MANUAL | CHAPTER | PROCEDURE | LEVEL | PRIORITY | DIRECT INSPEC. EFFORT IN STAFF HOURS EXPENDED THIS INSPECTION | PERCENTAGE COMPLETED TO DATE | STATUS | PHASE | MANUAL | CHAPTER | PROCEDURE | LEVEL | PRIORITY | DIRECT INSPEC. EFFORT IN STAFF HOURS EXPENDED THIS INSPECTION | PERCENTAGE COMPLETED TO DATE | STATUS | PHASE | MANUAL | CHAPTER | PROCEDURE | LEVEL | PRIORITY |
| 1 | 9 | 12 | 7 | 10 | 2 | B | 0.029 | | 1 | 2 | 5 | 10 | 19 | 10 | B | 0.149 | 11010 | | | | | | |
| 1 | 2 | 9 | 12 | 7 | 10 | 15 | B | 0.136 | | 1 | 2 | 3 | 10 | 7 | 10 | 13 | B | 0.1018 | | | | | |
| 1 | 2 | 3 | 7 | 10 | 15 | B | 0.153 | 11010 | | 1 | 0 | 9 | 19 | 10 | 12 | 10 | B | 0.104 | | | | | |
| 1 | 2 | 3 | 7 | 10 | 15 | B | 0.100 | | 1 | 2 | 2 | 5 | TA | 1 | V | P | A | 16.0 | 100 | | | | |

INSPECTOR'S REPORT
(Continuation)

of Inspection and Enforcement

| | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|--|--|--------|-----|---------------|---|---|---------------------------------|---|--------------|---|---|---|--|--|----|----|
| DOCKET NO. (8 digit) OR LICENSE NO. (BY PRODUCT) (13 digit) | | | | | | | | | | REPORT | | MODULE NUMBER | | | | | | | | | | | | |
| | | | | | | | | | | NC | SEQ | 21519091015 | | | | | | | | | | | | |
| 0 | 5 | 0 | 0 | 0 | 4 | 8 | 2 | | | 8 | 4 | 2 | 3 | A | VIOLATION SE-RTY OR DEVIATION D | | SITE RELATED | | | | | | | |
| | | | | | | | | | | | | | | B | 1 | 2 | 3 | 4 | 5 | 6 | | | AC | |
| | | | | | | | | | | | | | | C | | | | | | | | | | BD |
| | | | | | | | | | | | | | | D | | | | | | | | | | |

VIOLATION OR DEVIATION (Enter up to 2400 characters for each item. If the text exceeds this number, it will be necessary to paraphrase. Limit lines to 50 characters each.)

- 1.
2. *Contrary to Citation V of Appendix B to 10CFR Part 50 and*
3. *Daniel International, Drawing No. MCB-ETOW-CO21/231A,*
4. *Revision 5, the field weld (i.e., Weld 1) in the ETOW-CO21*
5. *component support received only a visual examination and*
6. *was not examined by either the magnetic particle or*
7. *liquid penetrant methods.*
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INSPECTOR'S REPORT
(Continuation)
Inspection and Enforcement

DOCKET NO (8 DIGIT) OR LICENSE
NO (BY PRODUCT) (13 DIGIT)

REPORT

MODULE NUMBER

NO

SEC

250101706

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8423

A

VIOLATION SEVERITY OR DEVIATION

SITE
RELATED

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