

SSER

Task: Allegations A-296, A-306a, 306k, 306l, 306m

Reference No.: 4-84-A-06/177, 184a, 184k, 184l, 184m

Characterization: It is alleged that Tompkins-Beckwith (T-B) may have violated the ASME Code requirements by failing to visually examine the shop pipe welds for leaks during hydrostatic tests.

Assessment of Allegation: ASME Code Section III requires that, at the completion of Class 1, 2, or 3 piping system or subsystem installation, a hydrostatic test be performed, during which a visual examination for leakage is made of all welds.

The allegation challenges the correctness of the T-B records on visual examination of pipe welds during hydrotesting. The allegor feels that all welds (shop and field) should be identified by name on the weld checkoff list and that it is particularly important to identify shop welds since they were not subjected to a hydrostatic test in the vendor's shop. The allegor claims that it is unlikely that shop welds were examined during hydrotesting, since they were not specifically mentioned on the test instruction sheet and do not appear on the weld checkoff list.

After completion of the Class 1 and 2 hydrostatic weld inspection, according to T-B's Hydrostatic Test Procedure TBP-36, the information from the Hydrostatic Test Data Sheet and the weld check-off list was combined with data from other sources and ASME Form N5, Certification of Inspection, was completed. The authorized nuclear inspector (ANI) signed the reverse side of Form N5 to verify that the piping was installed in accordance with the ASME Code.

The ASME Code and T-B Procedure TBP-36 specify only that a visual examination during hydrotesting for leakage is to be performed without reference to where the pipe weld was made. The Test Information Sheet, however, states that the inspection is to verify that there will be no leakage from any permanent field welds. The welds identified on the checkoff list are all field welds. Although the words "field welds" are included in the hydrostatic test

instructions, an inspector conducting a visual review of all field welds for leakage would certainly be aware of any shop welds that might be leaking. In addition, during the 10-minute minimum test period, plus the time required for visual examination, any drop in test pressure resulting from leakage would be noticeable and would indicate a condition requiring investigation.

The ASME Code does not require that all weld (shop or field) visual inspections be documented individually. A lack of documentation identifying each shop weld examined during field hydrotests does not violate the ASME Code. The basis for T-B system acceptance is the ANI's signature on Form N5, Certification of Inspection.

In assessing this allegation, the NRC staff reviewed the actual results obtained during the hydrostatic test. Although the wording on the test instruction sheet did not accurately reflect the intent of T-B Procedure TBP-36, the hydrostatic test was conducted in full accordance with the requirements of the procedure and the ASME Code.

The NRC staff discussed its findings with the allegor, who expressed general satisfaction with the resolution, but who feels that verification should be obtained to confirm that the shop welds were indeed inspected for leakage during the hydrostatic tests.

The staff concludes that this allegation has neither safety significance nor generic implications.

Potential Violations: The lack of confirmation that the shop welds were inspected may constitute a violation of the ASME Code.

Actions Required: LP&L shall, prior to issuance of the plant operating license, provide evidence to NRC for verifying visual shop weld inspections.

References

1. T/B Hydrostatic Test Procedure TBP-36
2. T/B Hydrostatic Test Data Sheet
3. T/B Weld Check Off List
4. T/B Hydrostatic Test Instructions
5. W3-QAIRG-0584, June 24, 1983
6. W3-QA-25549, July 1, 1983
7. W3-QA-23487, February 23, 1983

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