9.10C

WC-AP-077 1-1 (Rev. 1/21/82) 41/P 4

DANIEL

NONCONFORMANCE REPORT (NCR)

PROJECT NAME/NUMBER	ACTION REQ'D BY	CONTROL METHOD	Q	N	NCR NUMBER
WOLF CREEK / 7158	10/14/83	TAG # (SEE BELOW)	X		154/13524 PW

IDENTIFICATION OF AREA AND ITEM

SYSTEM ID BB

ASME

* W503, 55'-5, 34'W, 2009'EL TAG# 37908
FW309, 19'N, 13'W, 2032'EL TAG# 37950
F021, 19'N, 13'W, 2032 EL TAG# 37949
FW311, 49'-5, 30'W, 2010'EL TAG# 37948
S002-C, 50'-5, 32'W, 2010EL TAG# 37947
FW512, 37'-5, 32'W, 2084 TAG# 37944

CONTROLLING DOCUMENTS

QCP-VII-200 R/12
AP VII-02 R/18
CWP-537 R/0

QDS FINAL REVIEW

TRAVELERS NO.

PSI-M-13BB04(Q)
* PSI-M-03BB08(Q)-02

DESCRIPTION OF NONCONFORMANCE

N.E.S CAN NOT PERFORM AN ADEQUATE U.T.

WRITTEN PER WELDING ENG. REQUEST.

R. McCoy	SQS	9-30-83
[illegible]	MWQI	9-28-83
ORIGINATOR	TITLE	DATE

RECOMMENDED DISPOSITION & BASIS FOR RECOMMENDATION:

REFER TO PG. 2

☑ REWORK CAT. B
☐ REPAIR
☐ USE AS IS
☐ REJECT

DANIEL CONSTRUCTION CO

FOR INFORMATION ONLY

☑ [illegible] 10/12/83
AUTHORIZED NUCLEAR INSP

CAUSE OF NONCONFORMANCE AND ACTION TO PREVENT RECURRENCE:

REFER TO PG. 2

ACTION TAKEN TO CONTROL NONCONFORMANCE:

HOLD TAGS APPLIED.

[illegible] FOR	PQE	10/11/83

POTENTIAL 50.55(E) / PART 21
YES ☐ NO ☑

[illegible] FOR KH	WE	10/14/83
[illegible]	APWE for AK	10/10/83
SITE APPR.	TITLE	DATE

ROUTE TO FOR CORRECTIVE ACTION:

C. BALLARD

STATEMENT OF COMPLETED ACTION:

ACTION HAS BEEN COMPLETED PER THE DISPOSITION AND DOCUMENTATION OF ACCEPTANCE HAS BEEN ENTERED ON THE APPLICABLE PSI TRAVELERS.

[illegible]	SQS	12-3-83			
[illegible]	WE	12-3-83	[illegible]	MWQC	12-3-83
ACTION COMPLETED	TITLE	DATE	ACTION VERIFIED	TITLE	DATE

DISTRIBUTION: DIC QA
[illegible]
KGE Mgt QA
Disc. Eng.
Originator

8512160394 851107
PDR FOIA
BROSIUS84-291 PDR

R-11

WC-[illegible]
(Rev. 1/21/82).

DANIEL

NONCONFORMANCE REPORT (NCR)

Continuation Sheet Page 2 of __

Project Name/Number	Action Rqd By:	NCR Number
WOLF CREEK - 7158	10/4/83	1SN 13524 PW

RECOMMENDED DISPOSITION AND BASIS FOR RECOMMENDATION:

Welds listed on page 1 were prepped for PSI per Bechtel Specification M-204(Q), Appendix G and documented as accepted on the PSI travelers. Nuclear Energy Services, however, cannot perform a "meaningful UT examination" due to high, rounded weld crowns. Additional contouring of the welds is required and shall be performed in accordance with the existing travelers listed on page 1. This NCR shall be referenced on the applicable Weld Preparation Records and documentation of acceptability (visual, PT and UT) to be entered below existing acceptances. Additional preparation will facilitate an adequate UT by NES. This NCR may be closed upon acceptable Section III NDE for all welds listed.

CAUSE OF NONCONFORMANCE AND ACTION TO PREVENT RECURRENCE:

This nonconformance is a result of diverse interpretations of Bechtel Specification M-204, Appendix G in regard to acceptable weld crown configurations.

No action to prevent recurrence is necessary.

DANIEL CONSTRUCTION CO
DOCUMENT CONTROL
[illegible] SIMS.

10/10/83

DRW 10-10-83
[illegible] 10/12/83

FOR INFORMATION ONLY

WC-AP-153.7
(REV 1-26-82)

REQUEST FOR DOCUMENTS

TO: Document Control Supervisor

DATE: 1/9/87

Request the following documents be issued to: K/I-1

Control Number _____

FOR:

- ☐ Distribution D/C
- ☐ Additional Documents
- ☐ Replacement

No. Copies	Document Number	Rev. No.	Fold	Roll	Remarks
1	M-12P204 (Q)	1			

Requestors' Signature _____

Approval Required for Initial Issue of Controlled Documents

Group Manager _____

Project Manager _____

Document Control Supervisor _____

Reproduction Section & Date 1-9-84

White Copy - Returned With Documents Reproduced
Yellow Copy - Reproduction Section
Pink Copy - Requestor

DANIEL

WELD CONTROL RECORD F-101

REV NO. 1

DRAWING NO. I-M-13B804 (Q) WELD NO. FW512 WELD POSITION

COMPONENT/SUBASSEMBLY IDENTIFICATION NO. PC508 to S001

BASE MATERIAL SPECIFICATION NO. SA312 TP 304

JOINT SIZE 4" WALL THICKNESS .531" CODE ASME CLASS 2

WELDING TECH. N-8-8-B-1 N-8-8-BA-3 REV. WELDING TECH. NM-8-8-B-1 REV.

WELDING TECH N-8-8-BA-1 REV. WELDING TECH NM 8-8-B-2 REV.

TYPE OF WELD ROD			NDE-HEAT TREAT & AI HOLD POINTS
E 308 ✓	ER308 ✓	E 7018	A. LIQUID PENETRANT ✓ B. MAG PARTICLE INSP.
E308L	ER308L ✓ *	E 705-2	C. RADIOGRAPHIC INSP. D. ULTRASONIC INSP.
E 316	ER 316	OTHER	E. POST WELD HT. TREAT F. PREHEAT 50 °F
E 309L	ER 309L	OTHER	AI HOLD POINTS None

REV.	BY	DATE	APPR.	DATE	REV.	REFERENCE	BY	DATE	APPR.	DATE	REV.	REFERENCE	BY	DATE	APPR.	DATE
0	RC	7/8/81	CAO	7-23-81	1	DELETED NOTE 10	LC	10-30-81			0					

WIOO SERIAL NO.	HEAT CODE	WIOO SERIAL NO.	HEAT CODE	WELDER —	SYMBOL

REQUIRED INSPECTIONS	WELDING INSPECTOR	DATE	AI	DATE
1. Joint cleanliness verified, released for fit-up.				
2. Check fit-up Material Identification and verify above.				
3. Check flow rate.				
4. Shielding gas used ( ).				
5. Purge gas (if used) ( ).				
6. % Oxygen internal %.				
7. Preheat temperature F.				
8. Interpass temperature F.				
9. Purge dam removed.				
10. ~~Weld prepared for inservice inspection in accordance with Appendix G of Bechtel Spec. M-204.~~				
11. Weld visually examined.				
12. Released for P.W.H.T.				
13. Released for N.D.E.				

TEST METHOD	N.D.E. RESULTS REPORT NO. ACCEPTED	REJECTED	AI	DATE	COMMENTS
					* ER308L to be used for insert only
RT					
MT					
LP					
UT					

N.D.E. VERIFIED BY _____ (NAME AND TITLE) DATE _____

P.W.H.T. _____ CHART NO _____ VERIFIED _____ A.I. _____ DATE _____

FINAL QC ACCEPTANCE BY _____ DATE _____

CERTIFIED REPORT of NONDESTRUCTIVE EXAMINATION

GEO Construction Testing
1118 Chess Drive
Foster City, Calif. 94404

WOLF CREEK
GENERATING STATION
KANSAS GAS & ELECTRIC COMPANY
P.O. BOX 208
WICHITA, KANSAS 67201

TYPE OF EXAMINATION
MT ☐ UT ☐ PT ☑

REPORT No. PBT-PT-10527

DATE 20 Oct 83

83166

JOINT/COMPONENT IDENTIFICATION

FW 512 — PSIM-13BB04 (Q) (DRAWING NO)

LOCATION Reactor, Elev 2084

SURFACE CONDITION	HEAT NO	TYPE OF MATERIAL	TEMP OF MAT'L	~~HEAT TREAT~~ ~~BEFORE~~ ☐ ~~AFTER~~ ☐
Prepared	N/A	S/S	79°F	N/A

EXAMINATION STANDARD	ACCEPTANCE STANDARD	N.D.E. PROCEDURE NO
ASME, Sec III, Class I-74	IPDT 340 Para 8.6	IPDT 340 Rev 1701

ULTRASONIC EXAMINATION

EQUIPMENT	SERIAL NO	TRANSDUCER	TEST BLOCK	SCANNING METHOD	SENSITIVITY LEVEL
			N/A		

MAGNETIC PARTICLE EXAMINATION

EQUIPMENT	SERIAL NO	DRY ☐ / WET ☐	VISIBLE ☐ / FLOURESCENT ☐	AC ☐ / DC N/A / RECTIFIED ☐	AMPERAGE	PROD SPACING / HEAD ☐ COIL ☐	PARTICLES - COLOR

LIQUID PENETRANT EXAMINATION

METHOD	PENETRANT BRAND NO	PENETRANT BATCH NO	DWELL TIME	CLEANER BRAND NO	CLEANER BATCH NO	EMULSIFIER BRAND NO	EMULSIFIER BATCH NO	EMULS TIME	DEVELOPER BRAND NO	DEVELOPER BATCH NO	DEV TIME	DRY ☐ NON-AQUEOUS ☑ / WET ☑
Solvent removable	SKL-HF/S	53B018	10 min	SKC-S	53B027		N/A		SKD-S	83B001	7 min	

PART NO	TOTAL LENGTH EXAMINED FEET	INCHES	TYPE OF WORK NEW ☑ REPAIR ☐	NO OF ITEMS ACCEPTED	NO OF ITEMS REJECTED
See Below	100 %	of Weld area		ONE	None

TYPE OF DEFECTS CODE

C – Cracks P – Porosity NF – Non Fusion LI – Linear Indication S – Slag LA – Lamination OTHER – Specify

PC# OR SN#	ACC	REJ	DEFECT CODE	REMARKS	PC# OR SN#	ACC	REJ	DEFECT CODE	REMARKS
FW 512	✓			Incl will be in PSI-[illegible]					
									Dec 83

Note: Final IST 10.20.83
Ref/SN 13524-B PW

CRG Initials REVIEWED Date 3 Dec 83

EXAMINATION PERFORMED BY:

1. [signature] TECHNICIAN LEVEL II
2. [signature] TECHNICIAN LEVEL Asst.

NA
EXAMINATION WITNESSED BY (WHERE APPLICABLE)

[signature] LII 10-20-83
REPORT ACCEPTED BY DANIEL INTERNATIONAL DATE

AUTHORIZED INSPECTOR DATE

GEO Construction Testing assumes no responsibility for losses of any kind due to interpretation.

REPORT FORM 112-77

RADIOGRAPHY REPORT

Peabody Testing
CBS Engineering Company
1118 Chess Drive
Foster City, Calif. 94404

WOLF CREEK
GENERATING STATION
KANSAS GAS & ELECTRIC COMPANY
P.O. BOX 208
WICHITA, KANSAS 67201

Report No. FET RT 6913
DATE 2-8-82

6895

IDENTIFICATION INFORMATION

D464-76

JOINT/FILM ID: WC (SITE) KG&E (CLIENT) PBT XRE (NDE CON) FW512 (JOINT ID) N/A (REPAIR NO.) ID 13: BBC4(G)

DESCRIPTION: Pipe size 4" Wall thickness .531 Material S/S Other P-E

SPECIFICATION: ASME SEC. III [X] ANSI B31.1 [ ] ASME SEC. IX [ ] AWS D1.1 [ ] OTHER NM-B-E-B1 / N-B-E-B-1 (EDITION / ADDENDA)

LOCATION: 2081' REACTOR BLDG 38' S & 33 W

TECHNIQUE INFORMATION

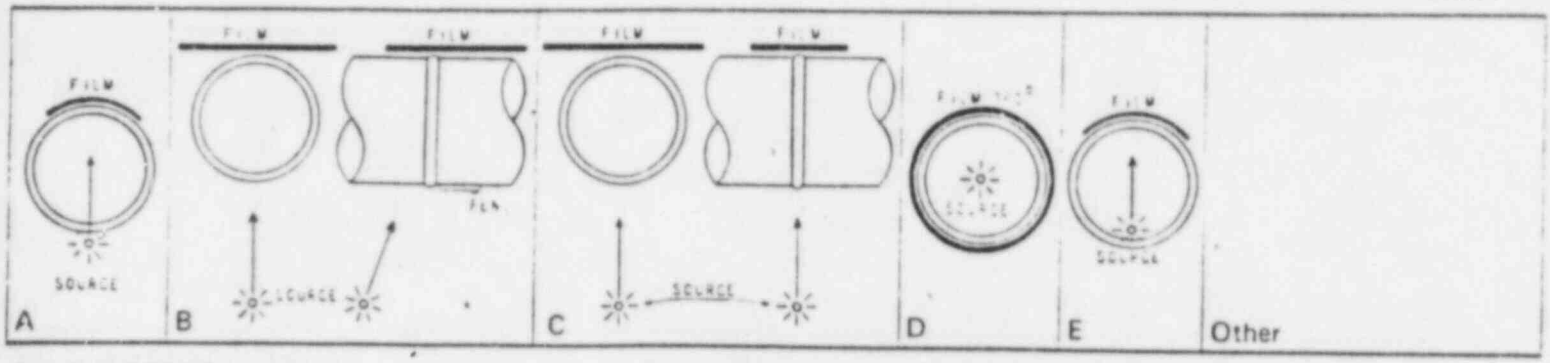
RT PROCEDURE: 3.20.A.1 Rev. 1701 2 Amendment N/A Other Procedure N/A

SOURCE OF RADIATION: Type IR-192 Mfr INC Strength KV (CI) 26 Effective size .141

Film type KODAK AA Film size 5X7 Pb Screens Front .010 Back .010 No. film cassette 2/5

Penetrameter 12 Located Source side [ ] Film side [X] Shim thickness .031 .0 SFD 5 1/2"

Technique used A-1 Exposure time 1min 40sec No. of exp. 5 Location Markers: Source side [ ] Film side [X]



FILM INTERPRETATION

Acceptance standard 3.20.A.1 PAR 8.1

FILM NO	ACCEPT	REJECT	CRACK	INCOMPLETE PENETRATION	INCOMPLETE FUSION	INDIVIDUAL SLAG OR ELONG INDICATION	ALIGNED SLAG OR ELONG INDICATION	POROSITY	TUNGSTEN INCLUSION	CONCAVITY	EXCESSIVE REINFORCEMENT	UNDERCUT	OXIDATION	INTERNAL ROOT CONDITION	OTHER/REMARKS
0-3	/														
3-6	/														
6-9	/								/						
9-12	/														
12-0	/														

RADIOGRAPHY PERFORMED BY:

1. Edwin L. Michael (TECHNICIAN) LEVEL I
2. John Fuller (TECHNICIAN) LEVEL I

Peabody Test [illegible]

FILM INTERPRETED/REVIEWED BY:

Daniel Davis (PEABODY TESTING) II (LEVEL) 2/8/82 (DATE)
Kelly Snyder (DANIEL INTERNATIONAL) II 2-8-82 (DATE)
Warren F. Beckie (AUTHORIZED INSPECTOR) 2-15-82 (DATE)

DANIEL

WELD CONTROL RECORD F-101

REV NO. 1

DRAWING NO IM-13E604(Q) WELD NO FW512 WELD POSITION 5G

COMPONENT/SUBASSEMBLY IDENTIFICATION NO FC503 & 3001

BASE MATERIAL SPECIFICATION NO. SA312 TP 304

JOINT SIZE 4" WALL THICKNESS .531 CODE ASME CLASS 3 1-13-83

WELDING TECH GTS-8-B-1 N-8-8-BA-3 REV 6 WELDING TECH NM-8-8-B-1 REV 6

WELDING TECH N-8-8-BA-1 REV. WELDING TECH NM-8-8-B-2 REV.

TYPE OF WELD ROD			NDE-HEAT TREAT & AI HOLD POINTS
E 308 ✓	ER308 ✓	E 7018	A. LIQUID PENETRANT ✓ 12-30-83 B. MAG PARTICLE INSP
E308L	ER308L ✓	E70S-2	C. RADIOGRAPHIC INSP D. ULTRASONIC INSP
E316	ER316	OTHER	E. POST WELD HT. TREAT F. PREHEAT 50°
E309L	ER309L	OTHER	AI HOLD POINTS None

REV	BY	DATE	APPR	DATE	REV	REFERENCE	BY	DATE	APPR	DATE	REV	REFERENCE	BY	DATE	APPR	DATE
4	[illegible]	[illegible]	CBO	2-23-81	4	DELETED NOTE 11	RC	10-21-81	FR	11-94	4					

WIDO SERIAL NO	HEAT CODE	WIDO SERIAL NO.	HEAT CODE	WELDER	SYMBOL
TACKS	ONLY	380283	A3547R305	R. Cherry	D-76
381174	464802	381165	464802	J. Austin	D-964
381179	464802	381181	464802	J. Austin	D-434
* 381179	464802			R. Cherry	D-76

* Ref (SN) 10577 P.(1) 8(4) 211 01 83

PDIV NMI KSK 12-21-83

CRG Initials REVIEWED Date 12-21-83

REQUIRED INSPECTIONS	WELDING INSPECTOR	DATE	AI	DATE
1. Joint clearliness verified, released for fit-up.	[illegible]	1-26-82		
2. Check fit-up Material Identification and verify above.	[illegible]	1-26-82		
3. Check flow rate. 15 CFH	[illegible]	1-26-82		
4. Shielding gas used (ARGON).	[illegible]	1-26-82		
5. Purge gas (if used) ARGON).	[illegible]	1-26-82		
6. % Oxygen internal GEN < 1%.	[illegible]	1-26-82		
7. Preheat temperature 50°.	[illegible]	1-26-82		
8. Interpass temperacure GTAW 120° F.	[illegible]	2-1-82		
9. Purge dam removed.	SS II	2-2-82		
10. ~~Weld prepared for inservice inspection in accordance with Appendix C of Bechtel Spec. M-204.~~				
11. Weld visually examined.	SS II	2-2-82		
12. Released for P.W.H.T. N/A	SS II	2-2-82		
13. Released for N.D.E. RT MT PT	SS II	2-2-82		

TEST METHOD	N.D.E. RESULTS REPORT NO. ACCEPTED	REJECTED	AI	DATE	COMMENTS
RT	PT-RT-6818				* SCHEDULE to be used for WELDER ONLY
MT					Incorporate Sheet Added Fit-up
LP	PT-10527				Break Bar As required 2Am 1/30/82
UT					Fit-up
					Land bevel end prep + check RAS 4/5 1-25-82

N.D.E. VERIFIED BY [illegible] II M/W QC [illegible] II 12-28-82 DATE 2-12-82
(NAME AND TITLE)

P.W.H.T. _____ CHART NO. _____ VERIFIED _____ AI _____ DATE _____

FINAL QC ACCEPTANCE BY [illegible] II [illegible] II DATE 11-18-83 12-389

RADIOGRAPHY REPORT

Peabody Testing
Engineering Company
118 Chess Drive
Foster City, Calif 94404

WOLF CREEK
GENERATING STATION
KANSAS GAS & ELECTRIC COMPANY
P.O. BOX 208
WICHITA, KANSAS 67201

Report No. RT-RT 6513
DATE 2-8-82

IDENTIFICATION INFORMATION

D-164-76

JOINT/FILM ID: WC (SITE) KG&E (CLIENT) PBT-XRT (NDE CON) F-0512 (JOINT ID) N/A (REPAIR NO.) (IM 13-6204(G))

DESCRIPTION: Pipe size 4" Wall thickness .531 Material S/S Other P-E

SPECIFICATION: ASME SEC III ☒ ANSI B31.1 ☐ ASME SEC IX ☐ AWS D1.1 OTHER N-D-B-61/N-D-B-61

LOCATION: 2000' REACTOR 2006 38.5 35.61

TECHNIQUE INFORMATION

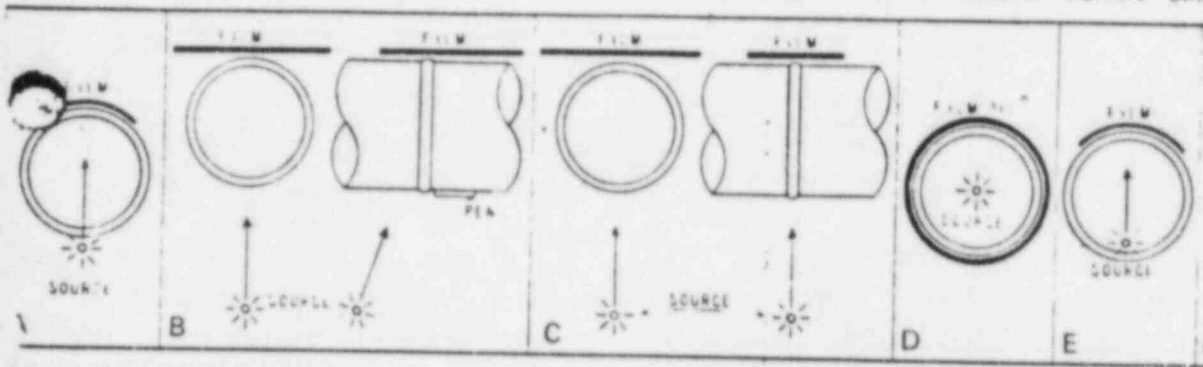
RT PROCEDURE: 3.20 A.1 Rev. 1701 2 Amendment N/A Other Procedure N/A

SOURCE OF RADIATION: Type IR 192 Mfr INC Strength KV(U) 26 Effective size .141

Film type KODAK M Film size 5X7 Pb Screens Front .010 Back .010 No. film cassette 2/5

Penetrameter 12 Located Source side Film side X Shim thickness .531 - C SFD 5 1/2"

Technique used A-1 Exposure time 1min 40sec No. of Exp. 5 Location Markers Source side Film side X



FILM INTERPRETATION

Acceptance standard 3.20.A.1 PAR 8.1

FILM NO.	ACCEPT	REJECT	CRACK	INCOMPLETE PENETRATION	INCOMPLETE FUSION	INDIVIDUAL SLAG OR ELONG. INDICATION	ALIGNED SLAG OR ELONG. INDICATION	POROSITY	TUNGSTEN INCLUSION	CONCAVITY	EXCESSIVE REINFORCEMENT	UNDERCUT	OXIDATION	INTERNAL ROOT CONDITION	OTHER/REMARKS
0-3	/														
3-6	/														
6-9	/								/						
9-12	/														
12-0	/														

RADIOGRAPHY PERFORMED BY:

Edward L. Michael LEVEL I
TECHNICIAN

[illegible] LEVEL I
TECHNICIAN

FILM INTERPRETED/REVIEWED BY:

Daniel [illegible] II 2/9/82
PEABODY TESTING LEVEL DATE

[illegible] 2-9-82
DANIEL INTERNATIONAL DATE

AUTHORIZED INSPECTOR DATE