



UNITED STATES  
NUCLEAR REGULATORY COMMISSION  
REGION II  
101 MARIETTA STREET, N.W.  
ATLANTA, GEORGIA 30323

Report Nos.: 50-424/85-43 and 50-425/85-32

Licensee: Georgia Power Company  
P. O. Box 4545  
Atlanta, GA 30302

Docket Nos.: 50-424 and 50-425

License Nos.: CPPR-108 and CPPR-109

Facility Name: Vogtle 1 and 2

Inspection Conducted: September 3-September 26, 1985

Inspectors: *J. F. Rogge*  
for J. F. Rogge, Senior Resident  
Inspector, Operations

10/11/85  
Date Signed

*R. J. Schepens*  
for R. J. Schepens, Resident  
Inspector, Construction

10/11/85  
Date Signed

Approved By: *M. V. Sinkule*  
M. V. Sinkule, Section Chief  
Division of Reactor Projects

10/11/85  
Date Signed

SUMMARY

Scope: This routine, unannounced inspection entailed 242 resident inspector-hours on site (32 hours were on backshifts) inspecting: containment and safety-related structures, piping systems and supports, safety-related components, auxiliary systems, electrical equipment and cables, and quality programs and administrative controls affecting quality.

Results: One violation was identified - "Failure to Provide Adequate Protection to Safety-Related Components During In-Plant Storage" - Paragraph 15.

## REPORT DETAILS

### 1. Persons Contacted

#### Licensee Employees

D. O. Foster, Vice President and Project General Manager  
P. D. Rice, Vice President and General Manager, Q.A.  
W. T. Nickerson, Deputy Project General Manager  
\*D. G. Smith, Assistant Deputy Project General Manager  
W. C. Ramsey, Readiness Review Manager  
H. H. Gregory III, General Manager Nuclear Construction  
\*M. H. Googe, Project Construction Manager  
G. Bockhold, Jr., General Manager Nuclear Operations  
O. Batum, General Manager Engineering and Licensing  
C. W. Hayes, Vogtle Quality Assurance Manager  
\*C. E. Belflower, Quality Assurance Site Manager - Operations  
E. D. Groover, Quality Assurance Site Manager - Construction  
S. D. Haltom, Quality Assurance Engineering Support Supervisor  
\*W. E. Mundy, Quality Assurance Audit Supervisor  
J. E. Sanders, Project Construction Manager - Unit 1  
\*D. M. Fiquett, Project Construction Manager - Unit 2  
\*B. C. Harbin, Manager Quality Control  
C. R. Brewer, Assistant Quality Control Manager  
T. L. Weatherspoon, Assistant Quality Control Manager  
\*G. A. McCarley, Project Compliance Coordinator  
W. C. Gabbard, Assistant Project Compliance Coordinator  
J. O. Dorrough, Administrative Manager  
W. F. Kitchens, Operations Superintendent  
\*P. T. Ciccanesi, Regulatory Compliance  
M. Stone, Engineering Supervisor  
T. Dannemiller, Senior QA Engineer  
\*R. C. Walker, Quality Assurance Field Representative  
\*G. C. Lapsley, Quality Control - Mechanical  
\*J. F. D'Amico, Regulatory Compliance Superintendent

Other licensee employees contacted included craftsmen, technicians, supervision, engineers, inspectors, and office personnel.

#### Other Organizations

\*J. Mamon, Quality Engineer - Bechtel  
R. Bends, NSCW Flushing Engineer  
M. L. Bagale, Surveillance Specialist - Bechtel  
J. R. Baleicki, Lead HVAC Equipment/Maintenance Engineer - Pullman/Kenith-Fortson Co., Inc.

\*Attended Exit Interview

## 2. Exit Interview (30703C)

The inspection scope and findings were summarized on September 26, 1985 with those persons indicated in paragraph 1 above. The inspector described the areas inspected and discussed in detail the inspection finding listed below. No dissenting comments were received from the licensee. The licensee did not identify as proprietary any of the materials provided to or reviewed by the inspector during this inspection.

(Open) Violation, 50-424/85-43-01 & 50-425/85-32-01 "Failure to provide adequate protection to safety related components during in plant storage" - paragraph 15.

The following NRC exit interviews were attended during the inspection period by a resident inspector:

September 6, 1985	L. H. Jackson & R. W. Wright
September 6, 1985	S. J. Vias
September 13, 1985	R. M. Latta

## 3. Licensee Action on Previous Enforcement Matters (92702)

Not inspected.

## 4. Unresolved Items (92701)

Unresolved items are matters about which more information is required to determine whether they are acceptable or may involve violations or deviations. Unresolved items were not identified during this inspection.

## 5. Construction Inspection - Units 1 & 2

Periodic inspections were made throughout this reporting period in the form of general type inspections in different areas of both facilities. The areas were selected on the basis of the scheduled activities and were varied to provide wide coverage. Observations were made of activities in progress to note defective items or items of noncompliance with the required codes and regulatory requirements. On these inspections, particular note was made of the presence of quality control inspectors, supervisors, and quality control evidence in the form of available process sheets, drawings, material identification, material protection, performance of tests, and housekeeping.

Interviews were made with craft personnel, supervisors, coordinators, quality control inspectors, and others as they were available in the work areas.

Independent inspection encompassed but was not limited to the following areas:

- Unit No. 1 Condensate Storage Tank (CST) Level Instrumentation Piping Installation

- Unit No. 1 Main Condenser, Associated Connections, and Feedwater Heaters
- Unit No. 2 Main Condenser and Feedwater Heaters
- Unit No. 2 Backfilling West of Containment Near Tower Crane No. 1

No violations or deviations were identified.

6. Fire Prevention/Protection and Housekeeping Measures - Units 1 & 2 (42051C)

The inspector observed fire prevention/protection measures throughout the inspection period. Welders were using welding permits with fire watches and extinguishers. Post indicator valves were being maintained in the open position. Fire fighting equipment is in its designated areas throughout the plant.

The inspector reviewed and examined implementation portions of the following procedures pertaining to the placement of concrete to determine whether they comply with applicable codes, standards, NRC Regulatory Guides and licensee commitments.

- SD-T-05, Rev. 6 Fire-Protection Equipment Inspection and Testing
- GD-T-15, Rev. 5 Welding and Cutting
- GD-T-17, Rev. 3 Housekeeping

The inspector observed fire prevention/protection measures in work areas containing safety-related equipment during the inspection period to verify the following:

- Combustible waste material and rubbish was removed from the work areas as rapidly as practicable to avoid unnecessary accumulation of combustibles
- Flammable liquids are stored in appropriate containers and in designated areas throughout the plant
- Cutting and welding operations in progress have been authorized by an appropriate permit, combustibles have been moved away or safety covered, and a fire watch and extinguisher was posted as required
- Fire protection/suppression equipment was provided and controlled in accordance with applicable requirements

No violations or deviations were identified.

## 7. Containment (Structural Concrete) - Unit 2 (47053C)

### a. Procedure and Document Review

The inspector reviewed and examined implementation portions of the following procedures pertaining to the placement of concrete to determine whether they comply with applicable codes, standards, NRC Regulatory Guides and license commitments.

- CD-T-02, Rev. 15                      Concrete Quality Control
- CD-T-06, Rev. 9                      Rebar and Cadweld Quality Control
- CD-T-07, Rev. 8                      Embed Installation and Inspection
- CD-T-20, Rev. 6                      Installation and Inspection of Trumpets, Rigid Extensions, and Duct Sheathing
- 2X2D01A002, Rev. 11                  Containment Concrete Forming and Placing Plan and Section
- 2X2D48A003, Rev. 5                  Containment Internals Concrete Forming Plan at El 220'-0"
- 2X2D44008, 010 & 011, Rev. 1              Outside Area Tunnels Forming Plan- Bottom & Top 2T3A & 2T3B

### b. Installation Activities

The inspector witnessed portions of concrete placement indicated below to verify the following:

#### (1) Forms, Embedment, and Reinforcing Steel Installation

- Forms were properly placed, secure, leak tight and clean. Rebar and other embedment installation was installed in accordance with construction specifications and drawings, secured, free of concrete and excessive rust, specified distance from forms, proper on-site rebar bending (where applicable) and clearances consistent with aggregate size.

#### (2) Delivery, Placement and Curing

- Preplacement inspection was completed and approved prior to placement utilizing a Pour Card (Exhibit CD-T-02\*18).
- Construction joints were prepared as specified.
- Proper mix was specified and delivered.
- Temperature control of the mix, mating surfaces, and ambient were monitored.
- Testing at placement location was properly performed in accordance with the acceptance criteria and recorded on a Concrete Placement Pour Log (Exhibit CD-T-02\*20).
- Adequate crew, equipment and techniques were utilized.

- Inspections during the placement were conducted by qualified personnel.
  - Curing temperature was monitored.
- (3) Installation of Trumpets, Tendon Sheaths and Anchorage Components for Containment Pours Only
- Trumpets, sheaths and anchorage components were oriented properly, installed within specified tolerances, clear and free of damage.
- (4) Fabrication of Dome Tendon Sheathing Vent Connections

<u>Pour No.</u>	<u>Location</u>	<u>Inspection Activity</u>
2-010-040	Containment Dome E1 363' 1-1/4" - 369' 4-3/4"	Curing
2-010-041	Containment Dome E1 369' 4-3/4" - 375' 3-1/8"	Preplacement, Placement & Curing
2-010-151,157	Pressurizer Wall	Preplacement and Curing
2-44A-053,056	2T3A&B Tunnels-Walls	Preplacement and Slab
2-44A-051,052,063	2T3A&B Tunnels-Walls	Preplacement
N/A	Auxiliary Building Level II-Roof	Reinforcing Steel Installation

No violations or deviations were identified.

8. Containment (Prestressing) - Observation of Work Activities - Unit 1 (47063C)

a. Procedure and Document Review

The inspector reviewed and examined implementation portions of the following specification, procedure, and quality assurance manual pertaining to the installation of horizontal tendons, to determine whether they comply with applicable codes, standards, NRC Regulatory Guides and licensee commitments.

- AX2AF04-100-12 Field Instruction Manual for Installation of VSL E5-55 Post-Tensioning System Within Nuclear Containment Structures, Rev. 9

- 1X2AF04-50-5 Horizontal Tendon Elevation-Unit 1 Buttress #1 to #2
- 1X2AF04-51-4 Horizontal Tendon Elevation-Unit 1 Buttress #3 to #1
- 1X2AF04-52-3 Horizontal Tendon Elevation-Unit 1 Buttress #2 to #3
- AX2AF04-78-4 Horizontal Tendon Stressing Data
- AX2AF04-79-4 Horizontal Tendon Stressing Data

b. Installation Activities

The inspector witnessed portions of the installation activities indicated below to verify the following:

- The latest issue (revision) of applicable drawings or procedures are available to the installers and were being used.
- Tendons were free of nicks, kinks, corrosion; were installed in designated locations; and that the installation sequence and technique was per specified requirements.
- Installation crew was properly trained and qualified.
- QC inspection was properly performed by qualified personnel in accordance with applicable requirements.
- Adequate protective measures were being taken to ensure mechanical and corrosion protection during storage, handling, installation, and post installation.

The following tendons were observed:

<u>Horizontal Tendon No.</u>	<u>From Buttress to Buttress</u>	<u>Seq. No.</u>	<u>Activity</u>
69	2 North-3 West	12	Installation
68	1 South-2 East	12	Installation
67	1 North-3 East	12	Installation

No violations or deviations were identified.

9. Containment (Steel Structures and Supports) - Units 1 & 2 (48053C)

Periodic inspections were conducted to observe containment steel and support installation activities in progress, to verify the following:

- Components were being properly handled (included bending or straightening).
- Specified clearances were being maintained.
- Edge finishes and hole sizes were within tolerances.
- Control, marking, protection and segregation were maintained during storage.
- Fit-up/alignment meets the tolerances in the specifications and drawings.

No violations or deviations were identified.

10. Safety-Related Structures (Structural Steel and Supports) - Units 1 & 2 (48063C)

Periodic inspections were conducted to observe construction activities of safety-related structures/equipment supports for major equipment outside the containment to verify that:

- Materials and components were being properly handled to prevent damage.
- Fit-up/alignment were within tolerances in specifications and drawing requirements.
- Specified clearances from adjacent components were being met.

Welding Activity Unit 1

The inspector observed in-process welding activities and reviewed records for supports as described below to determine whether applicable codes and procedure requirements were being met.

<u>Support No.</u>	<u>WPS</u>	<u>Process</u>	<u>Applicable Code</u>
1206-003-H005 R/2	IT8-III/I-1-BR-2	SMAW*	AISC & Section III NA NF
VI-1407-094- H601 R/O	IT12-III/1-OB-12	SMAW/GTAW**	AISC
1418-042-H613, R/O	IT8-III/I-1-/BR-2	SMAW*	AISC

\*Shielded Metal Arc Welding

\*\*GAS Tungsten Arc Welding

No violations or deviations were identified.



11. Safety-Related Piping - Observation of Work and Work Activities - Unit 1 (49063C) (337301)

During the inspection period, pipe run walkdowns were performed where piping installation is near completion to determine whether the piping run is installed as shown on current, approved drawings and in accordance with applicable construction specifications. Specific pipe run walkdowns of ASME B&PVC, Section III, Class II piping are listed below:

<u>DWG. No./Revision</u>	<u>Title</u>	<u>Pipe Run Inspected</u>
1X4DB133-1, Rev. 15	P&I Diagram Nuclear Service Cooling Water System (NSCW) Train "A"	Line No's. 023-18", 004-24", 031-18", 390-18", 181-20", 181-24"
1X4DB135-1, Rev. 16	P&I Diagram-NSCW Train "A"	Line No's. 174-18", 174-14", 179-14", 180-14", 181-14", 181-16
1X4DB133-2, Rev. 16	P&I Diagram-NSCW Train "B"	Line No's. 024-18", 032-18", 034-18", 006-24", 084-18", 086-18", 086-16", 086-14", 087-14", 088-14", 089-14", 088-16", 088-24"

Specific areas examined during the pipe run walkdown for compliance with the applicable isometric drawings and the Plant Design and Instrumentation Construction Specification No. X4AZ01, Revision 19 were as follows:

- Vent and Drain Connections and Locations
- Instrumentation Connections and Locations
- Valve Installation and Orientation
- Line Size and Location
- Fittings Type and Size
- Pipe/Valve/Fitting/End Connections
- Hanger Locations and Types

During the inspection period the following flushes were observed:

- \*1-1EF-04, Rev. 0, Flow Path 4.7-NSCW Supply & Return to Diesel Train "A"
- \*1-1EF-04, Rev. 0, Flow Path 4.20-NSCW Supply & Return to RHR Train "A" Pump
- \*NSCW Train B operation of circulating water from the basis thru the NSCW tunnel supply header piping bypassing the ACCW and CCW heat exchangers back thru the NSCW tunnel return header piping and discharging out into the top of the basin via a temporary strainer. The purpose of this flow path is to circulate the water in the basin thereby cleaning it and the supply and return header piping prior to starting the NSCW flush.

No violations or deviations were identified.

12. Reactor Vessel Protection - Unit 1 & 2 (50053C)

The Unit No. 1 inspection consisted of examination of the Reactor Vessel installed in Containment to determine that proper storage protection practices were in place and that entry of foreign objects and debris was prevented.

The Unit No. 2 inspection consisted of examination of the Reactor Vessel installed in containment to determine that proper storage protection practices were in place and that entry of foreign objects and debris was prevented.

No violations or deviations were identified.

13. Reactor Vessel Integrated Head Package - Unit 1 & 2 (50053C)

The Unit No. 1 inspection consisted of examination of the integrated head package stored on the refueling floor in its designated laydown area to determine that proper storage protection practices were in place, entry of foreign objects and debris was prevented, and that access was controlled.

The Unit No. 2 inspection consisted of examination of the Reactor Vessel head with the installed control rod drive mechanisms on the refueling floor in its designated laydown area. During the assembly of the integrated head package, proper storage protection practices were observed to be in place and maintained during the performance of this work.

No violations or deviations were identified.

14. Reactor Vessel Internals - Unit 1 (50063C)

Periodic inspections were conducted during the inspection period when the upper and lower internals were stored in their designated storage area to determine that proper storage protection practices were in place, entry of foreign objects and debris was prevented and that access was controlled.

No violations or deviations were identified.

15. Safety-Related Components - Units 1 & 2 (50073C)

- a. The inspector reviewed and examined implementation portions of the following procedures pertaining to the storage and maintenance requirements for safety related components to determine whether they comply with applicable codes, standards, NRC Regulatory Guides and licensee commitments.

- GD-T-09, Rev. 8, Inspection and Maintenance of Items In Storage
- MI-A-13, Rev. 4, Mechanical Equipment Maintenance and Storage Program

- 00851-C, Rev. 0, Storage, Handling and Shipping Requirements
- PKF No. JP-518, Rev. 0, Instorage Maintenance
- AX4AJ06-55-0, Receiving, Installation & Maintenance Manual for Model "N" Air Handling Units

b. Observation of Storage Activities

The inspection consisted of plant tours to observe protection of installed components to determine that adequate protection from dirt, dust, debris, water, or adjacent construction activities were in place.

Unit 1 equipment examined included:

- Residual Heat Removal Pumps
- Diesel Generators Train A & B
- Containment Spray Pumps
- Auxiliary Feed Water Motor & Turbine Driven Pumps
- NSCW Train A & B Pumps
- Auxiliary Component Cooling Water (ACCW) Heat Exchangers
- Component Cooling Water (CCW) Heat Exchangers
- ACCW & CCW Pumps
- Battery & Charger Rooms Train A & B
- Train A Remote Shutdown Panel 1-1605-P5-SDA
- Cable Spreading Room Train A & B
- 4160 V Train A Switchgear (1AA02)
- Main Control Board Termination Cabinets Nos. 1-1601-U3-T02, 04, 06, 08, 10, 12, 14, 16, 18, 20, 22, 24, 26 & 28

Unit 2 equipment examined included:

- ACCW Heat Exchangers
- CCW Heat Exchangers
- CCW Surge Tank
- Reactor Coolant Pump Casings
- CCW Pump Room Cooler (2-155-A7-012)
- Safety Injection (SI) Pump Room Coolers (2-1555-A7-015 & 016)
- Train A Remote Shutdown Panel (2-1605-P5-SDA)

During an inspection of the CCW & SI Pump Room Coolers the inspector reviewed the following preventative maintenance work orders.

2-1555-A7-012 CCW Pump Room Cooler  
 2-1555-A7-015 SI Train A Pump Room Cooler  
 2-1555-A7-016 SI Train B Pump Room Cooler

The inspector observed the inplant storage condition of the above equipment after review of the above preventative maintenance work orders. The inspector noted that the preventative maintenance work

order for the SI Train B Pump Room Cooler had been signed as being complete and the chiller portion of cooler had not been cleaned. The licensee advised the inspector that this was in error and that what happened is that the preventative maintenance work order was accidentally signed off based on the electrical portion of the inspection being complete and not the mechanical. The licensee took immediate action to clean the chiller portion of the cooler, thereby completing the mechanical portion of the preventative maintenance work order.

During an inspection of the storage of safety related components in Units 1 & 2 on September 3, 5, 19, & 20 the following components were found not being properly protected in accordance with the requirements of Paragraph 7.4 contained in GD-T-09, Rev. 8, Paragraph VI.B.3.f contained in MI-A-13, Rev. 4, and Paragraph 7.4.4.g contained in 00851-C, Rev. 0.

Component Identification

As Found Condition

Valve No. 2HY-212B

Valve was lying on floor on the limit switch without cribbing for protection. Herculite draped over the valve did not provide adequate protection from the sand blasting activities in the general area as evidenced by grit being on the exterior valve surfaces.

Valve No. 2HY-212C

The air pressure regulator supply line solenoid electric connection junction box, solenoid valve port to atmosphere, and end connections were not capped. Herculite draped over the valve did not provide adequate protection from the sand blasting activities in the general area as evidenced by grit being on the exterior valve surfaces.

Valve No. 2HY-216B

The solenoid electrical connection junction box limit switch electrical connection box was not capped. Herculite draped over the valve did not provide adequate protection from the sand blasting activities in the general area as evidenced by grit being on the exterior valve surfaces.

Valve No. 2HY-216C

Valve was lying on the Air Pressure regulator evidenced by a bent bracket. Two limit switch electrical connections

and solenoid electrical connection junction box were not capped. Valve was located in middle of walkway with two pipe support tripods over the top of the valve where fitters were working on pipe. Herculite draped over the valve did not provide adequate protection from the sand blasting activities in the general area as evidenced by grit being on the exterior valve surfaces.

Valve No. HV 8812A  
RWST Suction Inlet  
VLV to RHR

Valve was found disassembled with the bonnet portion removed from the body without protection provided to the gate.

Train "A" Remote Shutdown  
Panel 1-1605-P5-SDA

Panel was found with door open with no work in progress. In addition welding of a support was in progress overhead.

The above conditions are examples of failure to provide adequate protection to safety related components during in plant storage in accordance with existing procedures. This is considered to be in violation of 10 CFR Part 50, Appendix B, Criterion V and will be identified as Violation 50-424/85-43-01 & 50-425/85-32-01 "Failure to Provide Adequate Protection to Safety Related Components During Inplant Storage".

#### 16. Electrical (Components and Systems) - Units 1 & 2 (51053C)

Periodic inspections were conducted during the inspection period to observe safety-related electrical equipment to verify that the installation and storage were accomplished in accordance with applicable requirements. The following areas were examined at during the inspections:

- Location and alignment
- Type and size of anchor bolts
- Identification
- Segregation and identification of nonconforming items
- Equipment space heating
- Rotation of motor shafts
- Lubrication and fluid levels
- Protective coatings, preservations, desiccants, inert gas blanket, etc.

The inspector observed in process anchor bolt installation and reviewed records for an electrical panel as described below to determine whether applicable code and procedure requirements were being met.

Concrete Expansion Anchor  
Location and Hole Report

Panel Identification

Control Building

1-1623-D5-006A

Display Processing  
Unit (DPU) Train "A" -Post  
Accident Sampling Unit

No violations or deviations were identified.

17. Electrical (Cables and Terminations) - Unit 1 (51063C)

Periodic inspections were conducted during the inspection period to determine whether the raceway installation and protection of installed cable is in accordance with applicable codes, standards, and NRC Regulatory Guides.

In reference to the raceway installation, the following areas were inspected to verify compliance with the applicable requirements:

- Identification
- Alignment
- Bushings (Conduit)
- Grounding
- Supports and Anchorages

In reference to the installed cable, the following areas were inspected to verify compliance with the applicable requirements:

- Protection from adjacent construction activities (welding, etc.)
- Coiled cable ends properly secured
- Unterminated cable ends taped
- Cable trays, junction boxes, etc., reasonably free of debris
- Conduit capped, if no cable installed
- Cable supported

The inspector observed in process cable lugging preparation of the A Train Calvert Bus to the Diesel. Cable cutback of the "W" run cables A-1 and C-1 was witnessed. Train A and B RHR Pump power terminations were also witnessed.

No violations or deviations were identified.

18. Safety Related Piping (Welding) - Unit 2 (55083C)

Periodic inspections were conducted on Reactor Coolant System Primary Loop pipe welds at various stages of weld completion. The purpose of the inspection was to determine whether the requirements of applicable specifications, codes, standards, work performance procedures and (QC) procedures were being met as follows:

- Work was conducted in accordance with a process sheet which identifies the weld and its location by system, references procedures or instructions, and provides for production and QC signoffs.
- Welding procedures, detailed drawings and instructions, were readily available and technically adequate for the welds being made.
- Welding procedure specification (WPS) were in accordance with the applicable ASME Code requirements and that a Procedure Qualification Record (PQR) is referenced and exists for the type of weld being made.
- That the base metals, welding filler materials, fluxes, gases, and insert materials were of the specified type and grade, have been properly inspected, tested and were traceable to test reports or certifications.
- That the purge and/or shielding gas flow and composition were as specified in the welding procedure specification and that protection was provided to shield the welding operation from adverse environmental conditions.
- That the weld joint geometry including pipe wall thickness was specified and that surfaces to be welded have been prepared, cleaned and inspected in accordance with applicable procedures or instructions.
- That the pipe to be welded to the component was assembled and held in place within specified gap and alignment tolerances allowed by the ASME Code.
- That a sufficient number of adequately qualified QA and QC inspection personnel were present at the work site, commensurate with the work in progress.
- That disbursement of welding materials was controlled in accordance with approved procedures.

#### Installation Activities

The inspector observed the above criteria on the following Reactor Coolant System primary pipe welds at various stages of weld out during the inspection period.

<u>ISO No.</u>	<u>Weld No's.</u>	<u>Procedure No.</u>	<u>Joint Configuration</u>	<u>Weld Out Stage Code</u>	<u>Inspected</u>
2K4- 1217-067- 01,R/2	106-W-02	ITI-III/I	10" Carbon Steel K- Insert	ASME, CL II, III	Capped, grinding for Visual Inspection

<u>ISO No.</u>	<u>Weld No's.</u>	<u>Procedure No.</u>	<u>Joint Configuration</u>	<u>Weld Out Code</u>	<u>Stage Inspected</u>
2K4- 1202-216- 01,R/4	216-W-105, 106,107, 108	24-III/I	1" Stainless Socket	ASME III, CL II	Fit-up, Observed Marking for Socket Enlargement
2K4- 1206-008- 10	008-W-16	24-III/I	8" Stainless Steel K- Insert	ASME III, CL II	Root
2K4- 1202-216- 01,R/4	216-W-05	24-III/I	8" Stainless Steel K- Insert	ASME III, CL II	Fit-up, K-Insert
2K4- 1206-007- 08,R/3	007-W-24	24-III/I	10" Stainless Steel K- Insert	ASME III, CL II	Final Tacked - Repair Grind Thru Wall

No violations or deviations were identified.