

TEXAS UTILITIES GENERATING CO CPSES	PROCEDURE NUMBER	REVISION	ISSUE DATE	PAGE
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REINSPECTION OF COMANCHE PEAK DIESEL GENERATOR AUXILIARY SKID AND SUPPORT BRACKETS	PREPARED BY: <u>[Signature]</u>			7/28/81 DATE
	APPROVED BY: <u>[Signature]</u>			7/28/81 DATE

1.0 REFERENCES

- 1-A AISC MANUAL OF STEEL CONSTRUCTION, Seventh Edition
- 1-B AWS D1.1-1975
- 1-C CP-QP-16.0, "Nonconformancies and Deficiencies"

2.0 GENERAL

2.1 PURPOSE AND SCOPE

This procedure delineates the procedure for reinspection of the auxiliary skid and support brackets for the CPSES Diesel Generators as provided in P.O. CP-034 by Delaval.

2.2 RESPONSIBILITY

The TUGCO Vendor Compliance Lead Engineer shall have overall responsibility for the inspections required by this procedure.

3.0 PROCEDURE

3.1 FABRICATION DRAWING

Site Mechanical Engineering will make a composite sketch of the vendor drawing(s). This drawing shall be approved by the Project Mechanical Engineer and issued to the TUGCO Vendor Compliance Lead Engineer. All welds not specified on the drawing shall be a full strength fillet (both sides), and shall meet the following minimum size requirements, except that the weld size need not exceed the thickness of the thinner member.

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Base Metal Thickness
of Thicker Member

Minimum Size
Fillet

To 1/4" inclusive	1/8"
Over 1/4" to 1/2" inclusive	3/16"
Over 1/2" to 3/4" inclusive	1/4"
Over 3/4" to 1 1/2" inclusive	5/16"

Welds other than full strength fillets shall be so annotated on an as-built drawing by the inspector and shall be submitted to the Project Mechanical Engineer for review and approval.

3.2 MATERIAL VERIFICATION

Material verification will not be performed by the inspector. Material certification will be provided by the vendor.

3.3 WELDER QUALIFICATION VERIFICATION

Evidence of welder qualification (Certificates of Compliance) have been provided by Delaval and Kaiser Steel. Consequently, field verification of welder qualification is not required.

3.4 BOLTED CONNECTIONS

The QC Inspector shall verify for all bolted connections:

- Minimum thread engagement is obtained. Minimum thread engagement shall be defined as the end of the bolt at least flush with the nut.
- Bolting material is of the proper size and type.
- Washers are installed as required.
- If bolts are replaced, torque shall be verified by QC for at least 2 bolts in each connection.

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3.5 VISUAL INSPECTION OF WELDS

The QC Inspector shall perform a final visual inspection of all accessible welds. Welds which are inaccessible shall be so noted on the IR. For purposes of this procedure, inaccessible shall be defined as those welds which cannot have the paint removed to facilitate visual inspection. Questions to accessibility shall be resolved by the Lead Vendor Compliance Engineer or his designee. The visual inspection shall verify that:

- a. All welds are per drawing and Paragraph 3.1. All deviations are marked up on as-built drawing.
- b. The weld is free of slag, scale, and paint.
- c. The welds and surrounding base metal shall be free of arc strikes.
- d. Weld profiles are either slightly concave or convex, with the degree of concavity or convexity not to exceed 0.1 times actual leg length.
- e. Undercut does not exceed 1/32".
- f. Reinforcement of butt joints is not greater than 1/8".
- g. Welds are free from overlap.
- h. Welds are free from lack of fusion and cracks.
- i. Full penetration butt welds have complete penetration. If inaccessible, the IR shall be so noted and these cases evaluated on a case by case basis.
- j. Welds are of minimum size as specified on the drawing and Paragraph 3.1. Welds are permitted to be 1/16" undersize provided that the length of the undersize weld does not exceed 10% of the total weld length. Welds may be oversized without/limit except as noted below:
 - A. Amount of oversize does not cause excessive distortion.
 - B. For edge welds, the maximum size requirements of paragraph 2.7.1.2 of Reference 1-8 are met.

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- k. All craters are filled to the full cross section.
- l. The sum of the diameters of piping porosity does not exceed 3/8 inch in any linear inch of weld and does not exceed 3/4 inch in any 12 inch length of weld.

3.6 DOCUMENTATION

These inspections shall be documented on an inspection report, Attachment 1. Unsatisfactory items shall be so noted on the IR and returned to Construction for resolution. Welds which have been noted as inaccessible shall be evaluated by the Project Mechanical Engineer. Completed inspection reports shall be forwarded to the Permanent Plant Records Vault for retention.

3.7 WELD REPAIR

Weld repairs shall be performed in accordance with existing Site procedures. Reinspection shall be performed on the repairs as described in 3.5.

3.8 NONCONFORMANCES

Nonconforming conditions (other than welding size and location discrepancies described in Paragraph 3.1) will be reported in accordance with Reference 1-C.

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ATTACHMENT 1

COMANCHE PEAK STEAM ELECTRIC STATION
INSPECTION REPORT

ITEM DESCRIPTION DIESEL GENERATOR SKID		IDENTIFICATION NO.		SYSTEM / STRUCTURE DESIGNATION DG	
SPEC. NO.	REV.	REF. Q.C. DOC. & REV. & CHANGE NO. CP-QP-11.11, Rev.		MEASURE OR TEST EQUIP. IDENT. NO. N/A	
<input type="checkbox"/> IN PROCESS INSPECTION		<input type="checkbox"/> PRE-INSTALLATION VERIFICATION		<input type="checkbox"/> INSTALLATION INSPECTION	
<input type="checkbox"/> INSPECTION COMPLETED, ALL APPLICABLE ITEMS SATISFACTORY		<input type="checkbox"/> FINAL INSPECTION		<input type="checkbox"/> PRE-TEST INSPECTION	
INSPECTION RESULTS					
<input type="checkbox"/> INSPECTION COMPLETED, UNSATISFACTORY ITEMS LISTED BELOW					
ITEM NO.	INSPECTION ATTRIBUTES				QC INSPECTOR
1.	Weld Free of Paint and Rust				DATE
2.	Weld Size per Drawing				
3.	Final Visual Inspection per Paragraph 3.5				
4.	Bolted Connections per Paragraph 3.4				
REMARKS (DWGS, SPECS, ETC.)					
RELATED NCR NO. <input type="checkbox"/> I.R. CLOSED <input type="checkbox"/> DATE <input type="checkbox"/> SIGNATURE <input type="checkbox"/> QC INSPECTOR					