

TEXAS UTILITIES GENERATING CO CPSES	PROCEDURE NUMBER	REVISION	ISSUE DATE	PAGE
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TACK WELD SURVEILLANCE  CONTROLLED COPY CONFIDENTIAL M-002	PREPARED BY: <u>William Horkman Jr. SA</u> 7/6/81 DATE  APPROVED BY: <u>[Signature]</u> 7/6/81 DATE			
1.0 REFERENCES  1-A CP-QP-18.0, "Inspection Reports"  2.0 GENERAL  2.1 PURPOSE  The purpose of this procedure is to outline the method used by QA/QC in performing surveillance of Construction's weld joint fitup tack weld activities.  2.2 SCOPE  The scope of this procedure covers surveillance inspections performed on conduit supports, cable tray supports and structural/miscellaneous steel weld joint fitup tack welds.  3.0 PROCEDURE  3.1 SURVEILLANCE  Surveillance of fitup tack welds will be done to assure that the quality of tacks inspected meets the visual inspection acceptance criteria of AWS D1.1 as delineated in Section 3.2 of this procedure.  3.2 INSPECTION ACCEPTANCE CRITERIA  The acceptance criteria for the inspection of tack welds is as follows:  a. No cracks  b. Thorough fusion between weld metal and base metal				

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- c. Stopping and starting ends prepared by grinding or other means so that they can be satisfactorily incorporated into the final weld.
- d. Discontinuities such as undercut, unfilled craters and porosity removed prior to incorporation into the final weld.

### 3.3 FREQUENCY

Surveillance shall be performed at a frequency necessary to maintain a desired "level of confidence" in Construction's fitup tack welding activities. This frequency shall be based on the quality of tack welds inspected and shall be determined by the Quality Engineering Supervisor.

### 3.4 DOCUMENTATION

Results of the tack weld surveillance shall be documented on Inspection Reports.

An Inspection Report (Attachment 1) shall be prepared for each tack weld inspected during this surveillance. The identification number information on the IR should include the weld number, if any, or else uniquely identify the weld by location. A brief sketch may be drawn in the remarks section to help identify the weld location.

Inspection Reports shall be processed as per Reference 1-A, except that upon closure they shall be forwarded to the Quality Engineering Supervisor for further processing and subsequent filing in the Permanent Plant Records Vault.

### 3.5 REPORTING

The Quality Engineering Supervisor, or his designee, shall review the Inspection Reports for completeness, accuracy and any trends prior to filing in the Permanent Plant Records Vault.

Results shall be summarized, along with the need for any necessary corrective action, and formally reported by the Quality Engineering Supervisor to the Site QA Supervisor on a quarterly basis.

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ATTACHMENT 1

COMANCHE PEAK STEAM ELECTRIC STATION

INSPECTION REPORT

SHEET 1 OF 1  
NO. IR-TW-

ITEM DESCRIPTION		IDENTIFICATION NO.		SYSTEM / STRUCTURE DESIGNATION	
TACK WELD SURVEILLANCE					
SPEC. NO.	REV.	REF. TO DOC. & REV. & CHANGE NO.	MEASURE OR TEST EQUIP. IDENT. NO.		
N/A		CP-QP-19.04			
<input type="checkbox"/> IN PROCESS INSPECTION	<input type="checkbox"/> PRE-INSTALLATION VERIFICATION	<input type="checkbox"/> INSTALLATION INSPECTION	<input type="checkbox"/> FINAL INSPECTION	<input type="checkbox"/> PRE-TEST INSPECTION	
INSPECTION RESULTS					
<input type="checkbox"/> INSPECTION COMPLETED, ALL APPLICABLE ITEMS SATISFACTORY					
<input type="checkbox"/> INSPECTION COMPLETED, UNSATISFACTORY ITEMS LISTED BELOW					
ITEM NO.	INSPECTION ATTRIBUTES			DATE	QC SIGNATURE
	TACK WELD INSPECTION ACCEPTANCE CRITERIA:				
1.	No Cracks				
2.	Thorough Fusion Between Weld Metal and Base Metal				
3.	Stopping and Starting Ends Prepared by Grinding or Other Means for Incorporation into the Final Weld				
4.	The Following Removed Prior to Incorporation into the Final Weld:				
	a. Undercut				
	b. Unfilled Craters				
	c. Porosity				
	Welder's Symbol:				
REMARKS (DWGS, SPECS, ETC.)					
RELATED VCR NO.	I.R. CLOSED	DATE	SIGNATURE	QC INSPECTOR	

**TYPICAL**