

VENDOR INSPECTION REPORT

U.S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT
REGION IV

Report No. 99900003/78-02

Program No. 44010

Company: General Electric Company
Wilmington Manufacturing
Department
Box 780
Wilmington, North Carolina 28401

Inspection Conducted: July 18-21, 1978

Inspector:

J. W. McNeill
J. W. McNeill, Contractor Inspector, Vendor
Inspection Branch

8-15-78
Date

Approved by:

J. W. Whitesell
D. E. Whitesell, Chief, Components Section I,
Vendor Inspection Branch

8-15-78
Date

Summary

Inspection on July 18-21, 1978 (99900003/78-02)

Areas Inspected: Implementation of the Topical Report including action on previous inspection findings; and handling, storage and shipping; and procurement procedures. The inspection involved twenty-eight (28) inspector-hours on site.

Results: In the areas inspected, the following three (3) deviations and two (2) unresolved items were identified.

Deviations: Handling, Storage, and Shipping - the controls did not assure packaging was in conformity with the Packaging Data Sheets in accordance with the Topical Report, Section 5, and the Quality Assurance Program, Section 6.13.5, (See Enclosure, Item A) Handling, Storage, and Shipping -

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DETAILS SECTION

A. Persons Contacted

J. E. Batounis, Foreman
#D. A. Burns, Manager Procurement and Material Logistics
#C. W. Doyle, Manager Quality Audits and Customer Service
J. A. Ferencak, Q. C. Planner
E. W. Hodges, Foreman
A. L. Kaplan, Manager Licensing
W. W. Lace, Q. C. Engineer
#E. A. Lees, Manager Quality Assurance
#J. W. Ludes, Q. A. Engineer
J. M. Minns, Manager Traffic and Material Distribution
V. L. Monroe, Manager Purchased Material Q. C.
D. E. Porzinski, Q. C. Engineer
G. G. Robertson, Q. C. Engineer
W. S. Singleton, Buyer
#D. Starr, Manager Equipment Quality
K. Toussaint, Q. C. Planner

#Denotes those attending the Exit Interview.

B. Action on Previous Inspection Findings

(Closed) Deviation (Report No. 76-03): Full implementation of ANSI 45.2.9 in respect to the establishment of storage requirements for special processed records. Procedures have been issued and implemented which now establish the environmental controls for records.

(Closed) Unresolved Item (Report No. 78-01): An inconsistency was found between P4AYP8 specification and the controls of this variable. An Engineering Change Notice (NE 98870) has been issued which has established resistivity, the method detailed in the procedure, as the control to be used.

C. Handling, Storage, and Shipping

1. Objectives

The objectives of this area of the inspection were to verify that these activities are controlled and implemented in accordance with the QA Manual, the ASME Code requirements, and the NRC rules and regulations as appropriate.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of Criterion XII, 10 CFR 50, Appendix B, and the approved topical report, to ascertain if handling, storage and shipping operations are conducted as described and provides reasonable assurance that damage or deterioration will be prevented.
- b. Review of the Purchase Orders, Change Orders, Quality Control Inspection Instructions (QCII) and Receiving Inspection Data Sheets for jet pump barrels and accumulator cylinders, to verify that inspections for shipping damage are performed on material given source inspection but are not inspected upon receipt.
- c. Reviewed QCII's Purchase Orders (H1X89 and H2V00), and five (5) other orders in receiving. To verify that these inspections included identification and marking, physical damage and cleanliness that received material has been properly dispositioned and status identified.
- d. Reviewed Packaging Specifications 21A8774, Revision 0, and 21A8575, Revision 1, Packaging Data Sheets #001 and #008 and their associated QCII's and drawings 117C4577 and 829E1111, and inspected the fuel assemblies, control rod drives and peripheral fuel supports, to verify conformance with the packaging requirements, and whether the packaging of reactor equipment such as environmental protection, cleanliness checks, protection from contamination, blocking and etc., is properly provided.
- e. Inspected the foregoing shipments to verify that shipping documentation are reviewed for completeness.
- f. Review the QA Manual, Practices and Procedures, Quality Assurance Section Administrative Routines and other procedures on packaging, shipping and storage.

3. Findings

The inspector observed that the packaging of items did not, in some instances, meet the requirements of the Packaging Data Sheets. In specific it was observed that rubber bands were

used in lieu of the tape specified by the Packaging Data Sheet #008, Revision 1, for the packaging of fuel supports. The Packaging Data Sheet #001, Revision 5, and Specification 21A3575 on Control Rod Drive packaging require the use of 1 1/4" steel straps, the marking of weight, lift points, and center of gravity, and prohibits use of filament tape being applied directly to stainless steel. It was observed however that 3/4" steel straps had been used, filament tape had been applied directly on stainless steel, and the boxes had not been marked with weight, lift points and center of gravity.

a. Deviation

See Enclosure, Item A.

b. Unresolved Items

- 1) ANSI 45.2.2, a commitment of General Electric in its Topical Report, requires controls of the deleterious content (eg. halogens), of tapes, desiccants, wraps, etc. Process Specification, P50YP107, Revision 1, "Control of Processing Materials," addresses the permissible content of deleterious substances. Documentation of wraps, desiccants, etc., to comply with P50YP107 could not be found. Also some confusion exists concerning an ambiguous note on an Engineering Change Notice to P50YP107. GE will initiate the necessary action, and eliminate the confusion.
- 2) General Electric uses RA-2 and RA-3 shipping containers for its fuel. Practices and Procedures requires the containers to comply with regulatory requirements. These containers are licensed under Certificate of Compliance #4986. Evidence that these shipping containers are in conformance with its Certificate of Compliance could not be located at this time. This evidence will be reviewed during the next inspection.

D. Procurement Procedures

1. Objectives

The objectives of this area of the inspection were to verify that these activities were controlled and implemented in accordance with the QA Manual and applicable NRC and ASME Code requirements:

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of Criteria IV and VII of 10 CFR 50, Appendix B and the approved topical report as documented in his QA Manuals, to verify that fuel fabricator's procurement activities are being implemented as described.
- b. Review of Purchase Orders Numbers H1X60 for castings, H1X49 for flanges, HIV08 for bolts, 6D559 for tees, and 6D573 for bellows to verify the following:
 - (1) The Purchase Orders define the scope of work, technical and quality requirements, access for inspections and audits, documentation requirements, and the manner in which nonconformances are to be handled.
 - (2) That the responsible Q. C. personnel had reviewed and approved the Purchase Orders and any changes thereto, prior to processing the POs.
- c. Review of the Survey Approved Vendors List, dated March 3, 1978, Vendor Audit Schedule 1978, two (2) of the most recent audits/surveys of vendors, to verify that the above Purchase Orders had been placed with vendors on the approved vendors list.
- d. Review of Quality Assurance Section Administrative Routines, #320-50.4, Revision 1 to verify that supplier quality histories are being maintained.
- e. Review of the source and receiving inspection reports on the above identified purchase orders, to verify that source and/or receiving inspections are performed in accordance with the QCIs.
- f. Review of Purchase Order Defect Notice #2347 and Vendor Notice of Rejections RB880 and RB692, to verify that procurement nonconformances and corrective actions are documented, and dispositioned properly.

3. Findings

Of the five (5) vendors sampled, two (2) were not on the Survey Approved Vendor List. Parts number 131C8489, and parts number 922D219, were being received from two (2) vendors who were not on the list, and there was no evidence that they had ever been surveyed.

a. Deviation

See Enclosure, Item B.

b. Unresolved Items

None.

E. Exit Interview

The inspector met with management representatives (denoted in paragraph A) at the conclusion of the inspection on July 21, 1978. The inspector summarized the scope and findings of the inspection. The management representatives had no comment in response to each item discussed by the inspector.