

HUB INC.

2146 FLINTSTONE DRIVE • TUCKER, GEORGIA 30084 • 404/934-3101

January 18, 1988

United States Nuclear Regulatory Commission
Washington, D.C. 20555

Mr. James C. Stone, Acting Chief
Vendor Inspection Branch
Division Of Reactor Inspection And Safeguards
Office Of Nuclear Reactor Regulation

Subject: Docket No. ⁹⁹⁹⁰⁰⁸⁶⁶ 9990866/87-01

Dear Mr. Stone,

In regard to the finding from the inspection on November 16 - 20, 1987, I offer the following:

Corrective Action

When Mr. Cilimberg discovered the nonconforming markings, the pipe was immediately segregated, tagged and documented on nonconformance number 124-87, copy enclosed. During reinspection of the nonconforming pipe it was discovered that the piece was additionally steel die stamped by the mill with heat number 60744, further confirming the correct identification.

All of the incorrect markings were removed, the pipe was die stamped again by Hub with the correct heat number, verified by a Q.C. Inspector, and the nonconformance was then closed.

Cause And Preventive Action

On January 11, 1988 a meeting was held with the chairman and CEO, President, Vice President and General Manager, Operations Manager and myself to discuss the cause and preventive action measures to be taken.

It was agreed that the cause of the nonconformance was due to either a) counter error during one or more previous inventories, or b) sabotage.

8802040071 880118
PDR QA999 EMVHUB
99900866 PDR

DISTRIBUTORS • PIPE • VALVES • FITTINGS
INSTRUMENTS • CONTROLS

IE:09
1/1

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Although this nonconformance has been deemed an isolated incident, we decided that preventive measures would be appropriate. We have decided to implement a material marking validation procedure whereby any identification transfers performed on material by us (including transfer of tagged identification when material is not per-piece marked) shall be validated by a Quality Assurance representative by use of unique inspector stamp on the material or tag, as applicable. A set of unique inspector stamps has been ordered, but not being sure of the delivery time I anticipate the aforementioned validation plan to be implemented by the end of February, 1988.

The remaining large, heavy wall pipe and drop pieces in storage will be reinspected by a quality representative to assure ourselves that the double marking of heats does not exist on any more of this material. This will be completed by the end of January, 1988 and will be considered a portion of our internal audit.

I trust the aforementioned will satisfy your concerns.

Very truly yours,


Charles E. Thornton, Jr.
Manager, Q.A.

cc: Q.A. File
B. Camp
M. Smith
G. Snyder
R. Dunster
Sales
Q.A. Staff

MASTER COPY WHEN IN RED

TITLE: NONCONFORMANCE REPORT FORM # 104

REV APPROVAL DATE SECTION PAGE

C.E. Johnston

2/13/87

DATE: 11/18/87 REPORT#: 124-87
 VENDOR: PHOENIX STEEL IMPACT ON VENDOR YES ☒ NO
 HUB P.O. NUMBER: T-38839
 CUSTOMER REF. NUMBER: N/A
 ITEM DESCRIPTION: 14" OD X .750 W SA-106 GR. C SALS PIPE
 HEAT NUMBER: 60744
 QUANTITY RECEIVED: 1 R/L QUANTITY REJECTED 1 R/L
 GAUGE USED: N/A
 DOCUMENT/STANDARD/CODE VIOLATED: NCA-3866.6
 REPORTABLE UNDER 10CFR21: YES ☒ NO

DESCRIPTION OF NONCONFORMANCE: PIPE IS IDENTIFIED WITH TWO HEAT NUMBERS. HUB STENCIL IS OF PHOENIX HT. 60744. PIPE IS DIE STAMPED BY PHOENIX WITH HT. 60744. PIPE IS ALSO MARKED IN WHITE INK (HANDWRITTEN WITH HUB INK) WITH HEAT 62879. A CMTR IS ON FILE FOR HEAT 60744. NO CMTR EXISTS FOR 14" OD X .750 W WITH A HEAT NUMBER OF 62879.

RECOMMENDED DISPOSITION: REMOVE ALL MARKINGS WITH HEAT 62879. DIE-STAMP PIPE WITH HEAT NUMBER 60744 FOR POSITIVE TRACEABILITY.

Management review	Q.C./Q.A. Representative	Date
<i>[Signature]</i>	<i>[Signature]</i>	11/18/87

CORRECTIVE ACTION AND FINAL DISPOSITION:

Material Die Stamped per spec. & with Heat #60744. All other markings removed.

Q.C./Q.A. Representative Date

[Signature] 11/30/87

DATE CLOSED: 11/30/87

SIGNED *[Signature]*
Q.A. Manager

cc: NCR Log ☒
 Vendor History File
 Vendor
 Customer
 Customer File
 Operations Mgr. ☒

PHOENIX STEEL CORPORATION

TUBE DIVISION
PHOENIXVILLE, PENNA.

CERTIFICATE OF INSPECTION AND TESTS

DATE: 9-16-80	DATE SHIPPED: 9-6-80	MILL ORDER NO. T-9547-B-30	SHIPPING LIST NO. 30A
Hub, Inc.		CUSTOMER ORDER NO. T-38839	
		CAR NO.	
		MATERIAL: SEAMLESS <input checked="" type="checkbox"/> PIPE <input type="checkbox"/> TUBE, HOT FINISHED	
		SPECIFICATION:	
		ASTM A-106-C-79b, ASME SA-106-C	

NO. PCS.	OD	WALL	LENGTH	TOTAL FT.	TOTAL WT.	HEAT NO.
	14.000"	x .750"				60744

The material was manufactured in accordance with the Quality System Program audited and approved by Hub, Inc. on 10-10-79 as conforming with the requirements of ASME Section III, Subarticle NCA-3800.

C	Mn.	P.	S.	Si.	Cu.	Ni.	Cr.	Mo.	V.
.25	.72	.010	.030	.20					

Q. A.
APPROVED
SIGNED Steve Collier 9-22-80

HEAT NO.	TENSILE (KSI)	YIELD (KSI)	% ELONG. IN 2"	% RA	ROCKWELL	HARDNESS BRINELL	GRAIN SIZE
60744	78.0	42.8	30.00				

JOMINY DISTANCE - 16TH			ROCKWELL C	FLATTENING	OK	HYDROSTATIC PSI	2575
1	2	4	6	8	10	12	14
16	20	24	28	32			

PHOENIX STEEL CORPORATION HEREBY CERTIFIES THAT THE ABOVE MATERIALS HAVE BEEN INSPECTED AND TESTED IN ACCORDANCE WITH THE DESCRIBED IN THE APPLICABLE SPECIFICATIONS AND THE RESULTS OF SUCH INSPECTION AND TESTS AS CONTAINED IN THE COMPANY'S ARE AS SHOWN ABOVE. FOR PROPERTIES OR CHARACTERISTICS FOR WHICH NO METHODS OF INSPECTION OR TESTING ARE PRESCRIBED BY SAID SPECIFICATIONS, THE STANDARD MILL INSPECTION AND TESTING PRACTICES OF THE PHOENIX STEEL CORPORATION HAVE BEEN APPLIED. BASED UPON SUCH INSPECTION AND TESTS, THE ABOVE MATERIALS HAVE BEEN APPROVED AS FULFILLING THE REQUIREMENTS OF SAID SPECIFICATION.

R. W. Pechter
ENGINEER OF TESTS

MATERIAL TO BE MARKED BY WHSE

RUSH ☐

Scheduled Ship Date 11/19/87

CUSTOMER NAME

Stock

P.O.#

N/A (NCR 124-87)

PACKING SLIP#

N/A

MARKING
done
1:40

Material Description	Quantity	Heat#	To Be Marked With	How To Be Mark
14" OD x .750W (True 80)	1 pc.		14" S/80 (.750)	Die
Smls. SA106 GR. C	SR/L (Drop)	60744	Smls. SA106	Stamp
Pipe			Gr. C Phoenix	
			HT. 60744	
			2575 PSI	

Location of Material:

1 pc. 0/s West

~~After Material has been stamped all of the other markings have to be blasted off. (copy of NCR is attached)~~