

APPENDIX

U. S. NUCLEAR REGULATORY COMMISSION  
REGION IV

NRC Inspection Report: 50-458/85-33

Construction Permit: CPPR-145

Docket: 50-458

Licensee: Gulf States Utilities (GSU)  
P. O. Box 2951  
Beaumont, Texas 77704

Facility Name: River Bend, Unit 1

Inspection At: River Bend Site

Inspection Conducted: April 15-June 27, 1985

Inspectors: *L. D. Gilbert* *W. M. McNeill for* 8/15/85  
L. D. Gilbert, Reactor Inspector Date

*W. M. McNeill* 8/15/85  
W. M. McNeill, Reactor Inspector Date

Approved: *J. P. Jaudon* 8/15/85  
J. P. Jaudon, Chief, Project Section A, Reactor Date  
Project Branch

Inspection Summary

Inspection Conducted April 15-June 27, 1985 (Report 50-458/85-33)

Areas Inspected: Routine, unannounced inspection of safety-related pipe supports and verification of as-builts for piping systems. The inspection involved 198 inspector-hours onsite and 3 inspector-hours offsite by two NRC inspectors.

Results: Within the two areas inspected, one violation was identified (failure to adequately document changes to inspection report results, paragraph 3.b).

DETAILS

1. Persons Contacted

Principal Licensee Personnel

- \*R. B. Stafford, Director Quality Services
- \*M. E. Walton, Supervisor Design Engineering
- \*R. E. Turner, Quality Assurance Engineer
- \*P. J. Dautel, Licensing Staff Assistant
- \*T. C. Crouse, Manager Quality Assurance
- \*T. F. Plunkett, Plant Manager
- \*L. A. England, Supervisor - Licensing
- \*I. M. Malik, Supervisor Quality Engineering
- \*D. R. Gipson, Asst. Plant Manager - Operations

Stone & Webster (S&W) Personnel

- \*R. L. Spense, Resident FQC Manager
- \*W. I. Clifford, Senior Construction Manager
- \*W. T. Tucker, Assistant to Superintendent of Engineering
- \*B. R. Hall, Assistant Superintendent FQC
- \*R. J. Fay, Chief Inspection Supervisor FQC
- R. Whitley, Assistant Superintendent FQC
- J. Green, FQC
- E. Fisher, FQC
- R. Ferguson, QC Engineer
- D. Cowart, FQC
- W. Wagner, FQC
- W. Edasi, Site Reconciliation Group Engineer
- J. Brook, FQC
- S. Fitzpatrick, FQC
- E. Tomlinson, FQC

\*Denotes those attending the exit interview on June 14 and/or June 27, 1985.

2. Safety-Related Pipe Supports

a. Dynamic Pipe Supports

The objectives of this inspection were to determine by visual examination that components were free from corrosion, not bent, deformed or loose, properly lubricated, free from foreign material that would obstruct operation and that fasteners were to be secure and of the correct materials.

A sample of seven Pacific Scientific Company snubbers were inspected by the NRC inspector. Approximately 300 of this type of component

are installed at River Bend. The visual inspection found the snubbers to have dirt, dust, and paint yet to be removed. S&W had not, as of the time of this inspection, performed a final cleanliness inspection. The final clearance inspection (CSI-8.1.1) had yet to be performed as a result the clearance of the pipe clamp, and snubber paddle on one snubber (1-BZ-108AAF) had yet to be evaluated. The inspection noted that one snubber (support 1-BZ-11 HP) was stiff to rotate. The cleanliness and clearance inspection was performed subsequently (see 3.b following). The supports inspected are listed below.

<u>Hanger No.</u>	<u>Support No.</u>	<u>Model No.</u>	<u>Bld./Elv</u>
1 DTM*PSSP 3004A1	1-BZ-31PW	PSA 1	RB/125
1 MSS*PSSP 3033A1	1-BZ-2DD	PSA.25	RB/155
1 RHS*PSSP 2367A2	1-BZ-71XD	PSA 10	AB/73
1 FWS*PSSP 3031A1	1-BZ-17JS	PSA 35	RB/137
1 RCS*PSSP 3040A1	1-BZ-970AU	PSA 35	RB/108
1 SWP*PSSP 1371A3	1-BZ-108AAF	PSA 35	GT/78
1 SVV*PSSP 3203A3	1-BZ-11 HP	PSA 35	RB/107

b. Component Supports

The objectives of this inspection were to determine by examination that location, welding certification of materials, and design clearances comply with design drawings, specifications, and code requirements.

A sample of six component supports were inspected (see table below). The first three listed in the table are multiple type pipe supports. The location of the supports and other drawing dimensions were verified by the NRC inspector by actual measurements. The welding of the components and their installation was inspected. This examination included verification of the welder qualifications, weld dimensions and the weld surface condition. The applicable design specifications and drawings were reviewed in order to establish the requirements. The certified material test reports (CMTRs) of the supports were reviewed to verify their conformance with specification and code requirements. In this regard Code Case N-225 was noted to have been invoked, however, CMTRs were found to be on file for the materials sampled.

One minor dimensional discrepancy was observed by the NRC inspector on support 1-RHS-196\*PSP-3A; however, an N&D 11712 was issued and the "as built" drawing revised. The welding on the standby service water pump motor stand was noted by the NRC inspector to be

particularly questionable. This was documented on N&D 11990 and also addressed in E&DCR C-7271. Nuclear Construction Issues Group (NCIG) requirements were invoked, and these welds were found to be acceptable. One problem was identified on the materials of support 1-BZ-108BG. The material call out change was documented on N&D 11658 and accepted. This problem was the result of a drawing change which had not been made retroactive.

<u>Support/Hanger No.</u>	<u>Drawing No.</u>	<u>Location</u>
1-RHS-196*PSP-3A	1-BZ-RHS-196*003	AB/77
1-BZ-108BG	1-BZ-108BG	DT/78
1-HVN*PSR 2026AZ	1-BZ-770CB	AB/147
1-SFC*SUP-1AB	1-SFC*SUP-1AB	FB/82
Non-Regen. H. E.	22871 (Teledyne Brown)	RB/146
SSW pump motor stand	1-500-153 (Haywood Tyler)	Standby Service Water Tower

c. Pipe Anchor Locations

The objectives of this inspection were to examine anchors and compare them with the drawings to ensure agreement as to their location and function.

A sample of 4 of the 200-plus anchor locations were inspected by the NRC inspector (see table below). The drawings were reviewed to establish dimensional requirements. The dimensions were verified by field measurements. The apparent function was verified at the same time.

<u>Anchor No.</u>	<u>Drawing No.</u>	<u>Location</u>
1-ICS*PSA 2014AZ	1-BZ-76L	AB/86
1-SFC*PSA 4061A3	1-BZ-77BN	FB/90
1-SWP*PSA 3034A3	1-BZ-19ANW	RB/159
1-WCS*PSA 2016A3	1-BZ-74AE	AB/107

d. As-Built Configuration

The NRC inspector selected three as-built safety-related pipe support structural drawings and compared the following selected supports with the actual installation.

(1) Reactor Water Clean-up System - Class 1 Piping Line  
1-WCS-003-006-1;

- Hanger 1 WCS\*PSSP3039A1
- Hanger 1 WCS\*PSSH3041A1
- Hanger 1 WCS\*PSSP3042A1
- Hanger 1 WCS\*PSSP3207A1
- Hanger 1 WCS\*PSSH3045A1
- Hanger 1 WCS\*PSSP3044A1
- Hanger 1 WCS\*PSSP3005A1

(2) Low Pressure Core Spray System - Class 1 Piping Line  
1-CSL-010-42-2;

- Hanger 1 CSL\*PSST2033A2
- Hanger 1 CSL\*PSSP2034A2
- Hanger 1 CSL\*PSST2035A2
- Hanger 1 CSL\*PSA2055A2
- Hanger 1 CSL\*PSSH2054A2
- Hanger 1 CSL\*PSSP2056A2

(3) Feedwater System - Class 2 Piping Line 1-FWS-020-062-2;

- Hanger 1 FWS\*PSR2011A2
- Hanger 1 FWS\*PSSP2010A2
- Hanger 1 FWS\*PSSP2008A2
- Hanger 1 FWS\*PSSP2007A2
- Hanger 1 FWS\*PSSP2006A2
- Hanger 1 FWS\*PSSP2005A2
- Hanger 1 FWS\*PSSH2004A2

In the areas inspected, the installed supports were consistent with the as-built drawings and dimensional tolerances specified in S&W Specification 228.312 except for one minor dimensional discrepancy for Hanger 1-WCS\*PSSP3207A1 which was determined to be a measurement error and dispositioned use-as-is. The as-built drawing was revised to show the correct dimension. This measurement error appears to be an isolated case.

No violations or deviations were identified.

3. Verification of As-Builts

a. Safety-Related Piping Systems

The NRC inspector selected eight piping isometric drawings for comparison of the drawing to the as-built condition. The eight drawings listed below represent four safety-related piping systems and 180 feet of piping ranging in sizes from 10 to 20 inches in diameter.

- (1) Residual Heating Removal System - Class 1
  - Drawing 1-RHS-034-CD-B
  - Drawing 1-RHS-034-CD-A
  - Drawing 1-RHS-067-CD-A
- (2) Feedwater System - Class 1
  - Drawing 1-FWS-047-CD-A
- (3) Low Pressure Core Spray - Class 2
  - Drawing 1-CSL-42-CD-A
- (4) High Pressure Core Spray - Class 2
  - Drawing 1-CSH-014-CD-B
  - Drawing 1-CSH-004-CD-A
  - Drawing 1-CHS-004-CD-B

In the areas inspected, the installed piping, including welds and supports, were consistent with the as-built drawing and dimensional tolerances specified in S&W specification 228.312 except for a support that had been added by Rework Control Form ABP-1336 and a minor dimensional discrepancy for the location of Hanger 1-BZ-83 AY. The new support added by ABP-1336 was in the process of being incorporated into the as-built drawing. The minor dimensional discrepancy for Hanger 1-BZ-83AY was determined to be a drafting error which was promptly corrected. The drafting error appeared to be an isolated case.

b. Clearances Around Safety-Related Piping Systems

The NRC inspector selected two piping systems to inspect for compliance with S&W Construction Site Instruction (CSI) 8.1.1 for adequate clearances around the piping and supports. The two piping systems inspected were the low pressure core spray (CSL) system and the residual heat removal (RHS) system. The portion of the CSL system inspected was designated as Class 2 and identified on Drawing 1-CSL-42-CD-A. The portion of the RHS system inspected was designated as Class 1 and identified on Drawings 1-RHS-034-CD-A and 1-RHS-034-CD-B.

In the areas inspected the clearances around the pipe, components and supports were consistent with the movements indicated by the reconciled AX load sheet for those areas evaluated by the Site Reconciliation Group (SRG) engineers during the area walkdown and consistent with CSI 8.1.1. The NRC inspector selectively inspected work performed after the SRG area walkdown for compliance with general clearance



requirements of CSI 8.1.1. The work inspected for general clearances included the following items of work from various craft disciplines.

- Work Control Form CCC No. 5-06-11-RB-4792 for Floor Grating in Reactor Building
- Work Control forms CCC No. 5-05-11-AB-33508 and CCC No. 5-05-11-AB-33510 for Lighting Transformers in Auxiliary Building
- Cable Pull Tickets 1HTSNNC013 and 1HTSNNX012 for Electrical Cable in Auxiliary Building
- Rework Control Form Nos. ABP-1656 and ABP-1669 for Pipe Supports in Control Building

In the areas inspected, the general clearances were consistent with CSI 8.1.1.

However, while reviewing the inspection report for two of the pipe supports, the NRC inspector determined that the results for the general clearances attribute on Inspection Report No P5400381 dated June 12, 1985, had been changed on June 13, 1985, from "not applicable" to "satisfactory" by a reviewer who neither had performed the inspection nor had any other inspection documentation to support the change.

The two pipe supports identified in Inspection Report No. P5400381 were inspected by the NRC inspector and were found to be in compliance with the general clearance requirements of CSI 8.1.1 Revision 4.

A preliminary review by the licensee determined that a small percentage of other safety-related inspection reports contained similar changes.

This is an apparent violation of Criterion XVII of 10 CFR 50, Appendix B, in that sufficient records were not maintained to furnish evidence that the inspector of record performed the inspection. (458/8533-01).

#### 4. Exit Meeting

The NRC inspectors met with licensee representatives (denoted in paragraph 1) and the NRC senior resident inspector, on June 14 and June 27, 1985, and summarized the scope and findings of the inspection.