

- NOTES:
1.

THIS DRAWING IS TO BE READ IN CONJUNCTION WITH ENGINEERING SPECIFICATION PROVIDED IN PURCHASE ORDER.
2.

SELECTION OF COMPONENTS ON THIS DRAWING IS A PROPOSAL ONLY. THE SELLER SHALL BE RESPONSIBLE FOR FULL VALIDATION OF THE COMPONENTS SELECTED FOR THE CONTRACTED APPLICATION, WHETHER IDENTICAL TO THE BUYER PROPOSAL OR OTHERWISE.
3.

THIS DRAWING PROVIDES BASIC OUTLINES, DESIGN OBJECTIVES AND BOUNDING DIMENSIONS TO CONTRACTED DESIGN OR FABRICATION SUPPLIER(S) AND SHALL NOT BE USED TO CONFIRM THE AS BUILT WTP STRUCTURE, SYSTEM OR COMPONENT IDENTIFIED HEREIN. SEE SELLER INFORMATION FOR FINAL CONFIGURATION PROVIDED IN CONFORMANCE TO PURCHASE ORDER.
4.

ALL DIMENSIONS, TOLERANCES, LIMITS OF SIZE, FORM, LOCATION AND RELATED TERMINOLOGY AND SYMBOLS SHALL BE INTERPRETED IN ACCORDANCE WITH ASME Y14.5-2018.
5.

BREAK ALL SHARP EDGES AND REMOVE ALL BURRS.
6.

UNLESS OTHERWISE SPECIFIED, MACHINED SURFACE FINISH SHALL BE 125 MICROINCHES OR GREATER.
7.

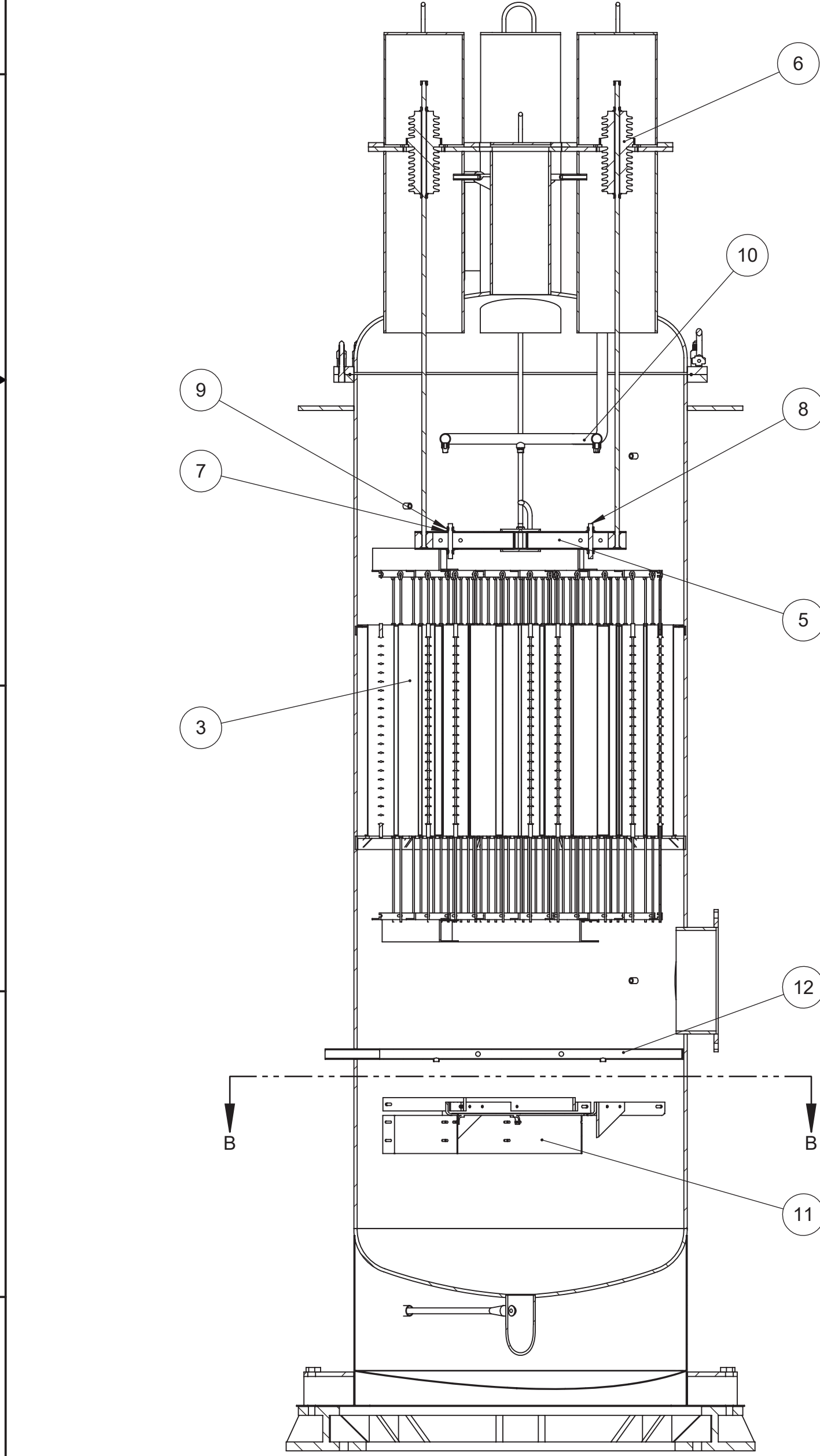
WELDS OF ALL NOZZLES SHALL BE INSPECTED THROUGH PT/RT METHODS.
8.

SUPPLIER TO PROVIDE PROOF OF OPERABILITY TOWARDS MAINTAINANCE OF THE VESSEL.
9.

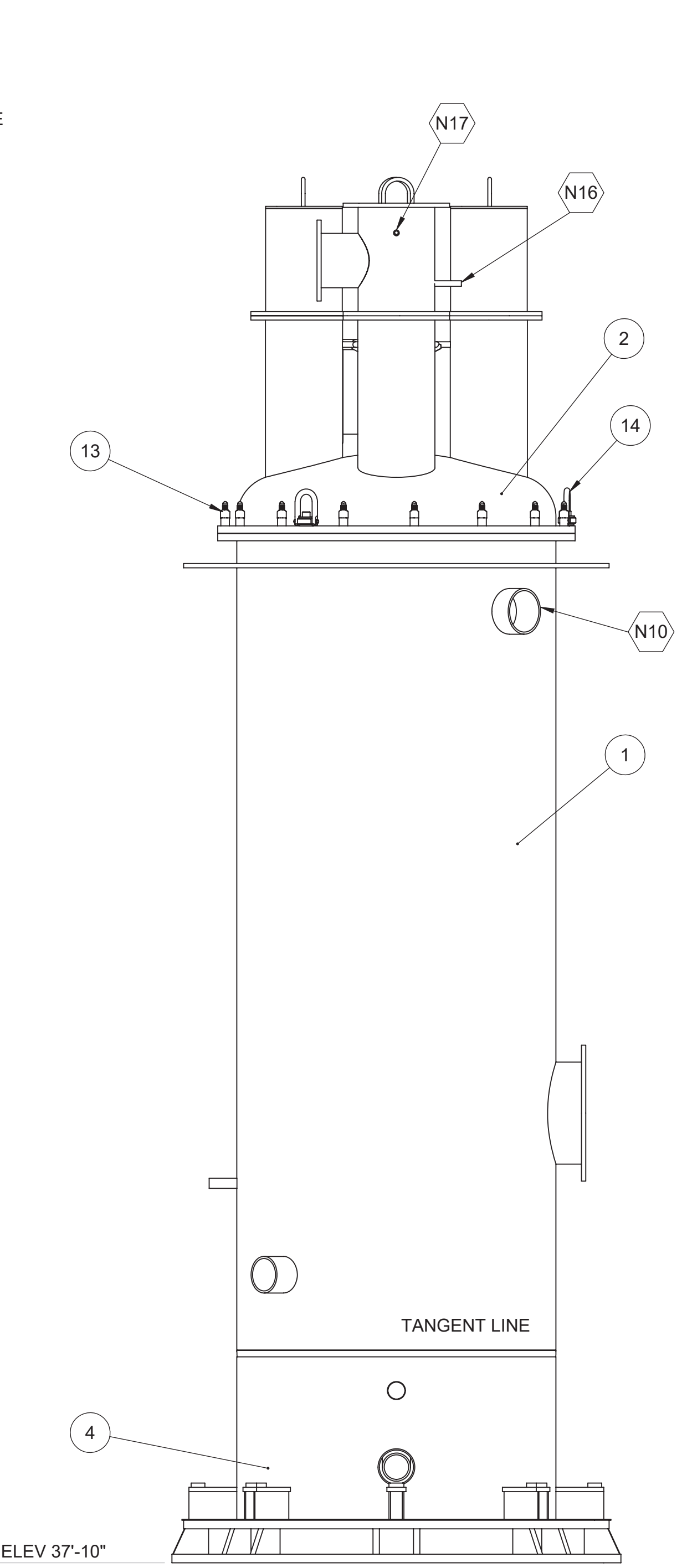
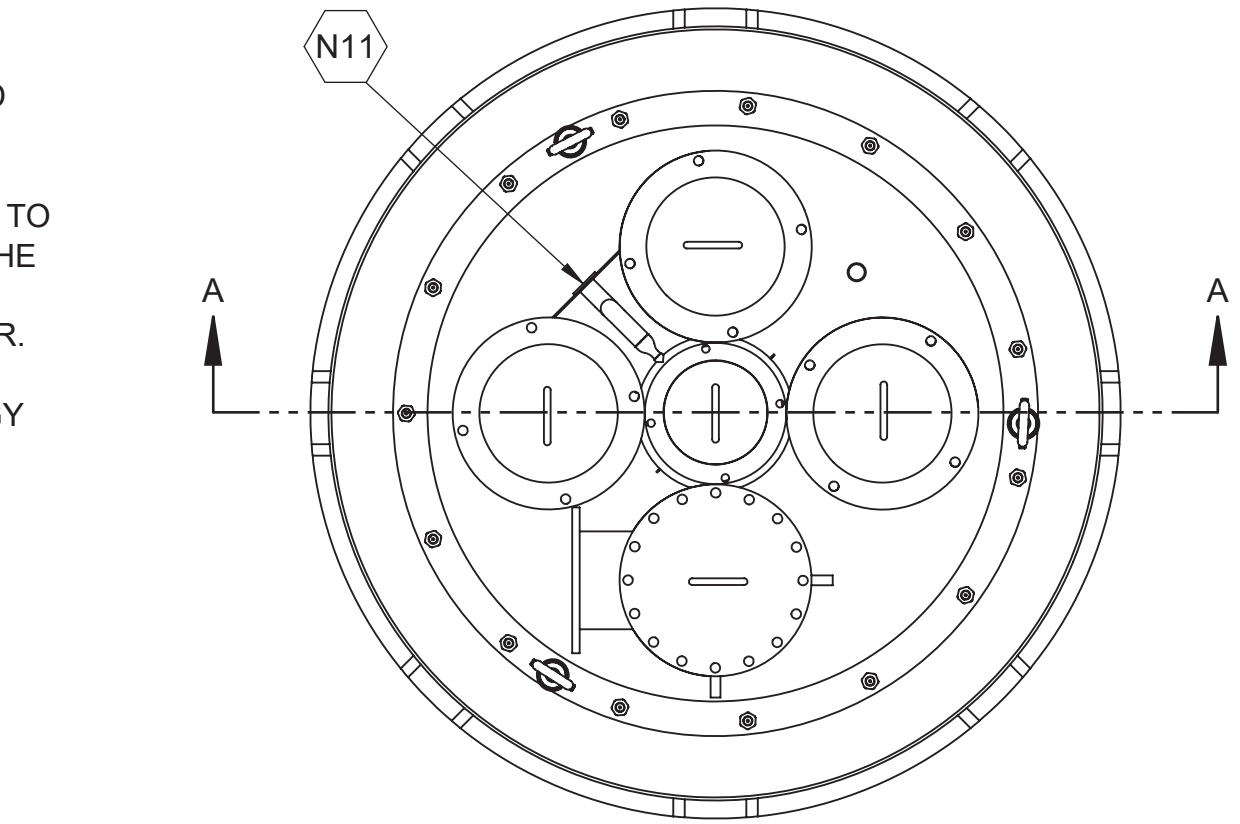
APPLY NO FINISH TO THE VESSEL.
10.

THIS AREA IS NOT FINALIZED PENDING AN UPDATED STRESS ANALYSIS REPORT
11.

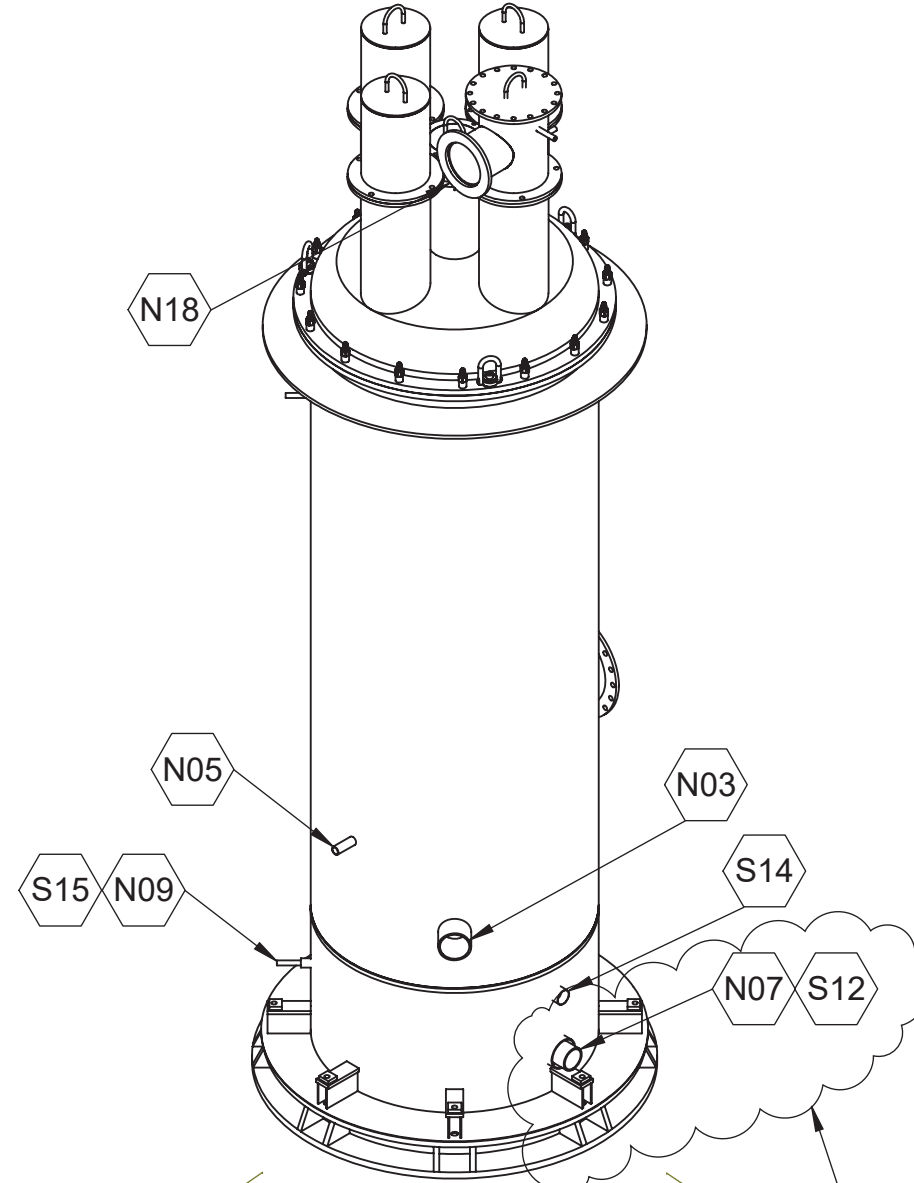
ALL "Z" DIMENSIONS MEASURED FROM THE 37" 10" ELEVATION TO THE CENTER LINEOF NOZZLE UNLESS OTHERWISE NOTED.



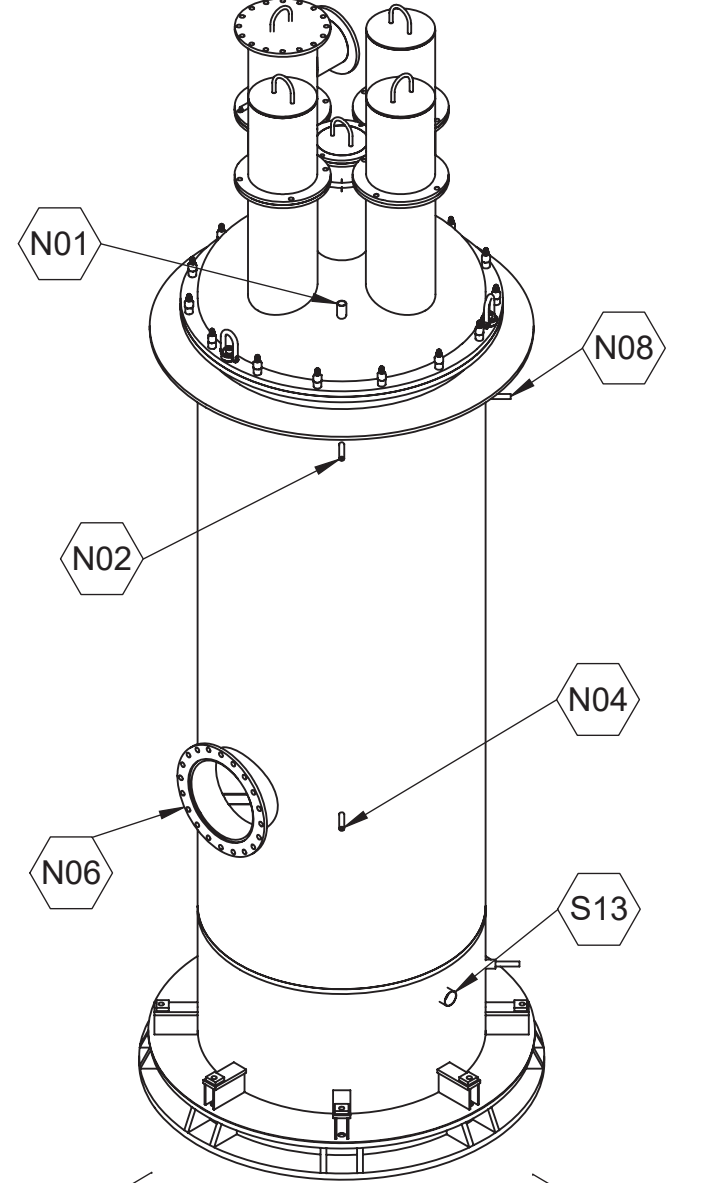
SECTION A-A



ELEV 37"-10"



ISOMETRIC VIEW  
(180° & 90° | NO SCALE)



ISOMETRIC VIEW  
(0° & 270° | NO SCALE)


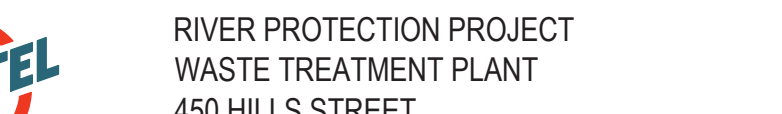
BILL OF MATERIALS				
ITEM	QTY	DESCRIPTION	DOCUMENT NUMBER	MATERIAL
1	1	WESP MAIN VESSEL ASSEMBLY	24590-HLW-MV-HOP-00004002	-
2	1	WESP TOP VESSEL HEAD ASSEMBLY	24590-HLW-MV-HOP-00004003	-
3	1	WESP COLLECTING TUBE ARRAY ASSEMBLY	24590-HLW-MV-HOP-00004005	-
4	1	WESP LOWER SKIRT ASSEMBLY	24590-HLW-MV-HOP-00004006	-
5	1	WESP MAIN BEAM ASSEMBLY	24590-HLW-MV-HOP-00004008	-
6	4	WESP INSULATOR ASSEMBLY	24590-HLW-MV-HOP-00004007	-
7	8	316 STAINLESS STEEL WASHER	-	316 Stainless Steel
8	4	WESP MAIN BEAM THREADED ROD	-	18-8 Stainless Steel
9	8	18-8 STAINLESS STEEL HEX NUT	-	18-8 Stainless Steel
10	1	WESP UPPER SPRAY RING ASSEMBLY	24590-HLW-MV-HOP-00004009	-
11	1	WESP BAFFLE PLATE ASSEMBLY	24590-HLW-MV-HOP-00004010	-
12	1	WESP INTERNALS LOWER FLUSH WATER HEADER	24590-HLW-MV-HOP-00004004	-
13	15	WESP REMOTE NUT	-	ASTM A194 Steel
14	3	STEEL HOIST RING FOR LIFTING	-	ASME B30.26 Steel

NOZZLE SCHEDULE					
NOZZLE	SIZE	SERVICE/REMARKS	SCH.	"Z" DIM.	WELD CONNECTION DETAIL PER 24590-WTP-MV-M59T-00016001
N01	2"	FLUSH WATER UPPER	80	21'-9"	DETAIL 3
N02	1"	PRESSURE TRANSMITTER 1	160	18'-8"	DETAIL 2
N03	8"	OFF GAS INLET	80	5'-8"	DETAIL 2
N04	1"	PRESSURE TRANSMITTER 2	160	8'-10"	DETAIL 2
N05	2"	FLUSH WATER LOWER	80	7'-5"	DETAIL 2
N06	24"	VESSEL INSPECTION PORT	40	8'-10"	DETAIL 2
N07	6"	VESSEL DRAIN	80	1'-11"	DETAIL 1
N08	1"	LEVEL TRANSMITTER 1	160	17'-9"	DETAIL 2
N09	1"	LEVEL TRANSMITTER 2	80	2'-8"	DETAIL 6
N10	10"	OFF GAS OUTLET	NA	18'-8"	DETAIL 2
N11	2"	TOP PURGE AIR	80	21'-11"	DETAIL 10
S12	8"	SKIRT SLEEVE 1	40	1'-11"	DETAIL 2
S13	4"	SKIRT VENT 1	40	3'-5"	DETAIL 2
S14	4"	SKIRT VENT 2	40	3'-5"	DETAIL 2
S15	2"	SKIRT SLEEVE 2	40	2'-8"	DETAIL 2
N16	1"	TOP PURGE AIR 2	160	-	DETAIL 2
N17	1"	TOP PURGE AIR 3	160	-	DETAIL 2
N18	12"	ELECTRICAL PORT	NA	25'-7"	DETAIL 8

NOZZLE SCHEDULE

DRAWING INDEX				
SH	DWG NO.	TITLE		
001	24590-HLW-MV-HOP-00004001	HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY		
002	24590-HLW-MV-HOP-00004002	HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY		
003	24590-HLW-MV-HOP-00004003	HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY		
004	24590-HLW-MV-HOP-00004004	HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY		
005	24590-HLW-MV-HOP-00004005	HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY		
006	24590-HLW-MV-HOP-00004006	HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY		
007	24590-HLW-MV-HOP-00004007	HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY		
008	24590-HLW-MV-HOP-00004008	HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY		
009	24590-HLW-MV-HOP-00004009	HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY		
010	24590-HLW-MV-HOP-00004010	HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY		

Q	A	ISSUED FOR PROPOSAL		BMS	KMB	JEP	JLM	SEE STAMPS	
	REV	DESCRIPTION		ORG	CHKD	RVWD	APVD	DATE	

PROJECT No.		24590		RIVER PROTECTION PROJECT WASTE TREATMENT PLANT 450 HILLS STREET RICHLAND, WA 99354	
SITE		HANFORD			
AREA		200E			
BUILDING No.		30 (HLW)			
BY			DATE	CONTRACT No: DE-AC27-01RV14136	WTP SUBCONTRACT No:
ORIGINATOR		B. SHOBE			
CHECKER		K. BAILEY			
REVIEWER		J. PATTERSON			
APPROVER		J. MAUSS			
WEIGHT		18851 LBS	CONTENT APPLICABLE TO ALARA? <input checked="" type="checkbox"/> YES <input type="checkbox"/> NO		SCALE: 1:25
SUPPLIER DWG NO.			ADR NO. N/A REV: N/A		
					REV A
					SHT 1 OF 10



H

G

F

E

D

C

B

A

H

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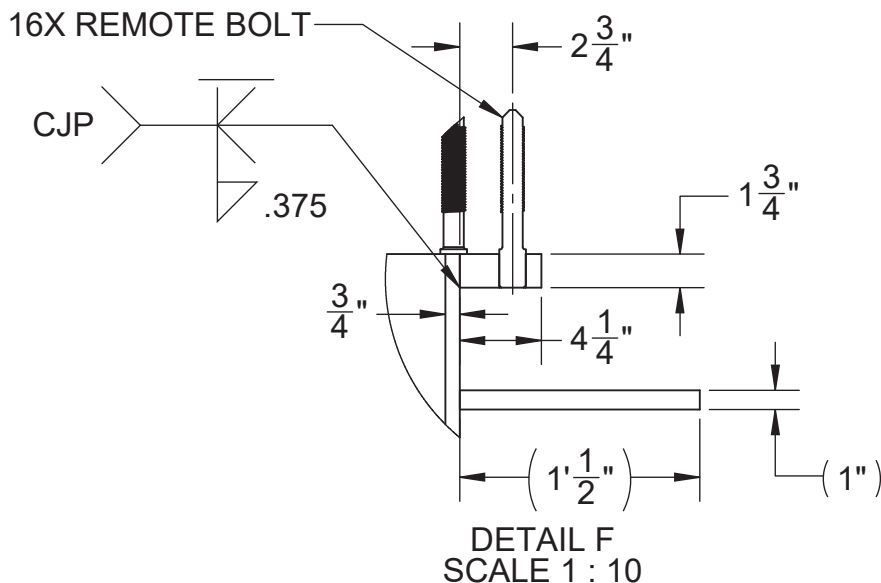
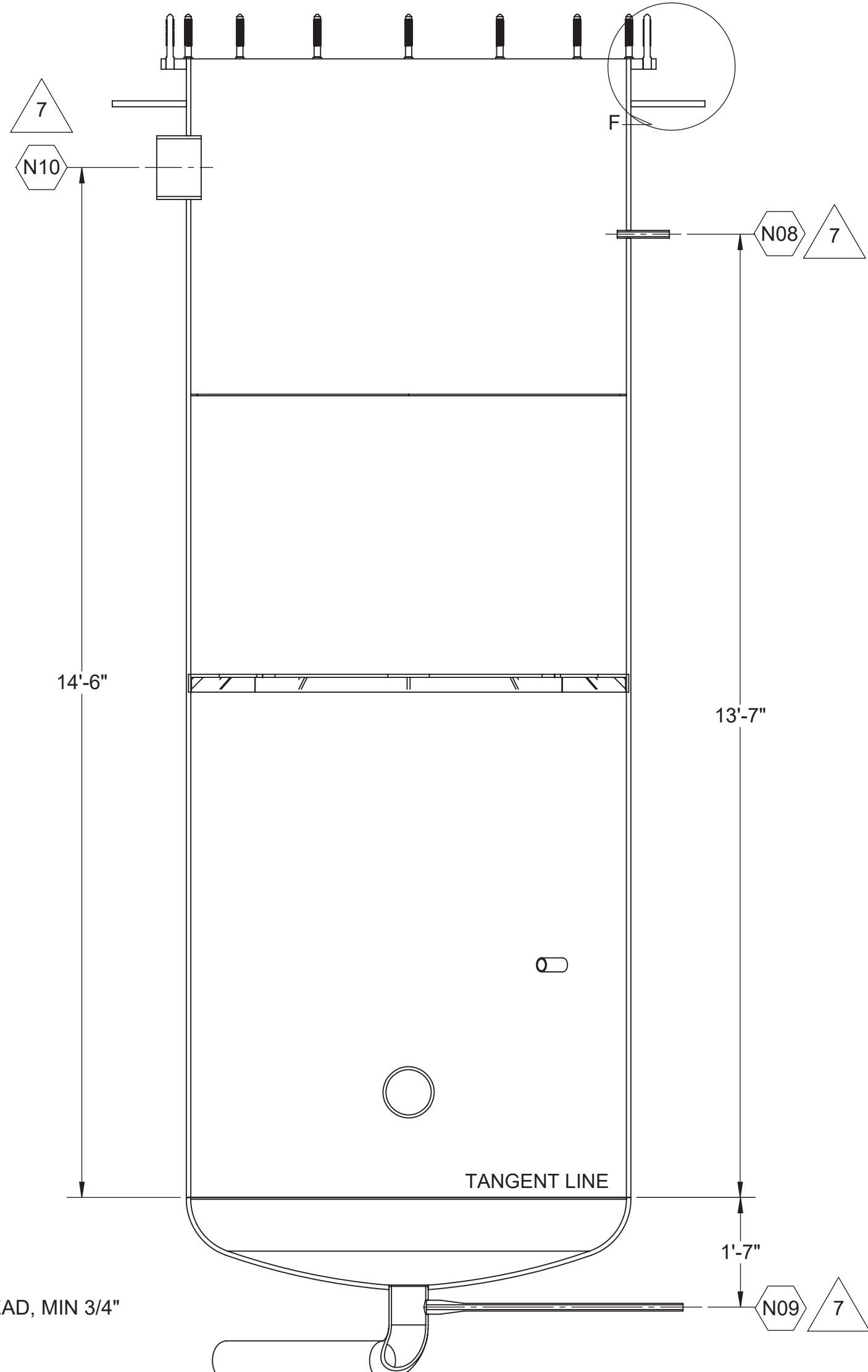
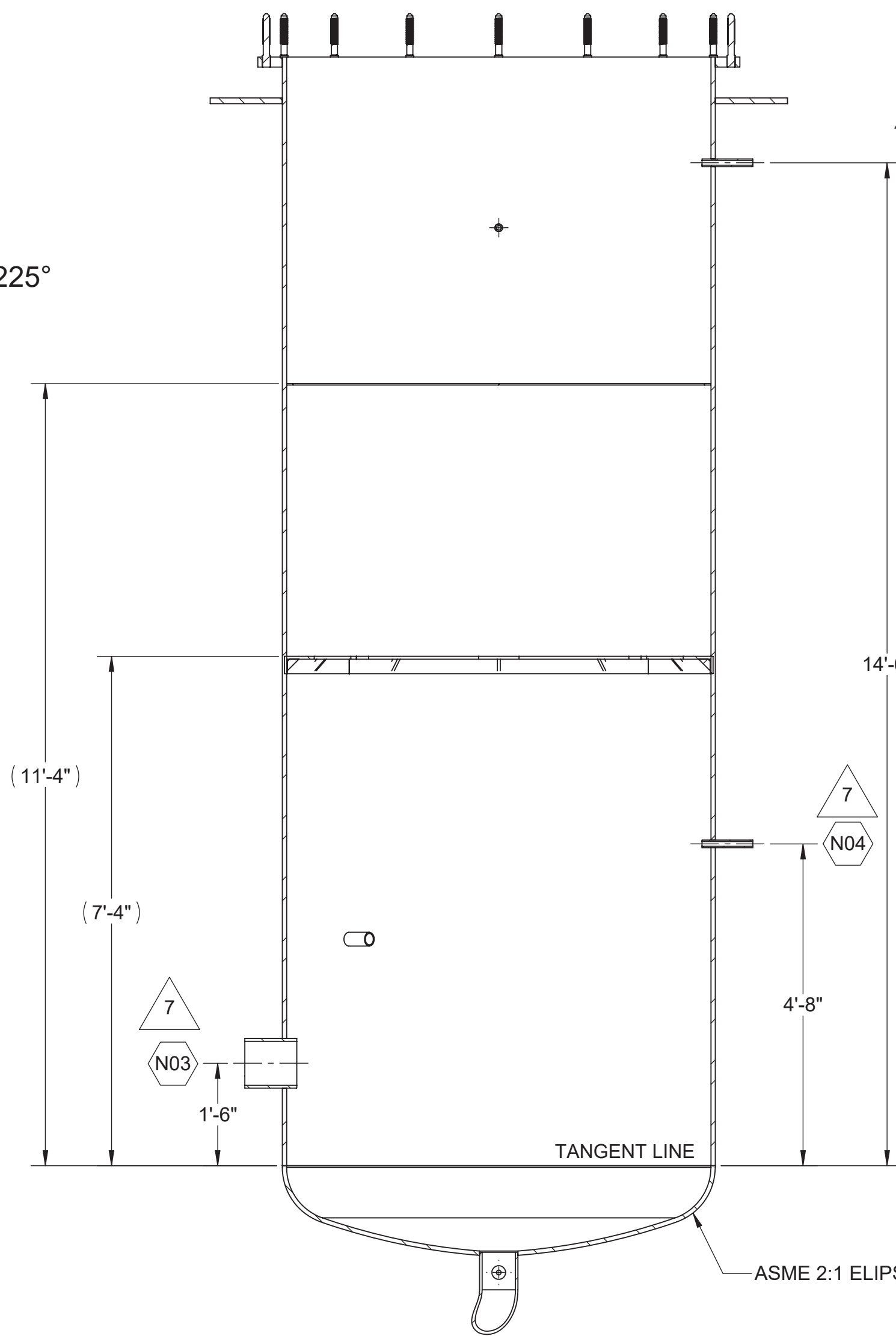
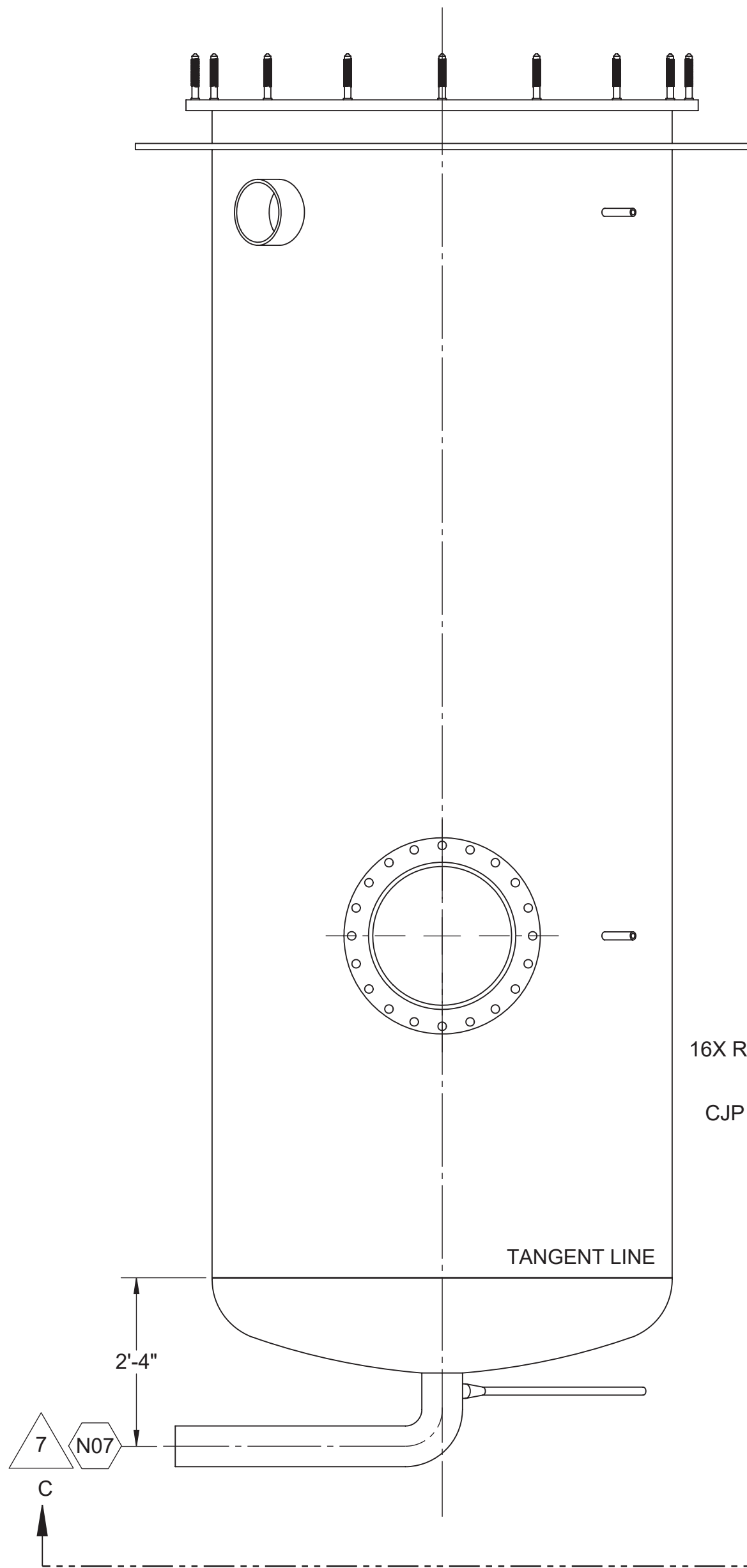
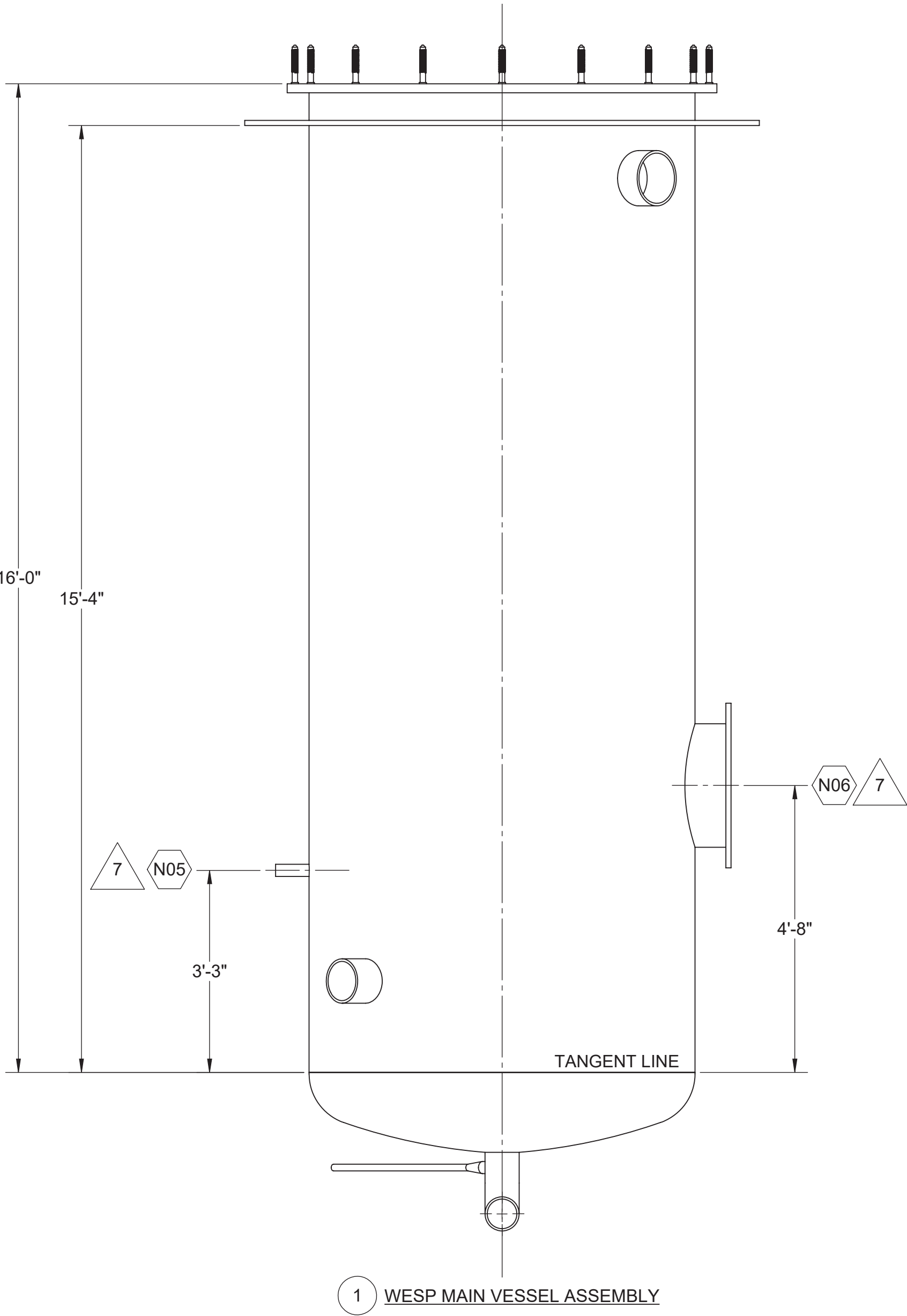
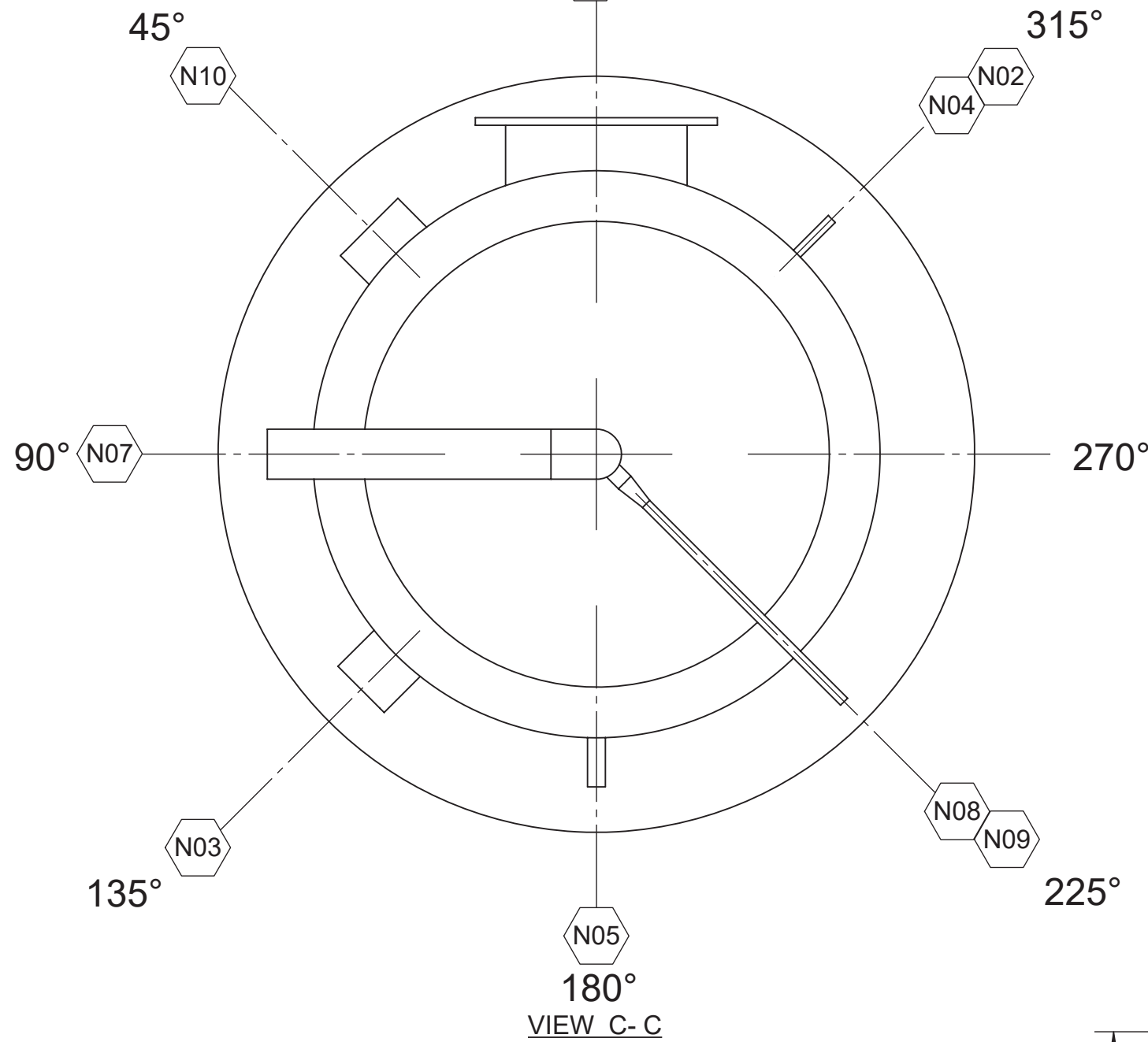
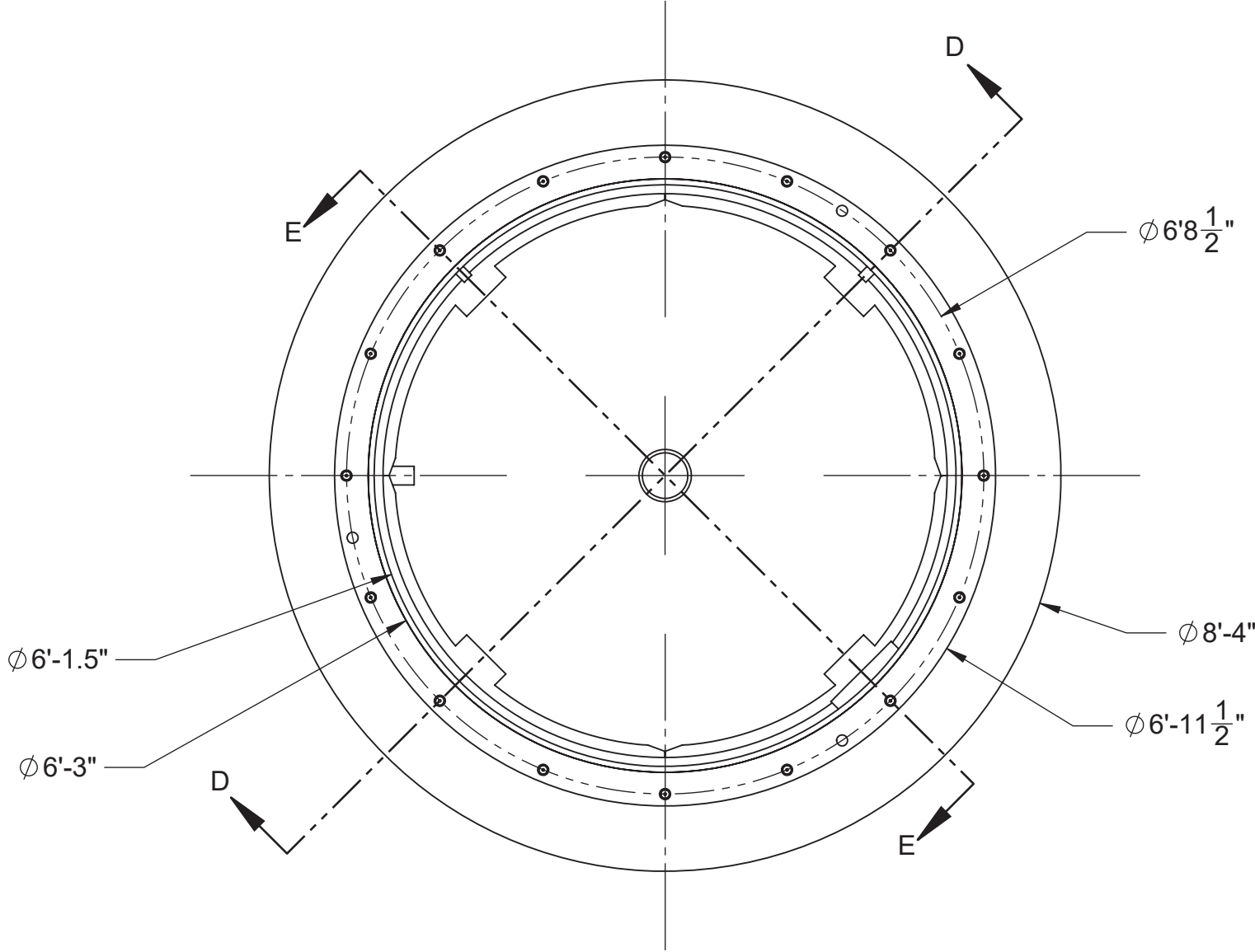
C

B

A


NOZZLE SCHEDULE				
NOZZLE	SIZE	SERVICE/REMARKS	SCH.	"Z" DIM.
N02	1"	PRESSURE TRANSMITTER 1	160	18'-8"
N03	8"	OFF GAS INLET	80	5'-8"
N04	1"	PRESSURE TRANSMITTER 2	160	8'-10"
N05	2"	FLUSH WATER LOWER	80	7'-5"
N06	24"	VESSEL INSPECTION PORT	40	8'-10"
N07	6"	VESSEL DRAIN	80	1'-11"
N08	1"	LEVEL TRANSMITTER 1	160	17'-9"
N09	1"	LEVEL TRANSMITTER 2	80	2'-8"
N10	10"	OFF GAS OUTLET	NA	18'-8"

NOTES:  
FOR NOTES, DRAWING INDEX, REFERENCE DRAWINGS AND PART LISTS,  
SEE 24590-HLW-MV-HOP-00004001.



DO NOT SCALE DRAWING	
THIRD ANGLE PROJECTION	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES UNLESS SPECIFIED	
NO TOLERANCES ARE APPLIED TO DIMENSIONS UNLESS NOTED	
WEIGHT 18161.83 LBS	
SUPPLIER DWG NO.	

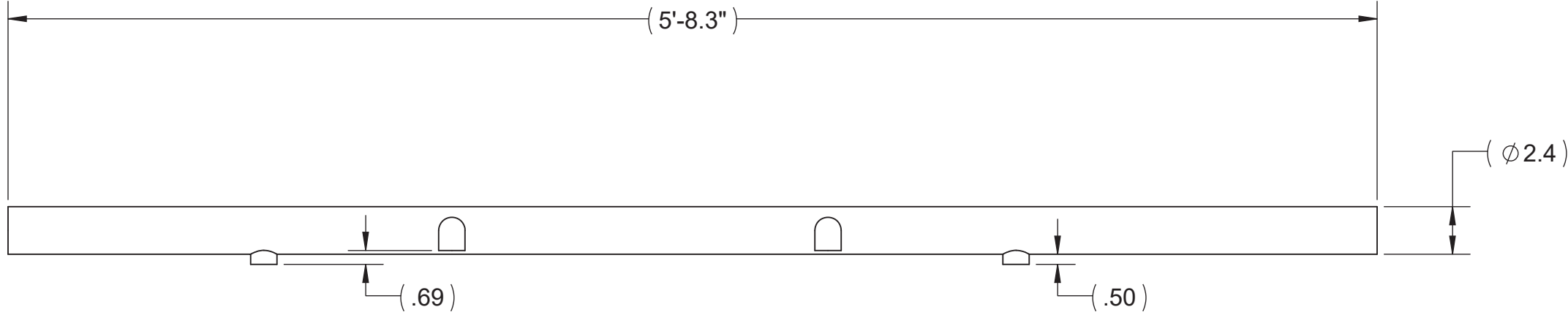
ISSUE STAMP	
ORIGINATOR	B. SHOBE
CHECKER	K. BAILEY
REVIEWER	J. PATTERSON
APPROVER	J. MAUSS
CONTENT APPLICABLE TO ALARA?	<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO
ADR NO. N/A	REV: N/A

Q	A	ISSUED FOR PROPOSAL		BMS	KMB	JEP	JLM	SEE STAMPS	
	REV	DESCRIPTION		ORG	CHKD	RVWD	APVD	DATE	
REVISION HISTORY									
QUALITY DESIGNATOR									
PROJECT No.		24590		<div></div> <div>RIVER PROTECTION PROJECT WASTE TREATMENT PLANT 450 HILLS STREET RICHLAND, WA 99354</div>					
SITE		HANFORD							
AREA		200E							
BUILDING No.		30 (HLW)							
BY		DATE		CONTRACT No: DE-AC27-01RV14136      WTP SUBCONTRACT No:					
B. SHOBE				<div>HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY</div>					
K. BAILEY									
J. PATTERSON									
J. MAUSS									
O ALARA? <input checked="" type="checkbox"/> YES <input type="checkbox"/> NO									
REV: N/A									
SCALE:		1:20		24590-HLW-MV-HOP-00004002				REV A	SHT 2 OF 10

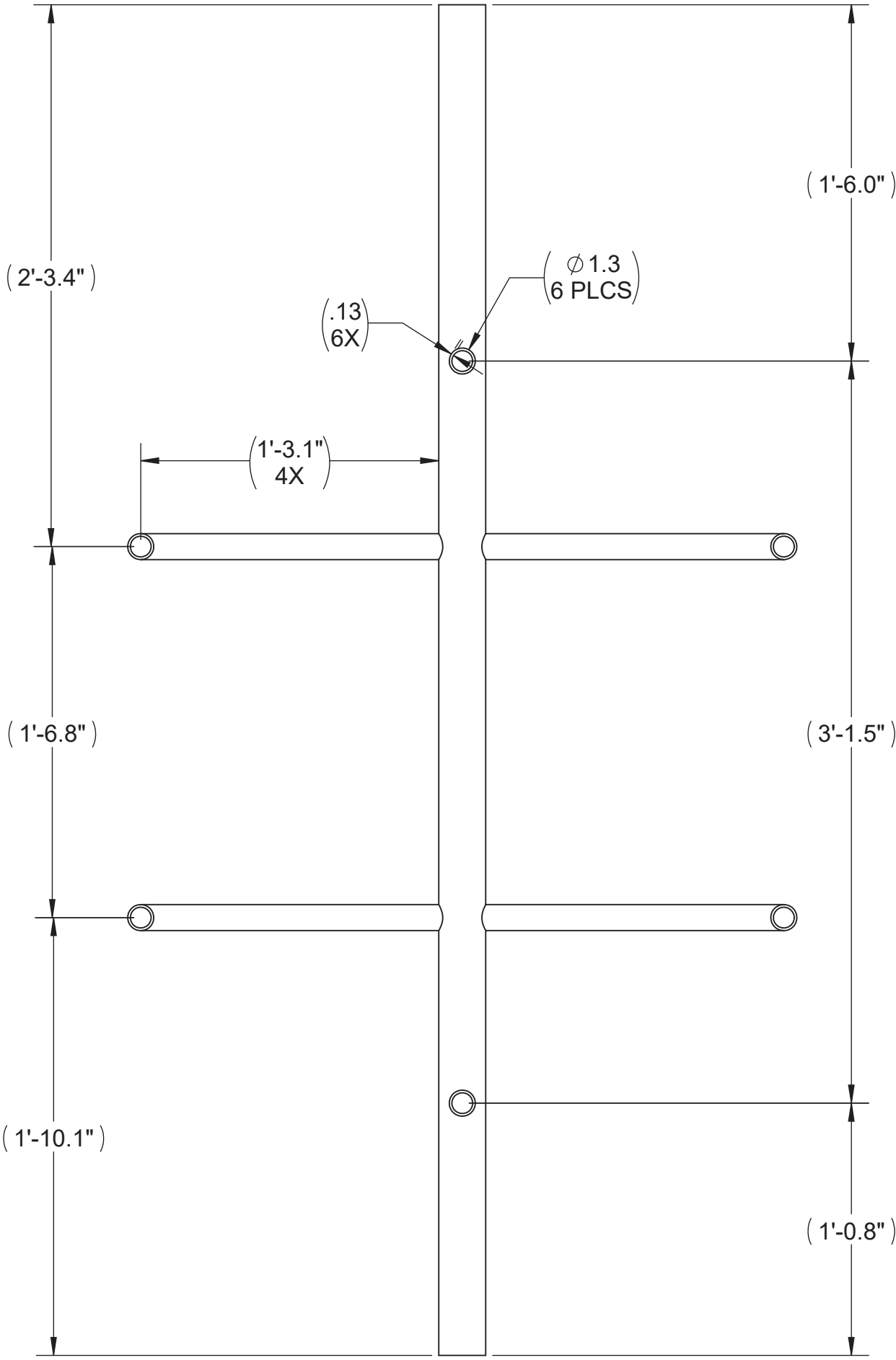




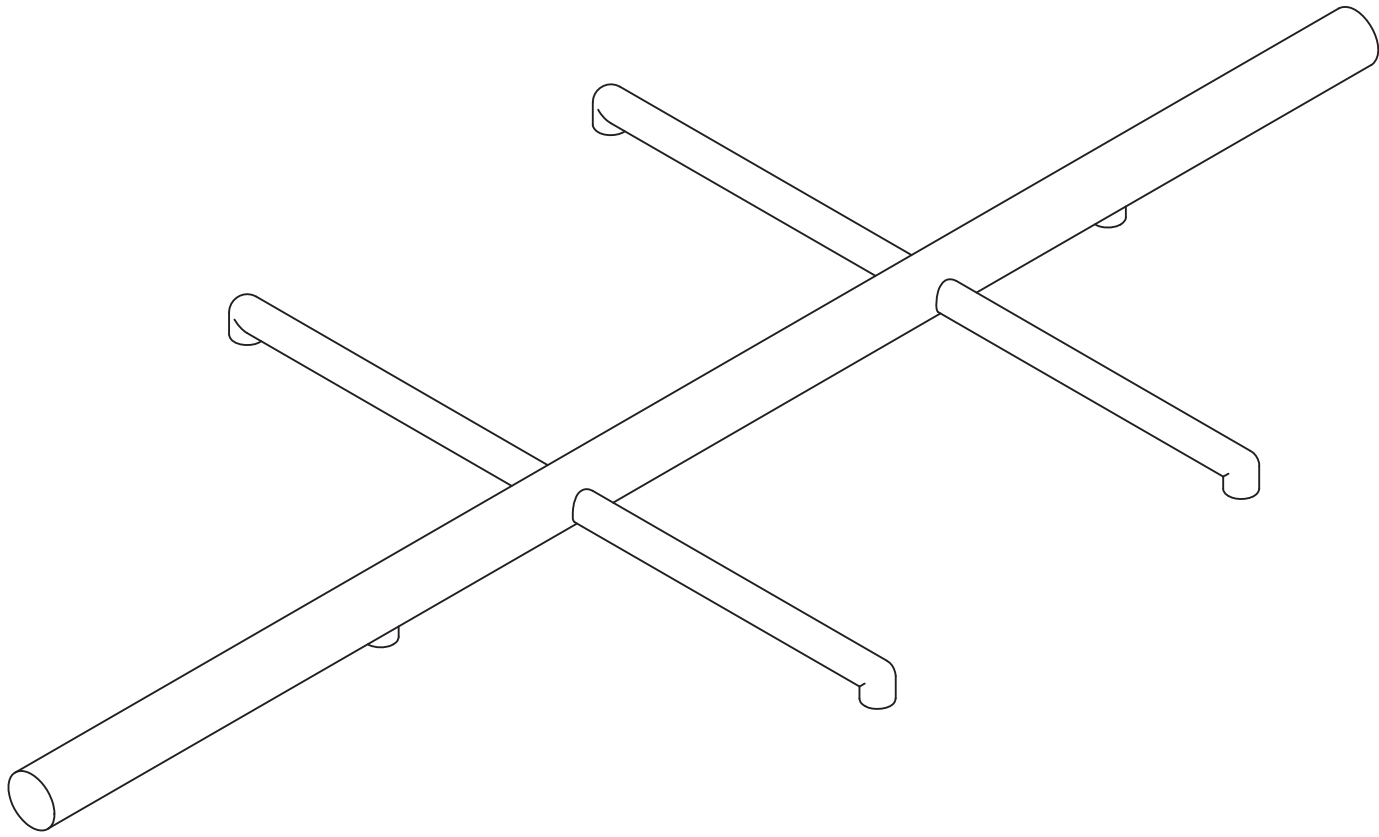
NOTES:  
FOR NOTES, DRAWING INDEX, REFERENCE  
DRAWINGS AND PART LISTS, SEE  
24590-HLW-MV-HOP-00004001.



SIDE VIEW




TOP VIEW



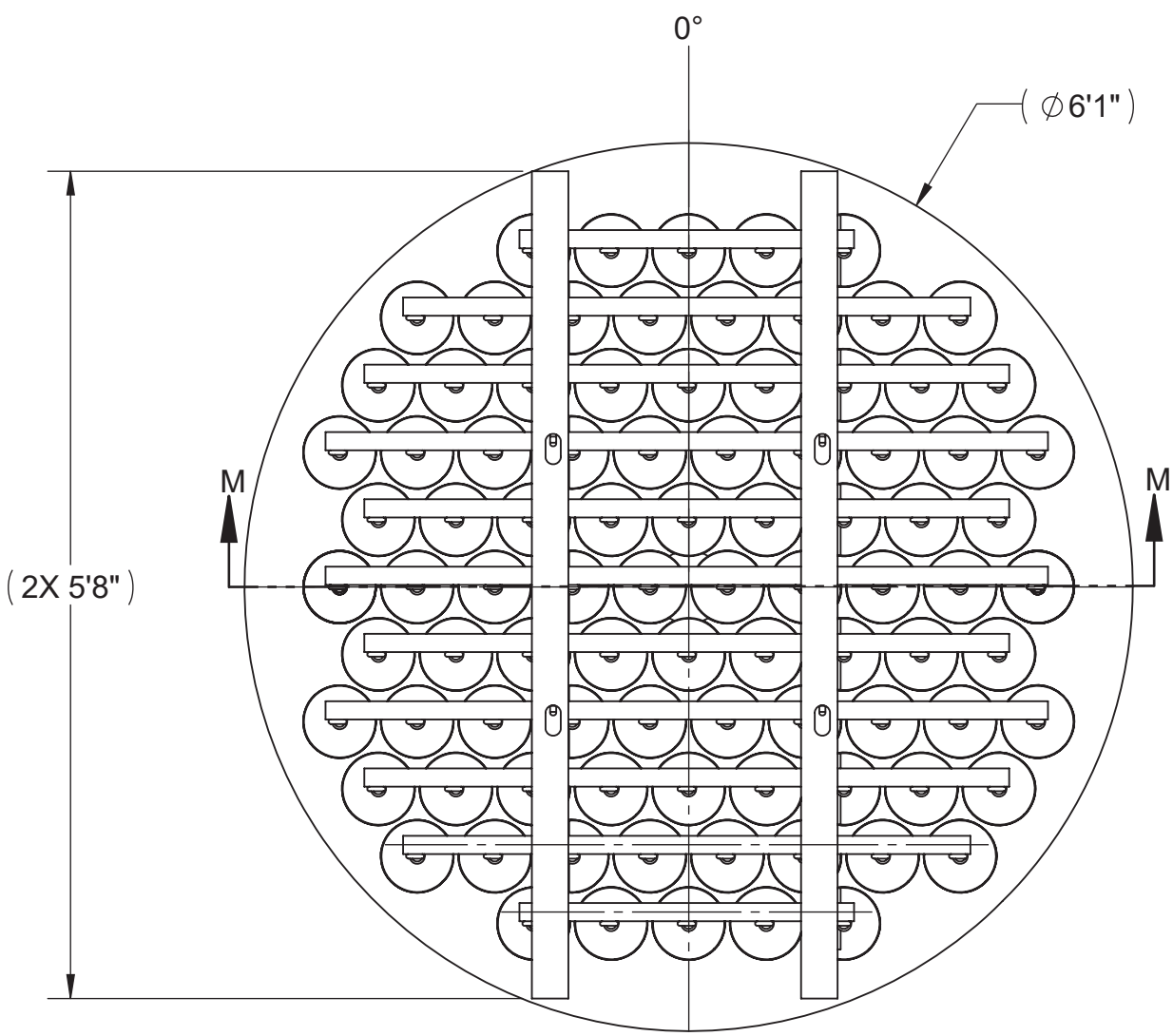
ISOMETRIC VIEW  
(NO SCALE)

12 WESP INTERNALS LOWER FLUSH WATER HEADER

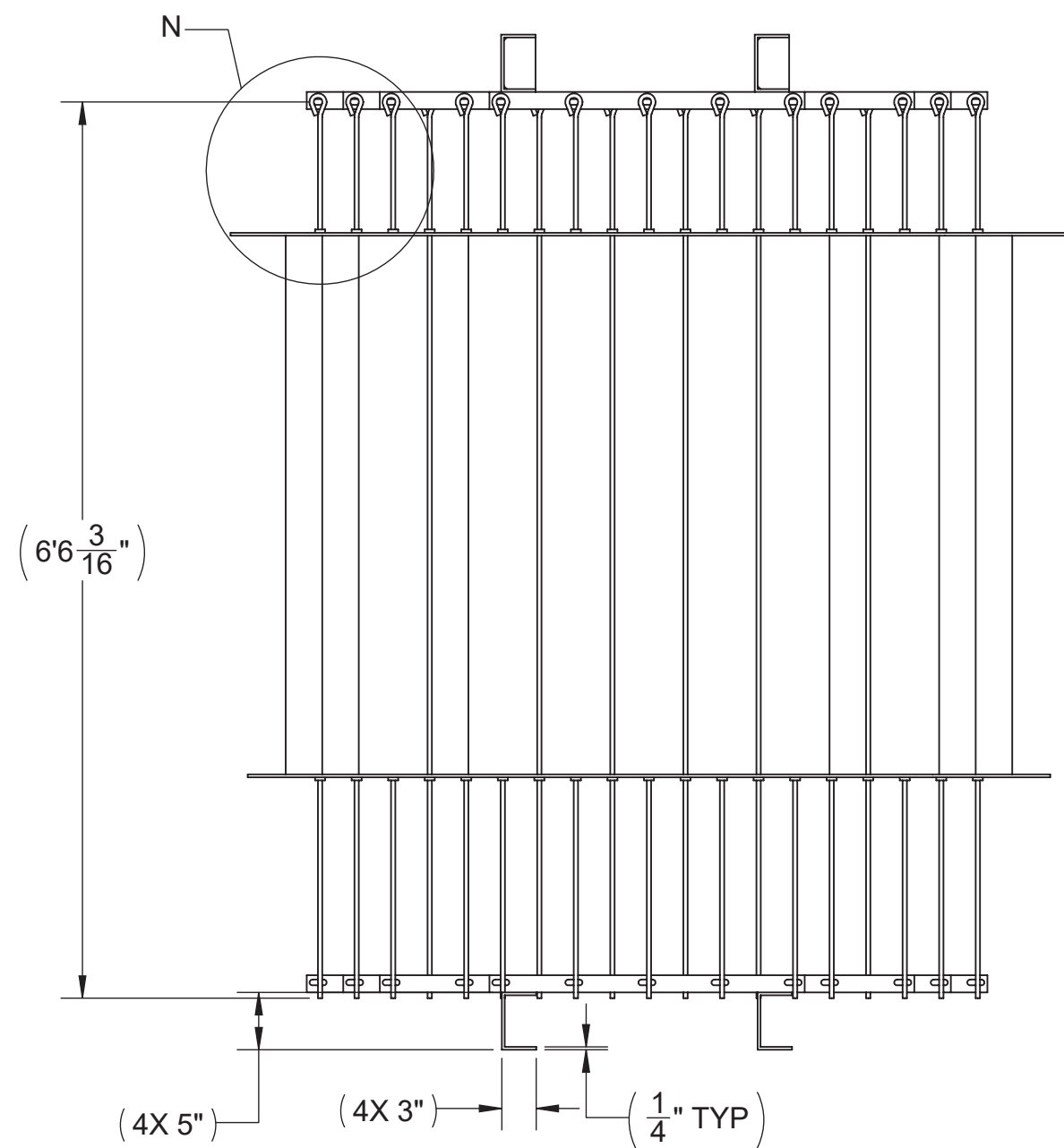
Q	A	ISSUED FOR PROPOSAL				KMB	BMS	JEP	JLM	see stamp
	REV	DESCRIPTION				ORG	CHKD	RVWD	APVD	DATE
REVISION HISTORY										
QUALITY DESIGNATOR										
PROJECT No.		24590		<div></div> <div>RIVER PROTECTION PROJECT WASTE TREATMENT PLANT 450 HILLS STREET RICHLAND, WA 99354</div>						
SITE		HANFORD								
AREA		200E								
BUILDING No.		30 (HLW)								
BY		DATE		CONTRACT No: DE-AC27-01RV14136      WTP SUBCONTRACT No:						
K. BAILEY				<div>HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY</div>						
B. SHOBE										
J. PATTERSON										
J. MAUSS										
NO ALARA? <input checked="" type="checkbox"/> YES <input type="checkbox"/> NO										
REV: N/A										
SCALE: 1:7		24590-HLW-MV-HOP-00004004						REV A		SHT 4 OF 10



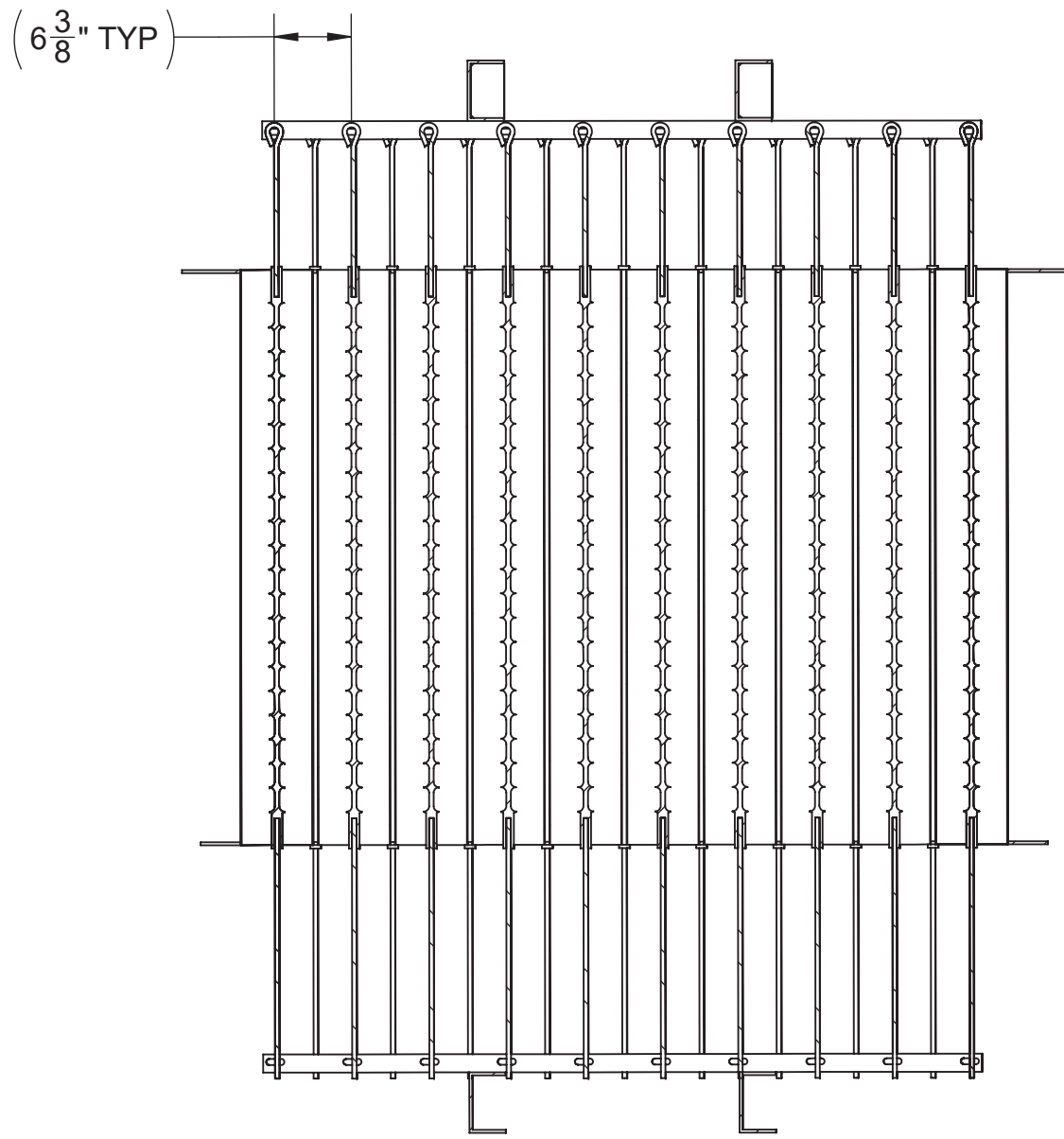
NOTES:  
FOR NOTES, DRAWING INDEX, REFERENCE  
DRAWINGS AND PART/MATERIAL LISTS,  
SEE 24590-HLW-MV-HOP-00004001.



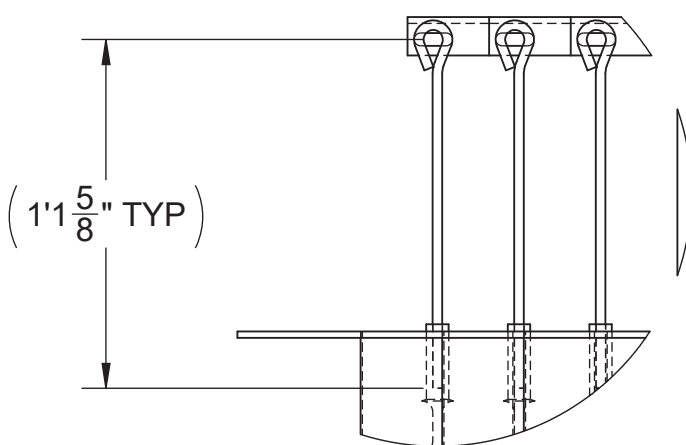
3 WESP COLLECTING TUBE ARRAY ASSEMBLY  
TOP VIEW



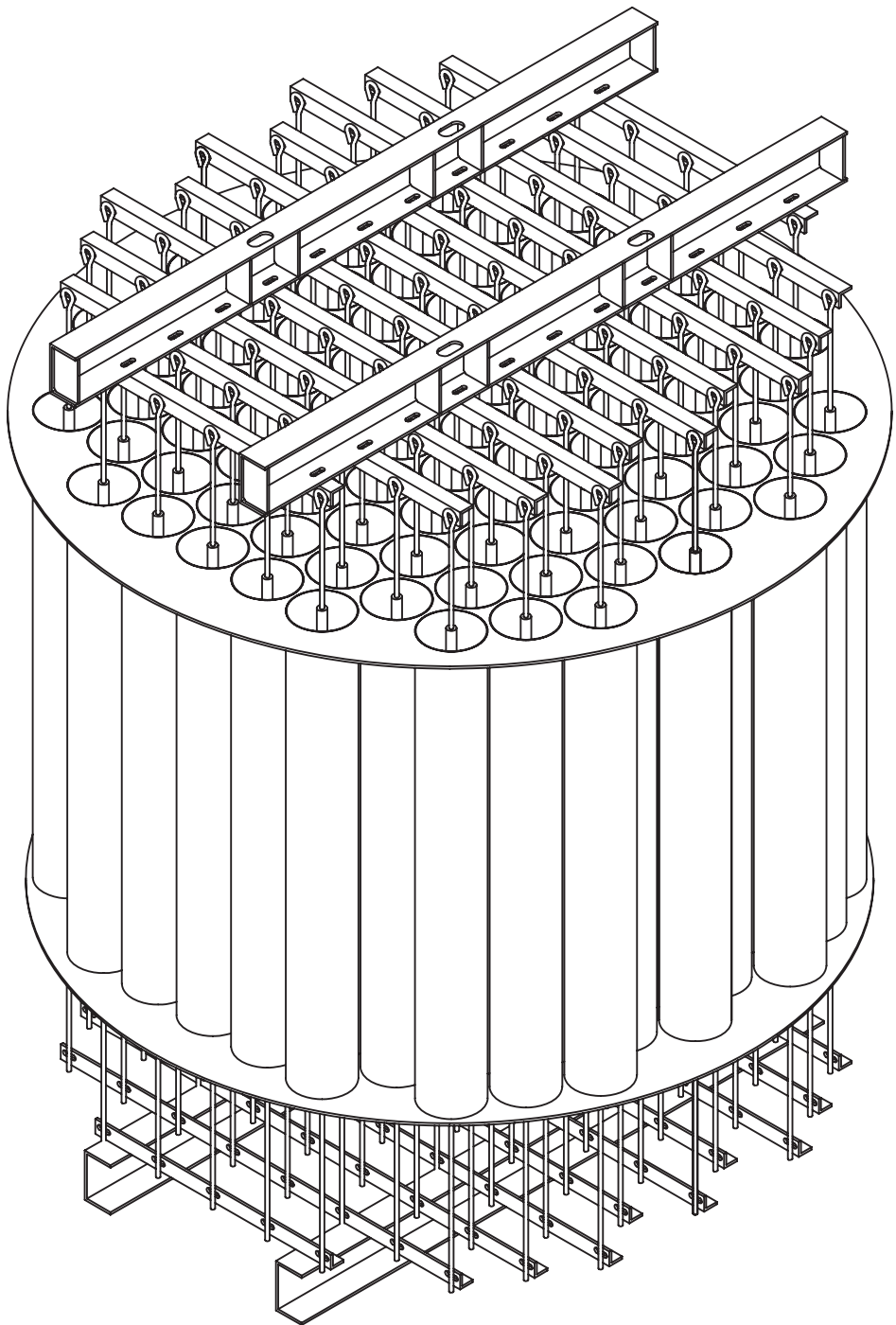
SIDE VIEW




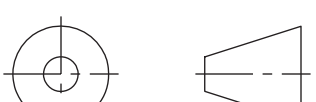
SECTION M-M



DETAIL N  
SCALE 2 : 15



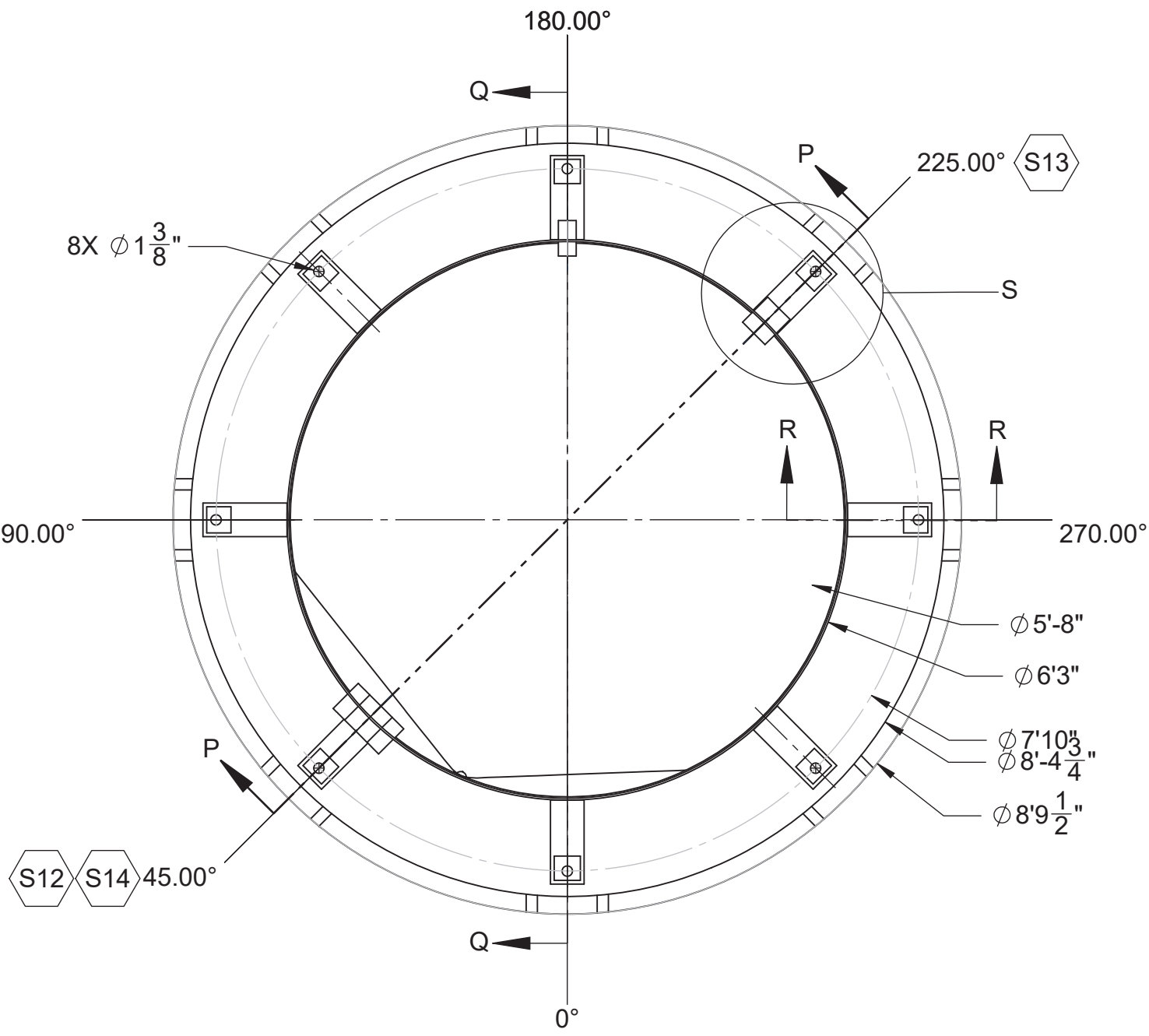
ISOMETRIC VIEW  
(NO SCALE)

		Q	A		ISSUED FOR PROPOSAL		KMB	BMS	JEP	JLM	see stamp
			REV		DESCRIPTION	ORG	CHKD	RVWD	APVD	DATE	
		REVISION HISTORY									
DO NOT SCALE DRAWING		PROJECT No.		24590		<div></div> <div>RIVER PROTECTION PROJECT WASTE TREATMENT PLANT 450 HILLS STREET RICHLAND, WA 99354</div>					
		SITE		HANFORD							
		AREA		200E							
		BUILDING No.		30 (HLW)							
ISSUE STAMP		BY		DATE		CONTRACT No: DE-AC27-01RV14136      WTP SUBCONTRACT No:					
THIRD ANGLE PROJECTION		ORIGINATOR		K. BAILEY		<div>HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY</div>					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CHECKER		B. SHOBE							
TOLERANCES UNLESS SPECIFIED		REVIEWER		J. PATTERSON							
NO TOLERANCES ARE APPLIED TO DIMENSIONS UNLESS NOTED		APPROVER		J. MAUSS							
WEIGHT      18161.85 LBS		CONTENT APPLICABLE TO ALARA?		<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO		SCALE: 1:15      24590-HLW-MV-HOP-00004005      REV A      SHT 5 OF 10					
SUPPLIER DWG NO.		ADR NO.    N/A		REV: N/A							

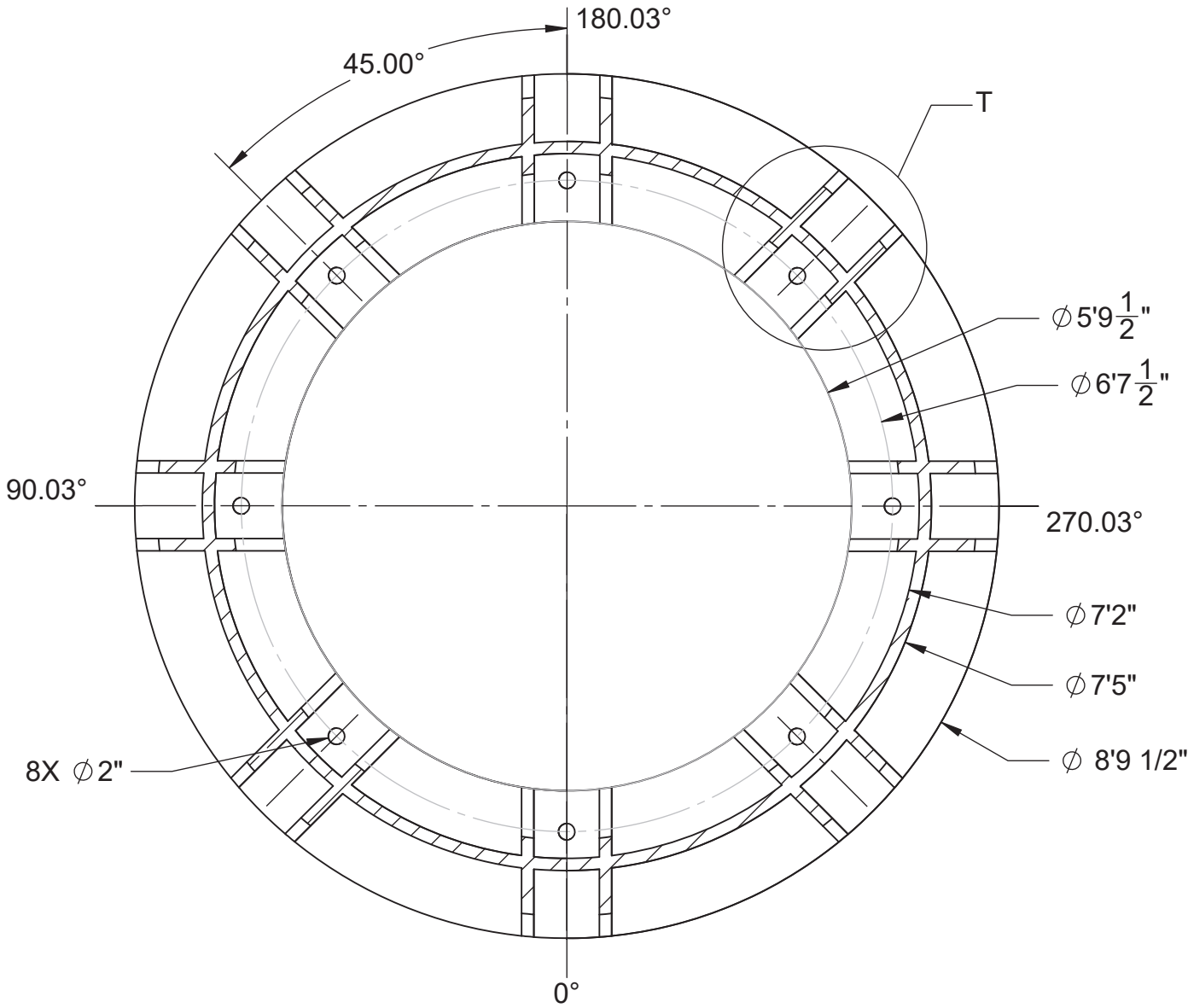
NOZZLE SCHEDULE				
NOZZLE	SIZE	SERVICE/REMARKS	SCH.	"Z" DIM.
S12	-	SKIRT SLEEVE 1	40	1'-11"
S13	-	SKIRT VENT 1	40	3'-5"
S14	-	SKIRT VENT 2	40	3'-5"
S15	-	SKIRT SLEEVE 2	40	2'-8"

NOTES:

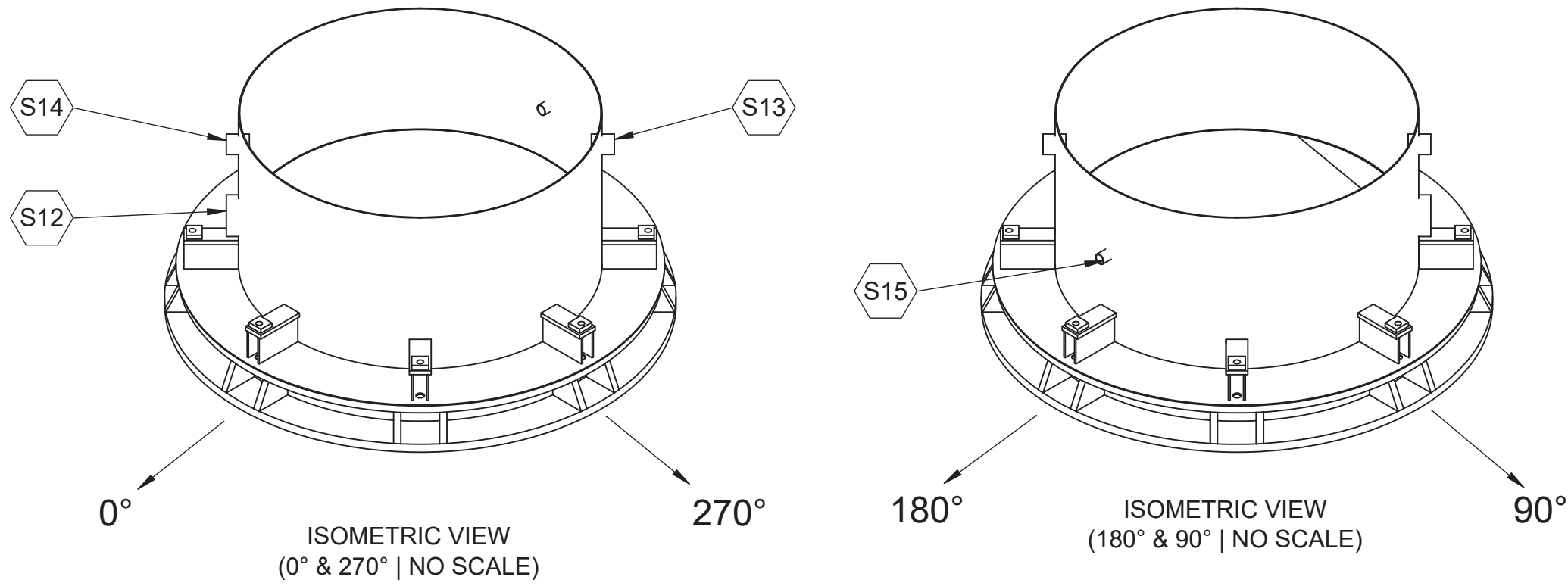
FOR NOTES, DRAWING INDEX, REFERENCE DRAWINGS AND PART/MATERIAL LISTS, SEE 24590-HLW-MV-HOP-00004001.



4 WESP LOWER SKIRT ASSEMBLY  
TOP VIEW

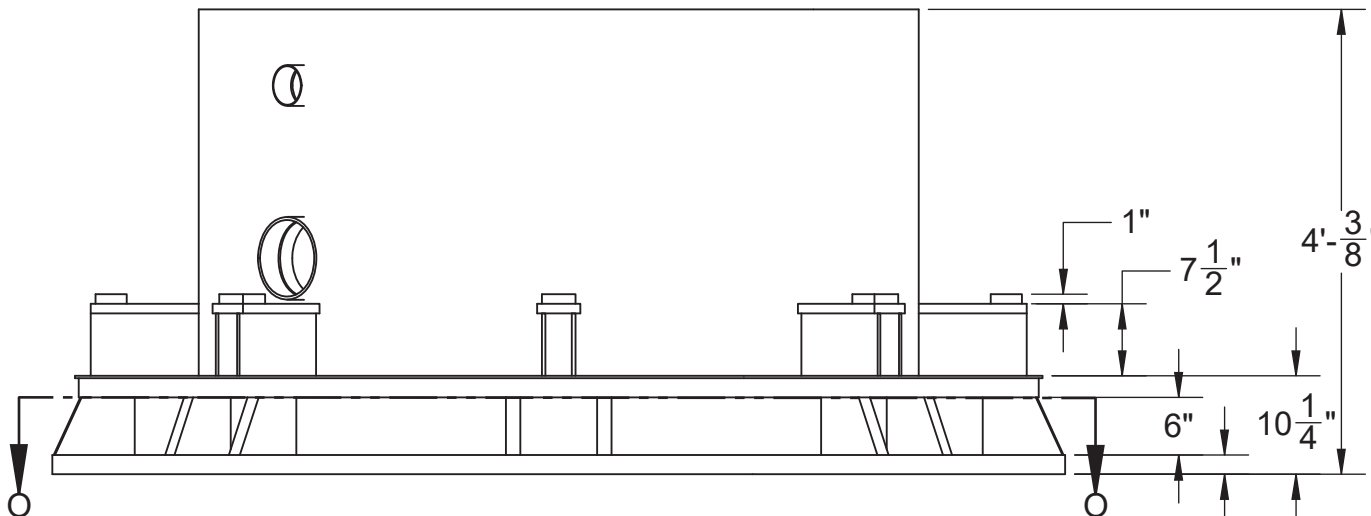


BOTTOM VIEW  
SECTION O-O

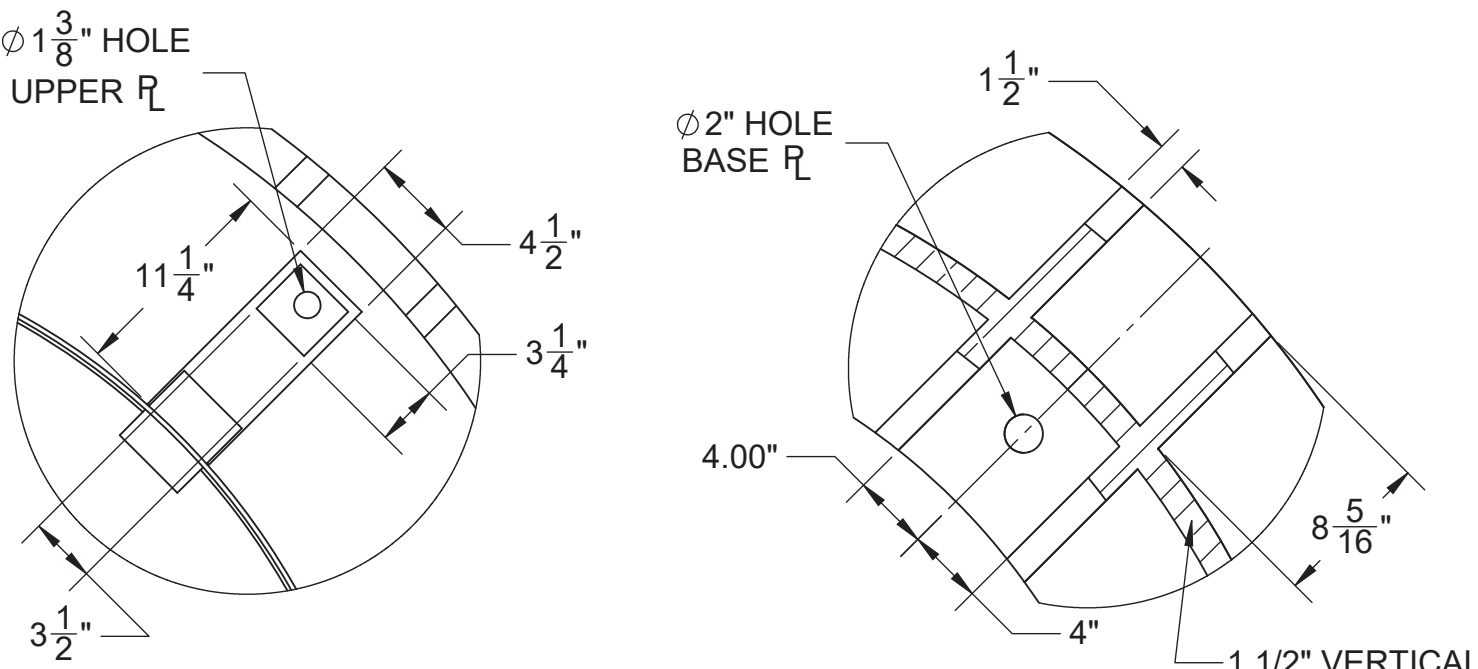


ISOMETRIC VIEW  
(0° & 270° | NO SCALE)

ISOMETRIC VIEW  
(180° & 90° | NO SCALE)

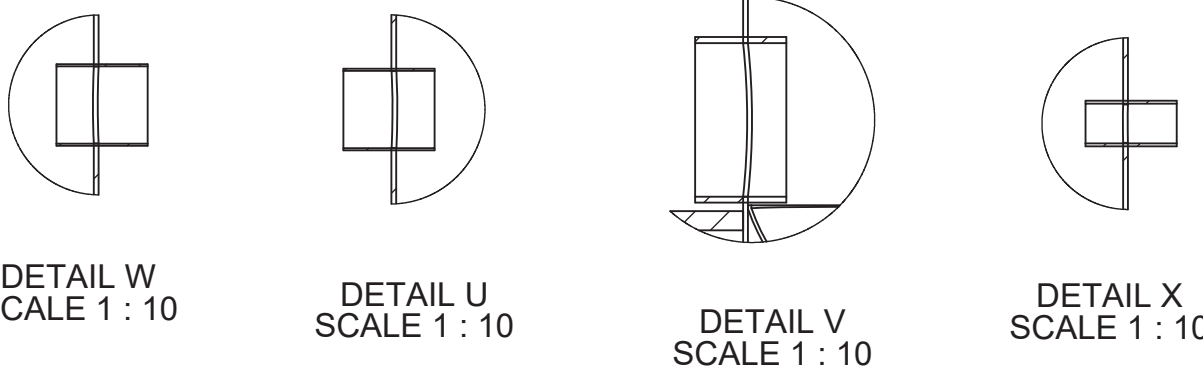


SIDE VIEW



DETAIL S  
SCALE 1 : 10

DETAIL T  
SCALE 1 : 10

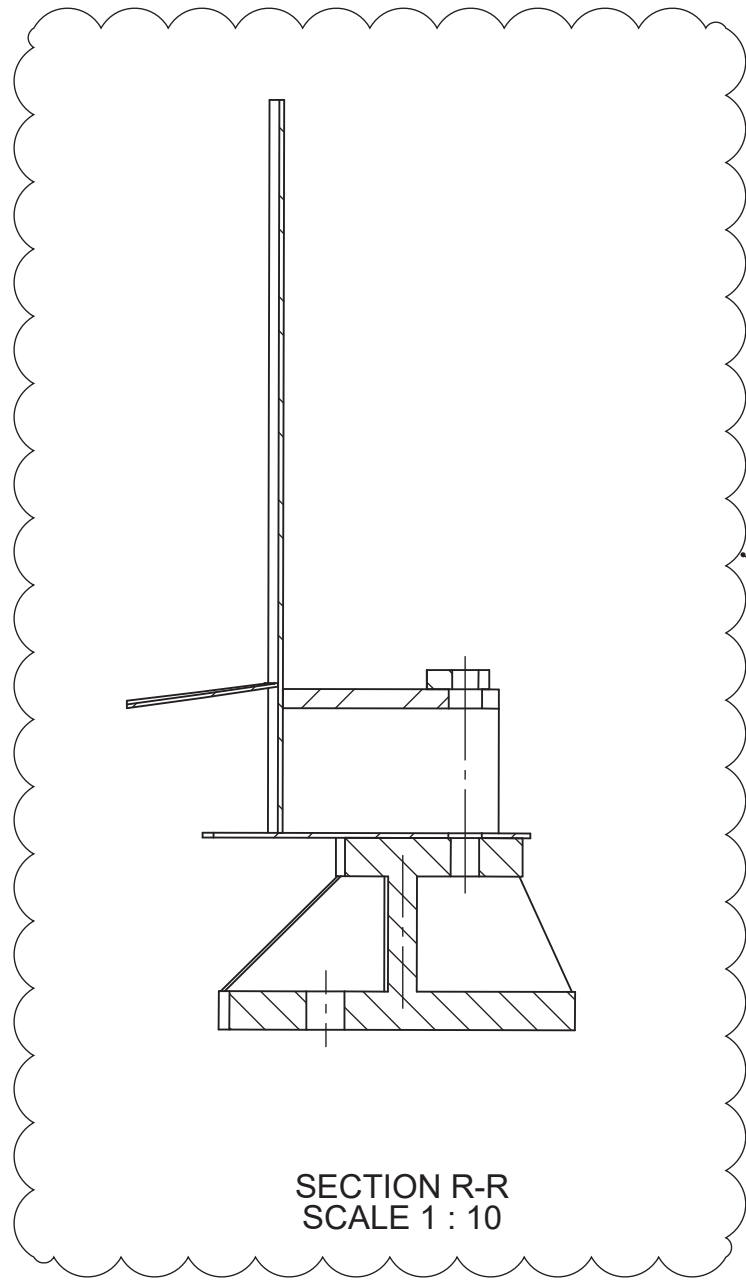


DETAIL W  
SCALE 1 : 10

DETAIL U  
SCALE 1 : 10

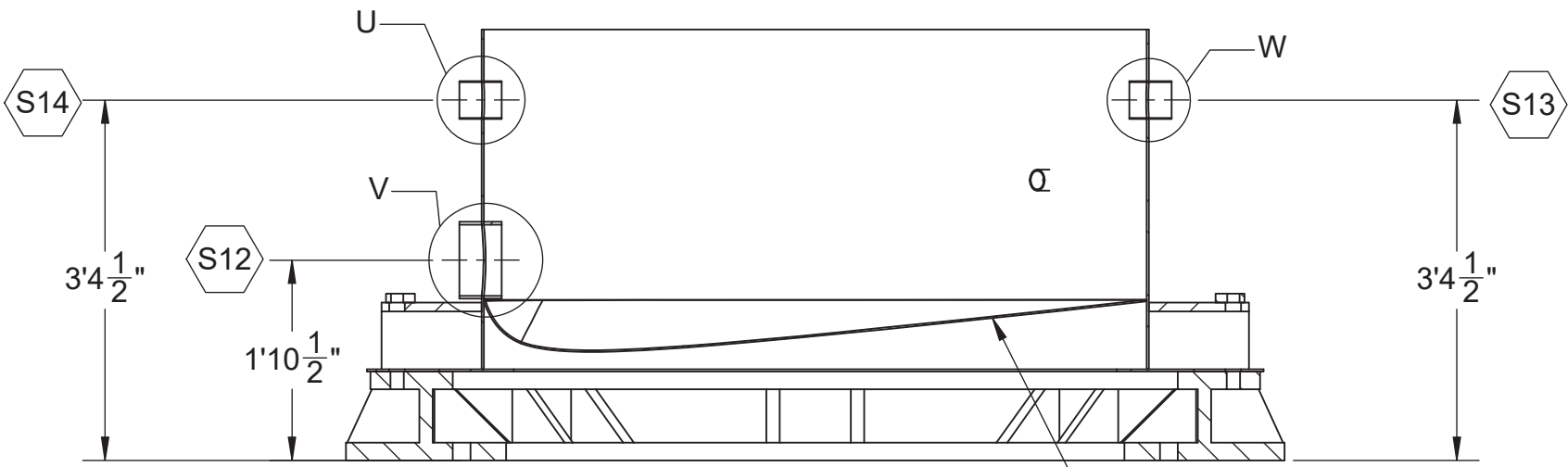
DETAIL V  
SCALE 1 : 10

DETAIL X  
SCALE 1 : 10



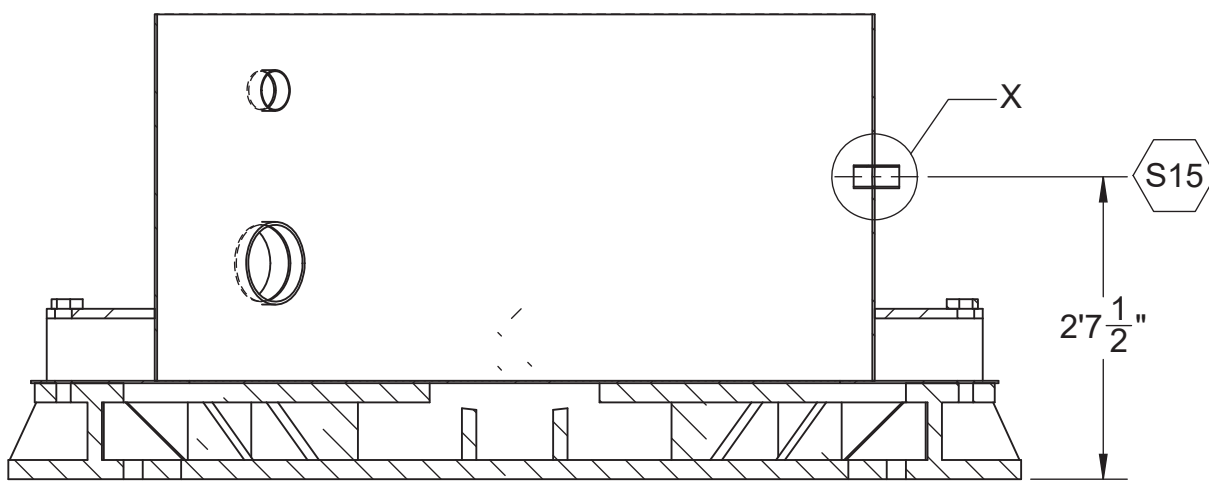
SECTION R-R  
SCALE 1 : 10

HOLD  
SEE NOTE 10 ON  
24590-HLW-MV-HOP-00004001  
10




SECTION P-P

3/16" THICK SS PLATE  
SLOPING TO 1/2" DRAIN HOLE

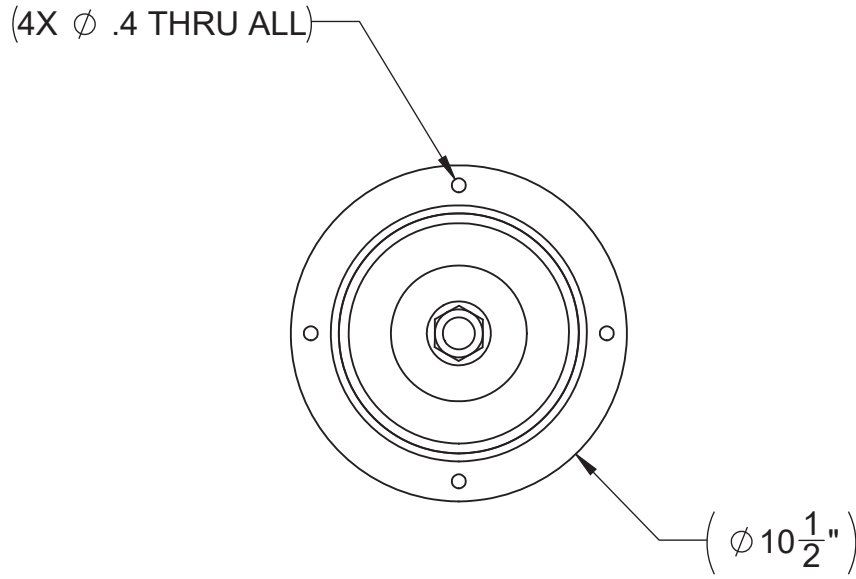


SECTION Q-Q

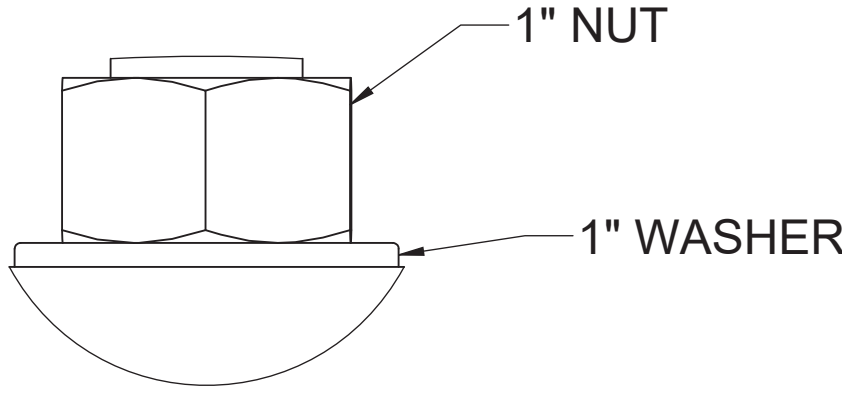
<div>Q</div>	A	ISSUED FOR PROPOSAL				KMB	BMS	JEP	JLM	see stamp
	REV	DESCRIPTION				ORG	CHKD	RVWD	APVD	DATE
REVISION HISTORY										
QUALITY DESIGNATOR										
PROJECT No.		24590		<div></div> <div>RIVER PROTECTION PROJECT WASTE TREATMENT PLANT 450 HILLS STREET RICHLAND, WA 99354</div>						
SITE		HANFORD								
AREA		200E								
BUILDING No.		30 (HLW)								
BY		DATE		CONTRACT No: DE-AC27-01RV14136      WTP SUBCONTRACT No:						
K. BAILEY				<div>HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY</div>						
B. SHOBE										
J. PATTERSON										
J. MAUSS										
TO ALARA? <input checked="" type="checkbox"/> YES <input type="checkbox"/> NO										
REV: N/A										
SCALE:		1:20		24590-HLW-MV-HOP-00004006					REV A	SHT 6 OF 10



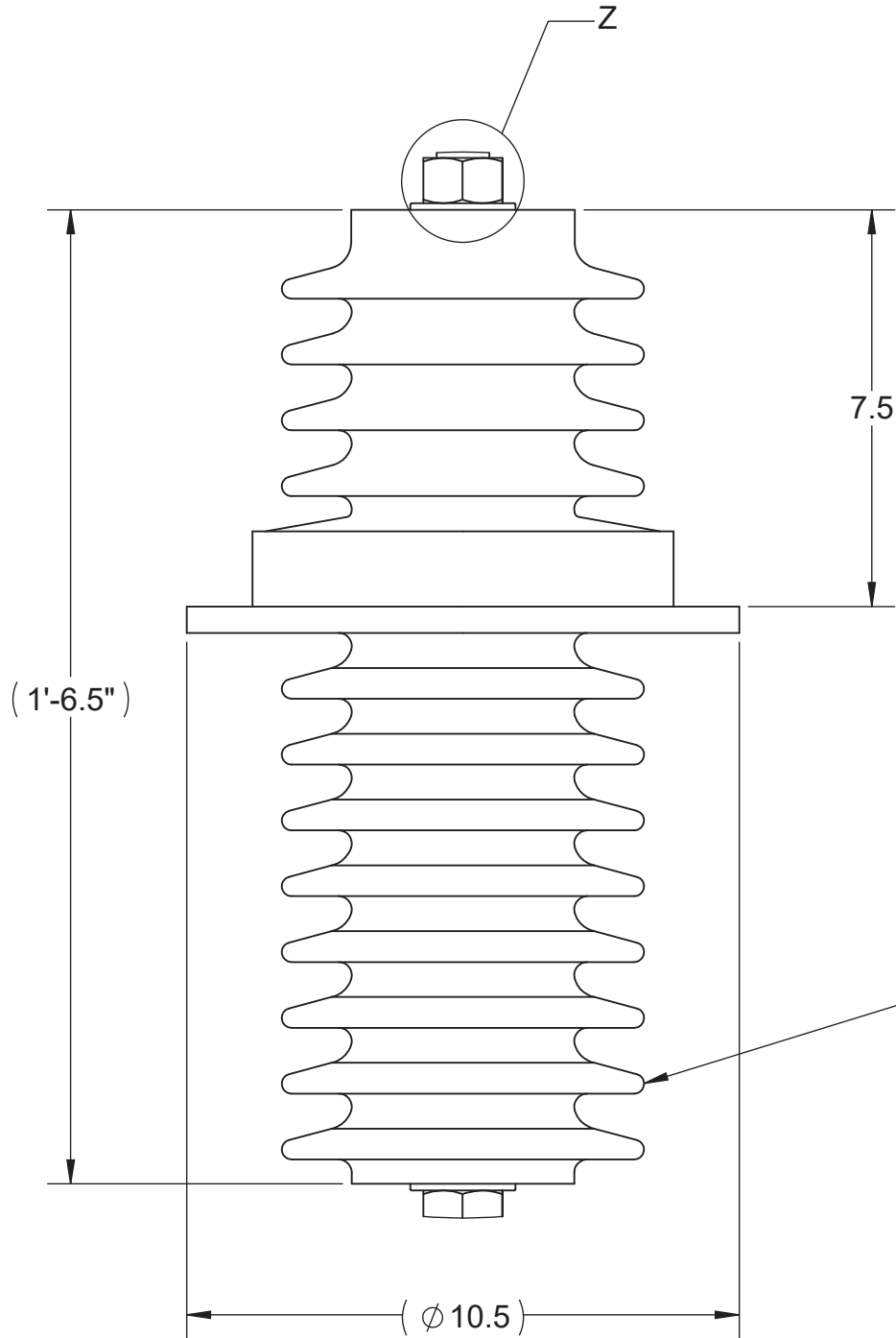
NOTES:  
FOR NOTES, DRAWING INDEX, REFERENCE  
DRAWINGS AND PART LISTS, SEE  
24590-HLW-MV-HOP-00004001.



TOP VIEW

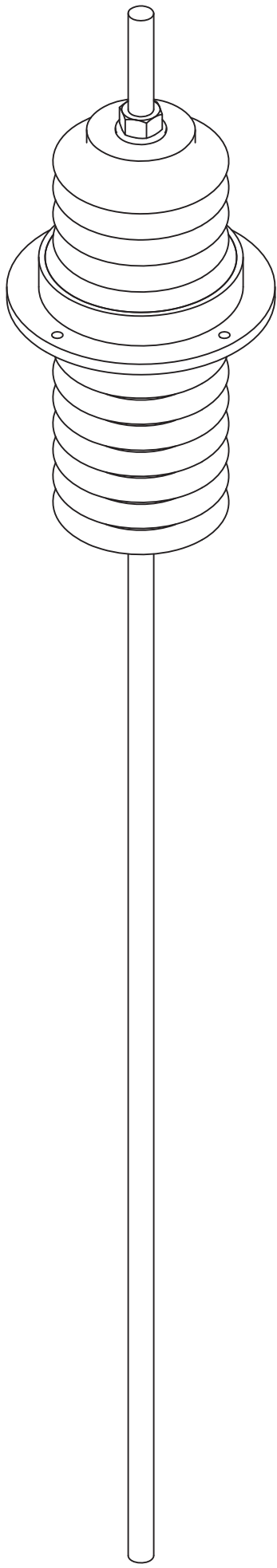


DETAIL Z  
SCALE 1 : 1

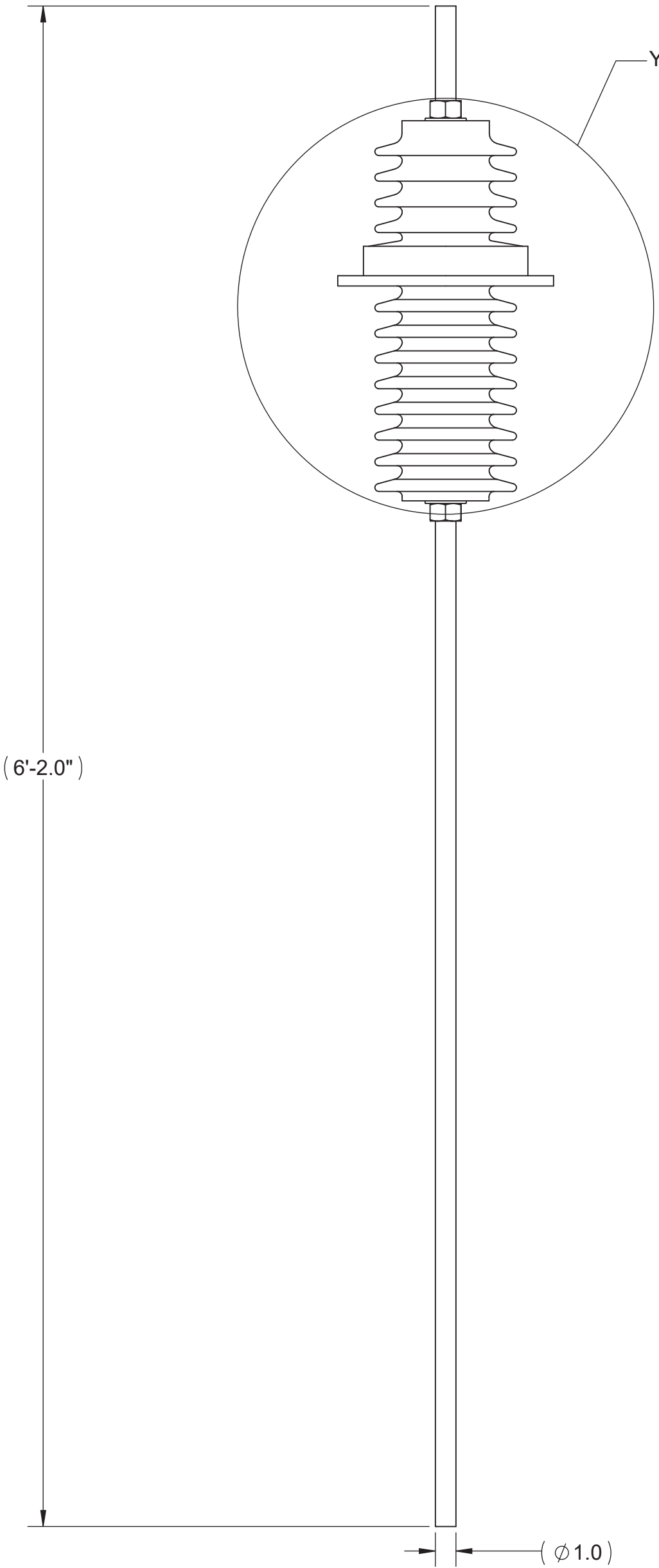


DETAIL Y  
SCALE 2 : 7

INSULATOR FOR THE  
ELECTRODES. THE SELLER  
SHALL BE RESPONSIBLE FOR  
FULL VALIDATION OF THE  
INSULATOR



ISOMETRIC VIEW  
(NO SCALE)

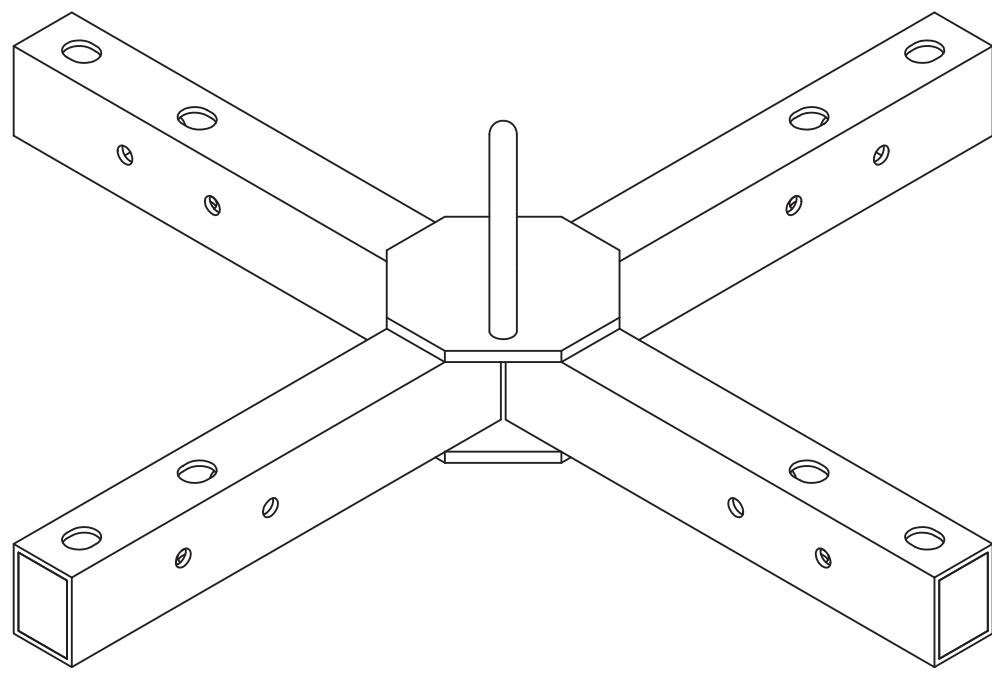
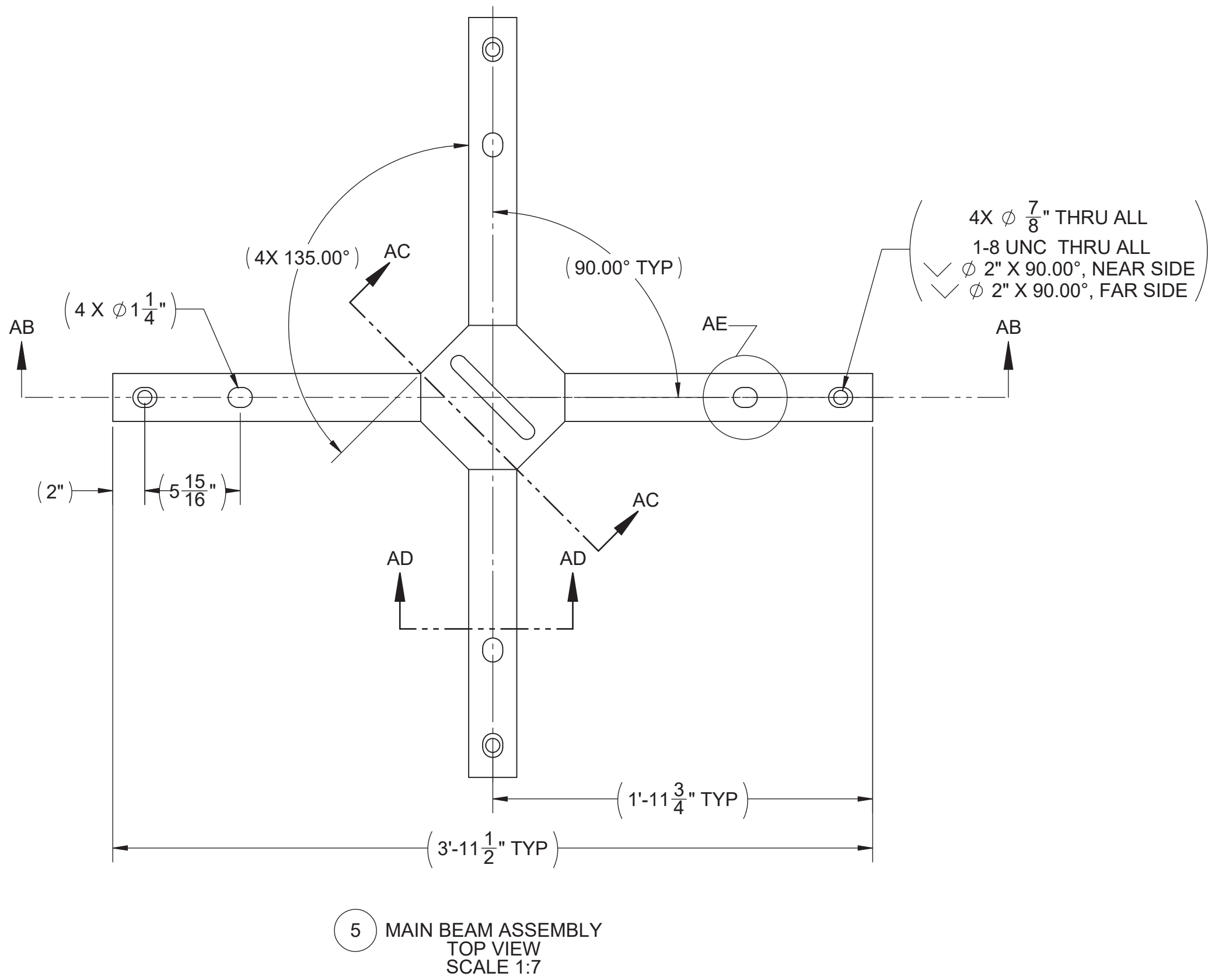


SIDE VIEW

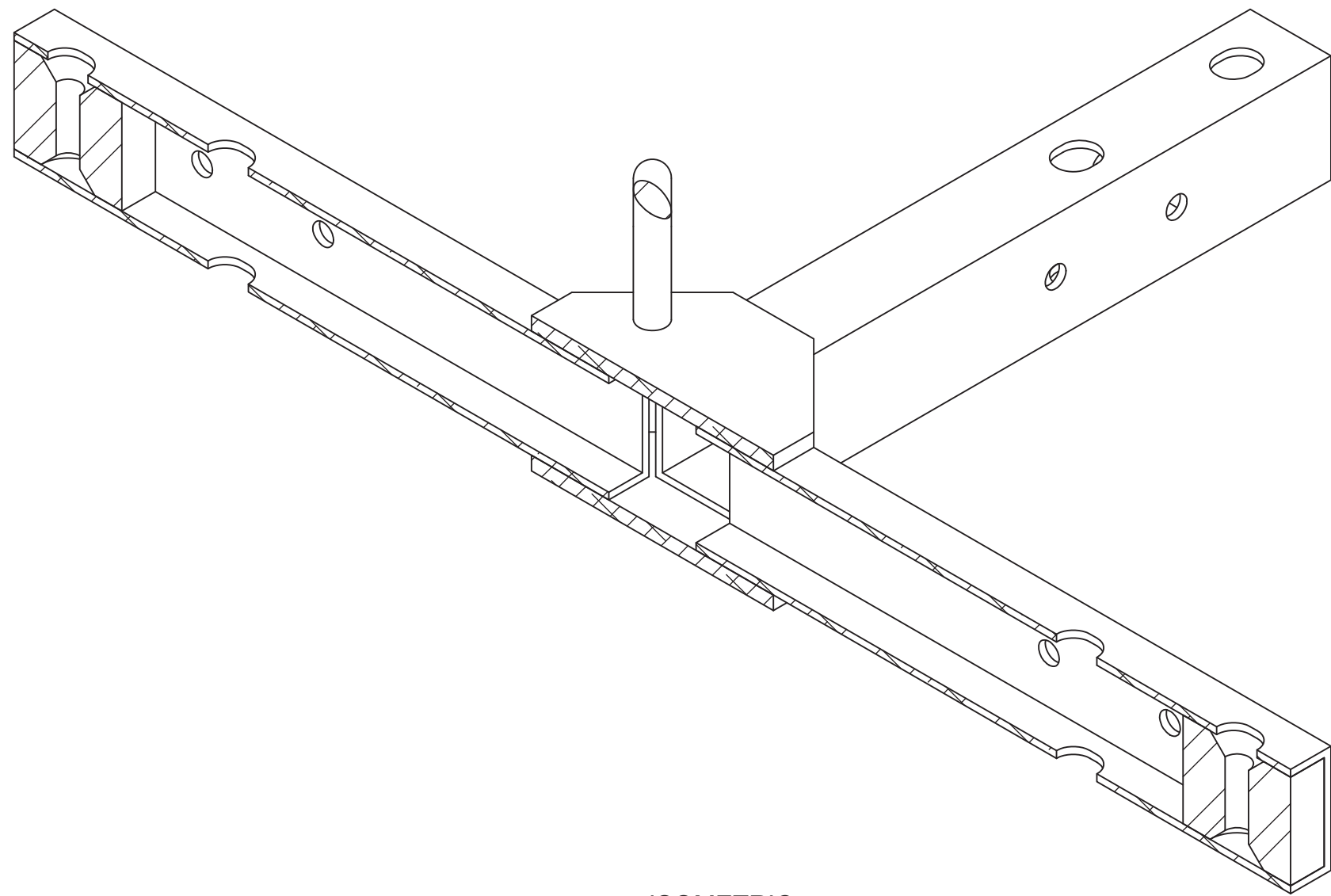
⑥ WESP INSULATOR ASSEMBLY

<div>Q</div>	A	ISSUED FOR PROPOSAL				KMB	BMS	JEP	JLM	see stamp
	REV	DESCRIPTION				ORG	CHKD	RVWD	APVD	DATE
REVISION HISTORY										
QUALITY DESIGNATOR										
PROJECT No.		24590								
SITE		HANFORD								
AREA		200E								
BUILDING No.		30 (HLW)								
BY		DATE		CONTRACT No: DE-AC27-01RV14136      WTP SUBCONTRACT No:						
K. BAILEY		<div><div>BECHTEL</div><div>RIVER PROTECTION PROJECT WASTE TREATMENT PLANT 450 HILLS STREET RICHLAND, WA 99354</div></div> <div>HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY</div>								
B. SHOBE										
J. PATTERSON										
J. MAUSS										
NO ALARA?		<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO								
		REV: N/A								
		SCALE: 1:6		24590-HLW-MV-HOP-00004007					REV A	
									SHT 7 OF 10	

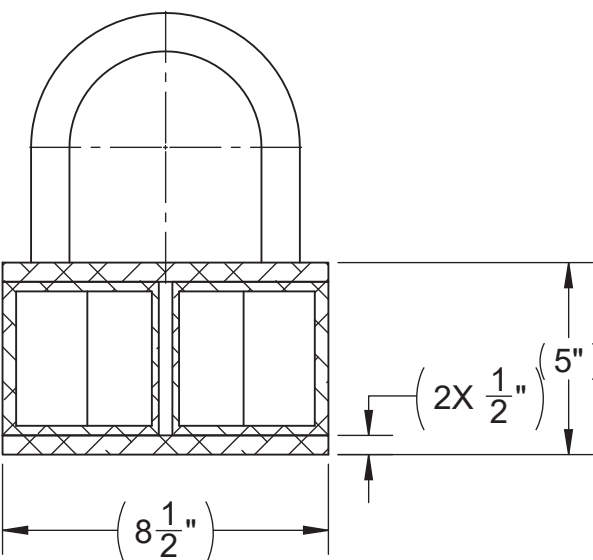
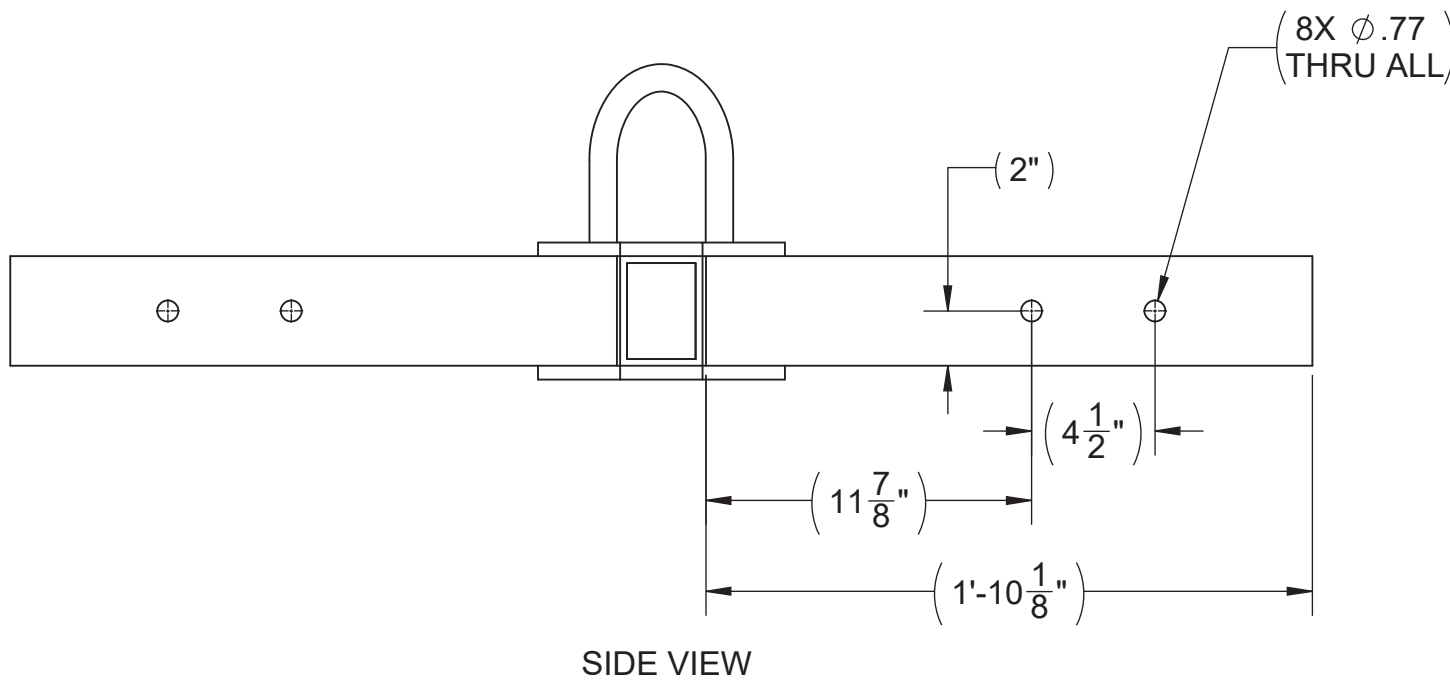
NOTES:  
FOR NOTES, DRAWING INDEX, REFERENCE DRAWINGS AND  
PART/MATERIAL LISTS, SEE 24590-HLW-MV-HOP-00004001.



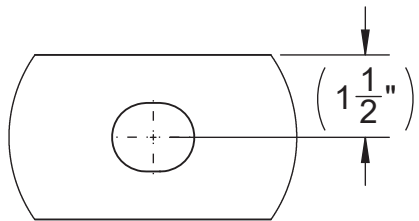
ISOMETRIC VIEW  
(NO SCALE)



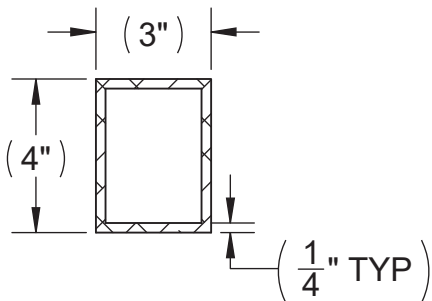
ISOMETRIC  
SECTION AB-AB  
SCALE 1 : 4

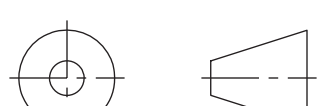



SECTION AC-AC  
SCALE 1 : 5



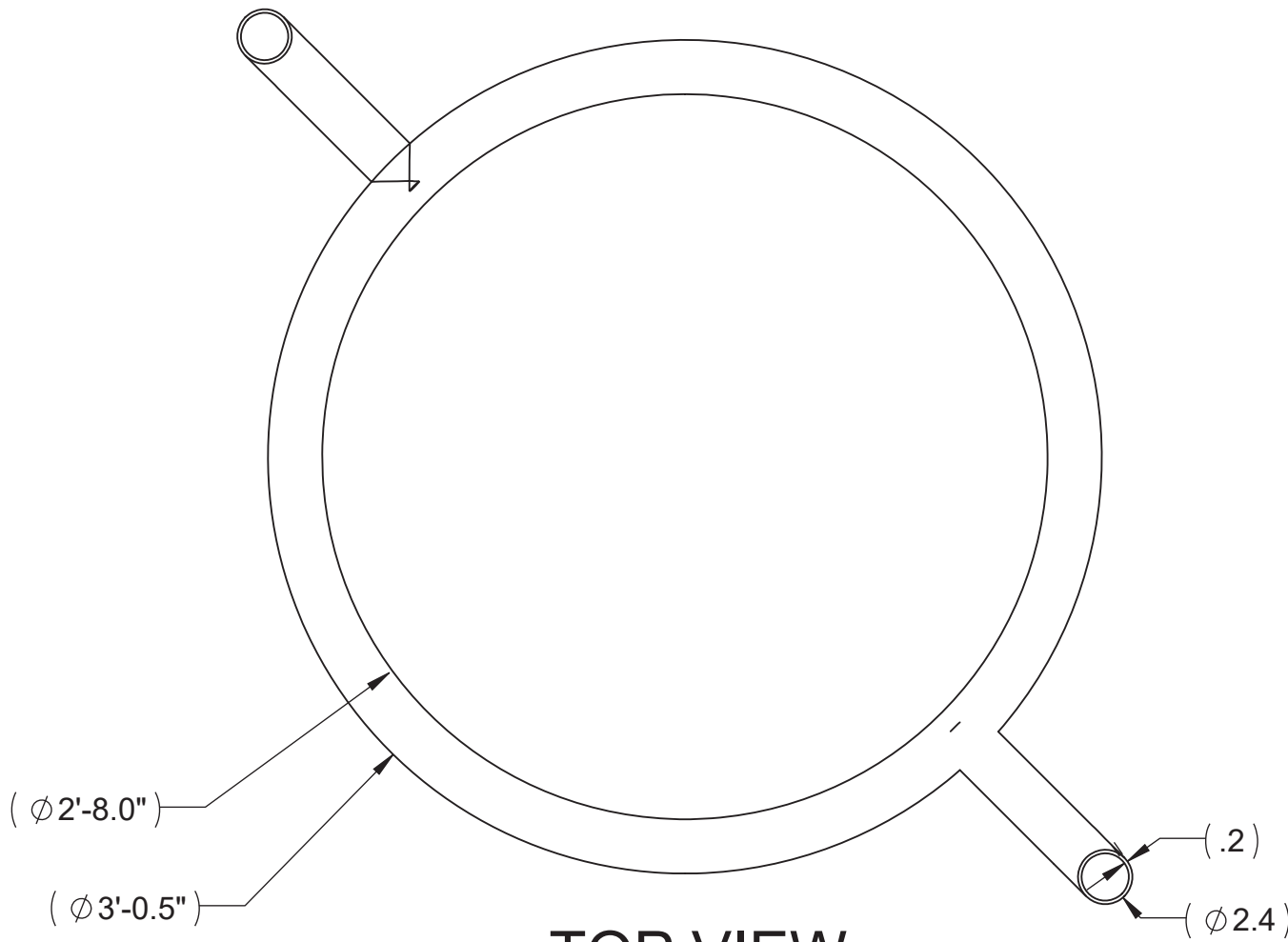
DETAIL AE  
SCALE 2 : 7



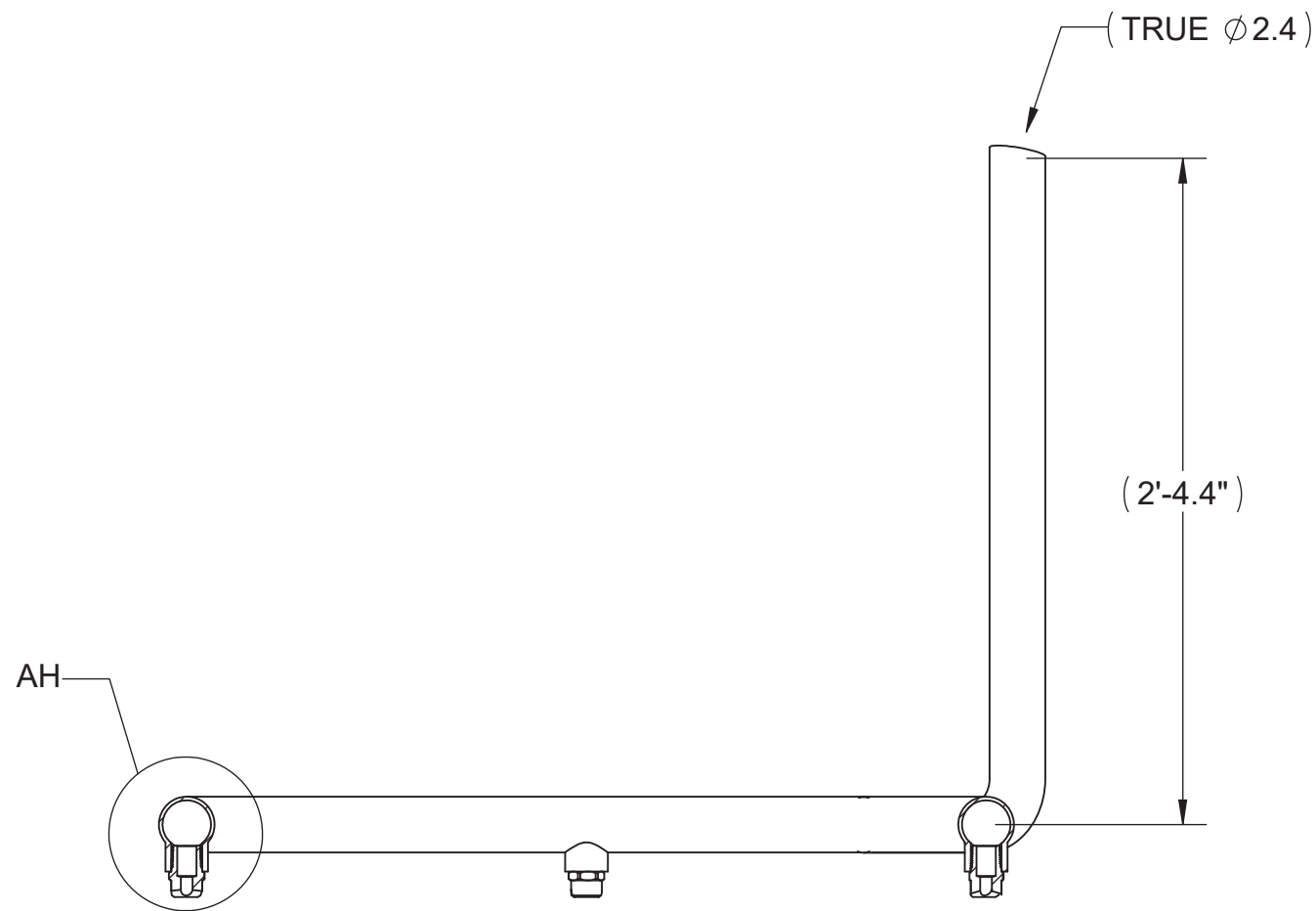
		Q	A	ISSUED FOR PROPOSAL				KMB	BMS	JEP	JLM	see stamp
			REV	DESCRIPTION				ORG	CHKD	RVWD	APVD	DATE
		QUALITY DESIGNATOR										
<div>DO NOT SCALE DRAWING</div> <div></div>		PROJECT No.		24590								
		SITE		HANFORD								
		AREA		200E								
		BUILDING No.		30 (HLW)								
<div>THIRD ANGLE PROJECTION</div> <div>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</div> <div>TOLERANCES UNLESS SPECIFIED</div> <div>NO TOLERANCES ARE APPLIED TO DIMENSIONS UNLESS NOTED</div>		ISSUE STAMP		REVISION HISTORY								
		BY		DATE		<div> RIVER PROTECTION PROJECT WASTE TREATMENT PLANT 450 HILLS STREET RICHLAND, WA 99354</div> <div>CONTRACT No: DE-AC27-01RV14136      WTP SUBCONTRACT No:</div> <div>HLW VITRIFICATION SYSTEM DESIGN PROPOSAL DRAWING WESP FULL ASSEMBLY</div>						
		ORIGINATOR		K. BAILEY								
		CHECKER		B. SHOBE								
		REVIEWER		J. PATTERSON								
		APPROVER		J. MAUSS								
WEIGHT      18161.85 LBS		CONTENT APPLICABLE TO ALARA?		<input checked="" type="checkbox"/> YES <input type="checkbox"/> NO		SCALE: 1:7      24590-HLW-MV-HOP-00004008      REV A      SHT 8 OF 10						
SUPPLIER DWG NO.		ADR NO.    N/A		REV: N/A								



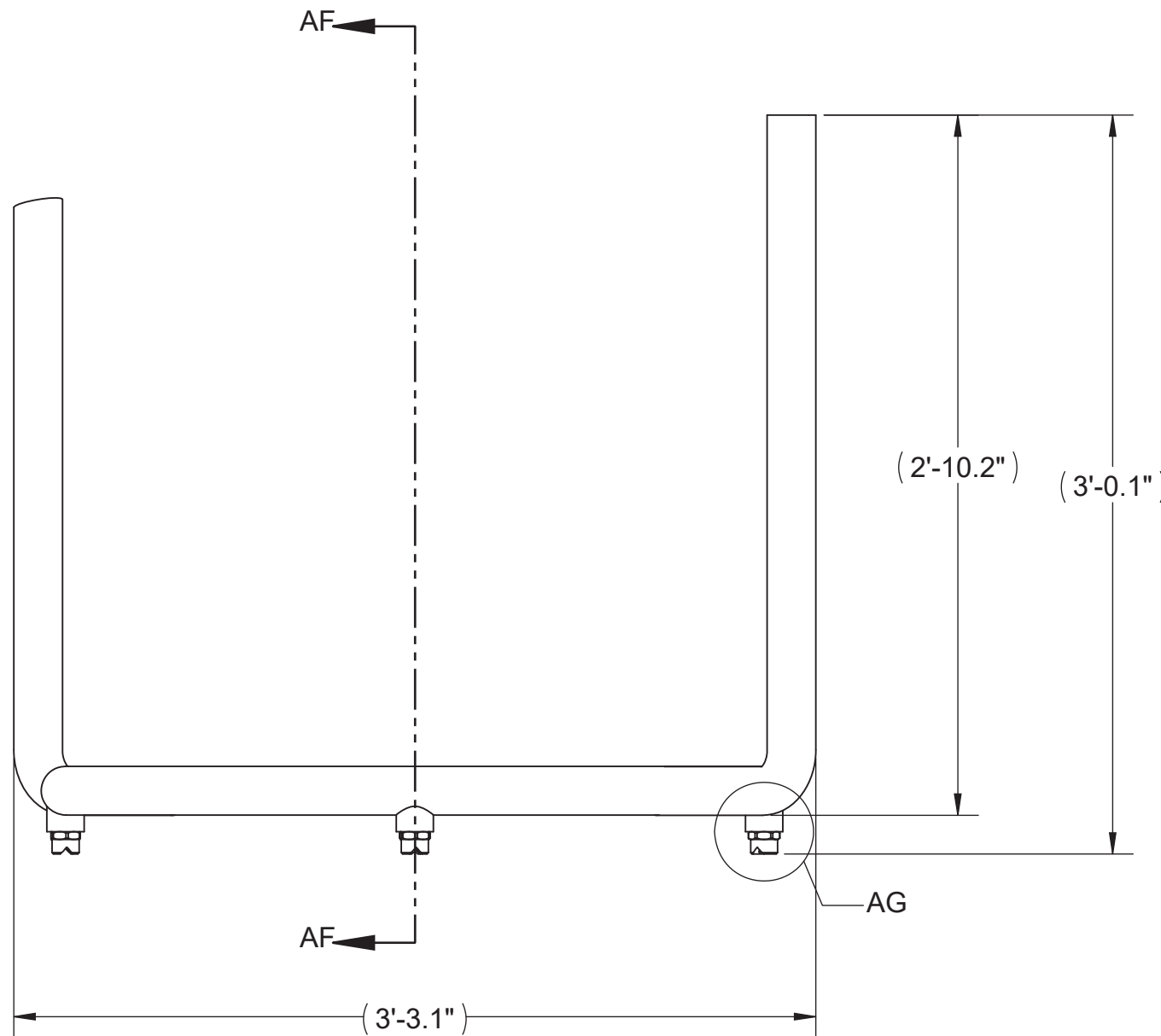
NOTES:  
FOR NOTES, DRAWING INDEX, REFERENCE  
DRAWINGS AND PART LISTS, SEE  
24590-HLW-MV-HOP-00004001.



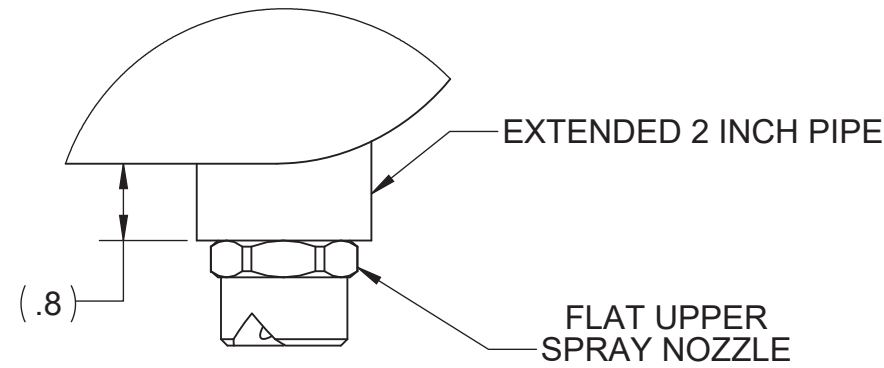
TOP VIEW



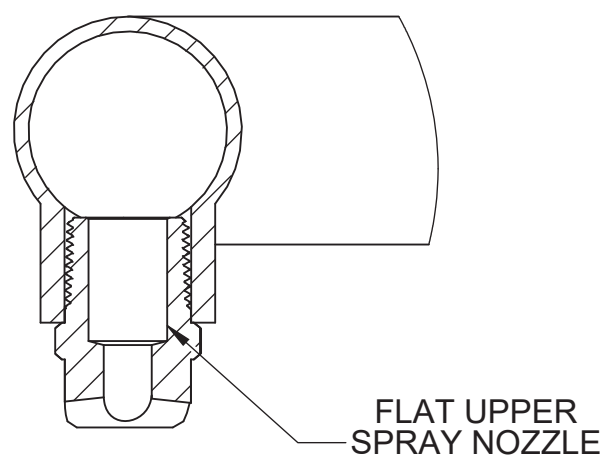
SECTION AF-AF



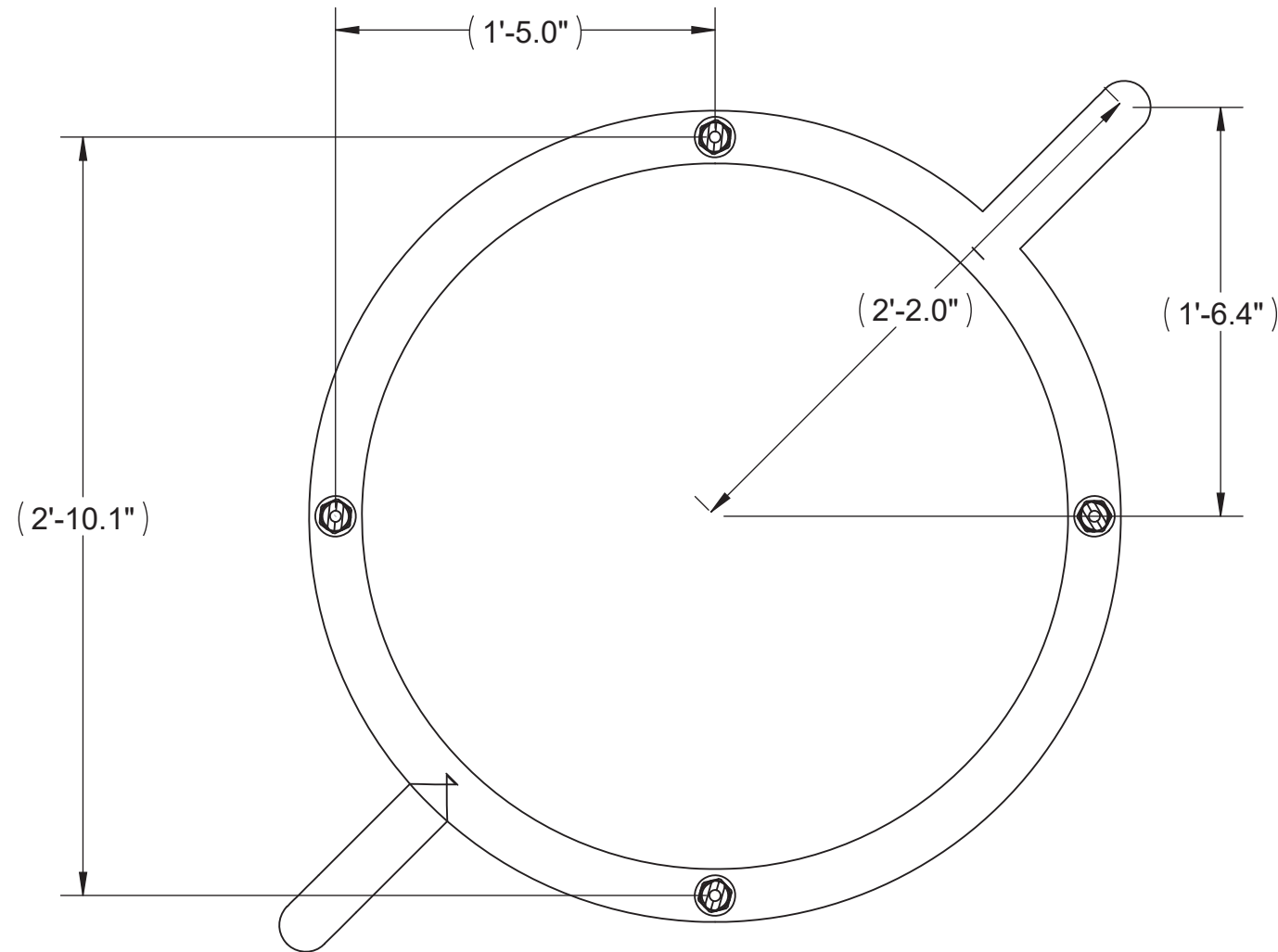
SIDE VIEW



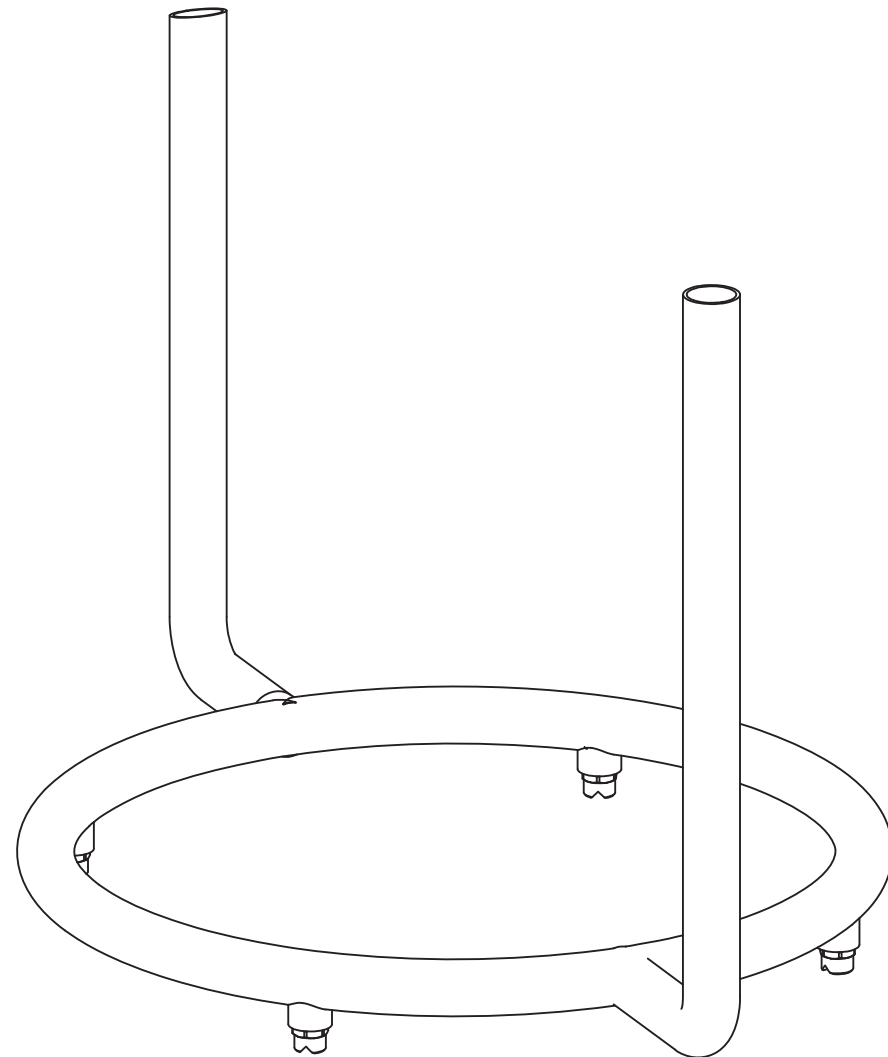
DETAIL AG  
SCALE 1 : 2



DETAIL AH  
SCALE 1 : 2





BOTTOM VIEW



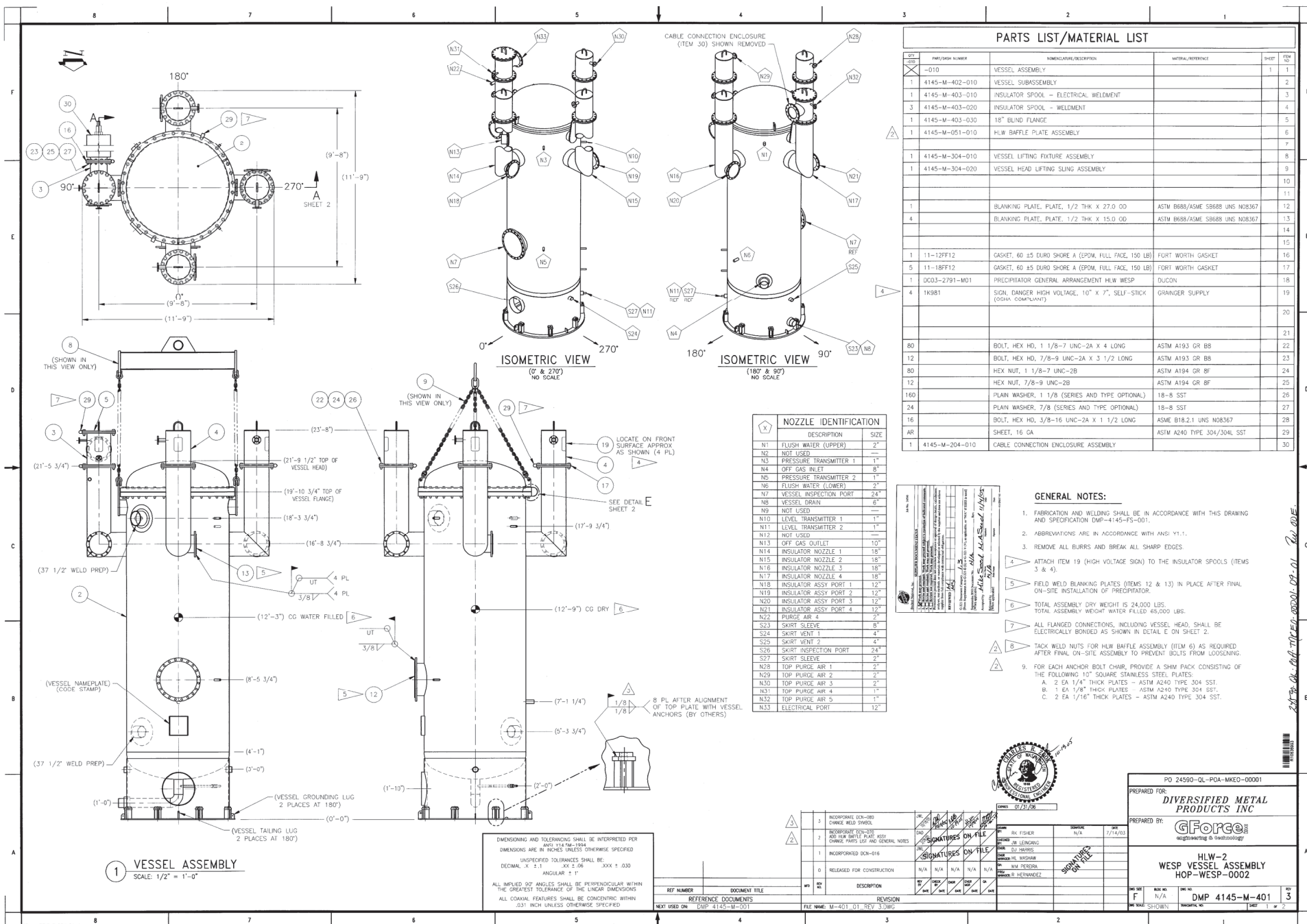
ISOMETRIC VIEW  
(NO SCALE)

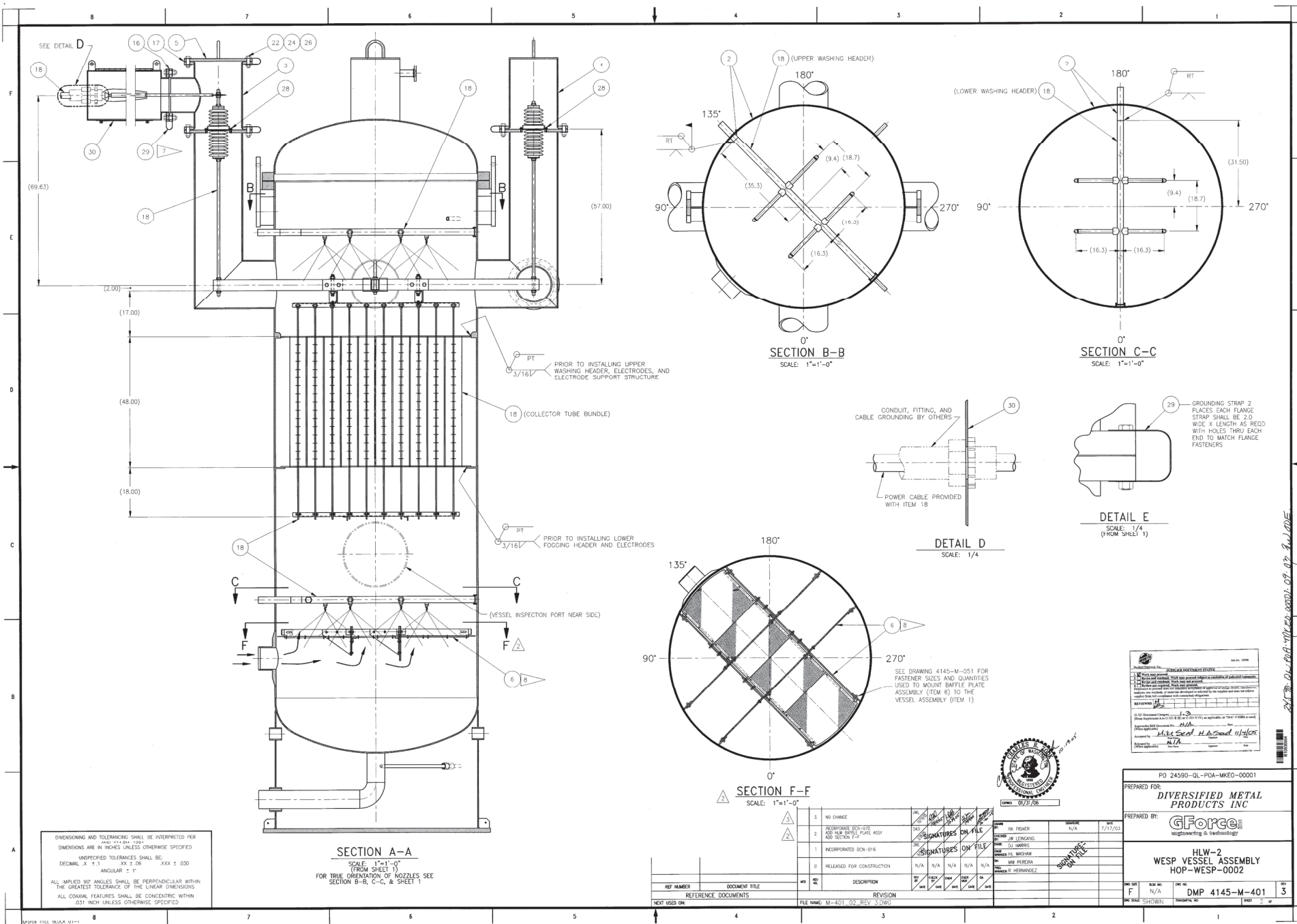
10 WESP UPPER SPRAY RING ASSEMBLY

DO NOT SCALE DRAWING		<div>PROJECT No. 24590</div> <div>SITE HANFORD</div> <div>AREA 200E</div> <div>BUILDING No. 30 (HLW)</div>		<div></div> <div>RIVER PROTECTION PROJECT</div> <div>WASTE TREATMENT PLANT</div> <div>450 HILLS STREET</div> <div>RICHLAND, WA 99354</div>			
						ISSUE STAMP	
						BY _____ DATE _____	
THIRD ANGLE PROJECTION						ORIGINATOR K. BAILEY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES						CHECKER B. SHOBE	
TOLERANCES UNLESS SPECIFIED		REVIEWER J. PATTERSON					
APPROVER J. MAUSS							
NO TOLERANCES ARE APPLIED TO DIMENSIONS UNLESS NOTED							
WEIGHT 18161.85 LBS		CONTENT APPLICABLE TO ALARA? <input checked="" type="checkbox"/> YES <input type="checkbox"/> NO		<div>CONTRACT No: DE-AC27-01RV14136</div> <div>WTP SUBCONTRACT No: _____</div>			
SUPPLIER DWG NO. _____		ADR NO. N/A				REV: N/A	







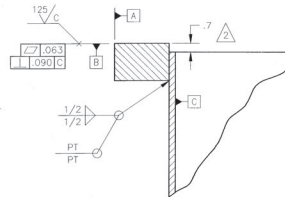






The image contains four technical drawings of nozzle types, each showing a cross-section and dimensions. The drawings are arranged in a 2x2 grid.

- NOZZLE TYPE 1:** Shows a cross-section of a nozzle with a central hole. The top edge is labeled "DIAMETER THRU AS READ FOR NOZZLE". The bottom edge is labeled "EXT PROJECTION". The top edge has a radius of "R.19". The bottom edge has a radius of "RT". The bottom edge is also labeled "INT PROJECTION (ALL AROUND)". The bottom edge has a dimension of "B" and a dimension of "A". The bottom edge has a dimension of "G".
- NOZZLE TYPE 2:** Shows a cross-section of a nozzle with a central hole. The top edge is labeled "DIAMETER THRU AS READ FOR NOZZLE". The bottom edge is labeled "EXT PROJECTION". The top edge has a radius of "R.19". The bottom edge has a radius of "RT". The bottom edge is also labeled "INT PROJECTION (ALL AROUND)". The bottom edge has a dimension of "B" and a dimension of "A". The bottom edge has a dimension of "G".
- NOZZLE TYPE 3:** Shows a cross-section of a nozzle with a central hole. The top edge is labeled "DIAMETER THRU AS READ FOR NOZZLE". The bottom edge is labeled "EXT PROJECTION". The top edge has a radius of "R.19". The bottom edge has a radius of "RT". The bottom edge is also labeled "INT PROJECTION (ALL AROUND)". The bottom edge has a dimension of "B" and a dimension of "A". The bottom edge has a dimension of "G".
- NOZZLE TYPE 4:** Shows a cross-section of a nozzle with a central hole. The top edge is labeled "DIAMETER THRU AS READ FOR NOZZLE". The bottom edge is labeled "EXT PROJECTION". The top edge has a radius of "R.19". The bottom edge has a radius of "RT". The bottom edge is also labeled "INT PROJECTION (ALL AROUND)". The bottom edge has a dimension of "B" and a dimension of "A". The bottom edge has a dimension of "G".



SCALE: 1/4

[illegible]

PROFESSIONAL ENGINEER		DATE	
DESIGN BY:	JW LEONGANG	SIGNATURE	N/A
CHECKED BY:	RK FISHER		7/24/06
INCH BY:	DJ HARRIS		
OWNER:	HL MASHAW		
QA:	MM PEREIRA		
PMO:	R HERNANDEZ		

SIGNATURES ON FILE

FOR PARTS LIST AND  
GENERAL NOTES SEE SHEET 1

PREPARED FOR:  
**DIVERSIFIED METAL  
PRODUCTS INC**

PREPARED BY: **GForce** INC.

HLW-2  
VESSEL DETAILS  
HOP-WESP-0002

DWG SIZE <b>F</b>	BLDG NO. <b>N/A</b>	DWG NO. <b>DMP 4145-M-402</b>
DWG SCALE: <b>SHOWN</b>		SHEET <b>2</b>

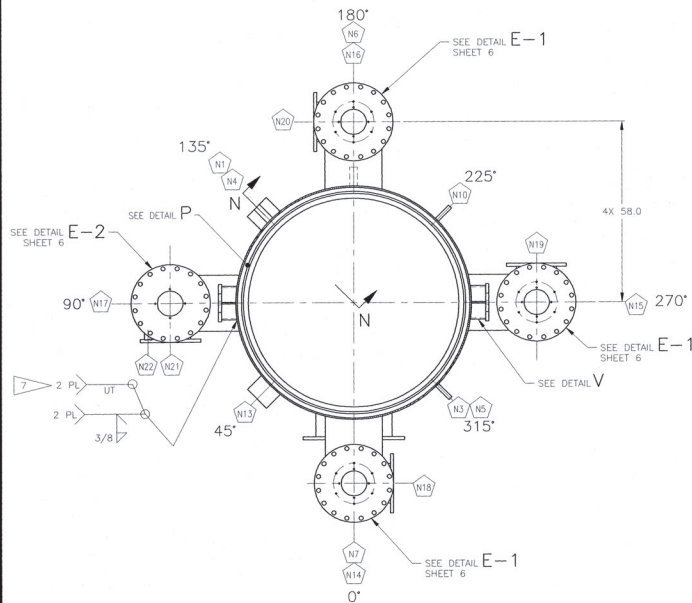
RPP-WTP

RECEIVED  
JAN 10 2010JAN 19 2006  
BY PBS

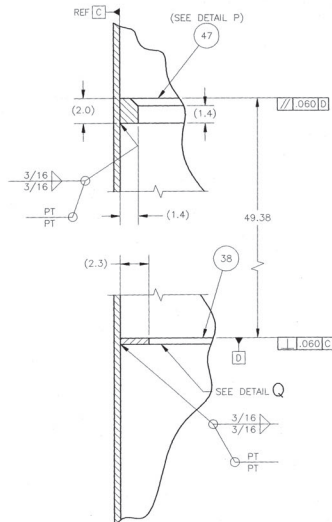
BY PDC

24590-01-PCA-MKED-00001-09-05

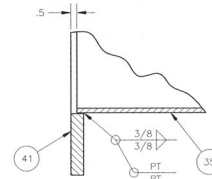
Rev 00E



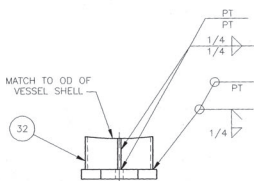
**SECTION G-G**  
SCALE: 3/4" = 1'-0"  
(FROM SHEET 2)



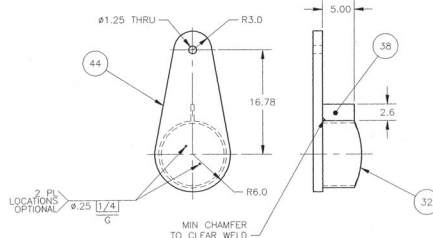
**SECTION F-F**  
SCALE: 1/4"  
(FROM SHEET 2)



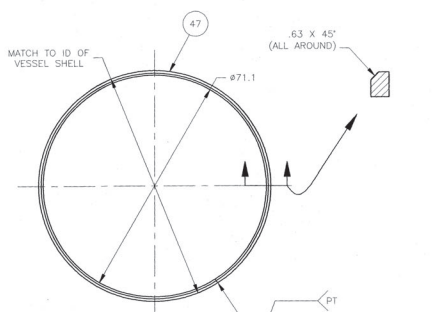
**SECTION T-T**  
SCALE: 1/4"  
(FROM SHEET 2)



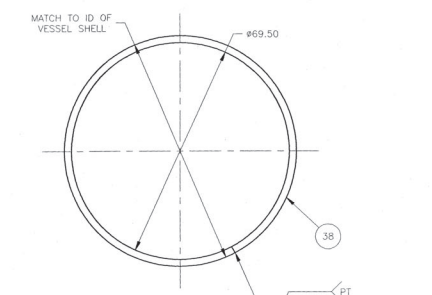
**DETAIL V**  
SCALE: 1/8"  
(2 REED)  
ROTATED 90° CW



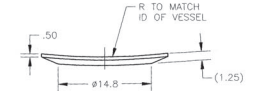
**DETAIL Q**  
SCALE: 3/4" = 1'-0"  
(SHOWN IN PLAN)



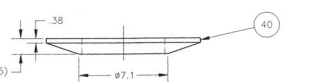
**DETAIL P**  
SCALE: 3/4" = 1'-0"  
(SHOWN IN PLAN)



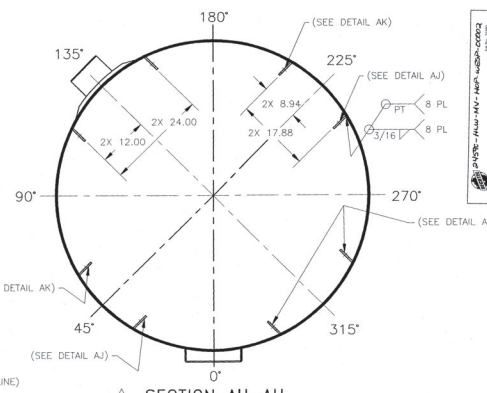
**DETAIL R-1**  
SCALE: 1/8"  
(FROM SHEET 2)



**DETAIL R-2**  
SCALE: 1/8"



**DETAIL S**  
SCALE: 1/4"  
(SHOWN IN PLAN)  
(FROM SHEET 2)



**SECTION AH-AH**  
SCALE: 1" = 1'-0"

**SECTION N-N**  
SCALE: 1/8"

DIMENSIONING AND TOLERANCING SHALL BE INTERPRETED PER  
ANSI Y14.5M-1994  
DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED  
UNSPECIFIED TOLERANCES SHALL BE:  
DECIMAL XX ± .06 XXX ± .030  
ANGULAR ± 1°  
ALL IMPLIED 90° ANGLES SHALL BE PERPENDICULAR WITHIN  
THE GREATEST TOLERANCE OF THE LINEAR DIMENSIONS  
ALL COAXIAL FEATURES SHALL BE CONCENTRIC WITHIN  
.031 INCH UNLESS OTHERWISE SPECIFIED

REF NUMBER	DOCUMENT TITLE
1	REFERENCE DOCUMENTS

NO	DESCRIPTION	REVISION
1	NO CHANGE	1
2	NO CHANGE	2
3	NO CHANGE	3
4	NO CHANGE	4

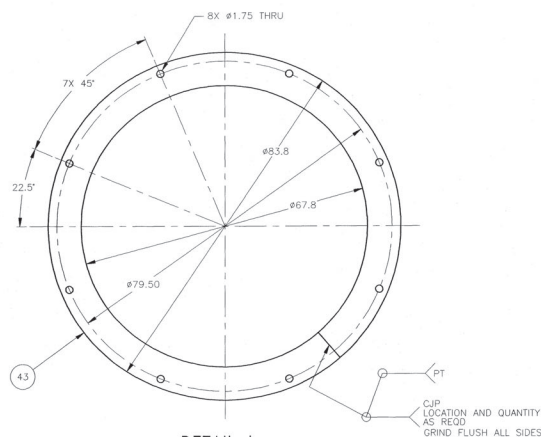
DATE	7/24/03
BY	JW
CHECKED	JK
APPROVED	JK
DATE	7/24/03
BY	JW
CHECKED	JK
APPROVED	JK



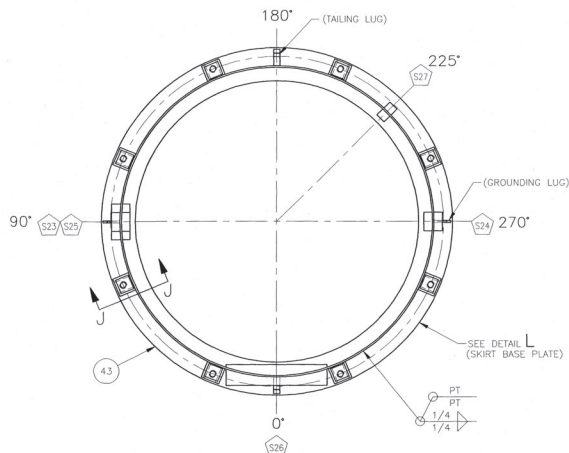
PO 24590-01-POA-MKEO-00001
PREPARED FOR: <b>DIVERSIFIED METAL PRODUCTS INC</b>
PREPARED BY: <b>GForce</b> engineering & technology
HLW-2 VESSEL DETAILS HOP-WESP-0002
DMP 4145-M-402
REV 4

RFP-WTP  
RECEIVED  
JAN 13 2006  
BY PDC

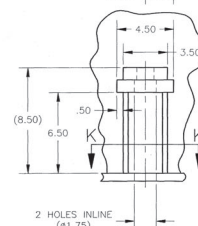
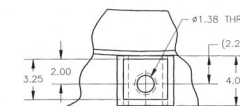




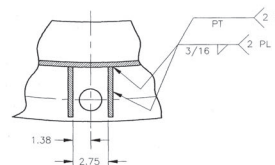
**DETAIL L**  
SCALE: 1" = 1'-0"



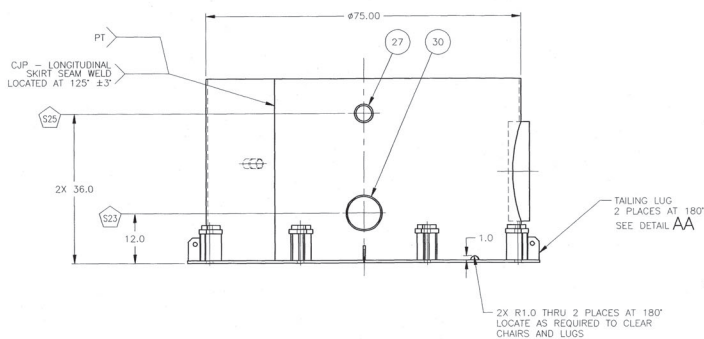
**DETAIL B**  
SCALE: 1" = 1'-0"  
(FROM SHEET 1)



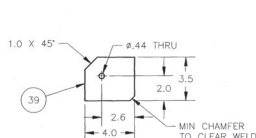
**SECTION J-J**  
SCALE: 1/4"  
(8 PLACES TYP)



**SECTION K-K**  
SCALE: 1/4"



**DETAIL AA**  
SCALE: 1/4"  
(2 RECD)



**DETAIL AB**  
SCALE: 1/4"  
(2 RECD)

DIMENSIONING AND TOLERANCING SHALL BE INTERPRETED PER  
AND Y14.5M-1994.  
DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED  
UNSPECIFIED TOLERANCES SHALL BE:  
DECIMAL .X ± .1 .XX ± .06 .XXX ± .030  
ANGULAR ± 1°  
ALL IMPLIED 90° ANGLES SHALL BE PERPENDICULAR WITHIN  
THE GREATEST TOLERANCE OF THE LINEAR DIMENSIONS  
ALL COAXIAL FEATURES SHALL BE CONCENTRIC WITHIN  
.031 INCH UNLESS OTHERWISE SPECIFIED

REF NUMBER	DOCUMENT TITLE
1	REFERENCE DOCUMENTS
2	NOT USED ON

NO	REV	DESCRIPTION	DATE	BY	CHKD	APP'D
4	1	NO CHANGE	7/18/03	JK	JK	JK
3	1	NO CHANGE		JK	JK	JK
2	1	NO CHANGE		JK	JK	JK
1	1	NO CHANGE		JK	JK	JK
0	1	RELEASED FOR CONSTRUCTION		JK	JK	JK

NO	REV	DESCRIPTION	DATE	BY	CHKD	APP'D
4	1	NO CHANGE	7/18/03	JK	JK	JK
3	1	NO CHANGE		JK	JK	JK
2	1	NO CHANGE		JK	JK	JK
1	1	NO CHANGE		JK	JK	JK
0	1	RELEASED FOR CONSTRUCTION		JK	JK	JK

FOR PARTS LIST AND  
GENERAL NOTES SEE SHEET 1

PO 24590-OL-POA-MKEO-00001  
PREPARED FOR:  
**DIVERSIFIED METAL PRODUCTS INC**  
PREPARED BY:  
**GForce**  
HLW-2  
VESSEL DETAILS  
HOP-WESP-0002

PP-107  
RECEIVED  
JAN 19 2006  
BY PDC

24590-OL-POA-MKEO-00001-09-07  
Rev 001



2



### DETAIL 1



DETAIL 0



DETAIL H



DETAIL Z



SECTION X-X

ALL IMPLIED 90° ANGLES SHALL BE PERPENDICULAR WITHIN  
THE GREATEST TOLERANCE OF THE LINEAR DIMENSIONS

ALL COAXIAL FEATURES SHALL BE CONCENTRIC WITHIN  
.031 INCH UNLESS OTHERWISE SPECIFIED

REF NUMBER	DOCUMENT
REFERENCE DOCUMENTS	
NEXT USED ON:	

[illegible]

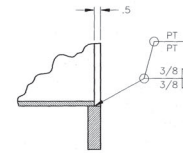
NAME	STATION	SIGNATURE	DATE
CHIEF	RK FISHER		07/22
CHECKER	JW LEONGANG		
ENGR	DJ HARRIS		
CHGR	RL MASHAW		
CR	MM PEREIRA		
TRNG	R HERNANDEZ		
DATE			

[illegible]

FOR PARTS LIST AND  
GENERAL NOTES SEE SHEET 1

PO 24590-QL-POA-MKEO-00001		
PREPARED FOR: <b>DIVERSIFIED METAL PRODUCTS INC</b>		
PREPARED BY: <b>GForce<sub>inc</sub></b> <i>engineering &amp; technology</i>		
HLW-2 VESSEL DETAILS HOP-WESP-0002		
DWG. SIZE: <b>F</b>	BUILD NO: N/A	DWG. NO. <b>DMP 4145-M-402</b>
DWG. SCALE: SHOWN	REVISION: NO.	SHEET 5





Technical drawing of a circular flange. The drawing shows a top view of a circular part with a central hole. The outer diameter is dimensioned as  $\phi 19.00$ . The inner diameter is dimensioned as  $\phi 17.000$ . There are 12 holes around the perimeter, each with a diameter of  $\phi .0950$ . The text "12X  $\phi 1.000$  THRU" is present, along with a callout box containing  $\phi .0950$ . A dimension line indicates a distance of  $\phi 19.00$  from the center to the outer edge. A note "MATCH TO OD OF ITEM 33" is present. A callout box contains the number 4.

[illegible]

Technical drawing of a rectangular plate. The top view shows a rectangle with a width of 4.13 and a length of 4.03. A detail view of the top edge shows a fillet with a radius of 1.4. The front view shows a plate with a total height of 10.5. It has three horizontal slots, each 1.50 high and 1.8 wide. The slots are positioned at 5.50 from the top edge and 4.12 from the bottom edge. The plate has a thickness of 0.1875 (labeled as 563 X 2XR). The material is 2X .438 4XR. A circular feature with the number 46 is shown on the right side.

28

1/16

6.625

37 1/2

1:4 INTERNAL TAPER TO MATCH CONNECTING PIPE

RT

1/8

3.5

125

3

0.30

B REF

34

BOLT HOLES SHALL STRA  
CENTERLINE AS SHOWN  
2 PLACES

(VESSEL SHELL)

(20.50)

Technical drawing of a pipe section. The drawing shows a cross-section of a pipe with a diameter of 24 inches. The pipe has a 1:4 internal taper. The length of the pipe is 37 1/2 inches. The drawing also indicates a 1/16 inch dimension and a 1.315 inch dimension. The text '1:4 INTERNAL TAPER TO MATCH CONNECTING PIPE' is present.

DIMENSIONING AND TOLERANCING SHALL BE INTERPRETED PER  
ANSI Y14.5M-1994  
DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED  
UNSPECIFIED TOLERANCES SHALL BE:  
DECIMAL  $X \pm .1$  .XX  $\pm .06$  .XXX  $\pm .030$   
ANGULAR  $\pm 1$   
ALL IMPLIED 90° ANGLES SHALL BE PERPENDICULAR WITHIN  
THE GREATEST TOLERANCE OF THE LINEAR DIMENSIONS  
ALL COAXIAL FEATURES SHALL BE CONCENTRIC WITHIN  
.031 INCH UNLESS OTHERWISE SPECIFIED

			4	NO CHANGE	JAN FEB MAR <del>APR</del> MAY JUN JUL AUG SEP OCT NOV DEC	SIGNATURES ON FILE
		3	3	INCORPORATED DCN-081 DETERMINATION REQUIREMENT	JAN FEB MAR <del>APR</del> MAY JUN JUL AUG SEP OCT NOV DEC	SIGNATURES ON FILE
		2	2	RECOGNIZED DCN-292 AND DETAIL AL DCMC AND DETAIL AL	JAN FEB MAR <del>APR</del> MAY JUN JUL AUG SEP OCT NOV DEC	SIGNATURES ON FILE
			1	INCORPORATED DCN-033 & -064	JAN FEB MAR <del>APR</del> MAY JUN JUL AUG SEP OCT NOV DEC	SIGNATURES ON FILE
			0	RELEASED FOR CONSTRUCTION	N/A	N/A N/A N/A
REF NUMBER	DOCUMENT TITLE	DWG NO.	REV NO.	DESCRIPTION	JAN FEB MAR APR MAY JUN JUL AUG SEP OCT NOV DEC	DESIGNED BY CHECKED BY DATE
<b>REFERENCE DOCUMENTS</b>						
NEXT USED ON:						
				FLE NAME: M-407- CG REV A-100	REVISION	

PO 24590-QL-POA-MKEO-00001	
PREPARED FOR:	<b>DIVERSIFIED METAL PRODUCTS INC</b>
PREPARED BY:	<b>GForce</b> engineering & technology

HLW-2  
VESSEL DETAILS  
HOP-WESP-0002

DWG SIZE <b>F</b>	BLOC NO. <b>N/A</b>	DWG NO. <b>DMP 4145-M-402</b>	REV. <b>4</b>
DWG SCALE <b>SHOWN</b>		INTERSECTION NO.	SHEET <b>6</b> OF

RPP-WTP  
RECEIVED  
JAN 19 2006  
BY PDC

24590-QL-POA-MKEO-00001-09-09  
Rev 001

# In-Progress 24590-WTP-NCR-MGT-22-0489

Attach ...



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Responsible Individual Creates Conditional Releases  
and Dispositions



New Interim Disposition



New Disposition

24590-WTP-NCR-MGT-22-0489

NCR Header





In-Progress 24590-WTP-NCR-MGT-22-0489

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Responsible Individual Creates Conditional Releases  
and Dispositions

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 New Interim Disposition

 New Disposition

Email	NCR Priority	Supplier/SubContractor
rajanyse@bechtel.us	2	Diversified Metal Products, Inc
Contract Number / Purchase Order	Quality Level	Custody Currently With
24590-QL-POA-MKE0-00001	Q	Construction
ASME Code Stamped Component or Assembly	Suspect/Counterfeit?	Commissioning Breakdown Structure
Yes	No	

Nonconformance Description

Inspection of all accessible external welds on the HOP-WESP-00001 was performed as per 24590-WTP-RPT-ENG-22-003.

1. Numerous welds were found to be rejectable.

2. There were rejectable surface defects (arc strikes).

3. In one case the weld specified was not actually obtainable due to configuration of the vessel head and flange.
- See attachment 1, 2 & 3 of NCR for details

Additional Information

Drawing/Specification References:

Document Number	Rev	Document Title	Sections	Comments
24590-WTP-MRR-PROC-0017737	001	DIVERSIFIED METAL PRODUCTS INC		
24590-WTP-MN-CON-01-001-10-26	002	VT-ASME VIII NONDESTRUCTIVE EXAMINATION STANDARD		
24590-QL-POA-MKE0-00001-09-19	00F	DRAWING - HLW-1 VESSEL DETAILS HOP-WESP-0001		
24590-QL-POA-MKE0-00001-09-18	00F	DRAWING - HLW-1 VESSEL DETAILS HOP-WESP-0001		
24590-QL-POA-MKE0-00001-09-16	00F	DRAWING - HLW-1 VESSEL DETAILS HOP-WESP-0001		
24590-QL-POA-MKE0-00001-09-15	00F	DRAWING - HLW-1 VESSEL DETAILS HOP-WESP-0001		
24590-QL-POA-MKE0-00001-09-14	00F	DRAWING - HLW-1 VESSEL SUBASSEMBLY HOP-WESP-0001		
24590-QL-POA-MKE0-00001-09-13	00E	DRAWING - HLW-1 WESP VESSEL ASSEMBLY HOP-WESP-0001		
24590-QL-POA-MKE0-00001-09-12	00E	DRAWING - HLW-1 WESP VESSEL ASSEMBLY HOP-WESP-0001		

Applicable Items

Item Number	Parent ID	Item Description	Item Location	Item Quantity
24590-HLW-MK-HOP-WESP-00001	HOP-WESP-00001	MELTER 1 WET ELECTROSTATIC PRECIPITATOR (WESP)	MHF - 4N545 W407	

## In-Progress 24590-WTP-NCR-MGT-22-0489

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Responsible Individual Creates Conditional Releases  
and Dispositions

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New Interim Disposition



New Disposition

## Validate and Screen

## Step 1: Is the NCR valid?

Yes

## NCR Title

HLW - HOP-WESP-00001 accessible external vendor weld inspection

## Step 2: Are hold tags required?

Yes

## Comments for Hold Tags

## Step 3: Select the NCR Category

Supplier

## Step 4: Stop Work?

No

## Occurrence Reporting

No

## Is this NCR related to an electrical item?

No

## Step 5. Please check each WTP Area that is affected by this NCR.

HLW

## Step 6. Select the Disposition Approval Authority to notify.

Skiffington, Mark

## Step 7. Select the RQO to notify.

Padilla, Richard\*

## Condition Reports

## Condition Reports Associated with this NCR

Are there any Condition Reports associated with this CR? If applicable, identify any Condition Reports associated to this NCR in the Condition Report section below.

If there are no associated Condition Reports, please enter N/A.

## Condition Reports Associated to this NCR

## Condition Report Number



Remove

Add CR Number

Enter a Standing/Shift Order Number:

If not applicable please enter N/A.

Related Processes

Hold Tags

Hold Tags - [View](#)

Tags Hung	Tags Removed	All Tags Removed or Accounted For?
0	0	False

Conditional Releases

Interim Dispositions

Dispositions

Disposition #001 - [View](#) Status: In Progress NOT Ready for Implementation

Recommended Disposition Type	Marked for Final	Submitted Date	Submitted By	Process Status
Other	No	3/13/2023 6:07 PM	Padilla, Richard	Active

Process Task	Is this a superseded Disposition?
Checker Concurs, Final Disposition	<input type="checkbox"/> Check this box to hide this Disposition until closure

Currently Active Users

Wells, Donnie

VA Concurrence Date	DAA Approval Date	Recommended Disposition
-	5/2/2024 4:26 PM	Route to Engineering to provide Disposition.

Final Disposition Type	Submitted Date	Submitted By
Use-As-Is	5/2/2024 5:58 PM	Sanvictores, Mac

Final Disposition

See attached NCR 24590-WTP-NCR-MGT-22-0489 ATTACHMENT 1 - USE-AS-IS



In-Progress 24590-WTP-NCR-MGT-22-0489

Attach ...

 View Full PDF

Press F5 To refresh

Responsible Individual Creates Conditional Releases and Dispositions

 New Interim Disposition

 New Disposition

☐ Check this box to hide this Disposition until closure

Currently Active Users

Mccann, Adam, Hartsfield, Gregg, Yetter, Kevin, Skiffington, Mark, Bhatt, Ajay, Opet, Paul, Bentley, Tom, Rehwalt, Andrew, George, Ronald, Cowan, Chris, Kump, Greg, Rogers, Rich, Walling, Joe

VA Concurrence Date	DAA Approval Date	Recommended Disposition
-	-	SEE ATTACHED NCR 24590-WTP-NCR-MGT-22-0489 ATTACHMENT 2-REPAIR

Final Disposition Type	Submitted Date	Submitted By
------------------------	----------------	--------------

-

Final Disposition

Attachments

REQUIRED FOR FINAL RECORD—Files attached here are part of the final record and will print with NCR.

Please ensure these files are formatted properly, and that documents (i.e. Word, Excel, emails, etc.) are converted to a PDF file format.

24590-WTP-NCR-MGT-22-0489 Rejected inspections HOP-WESP-00001.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	12/16/2022 6:08 PM	Janysek, Roy
NCR-22-0489 photos WESP-00001.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	12/16/2022 6:09 PM	Janysek, Roy
NCR-22-0489 weld maps WESP-00001a.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	12/16/2022 6:08 PM	Janysek, Roy

Attach ...

Comments

Use this section to add comments to this NCR

Add Comment

User	Date	Comment
Skiffington, Mark	3/13/2023 11:19 AM	reference 24590-HLW-FIR-CON-22-00006

 Save Comments

Routing Slip

In-Progress 24590-WTP-NCR-MGT-22-0489

Press F5 To refresh


Responsible Individual Creates Conditional Releases and Dispositions

Attach ...

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 New Interim Disposition

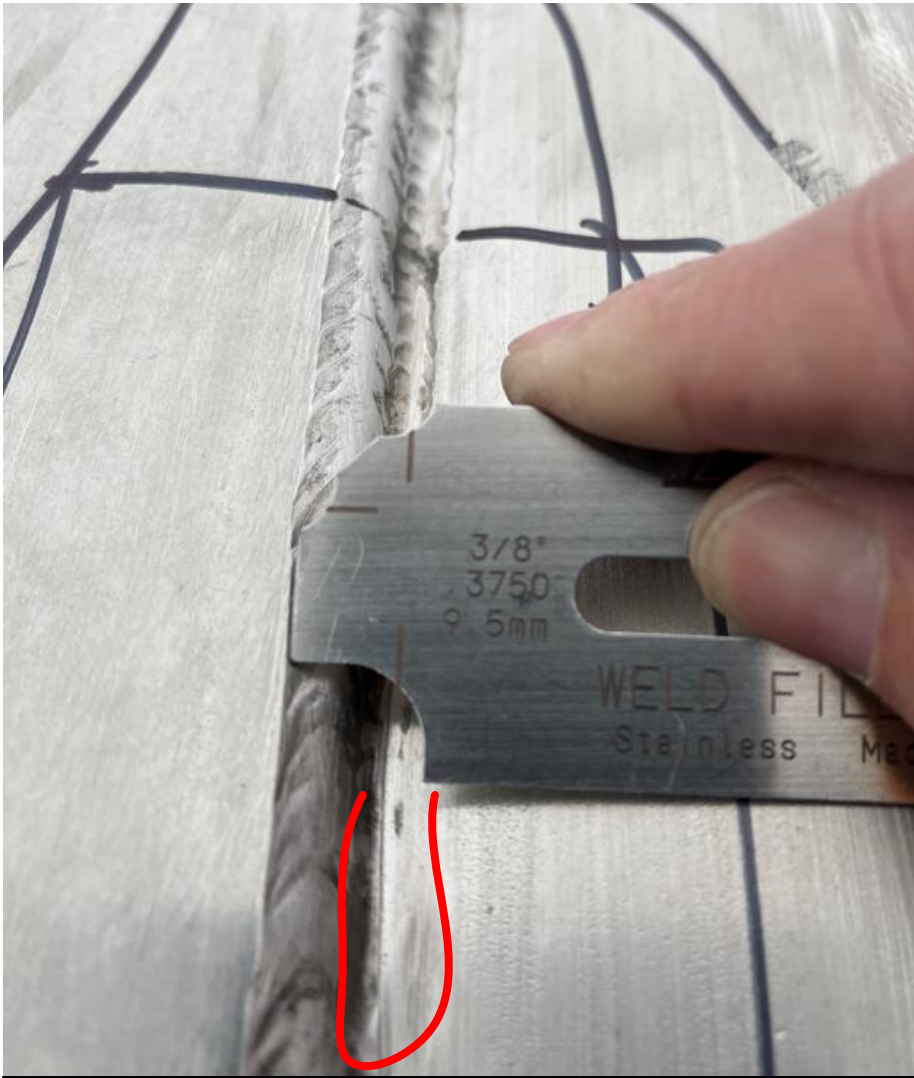
 New Disposition

Janysek, Roy	3/13/2023	Notified	
RQO Notified for Hold Tags		3/13/2023 2:21 PM	
Padilla, Richard	3/13/2023	Notified	
Disposition Approval Authority Assigns Responsible Individual		3/13/2023 2:21 PM	
Skiffington, Mark	3/13/2023	Completed	 Assign Responsible Individual
Responsible Individual Creates Conditional Releases and Dispositions		3/13/2023 2:23 PM	
Padilla, Richard	-	Active	

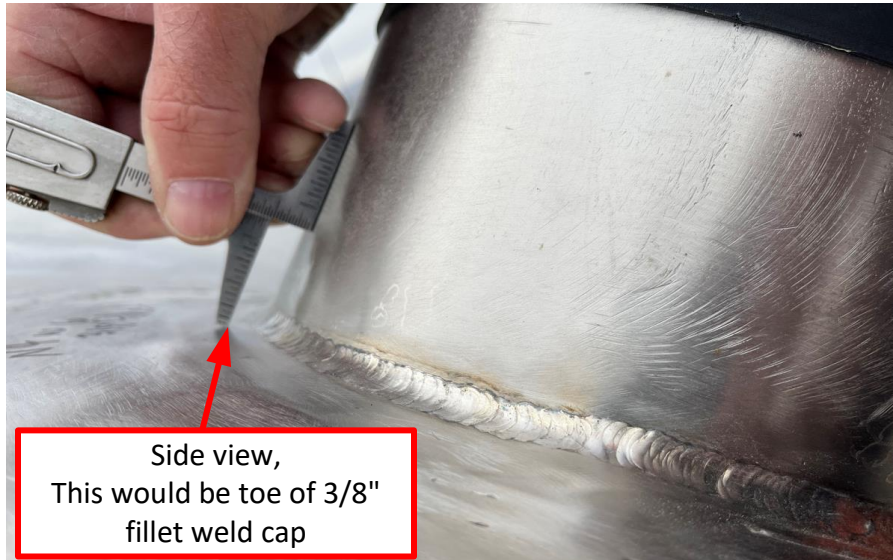
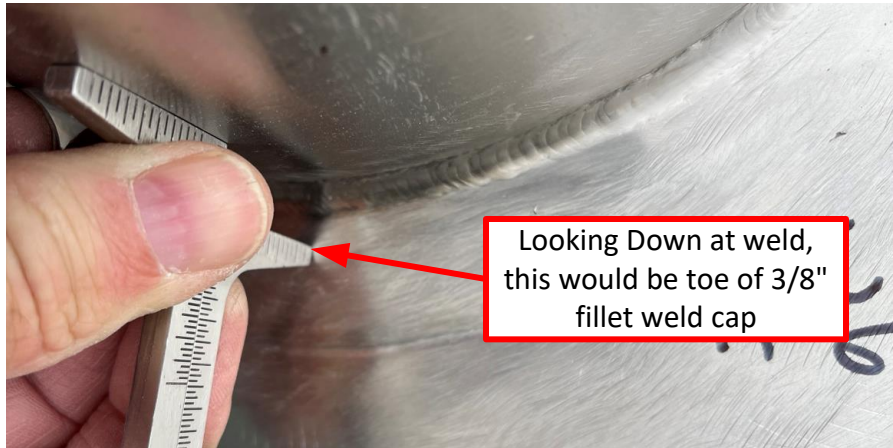


List of Rejects from 24590-HLW-FIR-CON-22-00006

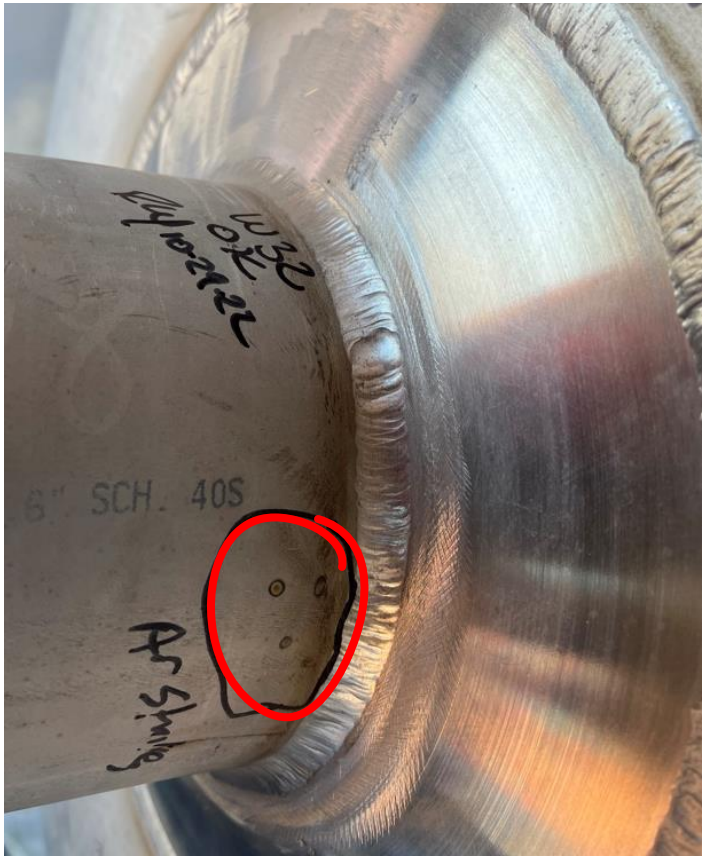
Weld ID/Description			See Weld map sht #	Dia.	Weld Type	Weld Size ID	Weld Size OD	Acc/Rej	By /Date	inspection remarks
WM-21 w-1	Skirt to Head	sht 1 detail C	1	NA	fs	NA	3/8"	REJECT	RAJ 10-29-22	~20" was undersized by ~1/16". Not able to inspect area from ~270° to 90°, weld hidden by the vessel support saddle & cribbing
WM-22 W-6	N-04, 8" sch 40 to 1-1/4" plate	sht 2 Nozzle type 2	2	8"	cjp/fw	3/8"	3/8"	REJECT	RAJ 10-28-22	Weld undersized
adjacent to WM-22 W-32	N-08, 6" pipe to repad insert	sht 2 Nozzle type 1, detail W sht 2	2	6"	cjp/fw	NA	1/4"	REJECT	RAJ 10-29-22	Arc strikes adjacent to W32
WM-23 W-1	10" tube to shell Lifting Lug Assembly @ Az 90	Section G-G sht 3	3	10"	cjp/fw	NA	3/8"	REJECT	TRB 10-29-22	insufficient throat at 2-3 O'clock
WM-23 W-2	10" tube to shell Lifting Lug Assembly @ Az 270	Section G-G sht 3	3	10"	cjp/fw	NA	3/8"	REJECT	TRB 10-29-22	insufficient throat at 7-10 O'clock
WM25 W-6	Det Y lug to flange @ Az 0	vessel head weldment detail , x-x	5	NA	fw	NA	3/8"	REJECT	RAJ 10-28-22	Configuration of lug to head only permits 1/4" fillet on OD of lug to head Flange
WM25 W-7	Det Y lug to flange @ Az 120	vessel head weldment detail , x-x	5	NA	fw	NA	3/8"	REJECT	RAJ 10-28-22	Configuration of lug to head only permits 1/4" fillet on OD of lug to head Flange
WM25 W-8	Det Y lug to flange @ Az 240	vessel head weldment detail , x-x	5	NA	fw	NA	3/8"	REJECT	RAJ 10-28-22	Configuration of lug to head only permits 1/4" fillet on OD of lug to head Flange
Adjacent to WM26 W-12	N-17, 18" tube, 45 degree Girth Seam @ Az 90	Detail E-1	6	18"	cjp	NA	3/32"	REJECT	RAJ 10-29-22	Arc strikes adjacent to W12 on nozzle N-17 shell
WM26 W-21	N-18 tie-in weld to 18" N14 tube @ Az 0	Nozzle Type 4 sht2	2 /6	12"	cjp/FW	NA	3/8"	REJECT	TRB 10-29-22	Insufficient weld throat @ 7 O'clock to 1 O'clock
WM26 W-22	N-19 tie-in weld to 18" N15 tube @ Az 270	Nozzle Type 4 sht2	2 /6	12"	cjp/FW	NA	3/8"	REJECT	TRB 10-29-22	Undersized weld, & Insufficient weld throat @ 11-12 O'clock and 2-3 O'clock
WM26 W-23	N-20 tie-in weld to 18" N16 tube@ Az 180	Nozzle Type 4 sht2	2 /6	12"	cjp/FW	NA	3/8"	REJECT	RAJ 10-28-22	Undersized ~ 12" long section
WM26 W-30	N-20, flange to 12" tube @ Az 180	Detail E-1, A-C	6	12"	fw	NA	3/8"	REJECT	RAJ 10-28-22	Undersized weld ~12" long @ 9 & 3 O clock.
WM26 W-32	N-21, flange to 12" tube @ Az 90	Detail E-1, A-C	6	12"	fw	NA	3/8"	REJECT	TRB 10-29-22	Insufficient weld throat for 90% of weld length
Adjacent to WM26 W-32	N-21, flange to 12" tube @ Az 90	Detail E-1, A-C	6	12"	fw	NA	3/8"	REJECT	RAJ 10-29-22	Arc Strikes adjacent to W-32 on N-21 shell
Adjacent to WM27 W-18 & 19	7/8" bar to 1" flange w/with N-16	sec C-C, 303, sh1	7	NA	fw	NA	1/4"	REJECT	RAJ 10-28-22	Arc strikes adjacent to W18 & 19



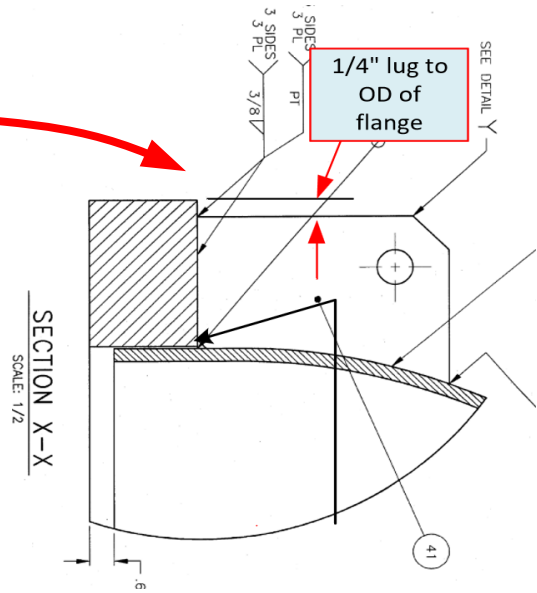
WM-21, W-1 Reject, ~20" overground, weld undersized by ~ 1/16"



WM-22, W-6, Reject, overground, re-enforcement fillet weld cap undersized by ~ 1/4"



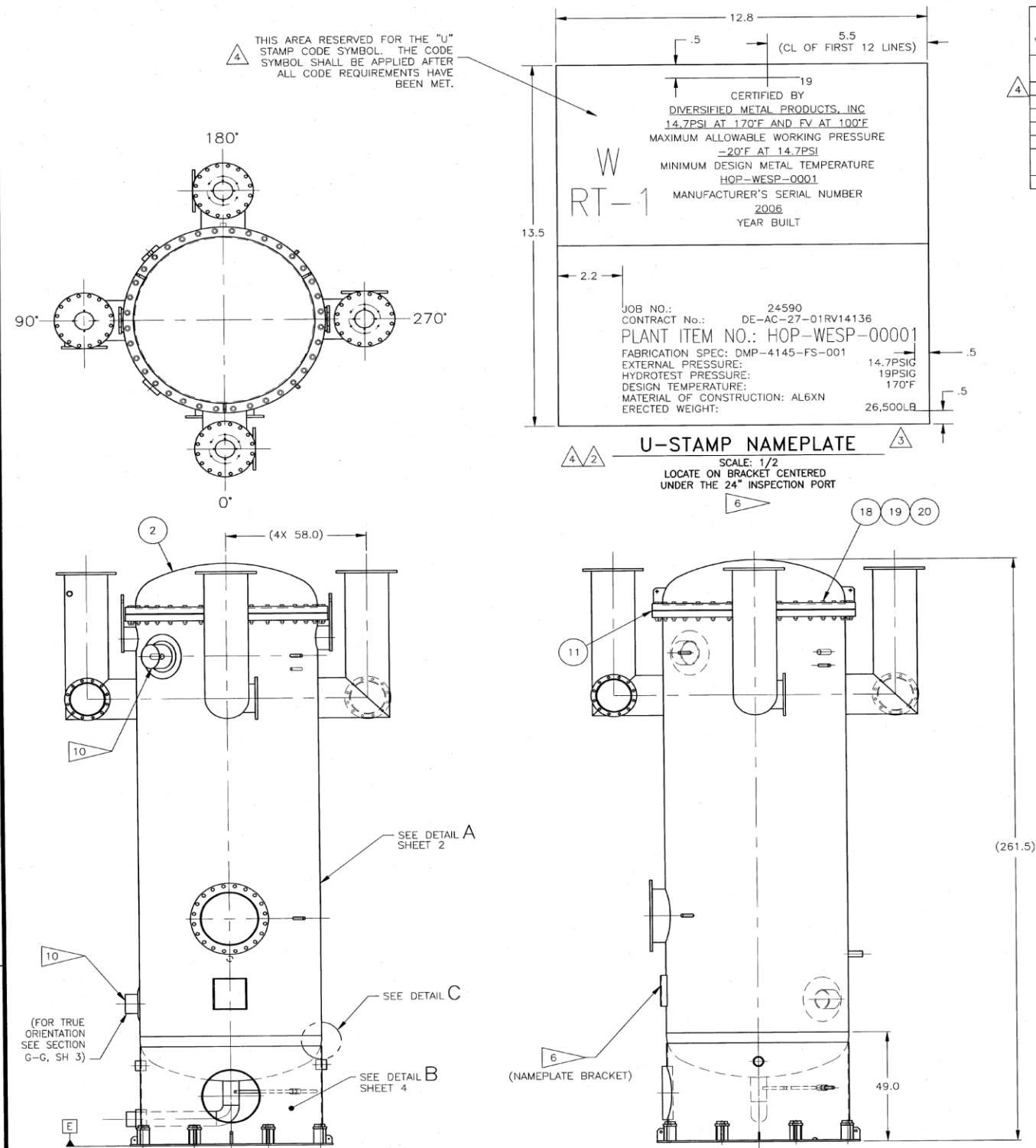
WM-22, W-32, Arc strikes adjacent to W-32



WM-25 W-6, 7 & 8 - 3/8" fillet weld not achievable. Configuration of lug to head only permits 1/4" fillet on Outside edge of lug to Top head Flange.

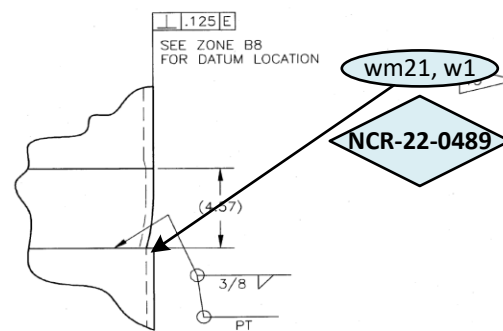
24590-WTP-NCR-MGT-22-0489  
Attachment 3,  
1 of 3  
Photos of areas rejected





VESEL TO BE CONSTRUCTED IN STRICT ACCORDANCE WITH 2001 EDITION, 2002 ADDENDA OF THE ASME CODE SECTION VIII DIVISION I FOR PRESSURE VESSELS AND IS TO BE SO STAMPED. INSPECTION BY HSB GLOBAL STANDARDS

	DESIGN	MAX A WORKING	MAX A N & C	HYDRO TEST
PRESSURE PSIG @	14.7/FV	16	125	19
TEMPERATURE °F	170	170	AMBIENT	AMBIENT
LIMITED BY	NA	NA	NA	NA
WIND PRESS. LBS/SQ FT	NA	CORROSION ALLOW INCHES	.04	
SEISMIC COEFFICIENT	NA	RADIOGRAPHIC EXAMINATION	RT-1	
WEIGHT FULL W/ WATER LBS	65,000	POST WELD HEAT TREATMENT @ 1100 °F	NA	
OPERATING WEIGHT LBS	26,500			



## DETAIL C

SCALE: 1/4

## GENERAL NOTES:

- FABRICATION AND WELDING SHALL BE IN ACCORDANCE WITH THIS DRAWING AND SPECIFICATION DMP-4145-FS-001.
- ABBREVIATIONS ARE IN ACCORDANCE WITH ANSI Y1.1.
- REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
- ATTACH DRAIN LINE AND LEVEL TRANSMITTER LINE AFTER THE SKIRT IS WELDED TO THE VESSEL TO ENSURE PROPER FIT UP WITH NOZZLE OUTLETS THROUGH SKIRT.
- OVERSIZE THICKNESS OF PLATES FOR FINISH MACHINING OF HEAD, VESSEL FLANGES AND REINFORCEMENT PADS IF REQD.
- U-STAMP NAMEPLATE SHALL BE IN ACCORDANCE WITH ASME PRESSURE VESSEL STANDARDS. WELD NAMEPLATE TO NAMEPLATE BRACKET WITH CONTINUOUS FILLET AFTER FINAL TESTING.
- THE LOCATION OF THE SHELL DIRECTLY UNDER THE LIFTING LUGS WILL BE ULTRASONICALLY EXAMINED OVER 100% OF THE AREA EXTENDING OUT 3 INCHES BEYOND THE PIPE WELDMENT.
- TUBES (ITEMS 32, 33, 34, & 35) SHALL BE FABRICATED FROM 3/8" THK PLATE WITH FULL PENETRATION SEAM WELDS. SEAM WELDS SHALL BE 100% RADIOGRAPHED. SEAM LOCATIONS OPTIONAL.
- VESSEL HEADS ARE 2:1 ELLIPSOIDAL WITH A 75.00 OD X 3/8 WALL THICKNESS. (ITEM 7) SHALL HAVE A 1.5 INCH STRAIGHT FLANGE AND SHALL BE WELD PREPPED, (ITEM 6) SHALL HAVE A 3.3 INCH STRAIGHT FLANGE AND SHALL NOT BE WELD PREPPED.
- PREP NOZZLES N4 & N13 FOR A 37 1/2° BEVEL WELD.
- PRIOR TO WELDING, ULTRASONIC EXAMINATION OF THE VESSEL BOUNDARY IS REQUIRED IN THE VICINITY WHERE COMPONENTS ARE ATTACHED BY FULL OR PARTIAL PENETRATION WELD.
- ITEM 31 MAY BE FABRICATED FROM 3/8 THK PLATE (ITEM 37) WITH FULL PENETRATION SEAM WELD. SEAM WELD REQUIRES PENETRANT EXAMINATION. SEAM LOCATION OPTIONAL.
- THE SPIRAL WOUND GASKET (ITEM 11) SHALL BE A RWI, OUTER RING 78 1/2" OD X 77 1/4" ID, INNER RING 76" OD X 75" ID. INNER RING, OUTER RING, AND WINDING MATERIAL SHALL BE AL6XN UNS N08367. FILLER MATERIAL SHALL BE GRAFOIL.
- POST WELD HEAT TREAT AS REQD AT A LATER DATE.
- ON NOZZLE N5 DUE TO SIZE AND SPACE RESTRAINTS RADIOGRAPHIC TESTING FOR THE WELD MAY NOT BE ACCURATELY COMPLETED. ULTRASONIC TESTING OF THE WELD IS AN ACCEPTABLE SUBSTITUTE IF NECESSARY.

PARTS LIST/MATERIAL LIST					
QTY	PART/DASH NUMBER	NOMENCLATURE/DESCRIPTION	MATERIAL/REFERENCE	SHEET	ITEM NO
-020	-010	VESEL SUBASSEMBLY		1	1
1	-020	VESEL HEAD WELDMENT		5	2
					3
					4
					5
1		TOP VESSEL HEAD	ASTM B688/ASME SB688 UNS N08367	6	
1		BOTTOM VESSEL HEAD	ASTM B688/ASME SB688 UNS N08367	7	
				8	
				9	
				10	
1		SPIRAL WOUND GASKET	GARLOCK	11	
				12	
				13	
				14	
				15	
				16	
				17	
36		BOLT, HEX HD, 1 1/2-6 UNC-2A X 8" LONG	ASTM A193 GR B8	18	
36		HEX NUT, 1 1/2-6 UNC-2B	ASTM A194 GR 8F	19	
72		PLAIN WASHER, 1 1/2 (SERIES AND TYPE OPTIONAL)	18-8 SST	20	
				21	
				22	
1		ELBOW, 90° 6" SR, SCHED 40, BUTT WELD	ASTM B366/ASME SB366 UNS N08367	23	
AR		PIPE, 1" SCHED 40	ASTM B675/ASME SB675 UNS N08367	24	
AR		PIPE, 2" SCHED 40	ASTM B675/ASME SB675 UNS N08367	25	
AR		PIPE, 2" SCHED 40	ASTM A312/ASME SA312 GR TP 304L	26	
AR		PIPE, 4" SCHED 40	ASTM A312/ASME SA312 GR TP 304L	27	
AR		PIPE, 6" SCHED 40	ASTM B675/ASME SB675 UNS N08367	28	
AR		PIPE, 8" SCHED 40	ASTM B675/ASME SB675 UNS N08367	29	
AR		PIPE, 8" SCHED 40	ASTM A312/ASME SA312 GR TP 304L	30	
AR		PIPE, 24" SCHED 40S	ASTM A312/ASME SA312 GR TP 304L	31	
AR		TUBE, 10.75 OD X 10.00 ID	ASTM B688/ASME SB688 UNS N08367	32	
AR		TUBE, 12.75 OD X 12.00 ID	ASTM B688/ASME SB688 UNS N08367	33	
AR		TUBE, 18.00 OD X 17.25 ID	ASTM B688/ASME SB688 UNS N08367	34	
AR		TUBE, 24.00 OD X 23.25 ID	ASTM B688/ASME SB688 UNS N08367	35	
AR		PLATE, 1/4 THK	ASTM B688/ASME SB688 UNS N08367	36	
AR		PLATE, 3/8 THK	ASTM A240/ASME SA240 TYPE 304L	37	
AR		PLATE, 1/2 THK	ASTM B688/ASME SB688 UNS N08367	38	
AR		PLATE, 1/2 THK	ASTM A240/ASME SA240 TYPE 304L	39	
AR		PLATE, 1 1/4 THK	ASTM B688/ASME SB688 UNS N08367	40	
AR		PLATE, 1" THK	ASTM B688/ASME SB688 UNS N08367	41	
AR		PLATE, 1" THK	ASTM A240/ASME SA240 TYPE 304L	42	
AR		PLATE, 5/8 THK	ASTM A240/ASME SA240 TYPE 304L	43	
AR		PLATE, 1 1/2 THK	ASTM B688/ASME SB688 UNS N08367	44	
AR		PLATE, 3 THK	ASTM B688/ASME SB688 UNS N08367	45	
AR		PLATE, 3/8 THK	ASTM B688/ASME SB688 UNS N08367	46	
AR		PLATE, 2 THK	ASTM B688/ASME SB688 UNS N08367	47	
-2		PIPE, 3" SCHED 40 X 1 1/4" LONG	ASTM B675/ASME SB675 UNS N08367	48	

24590-WTP-NCR-MGT-22-0489

Attachment 2,  
1 of 6Weld Maps locating rejected welds or  
area adjacent to weld that was rejected24590-HLW-FIR-CON-22-00006  
Attachment 2  
Weld Map - Sheet 1 of 10From 24590-QL-POA-MKE0-00001-09-14  
24590-HLW-FIR-CON-22-00006

Page \_\_\_\_ of \_\_\_\_

DIMENSIONING AND TOLERANCING SHALL BE INTERPRETED PER  
ANSI Y14.5M-1994  
UNSPECIFIED TOLERANCES SHALL BE:  
DECIMAL .XX ± .06  
ANGULAR ± 1°  
ALL IMPLIED 90° ANGLES SHALL BE PERPENDICULAR WITHIN  
THE GREATEST TOLERANCE OF THE LINEAR DIMENSIONS  
ALL COAXIAL FEATURES SHALL BE CONCENTRIC WITHIN  
.031 INCH UNLESS OTHERWISE SPECIFIED

REF NUMBER	DOCUMENT TITLE	WFO	REV	DESCRIPTION
5	NO CHANGE			
4	INCORPORATE DCN-082 CHANGE U-STAMP NAMEPLATE AND VESSEL DATA TABLE			
3	INCORPORATE DCN-079 CHANGE U-STAMP NAMEPLATE			
2	INCORPORATE DCN-078 INCORPORATE DCN-071 CHANGE U-STAMP NAMEPLATE			
1	INCORPORATED DCN-001, -002 & -003			
0	RELEASED FOR CONSTRUCTION			
REFERENCE DOCUMENTS		REVISION		
NEXT USED ON: DMP 4145-M-301		FILE NAME: M-302_01_REV 5.DWG		

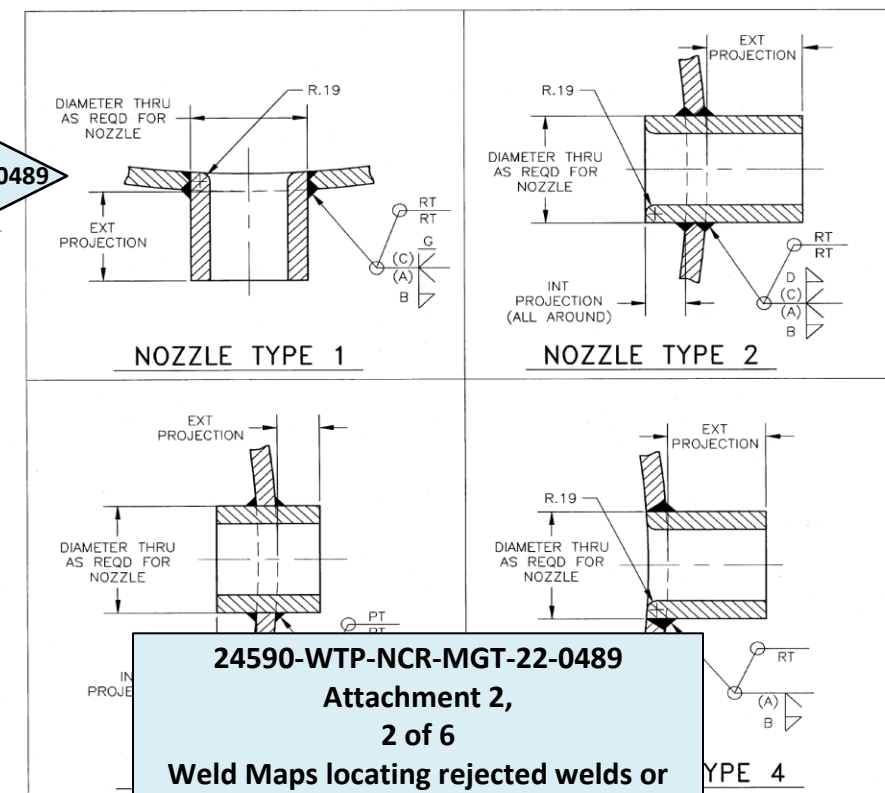
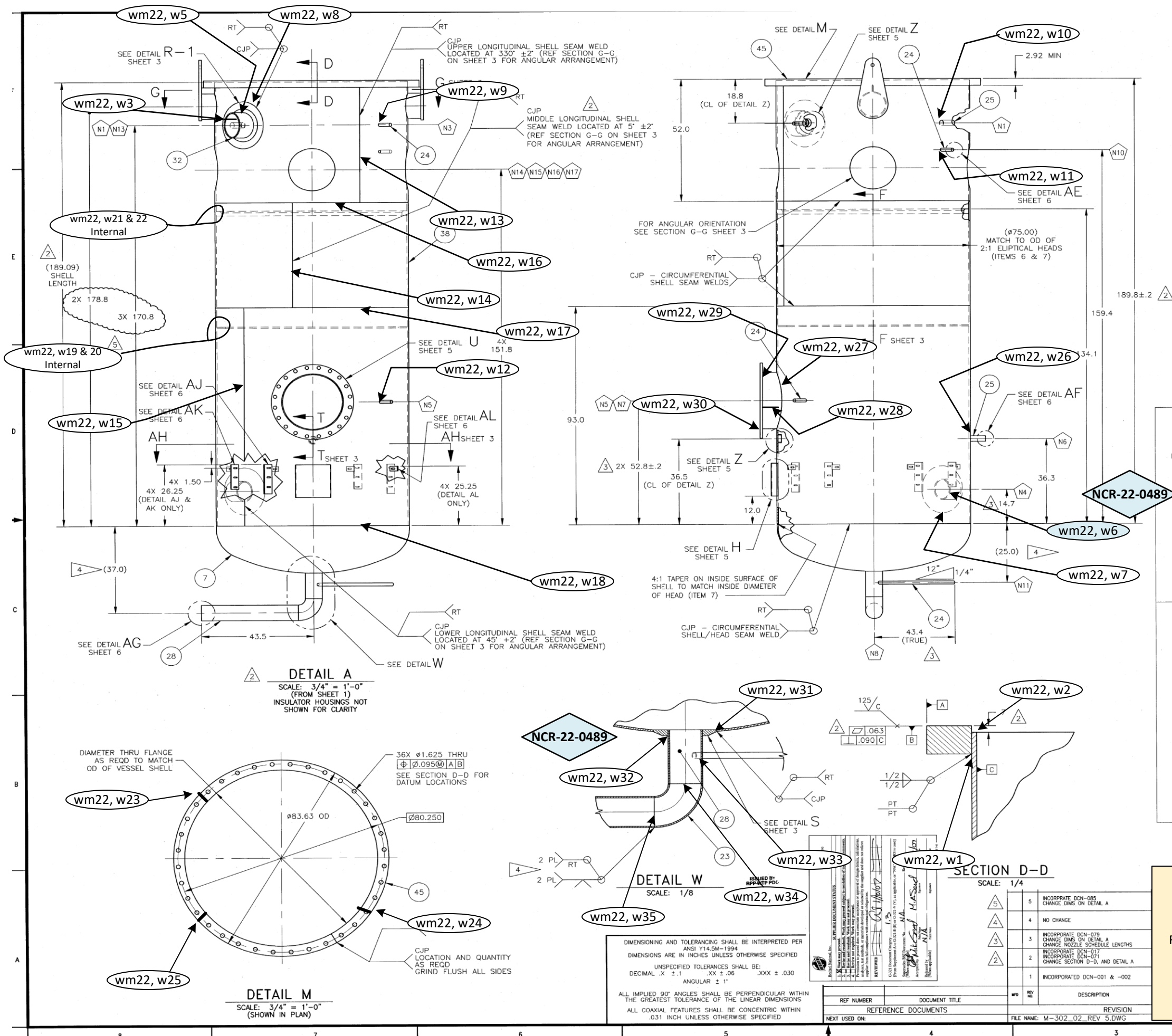
PO 24590-QL-POA-MKE0-00001-09-14

PREPARED FOR:  
DIVERSIFIED METAL  
PRODUCTS INC

PREPARED BY:  
GForce  
engineering & technology

HLW-1  
VESSEL SUBASSEMBLY  
HOP-WESP-0001

DWG NO: DMP 4145-M-302  
REV: 5  
SHEET: 1 of 6



**Attachment 2,  
2 of 6**

**Weld Maps locating rejected welds or area adjacent to weld that was rejected**

Attachment 2  
Field Map - Sheet 2 of 10

From 24590-QL-POA-MKE0-00001-09-15

24590-HLW-FIR-CON-22-00006

Page of

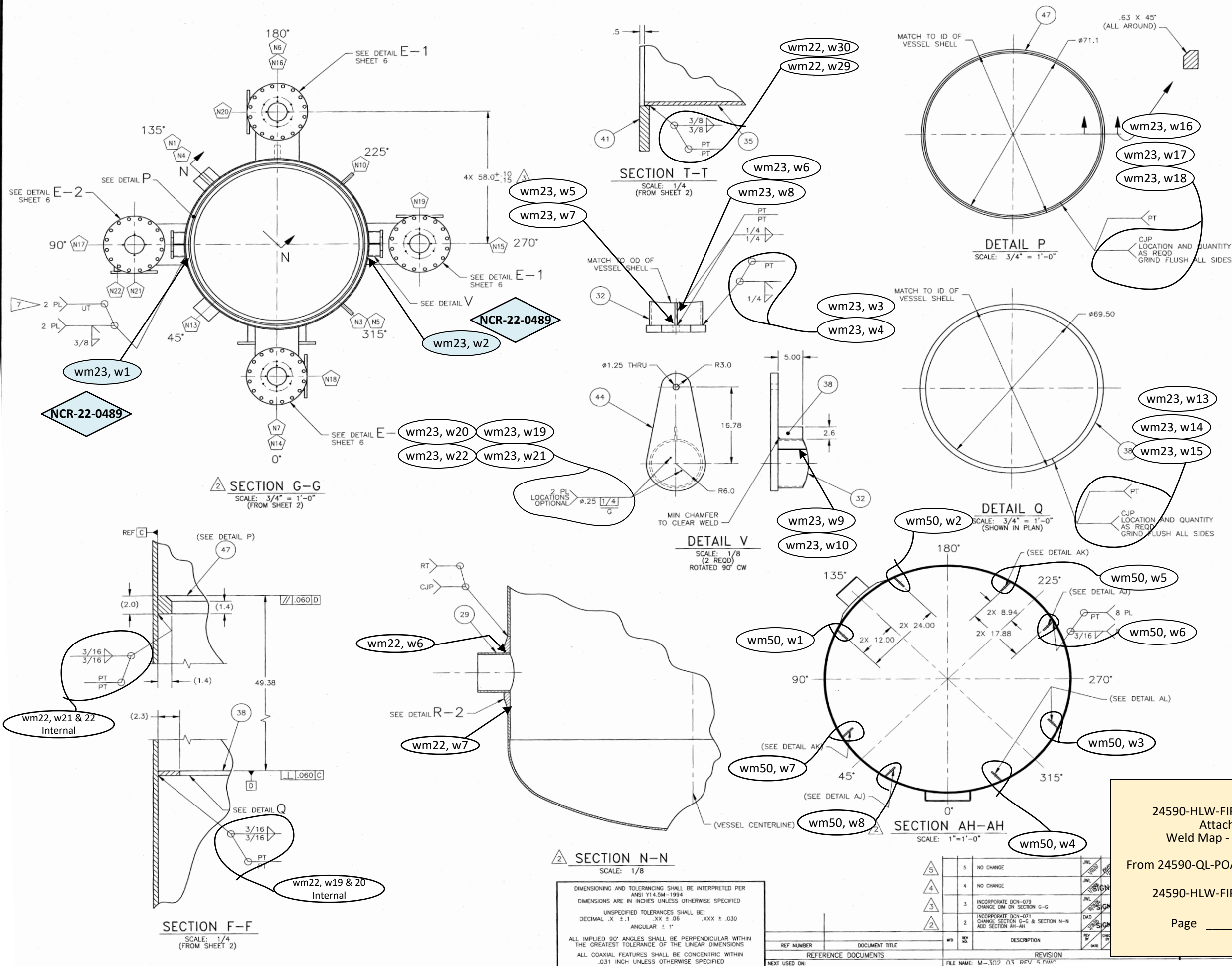
PREPARED FOR: *Rev. 00F*  
**DIVERSIFIED METAL  
PRODUCTS INC**

PREPARED BY: **GForce<sup>inc</sup>**  
engineering & technology

HLW-1  
VESSEL DETAILS  
HOP-WESP-0001

DWG. SIZE F	BLDG. NO. N/A	DWG. NO. DMP 4145-M-302	REV 5
DWG. SCALE: SHOWN		TRANSMITTAL NO.	SHEET 2 of





24590-WTP-NCR-MGT-22-0489  
Attachment 2,  
3 of 6  
Weld Maps locating rejected welds or  
area adjacent to weld that was rejected

24590-HLW-FIR-CON-22-00006  
Attachment 2  
Weld Map - Sheet 3 of 10  
From 24590-QL-POA-MKE0-00001-09-16  
24590-HLW-FIR-CON-22-00006

Page \_\_\_\_ of \_\_\_\_

DIMENSIONING AND TOLERANCING SHALL BE INTERPRETED PER  
ANSI Y14.5M-1994  
DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED  
UNSPECIFIED TOLERANCES SHALL BE:  
DECIMAL .XX ± .06 .XXX ± .030  
ANGULAR ± 1°  
ALL IMPLIED 90° ANGLES SHALL BE PERPENDICULAR WITHIN  
THE GREATEST TOLERANCE OF THE LINEAR DIMENSIONS  
ALL COAXIAL FEATURES SHALL BE CONCENTRIC WITHIN  
.031 INCH UNLESS OTHERWISE SPECIFIED

REV	NO	DESCRIPTION	DATE
5	NO CHANGE		
4	NO CHANGE		
3	INCORPORATE DCN-079 CHANGE DIM ON SECTION G-G		
2	INCORPORATE DCN-071 CHANGE SECTION G-G & SECTION N-N ADD SECTION AH-AH		

REF NUMBER DOCUMENT TITLE  
REFERENCE DOCUMENTS  
NEXT USED ON: FILE NAME: M-302 03 REV 5 11/17

FOR PARTS LIST AND  
GENERAL NOTES SEE SHEET 1

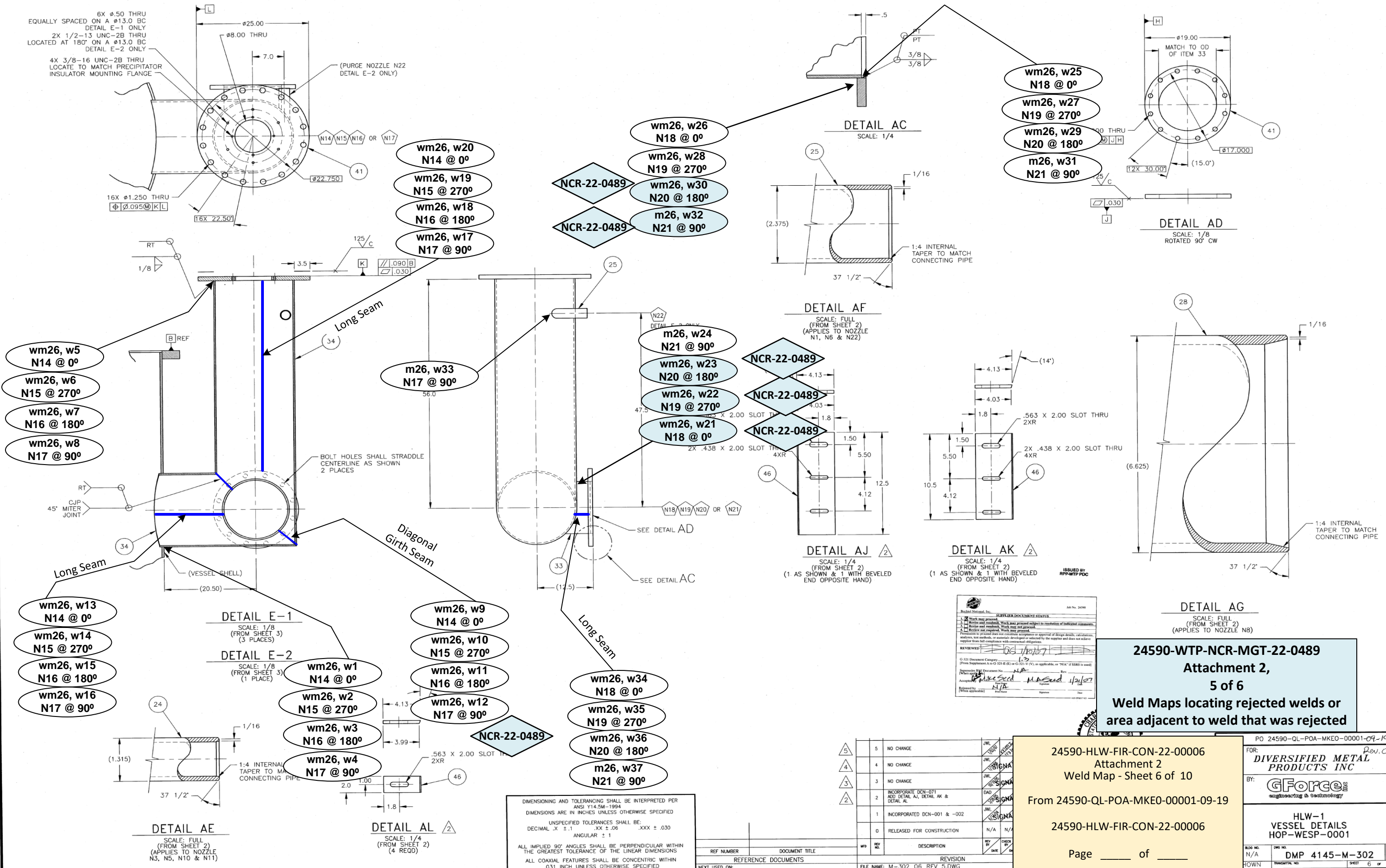
PD 24590-QL-POA-MKE0-00001-09-16  
Rev. 01  
ED FOR: DIVERSIFIED METAL  
PRODUCTS INC  
ED BY: GForce  
engineering & technology

HLW-1  
VESSEL DETAILS  
HOP-WESP-0001

RDD NO. N/A DMP 4145-M-302 5

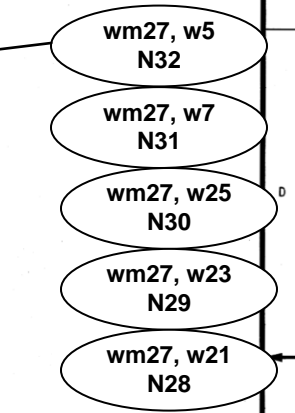
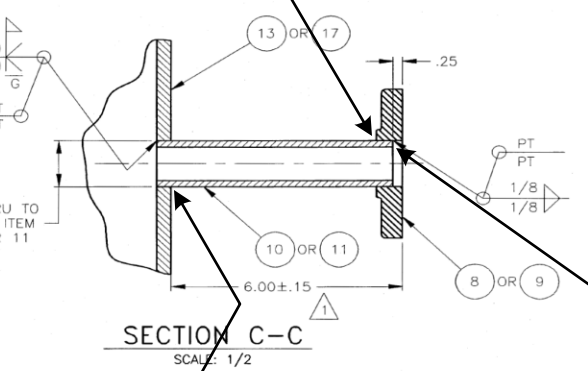
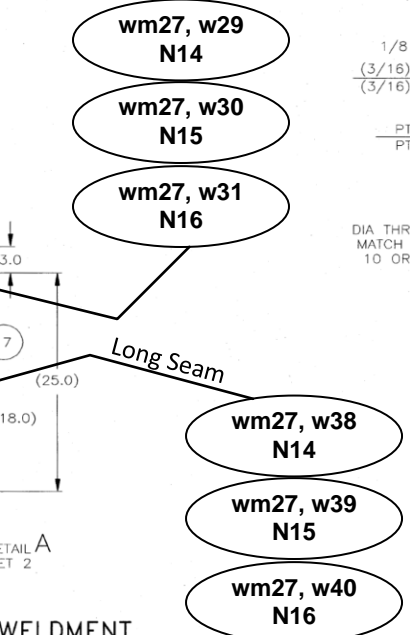
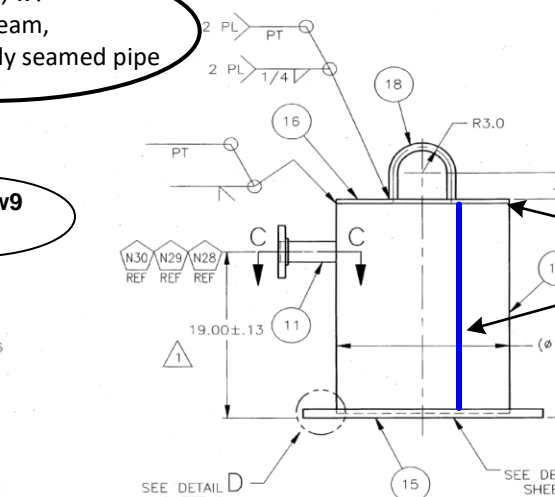
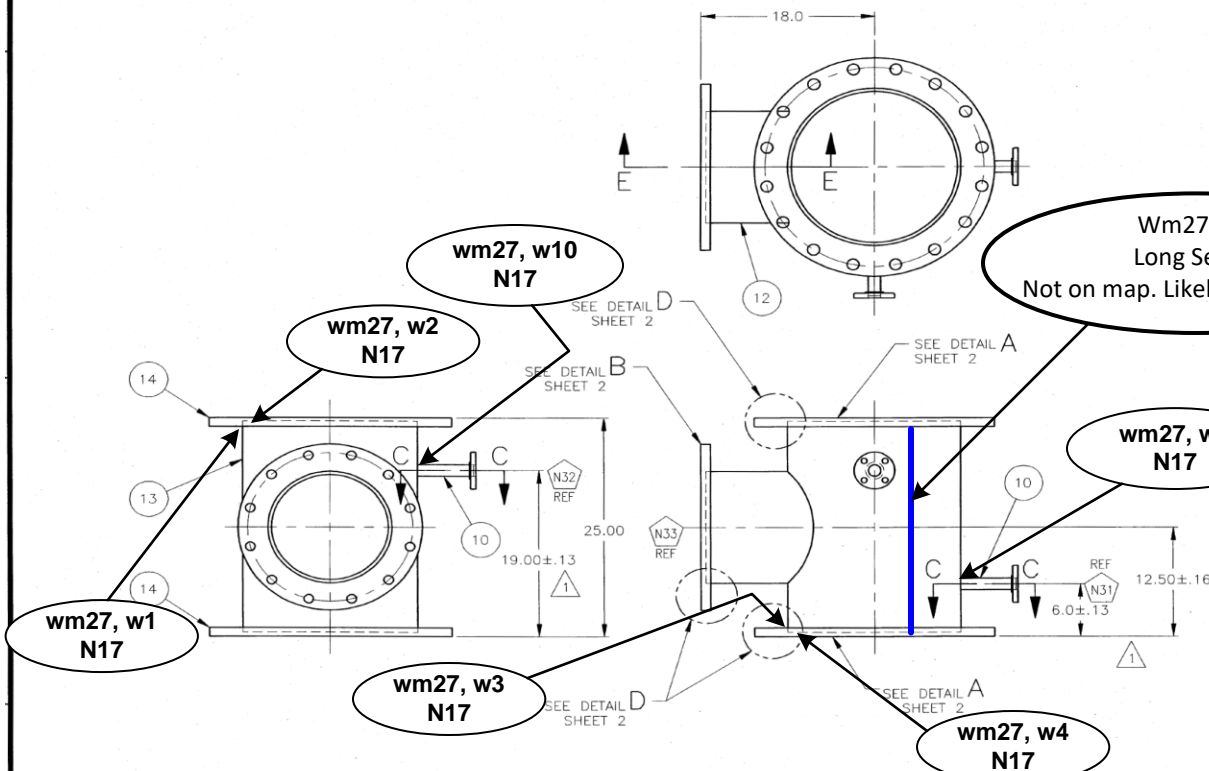
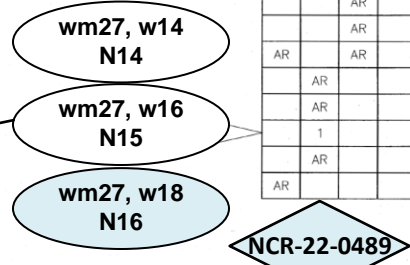
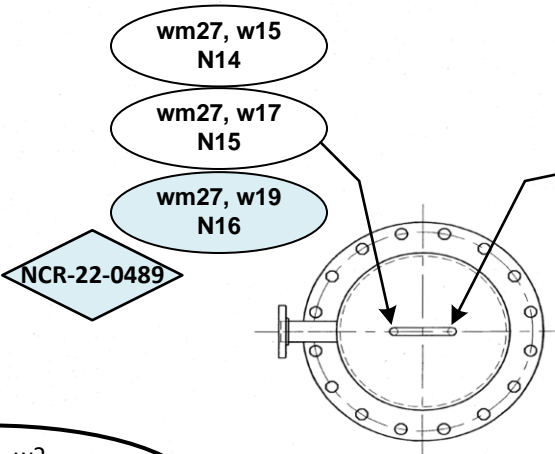
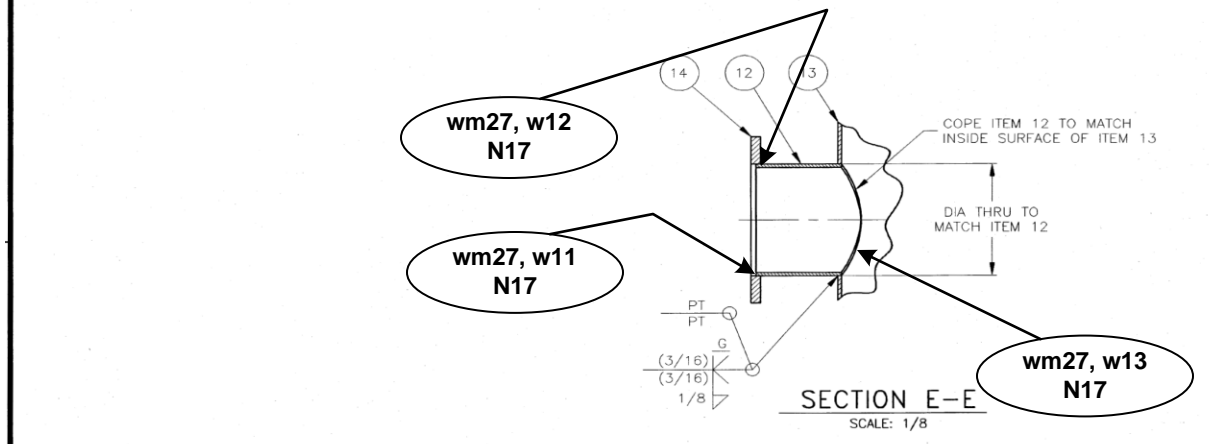






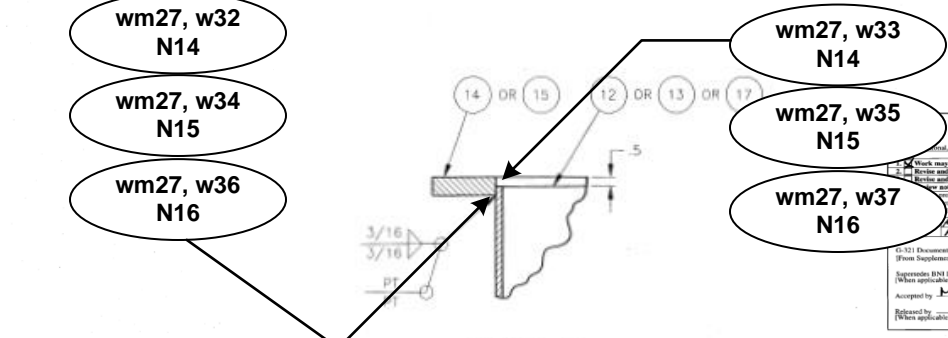
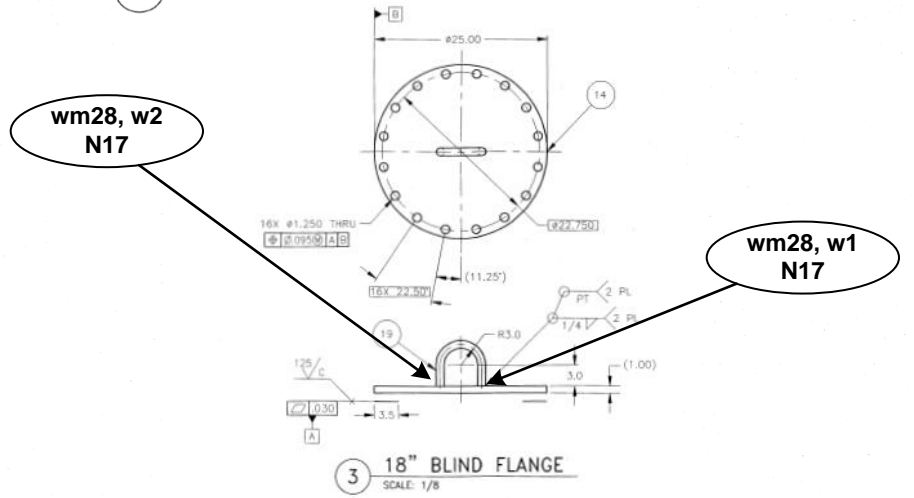


PARTS LIST/MATERIAL LIST					
QTY	PART/DASH NUMBER	NOMENCLATURE/DESCRIPTION	MATERIAL/REFERENCE	SHEET	ITEM NO
-010	-010	INSULATOR SPOOL - ELECTRICAL WELDMENT		1	1
-020	-020	INSULATOR SPOOL - WELDMENT		1	2
-030	-030	18" BLIND FLANGE		2	3
					4
					5
					6
					7
2		PIPE FLANGE, SLIP-ON, 1" CLASS 150 FL FACE	ASTM A182/ASME SA182 GR TP 304L	8	
1		PIPE FLANGE, SLIP-ON, 2" CLASS 150 FL FACE	ASTM B462/ASME SB462 UNS N08367	9	
AR		PIPE, 1" SCHED 40S	ASTM A312/ASME SA312 GR TP 304L	10	
AR		PIPE, 2" STD WALL (.154 THK)	ASTM B675/ASME SB675 UNS N08367	11	
AR		PIPE, 12" SCHED 40S	ASTM A312/ASME SA312 GR TP 304L	12	
AR		PIPE, 18" SCHED 40S	ASTM A312/ASME SA312 GR TP 304L	13	
AR		PLATE, 1" THK	ASTM A240/ASME SA240 TYPE 304L	14	
AR		PLATE, 1" THK	ASTM B688/ASME SB688 UNS N08367	15	
AR		PLATE, 1/2 THK	ASTM B688/ASME SB688 UNS N08367	16	
1		TUBE, 18.00 OD X 17.25 ID X 24.00 LONG	ASTM B688/ASME SB688 UNS N08367	17	
AR		BAR STOCK, #7/8	ASTM A479/ASME SA479 TYPE 304L	18	
AR		BAR STOCK, #1-1/8	ASTM A479/ASME SA479 TYPE 304L	19	



1 INSULATOR SPOOL - ELECTRICAL WELDMENT

2 INSULATOR SPOOL - WELDMENT



24590-WTP-NCR-MGT-22-0489  
Attachment 2,  
6 of 6  
Weld Maps locating rejected welds or  
area adjacent to weld that was rejected

DIMENSIONING AND TOLERANCING SHALL BE  
ANSI Y14.5M-1994  
DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED  
UNSPECIFIED TOLERANCES SHALL  
DECIMAL .XX ± .06  
ANGULAR ± 1°  
ALL IMPLIED 90° ANGLES SHALL BE PER  
THE GREATEST TOLERANCE OF THE LINE  
ALL COAXIAL FEATURES SHALL BE CONCENTRIC WITHIN  
.031 INCH UNLESS OTHERWISE SPECIFIED

REFERENCE DOCUMENTS  
NEXT USED ON: DMP 4145-M-301  
FILE NAME: M-303\_01\_REV 1.DWG

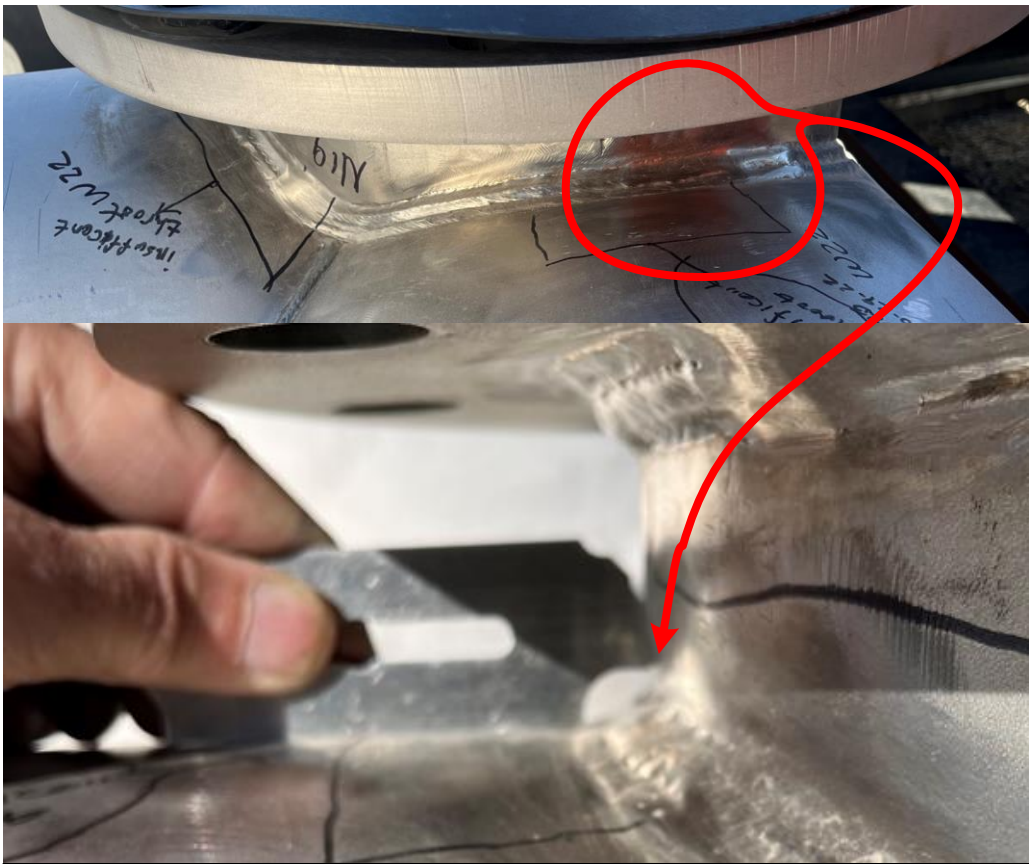
24590-HLW-FIR-CON-22-00006  
Attachment 2  
Weld Map - Sheet 7 of 10  
From 24590-QL-POA-MKE0-00001-09-20 & 21  
24590-HLW-FIR-CON-22-00006  
Page \_\_\_\_ of \_\_\_\_

PO 24590-QL-POA-MKE0-00001  
ED FOR:  
DIVERSIFIED METAL  
PRODUCTS INC  
ED BY:  
GForce  
HLW-1  
WELDMENTS & DETAILS  
HOP-WESP-0001  
DMP 4145-M-303  
1 of 2





WM-26 W-21  
Insufficient weld throat by ~ 1/16" between 7 to 1 O'clock



WM-26 W-22  
Undersized weld by ~1/16", & Insufficient weld throat @ 11-12 O'clock and 2-3 O'clock



WM-26 W-23  
Undersized weld by ~1/16", & Insufficient weld throat



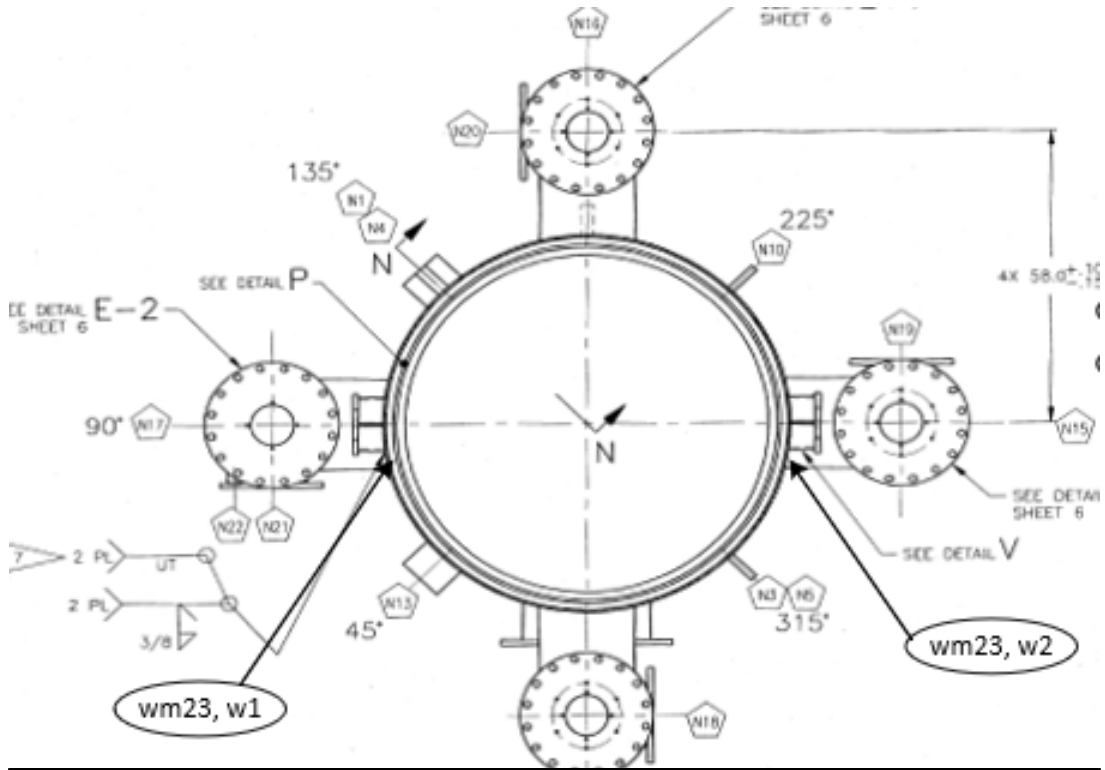
WM-26 W-30  
Undersized weld by ~ 1/16", & Insufficient weld throat

24590-WTP-NCR-MGT-22-0489  
Attachment 3,  
2 of 3  
Photos of areas rejected





WM-26 W-32  
Undersized weld, & Insufficient weld throat ~ 90% of over-all weld length

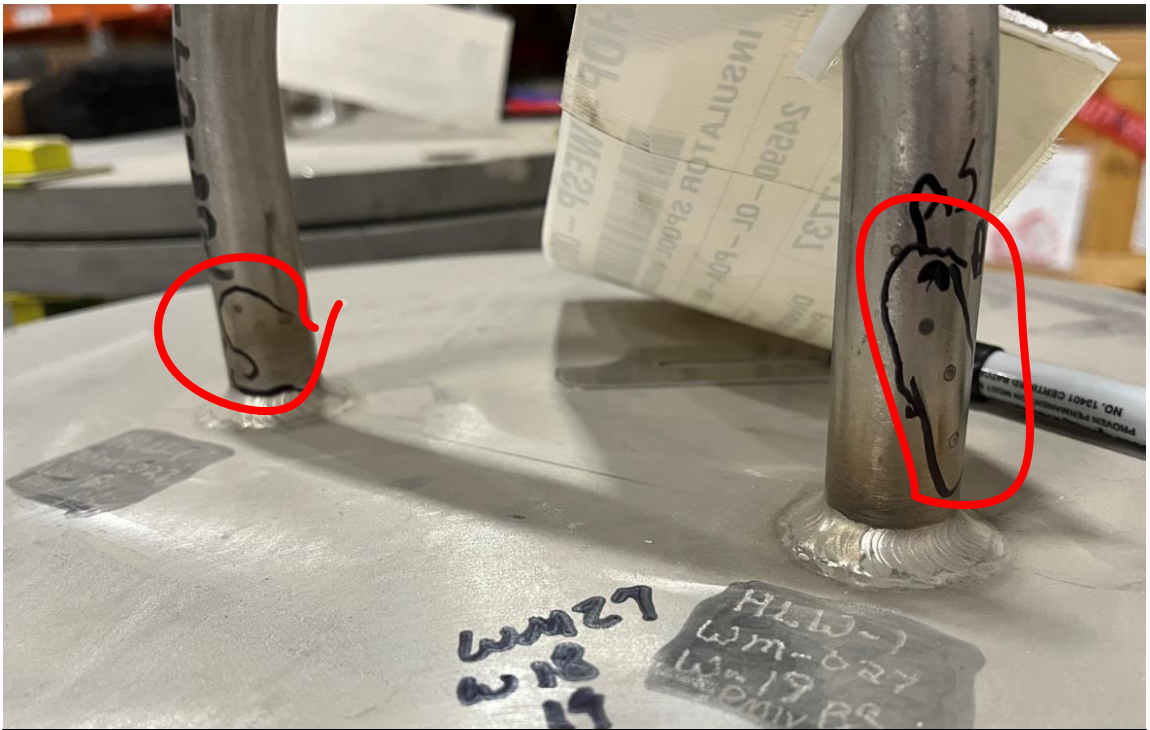


WM-23 W-1 - insufficient throat at 2-3 O'clock  
**NO PHOTO WAS TAKEN**  
10" tube to shell Lifting Lug Assembly @ Az 90

WM-23 W-2 – Insufficient throat at 7-10 O'clock  
**NO PHOTO WAS TAKEN**  
10" tube to shell Lifting Lug Assembly @ Az 270



Arc Strikes adjacent to WM-26 W-12



Arc Strikes adjacent to WM-27 W-18& 19

24590-WTP-NCR-MGT-22-0489  
Attachment 3,  
3 of 3  
Photos of areas rejected

# In-Progress 24590-WTP-NCR-MGT-22-0490

Attach ...



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Responsible Individual Creates Conditional Releases  
and Dispositions



New Interim Disposition



New Disposition

24590-WTP-NCR-MGT-22-0490

NCR Header





Weld ID/Description			See Weld map sht #	Dia.	Weld Type	Weld Size ID	Weld Size OD	Acc/Rej	By /Date	
WM-30 w-1	Skirt to Head	sht 1 detail C	1	NA	fs	NA	3/8"	REJECT	RAJ 10-29-22	~20" was undersized by ~1/16". Not able to inspect area from ~270° to 90°, weld hidden by the vessel support saddle & cribbing
WM-31 W-5	N-13, 10" tube to 1-1/4" plate	sht 2 Nozzle type 2	2	10"	cjp/fw	7/16"	3/8"	REJECT	TRB 10-28-22	Weld undersized @ 11:30- 2 and 4-5 Oclock
WM-32 W-1	10" tube to shell Lifting Lug Assembly @ Az 90	Section G-G sht 3	3	10"	cjp/fw	NA	3/8"	REJECT	TRB 10-29-22	insufficient throat at 1-3 & 4-5 O'clock
WM-32 W-2	10" tube to shell Lifting Lug Assembly @ Az 270	Section G-G sht 3	3	10"	cjp/fw	NA	3/8"	REJECT	TRB 10-29-22	insufficient throat for 1-1/2" area @ 8 O'clock
WM-34 W-6	Det Y lug to flange @ Az 0	vessel head weldment detail , x-x	5	NA	fw	NA	3/8"	REJECT	RAJ 10-28-22	Configuration of lug to head only permits 1/4" fillet on OD of lug to head Flange
WM-34 W-7	Det Y lug to flange @ Az 120	vessel head weldment detail , x-x	5	NA	fw	NA	3/8"	REJECT	RAJ 10-28-22	Configuration of lug to head only permits 1/4" fillet on OD of lug to head Flange
WM-34 W-8	Det Y lug to flange @ Az 240	vessel head weldment detail , x-x	5	NA	fw	NA	3/8"	REJECT	RAJ 10-28-22	Configuration of lug to head only permits 1/4" fillet on OD of lug to head Flange
WM-35 W-30	N-20, flange to 12" tube @ Az 180	Detail E-1, A-C	6	12"	fw	NA	3/8"	REJECT	RAJ 10-28-22	Undersized weld ~6" long @ 3 O clock by ~ 1/16".
WM-36 W-13	N-33 to N-17 Insulator spool weldment shell	sec C-C, 303, sh1	7	12"	cjp/fw	NA	1/8"	REJECT	RAJ 10-29-22	undersized weld ~1-1/2" long @ 2 O clock.
adjacent to WM-36 W-15	7/8" bar to 1" flange w/with N-14	sec C-C, 303, sh1	7	NA	fw	NA	1/4"	REJECT	RAJ 10-29-22	Arc strikes
WM-36 W-18	7/8" bar to 1" flange w/with N-16	sec C-C, 303, sh1	7	NA	fw	NA	1/4"	REJECT	RAJ 10-29-22	Undersized in weld throat by ~ 1/32"
adjacent to WM-36 W-18	7/8" bar to 1" flange w/with N-16	sec C-C, 303, sh1	7	NA	fw	NA	1/4"	REJECT	RAJ 10-29-22	Arc strikes
WM-36 W-19	7/8" bar to 1" flange w/with N-16	sec C-C, 303, sh1	7	NA	fw	NA	1/4"	REJECT	RAJ 10-29-22	Undersized in weld throat by ~ 1/32"

Email	NCR Priority	Supplier/SubContractor
rajanyse@bechtel.us	2	Diversified Metal Products, Inc
Contract Number / Purchase Order	Quality Level	Custody Currently With
24590-QL-POA-MKE0-00001	Q	Construction
ASME Code Stamped Component or Assembly	Suspect/Counterfeit?	Commissioning Breakdown Structure
Yes	No	

Nonconformance Description

Inspection of all accessible external welds on the HOP-WESP-00002 was performed as per 24590-WTP-RPT-ENG-22-00003.

1. Numerous welds were found to be rejectable.
2. There were rejectable surface defects (arc strikes).
3. In one case the weld specified was not actually obtainable due to configuration of the vessel head and flange.

See attachment 1, 2 & 3 of NCR for details

Additional Information

Drawing/Specification References:

Document Number	Rev	Document Title	Sections	Comments
24590-WTP-MRR-PROC-0017737	001	DIVERSIFIED METAL PRODUCTS INC		
24590-WTP-MN-CON-01-001-10-26	002	VT-ASME VIII NONDESTRUCTIVE EXAMINATION STANDARD		
24590-QL-POA-MKE0-00001-09-10	00C	DRAWING - HLW-2 WESP WELDMENTS & DETAILS, DMP 4145-M-403		
24590-QL-POA-MKE0-00001-09-09	00E	DRAWING - HLW-2 VESSEL DETAILS HOP-WESP-0002		
24590-QL-POA-MKE0-00001-09-08	00E	DRAWING - HLW-2 VESSEL DETAILS HOP-WESP-0002		
24590-QL-POA-MKE0-00001-09-06	00E	DRAWING - HLW-2 VESSEL DETAILS HOP-WESP-0002		
24590-QL-POA-MKE0-00001-09-05	00E	DRAWING - HLW-2 VESSEL DETAILS HOP-WESP-0002		
24590-QL-POA-MKE0-00001-09-04	00E	DRAWING - HLW-2 VESSEL SUBASSEMBLY HOP-WESP-0002		
24590-QL-POA-MKE0-00001-09-03	00E	DRAWING - HLW-2 WESP VESSEL ASSEMBLY HOP-WESP-00002		
24590-QL-POA-MKE0-00001-09-01	00E	DRAWING - HLW-2 WESP VESSEL ASSEMBLY HOP-WESP-0002		

Applicable Items

Item Number	Parent ID	Item Description	Item Location	Item Quantity
24590-HLW-MK-HOP-WESP-00002	HOP-WESP-00002	MELTER 2 WET ELECTROSTATIC PRECIPITATOR (WESP)	MHF - 4N545 W407	1

Condition Reports Associated with this NCR

Validator	Validation Date
-----------	-----------------

In-Progress 24590-WTP-NCR-MGT-22-0490

Press F5 To refresh

Responsible Individual Creates Conditional Releases and Dispositions

Attach ...

 View Full PDF

 New Interim Disposition

 New Disposition

Yes

NCR Title

HLW - HOP-WESP-00002

Step 2: Are hold tags required?

Yes

Comments for Hold Tags

Step 3: Select the NCR Category

Supplier

Step 4: Stop Work?

No

Occurrence Reporting

No

Is this NCR related to an electrical item?

No

Step 5. Please check each WTP Area that is affected by this NCR.

HLW

Step 6. Select the Disposition Approval Authority to notify.

Skiffington, Mark

Step 7. Select the RQO to notify.

Padilla, Richard\*

Condition Reports

Condition Reports Associated with this NCR

Are there any Condition Reports associated with this CR? If applicable, identify any Condition Reports associated to this NCR in the Condition Report section below.

If there are no associated Condition Reports, please enter N/A.

Condition Reports Associated to this NCR

Add CR Number

Work Order/Work Request and Standing/Shift Order Numbers



In-Progress 24590-WTP-NCR-MGT-22-0490

Press F5 To refresh  
Responsible Individual Creates Conditional Releases  
and Dispositions

Attach ...

View Full PDF

+ New Interim Disposition

+ New Disposition

Enter a Standing/Shift Order Number:

If not applicable please enter N/A.

Related Processes

Hold Tags

Hold Tags - [View](#)

Tags Hung	Tags Removed	All Tags Removed or Accounted For?
0	0	False

Conditional Releases

Interim Dispositions

Dispositions

Disposition #001 - [View](#) Status: **In Progress** **NOT Ready for Implementation**

Recommended Disposition Type	Marked for Final	Submitted Date	Submitted By	Process Status
Other	No	3/13/2023 6:18 PM	Padilla, Richard	Active

Process Task

Engineer Submits Final Disposition, Final Disposition

Is this a superseded Disposition?

☐ Check this box to hide this Disposition until closure

Currently Active Users

Castaneda, Melissa

VA Concurrence Date	DAA Approval Date	Recommended Disposition
-	-	Route to Engineering for Disposition.

Final Disposition Type	Submitted Date	Submitted By
------------------------	----------------	--------------

Final Disposition

Attachments

**REQUIRED FOR FINAL RECORD—Files attached here are part of the final record and will print with NCR.**

Please ensure these files are formatted properly, and that documents (i.e. Word, Excel, emails, etc.) are converted to a PDF file format.

NCR 22-0490 FIR reject list HOP-WESP-00002.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	12/16/2022 6:52 PM	Janysek, Roy
NCR-22-0490 Reject Photos HOP-WESP-00002.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	12/16/2022 6:52 PM	Janysek, Roy
NCR-22-0490 weld map WESP-00002.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	12/16/2022 6:52 PM	Janysek, Roy

Attach ...

Comments

In-Progress 24590-WTP-NCR-MGT-22-0490

Press F5 To refresh

Responsible Individual Creates Conditional Releases and Dispositions

Attach ...

View Full PDF

New Interim Disposition

New Disposition

Add Comment

User	Date	Comment
Skiffington, Mark	3/13/2023 11:26 AM	reference 24590-HLW-FIR-CON-22-00005

Save Comments

Routing Slip

Participants	Completed	Status	Result	Comments
Validating Authority Validates NCR		12/16/2022 6:59 PM		
Skiffington, Mark	3/13/2023	Completed	NCR is Valid	
Originator Notified of Valid NCR		3/13/2023 2:26 PM		
Janysek, Roy	3/13/2023	Notified		
RQO Notified for Hold Tags		3/13/2023 2:26 PM		
Padilla, Richard	3/13/2023	Notified		
Disposition Approval Authority Assigns Responsible Individual		3/13/2023 2:26 PM		
Skiffington, Mark	3/13/2023	Completed	Assign Responsible Individual	
Responsible Individual Creates Conditional Releases and Dispositions		3/13/2023 2:26 PM		
Padilla, Richard	-	Active		



WM-36 W-18, Undersized weld Throat & arc strike



WM-36 W-19, Undersized weld throat



adjacent to WM-36 W-15, Arc Strikes



WM-36 W-13, Undersized weld ~ 1-1/2" long section



WM-34 W-6, 7 & 8 undersized at end, 3/8" is not achievable



WM-32 W-2, Insufficient throat for ~ 1-1/2" segment at 8 O'clock



WM-32 W-1, Insufficient throat at 1-3 & 4-5 O'clock



WM-31 W-5, Weld undersized @ 11:30- 2 and 4-5 O'clock

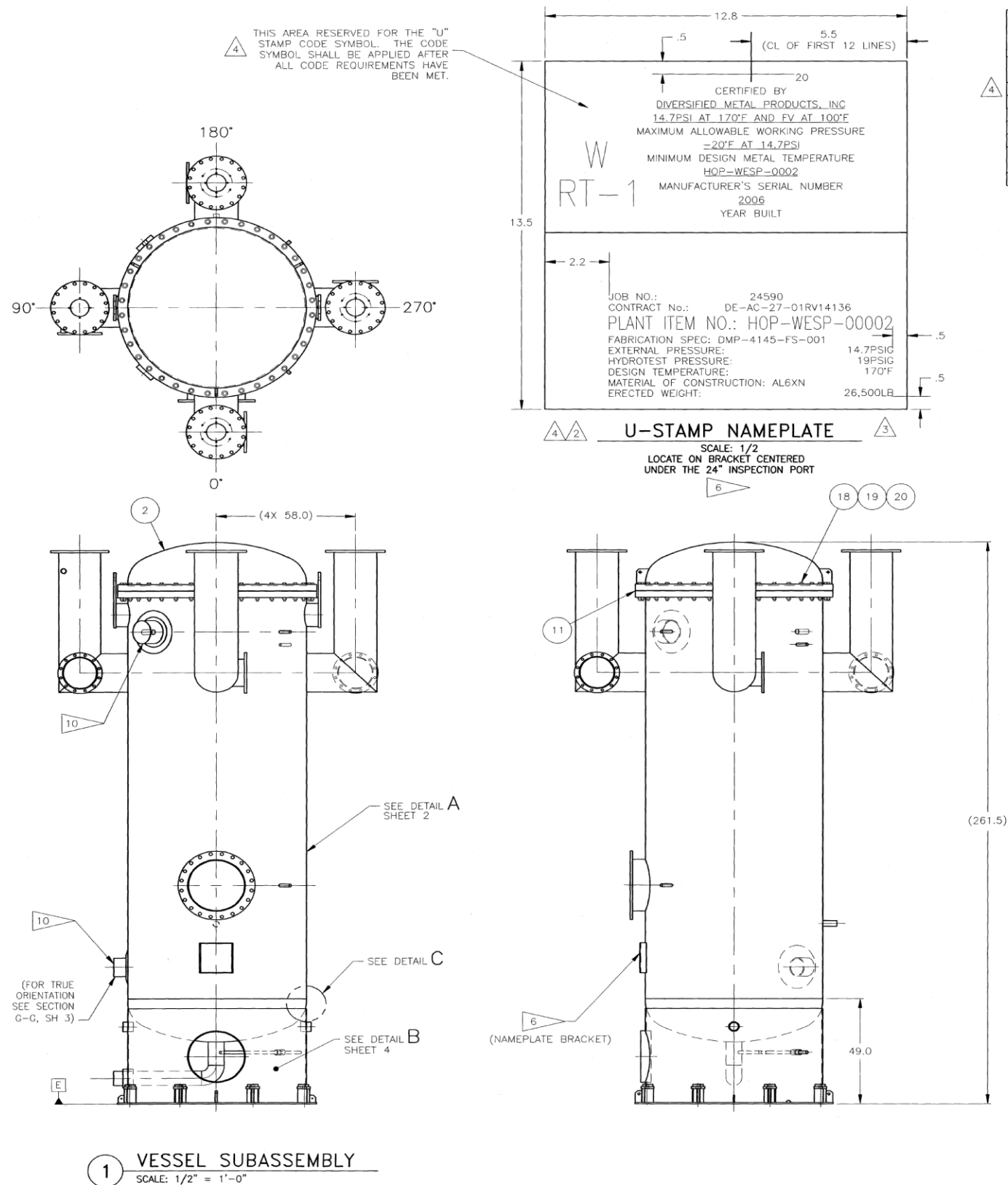
WM-35 W-30 – NO PHOTO TAKEN  
Fillet weld undersized by ~1/16" for 6" long segment at 6 O'clock

WM-30 W-1 – NO PHOTO TAKEN  
~20" undersized by ~ 1/16"

24590-WTP-NCR-MGT-22-0490  
Attachment 3  
1 of 1  
Photos of rejects

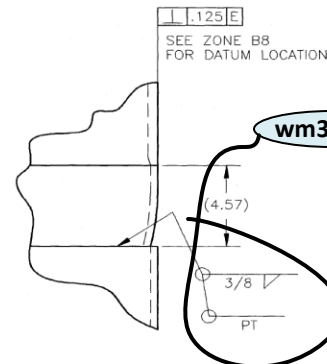
24590-HLW-FIR-CON-22-00005  
Attachment 3  
Rejected Weld Photo's - Sheet 1 of 1  
HOP-WESP-00002





VESSEL TO BE CONSTRUCTED IN STRICT ACCORDANCE WITH 2001 EDITION, 2002 ADDENDA OF THE ASME CODE SECTION VIII DIVISION 1 FOR PRESSURE VESSELS AND IS TO BE SO STAMPED. INSPECTION BY HSB GLOBAL STANDARDS

	DESIGN	MAX A WORKING	MAX A N & C	HYDRO TEST
PRESSURE PSIG @	14.7/FV	16	125	19
TEMPERATURE °F	170	170	AMBIENT	AMBIENT
LIMITED BY	NA	NA	NA	NA
WIND PRESS. LBS/SQ FT	NA	CORROSION ALLOW INCHES	.04	
SEISMIC COEFFICIENT	NA	RADIOGRAPHIC EXAMINATION	RT-1	
WEIGHT FULL W/ WATER LBS	65,000	POST WELD HEAT TREATMENT @ 1100 °F	NA	
OPERATING WEIGHT LBS	26,500			



DETAIL C  
SCALE: 1/4

## GENERAL NOTES:

- FABRICATION AND WELDING SHALL BE IN ACCORDANCE WITH THIS DRAWING AND SPECIFICATION DMP-4145-FS-001.
- ABBREVIATIONS ARE IN ACCORDANCE WITH ANSI Y1.1.
- REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
- ATTACH DRAIN LINE AND LEVEL TRANSMITTER LINE AFTER THE SKIRT IS WELDED TO THE VESSEL TO ENSURE PROPER FIT UP WITH NOZZLE OUTLETS THROUGH SKIRT.
- OVERSIZE THICKNESS OF PLATES FOR FINISH MACHINING OF HEAD, VESSEL FLANGES AND REINFORCEMENT PADS IF REQD.
- U-STAMP NAMEPLATE SHALL BE IN ACCORDANCE WITH ASME PRESSURE VESSEL STANDARDS. WELD NAMEPLATE TO NAMEPLATE BRACKET WITH CONTINUOUS FILLET AFTER FINAL TESTING.
- THE LOCATION OF THE SHELL DIRECTLY UNDER THE LIFTING LUGS WILL BE ULTRASONICALLY EXAMINED OVER 100% OF THE AREA EXTENDING OUT 3 INCHES BEYOND THE PIPE WELDMENT.
- TUBES (ITEMS 32, 33, 34, & 35) SHALL BE FABRICATED FROM 3/8" THK PLATE WITH FULL PENETRATION SEAM WELDS. SEAM WELDS SHALL BE 100% RADIOGRAPHED. SEAM LOCATIONS OPTIONAL.
- VESSEL HEADS ARE 2:1 ELLIPSOIDAL WITH A 75.00 OD X 3/8 WALL THICKNESS. (ITEM 7) SHALL HAVE A 1.5 INCH STRAIGHT FLANGE AND SHALL BE WELD PREPPED, (ITEM 6) SHALL HAVE A 3.3 INCH STRAIGHT FLANGE AND SHALL NOT BE WELD PREPPED.
- PREP NOZZLES N4 & N13 FOR A 37 1/2° BEVEL WELD.
- PRIOR TO WELDING, ULTRASONIC EXAMINATION OF THE VESSEL BOUNDARY IS REQUIRED IN THE VICINITY WHERE COMPONENTS ARE ATTACHED BY FULL OR PARTIAL PENETRATION WELD.
- ITEM 31 MAY BE FABRICATED FROM 3/8 THK PLATE (ITEM 37) WITH FULL PENETRATION SEAM WELD. SEAM WELD REQUIRES PENETRANT EXAMINATION. SEAM LOCATION OPTIONAL.
- THE SPIRAL WOUND GASKET (ITEM 11) SHALL BE A RW, OUTER RING 78 1/2" OD X 77 1/4" ID, INNER RING 76" OD X 75" ID. INNER RING, OUTER RING, AND WINDING MATERIAL SHALL BE AL6XN UNS N08367. FILLER MATERIAL SHALL BE GRAFOIL.
- POST WELD HEAT TREAT AS REQD AT A LATER DATE.
- ON NOZZLE N5 DUE TO SIZE AND SPACE RESTRAINTS RADIOGRAPHIC TESTING FOR THE WELD MAY NOT BE ACCURATELY COMPLETED. ULTRASONIC TESTING OF THE WELD IS AN ACCEPTABLE SUBSTITUTE IF NECESSARY.

DIMENSIONING AND TOLERANCING SHALL BE INTERPRETED PER ANSI Y14.5M-1994

UNSPECIFIED TOLERANCES SHALL BE:  
DECIMAL .XX ± .06  
ANGULAR ± 1°

ALL IMPLIED 90° ANGLES SHALL BE PERPENDICULAR WITHIN THE GREATEST TOLERANCE OF THE LINEAR DIMENSIONS

ALL COAXIAL FEATURES SHALL BE CONCENTRIC WITHIN .031 INCH UNLESS OTHERWISE SPECIFIED

REF NUMBER	DOCUMENT TITLE	REV	DESCRIPTION
4	INCORPORATED DCN-083 CHANGE U-STAMP NAMEPLATE AND VESSEL DATA TABLE		
3	INCORPORATED DCN-081 CHANGE U-STAMP NAMEPLATE		
2	INCORPORATED DCN-020 INCORPORATED DCN-072 CHANGE U-STAMP NAMEPLATE		
1	INCORPORATED DCN-003, -004 & -005		
0	RELEASED FOR CONSTRUCTION		
REVISION			
NEXT USED ON: DMP 4145-M-401			
FILE NAME: M-402_01_REV 4.DWG			

## PARTS LIST/MATERIAL LIST

QTY	PART/DASH NUMBER	NOMENCLATURE/DESCRIPTION	MATERIAL/REFERENCE	SHEET	ITEM NO
-020	-010	VESSEL SUBASSEMBLY		1	1
1	-020	VESSEL HEAD WELDMENT		5	2
					3
					4
					5
9	1	TOP VESSEL HEAD	ASTM B688/ASME SB688 UNS N08367	6	
9	1	BOTTOM VESSEL HEAD	ASTM B688/ASME SB688 UNS N08367	7	
				8	
				9	
				10	
13	1	SPIRAL WOUND GASKET	GARLOCK	11	
				12	
				13	
				14	
				15	
				16	
				17	
36		BOLT, HEX HD, 1 1/2-6 UNC-2A X 8" LONG	ASTM A193 GR B8	18	
36		HEX NUT, 1 1/2-6 UNC-2B	ASTM A194 GR 8F	19	
72		PLAIN WASHER, 1 1/2 (SERIES AND TYPE OPTIONAL)	18-8 SST	20	
				21	
				22	
1		ELBOW, 90° 6" SR, SCHED 40, BUTT WELD	ASTM B366/ASME SB366 UNS N08367	23	
AR		PIPE, 1" SCHED 40	ASTM B675/ASME SB675 UNS N08367	24	
AR		PIPE, 2" SCHED 40	ASTM B675/ASME SB675 UNS N08367	25	
AR		PIPE, 2" SCHED 40	ASTM A312/ASME SA312 GR TP 304L	26	
AR		PIPE, 4" SCHED 40	ASTM A312/ASME SA312 GR TP 304L	27	
AR		PIPE, 6" SCHED 40	ASTM B675/ASME SB675 UNS N08367	28	
AR		PIPE, 8" SCHED 40	ASTM B675/ASME SB675 UNS N08367	29	
AR		PIPE, 8" SCHED 40	ASTM A312/ASME SA312 GR TP 304L	30	
AR		PIPE, 24" SCHED 40S	ASTM A312/ASME SA312 GR TP 304L	31	
AR		TUBE, 10.75 OD X 10.00 ID	ASTM B688/ASME SB688 UNS N08367	32	
AR		TUBE, 12.75 OD X 12.00 ID	ASTM B688/ASME SB688 UNS N08367	33	
AR		TUBE, 18.00 OD X 17.25 ID	ASTM B688/ASME SB688 UNS N08367	34	
AR		TUBE, 24.00 OD X 23.25 ID	ASTM B688/ASME SB688 UNS N08367	35	
AR		PLATE, 1/4 THK	ASTM B688/ASME SB688 UNS N08367	36	
AR		PLATE, 3/8 THK	ASTM A240/ASME SA240 TYPE 304L	37	
AR		PLATE, 1/2 THK	ASTM B688/ASME SB688 UNS N08367	38	
AR		PLATE, 1/2 THK	ASTM A240/ASME SA240 TYPE 304L	39	
AR		PLATE, 1 1/4 THK	ASTM B688/ASME SB688 UNS N08367	40	
AR		PLATE, 1" THK	ASTM B688/ASME SB688 UNS N08367	41	
AR		PLATE, 1" THK	ASTM A240/ASME SA240 TYPE 304L	42	
AR		PLATE, 5/8 THK	ASTM A240/ASME SA240 TYPE 304L	43	
AR		PLATE, 1 1/2 THK	ASTM B688/ASME SB688 UNS N08367	44	
AR		PLATE, 3 THK	ASTM B688/ASME SB688 UNS N08367	45	
AR		PLATE, 3/8 THK	ASTM B688/ASME SB688 UNS N08367	46	
AR		PLATE, 2 THK	ASTM B688/ASME SB688 UNS N08367	47	
			ASTM B675/ASME SB675 UNS N08367	48	

24590-WTP-NCR-MGT-22-0490

Attachment 2,

1 of 6

Weld Maps locating rejected welds or  
area adjacent to weld that was rejected

24590-WTP-NCR-MGT-22-0490

Attachment 2, 1 of 6

Weld Maps locating rejected welds or area adjacent to weld that was rejected

24590-WTP-NCR-MGT-22-0490

Attachment 2, 1 of 6

Weld Maps locating rejected welds or area adjacent to weld that was rejected

24590-HLW-FIR-CON-22-00005

Attachment 2

Weld Map - Sheet 1 of 9

From 24590-QL-POA-MKE0-00001-09-04

24590-HLW-FIR-CON-22-00005

Page \_\_\_\_ of \_\_\_\_

PO 24590-QL-POA-MKE0-00001

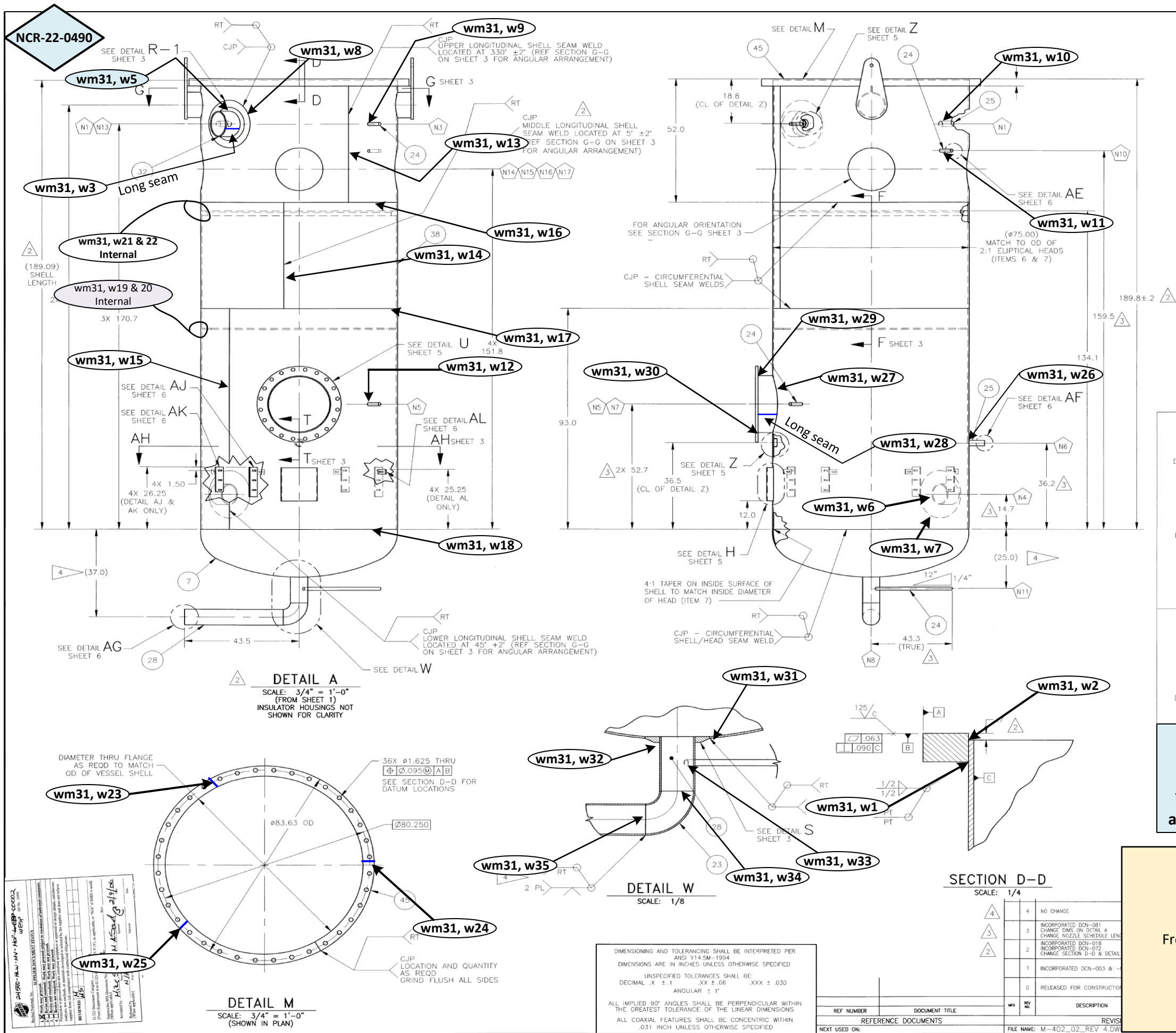
PREPARED FOR:  
DIVERSIFIED METAL PRODUCTS, INC.

PREPARED BY:  
GForce

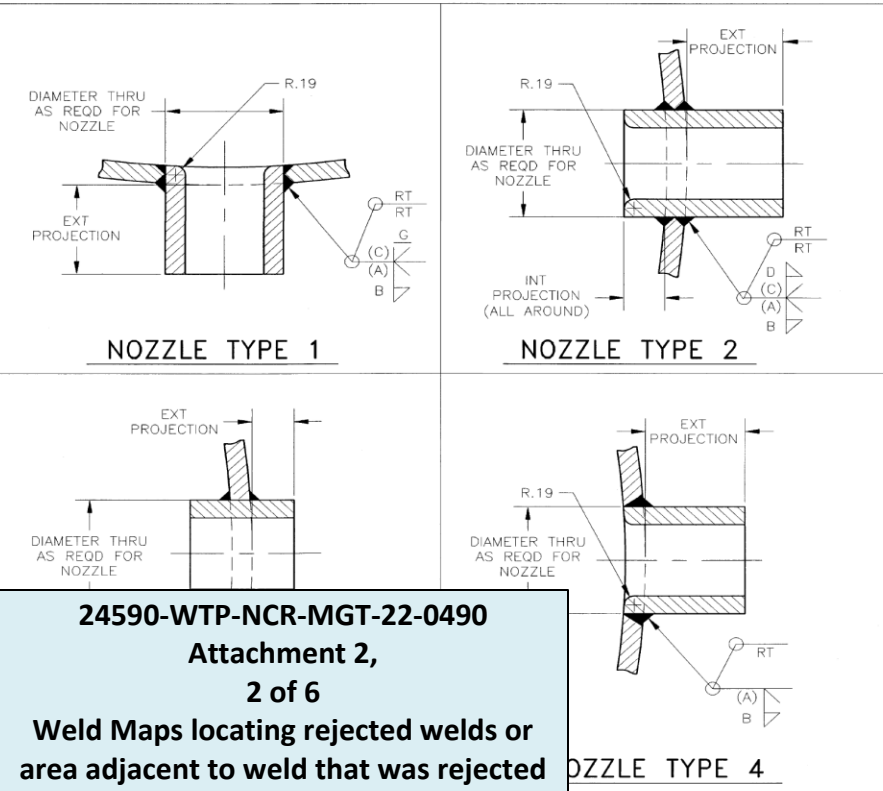
HLW-2  
VESSEL SUBASSEMBLY  
HOP-WESP-0002

DWG SIZE: F  
BLDG NO.: N/A  
DWG NO.: DMP 4145-M-402  
REV: 4

DWG SCALE: SHOWN  
TRANSMITTAL NO.:  
SHEET: 1 of 6



NOZZLE SCHEDULE									
MARK	TYPE	EXT PROJECTION		WELD		INT PROJECTION			
						A	B	C	D
N1	2	5.8	25	1.6		1/4	1/8	1/4	3/16
N2	2	5.8	25	1.6		1/4	1/8	1/4	3/16
N3	2	5.9	24	5		1/4	3/16	1/4	3/16
N4	2	6.0	29	2.0		5/8	3/8	5/8	3/8
N5	2	6.0	24	1.8		1/4	3/16	1/4	3/16
N6	2	6.0	25	5.3		1/4	1/8	1/4	3/16
N7	2	6.0	35	2.0		1/4	3/8	1/4	7/16
N8	1	AS SPECIFIED	28	0		5/8	1/4	5/8	
N9	2	5.9	24	4		1/4	3/16	1/4	3/16
N10	2	AS SPECIFIED	24	0		9/32	1/8		
N11	2	6.0	32	5		5/8	3/8	5/8	7/16
N12	2	AS SPECIFIED	34	5		1/4	3/8	1/4	7/16
N13	2	AS SPECIFIED	34	5		1/4	3/8	1/4	7/16
N14	2	AS SPECIFIED	34	5		1/4	3/8	1/4	7/16
N15	2	AS SPECIFIED	34	5		1/4	3/8	1/4	7/16
N16	2	AS SPECIFIED	34	5		1/4	3/8	1/4	7/16
N17	2	AS SPECIFIED	34	5		1/4	3/8	1/4	7/16
N18	4	3.0	33	0		3/8	3/8		
N19	4	3.0	33	0		3/8	3/8		
N20	4	3.0	33	0		3/8	3/8		
N21	4	3.0	33	0		3/8	3/8		
N22	4	6.0	25	0		3/8	1/8		
S23	3	2.0	30	2.0		1/8	1/8	1/8	1/8
S24	3	2.0	27	2.0		1/8	1/8	1/8	1/8
S25	3	2.0	27	2.0		1/8	1/8	1/8	1/8
S26	3	2.0	31	2.0		1/8	1/8	1/8	1/8
S27	3	2.0	26	2.0		1/8	1/8	1/8	1/8



24590-WTP-NCR-MGT-22-0490  
Attachment 2,  
2 of 6  
Weld Maps locating rejected welds or  
area adjacent to weld that was rejected

24590-HLW-FIR-CON-22-00005  
Attachment 2  
Weld Map - Sheet 2 of 9  
From 24590-QL-POA-MKE0-00001-09-05  
24590-HLW-FIR-CON-22-00005  
Page \_\_\_\_ of \_\_\_\_

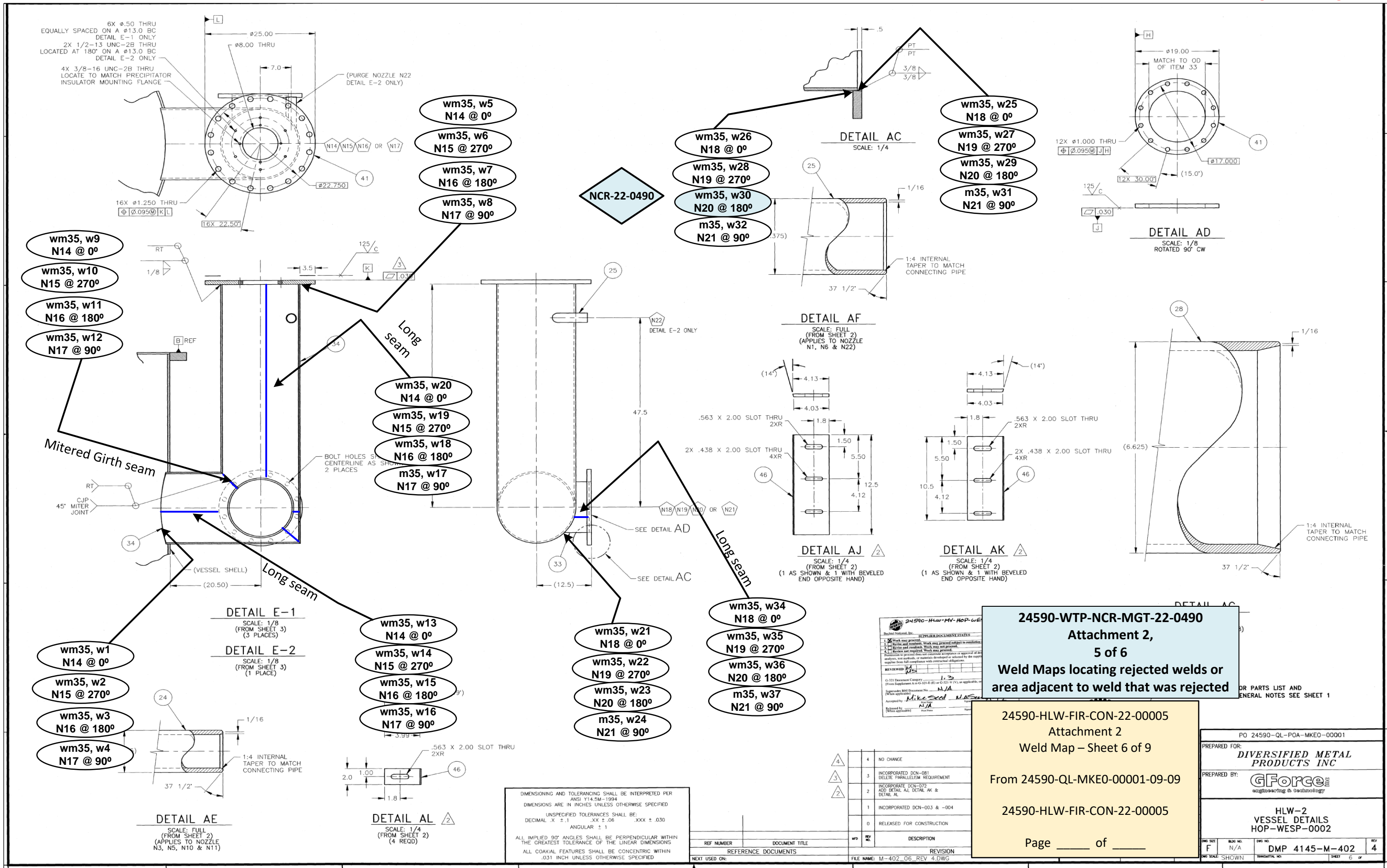
FOR PARTS LIST AND GENERAL NOTES SEE SHEET 1			
PO 24590-QL-POA-MKE0-00001			
FOR: DIVERSIFIED METAL PRODUCTS INC			
BY: GForce			
HLW-2 VESSEL DETAILS HOP-WESP-0002			
DO NO.	DWG NO.	REV	
4	DMP 4145-M-402	4	
OWN	TRANSMIT NO.	SHEET	2 OF



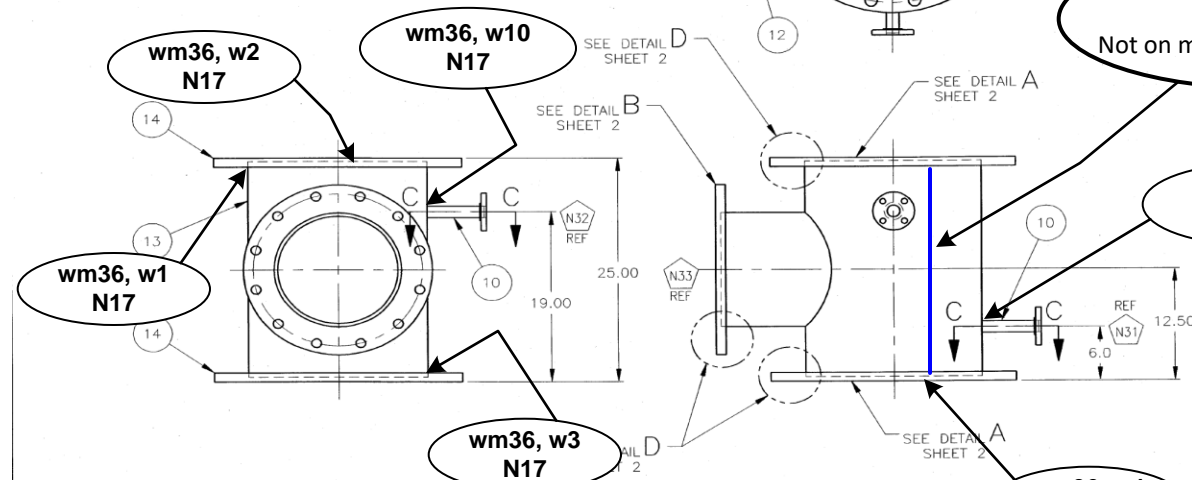
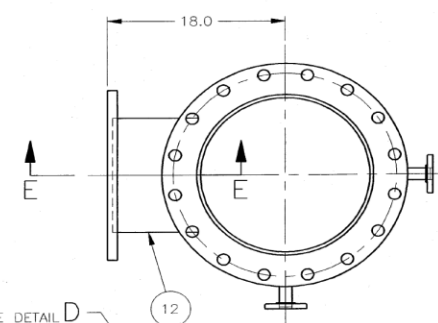
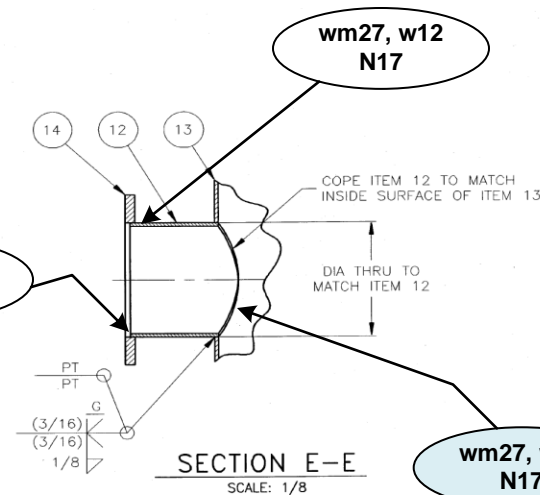




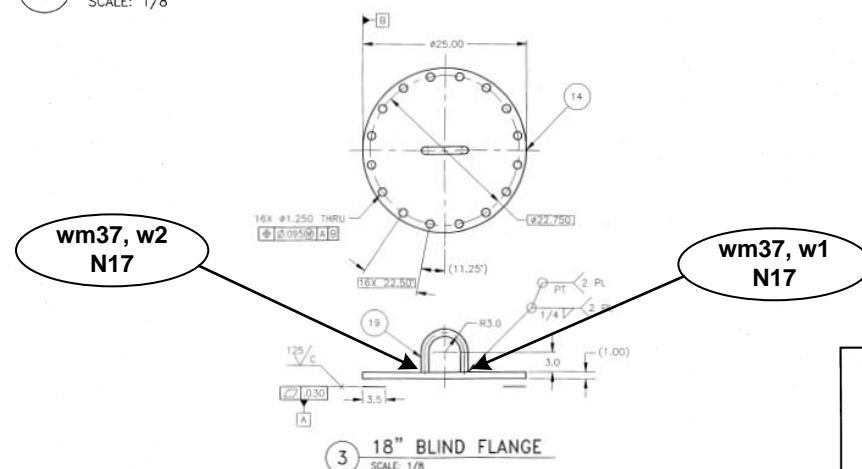




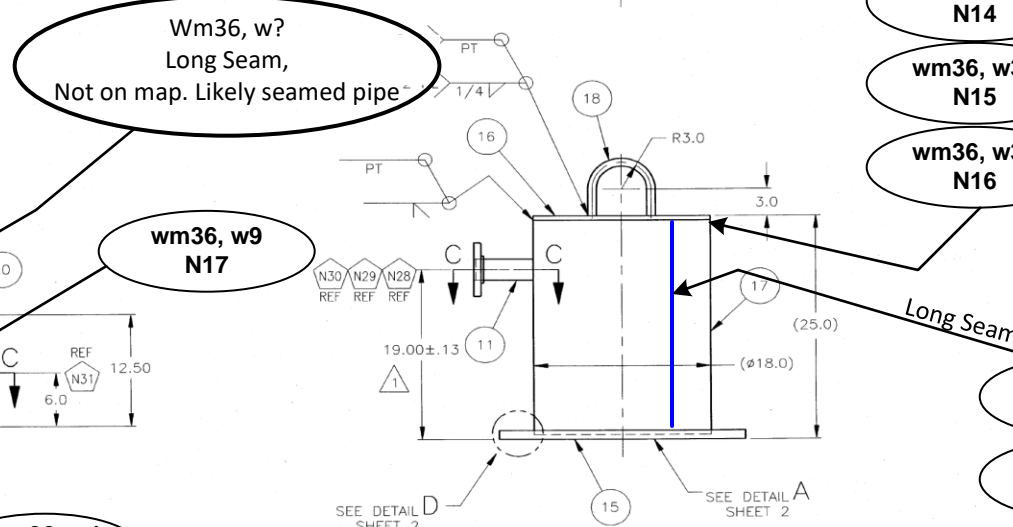




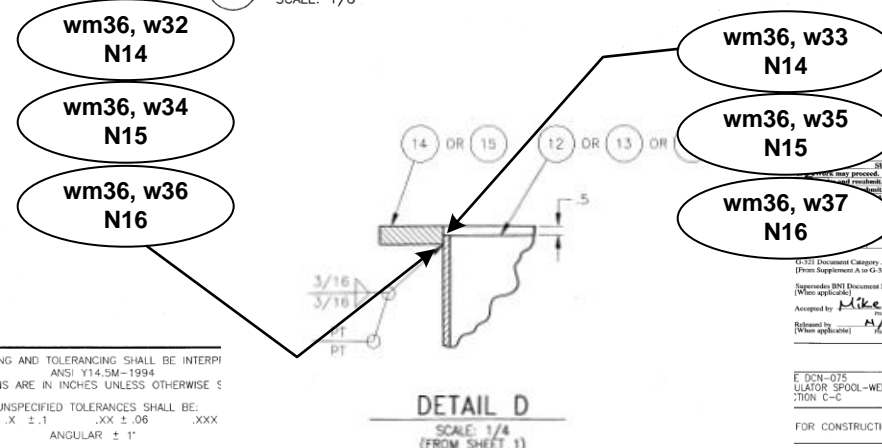
1 INSULATOR SPOOL - ELECTRICAL WELDMENT  
SCALE: 1/8



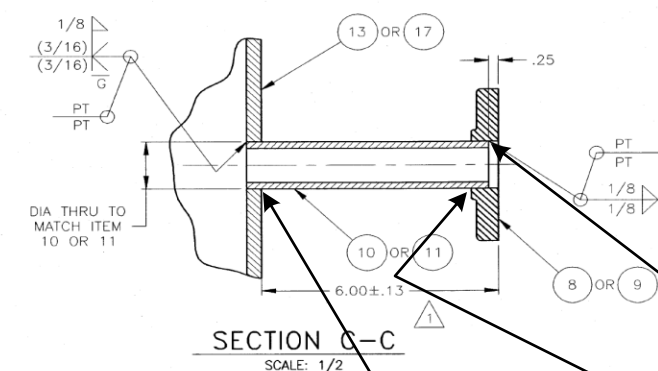
DIMENSIONING AND TOLERANCING SHALL BE INTERPRETED IN ACCORDANCE WITH THE FOLLOWING:  
ANSI Y14.5M-1994  
DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED  
UNSPECIFIED TOLERANCES SHALL BE:  
DECIMAL .X  $\pm$  .1 .XX  $\pm$  .06 .XXX  $\pm$  .005  
ANGULAR  $\pm$  1°  
ALL IMPLIED 90° ANGLES SHALL BE PERPENDICULAR  
THE GREATEST TOLERANCE OF THE LINEAR DIMENSIONS SHALL BE THE GREATEST TOLERANCE OF THE ANGLES  
ALL COAXIAL FEATURES SHALL BE CONCENTRIC  
UNLESS OTHERWISE SPECIFIED  
0.31 INCH UNLESS OTHERWISE SPECIFIED



2 INSULATOR SPOOL - WELDMENT  
SCALE: 1/8



DETAIL D  
SCALE: 1/4"  
(FROM SHEET 1)



SECTION C-C

SCALE: 1/2

GENERAL NOTES:

7 FABRICATION AND WELDING SHALL BE IN ACCORDANCE WITH  
DRAWING AND SPECIFICATION DMP-4145-FS-001.  
ALL DIMENSIONS ARE IN ACCORDANCE WITH ANSI  
REMOVE ALL BURRS AND BREAK ALL SHARP EDGES

24590-WTP-NCR-MGT-22-0490

**Attachment 2,  
6 of 6**

Weld Maps locating rejected welds or area adjacent to weld that was rejected

24590-HLW-FIR-CON-22-00005

Attachment 2

Weld Map – Sheet 7 of 9

From 24590-QL-MKE0-00001-09-10 & 11

24590-HLW-FIR-CON-22-00005

Page \_\_\_\_\_ of \_\_\_\_\_

wm36, w5  
N32

wm36, w7  
N31

wm36, w25  
N30

wm36, w23  
N29

wm36, w21  
N28

wm36, w6  
N32

wm36, w8  
N31

wm36, w24  
N30

wm36, w22

wm36, w20

PO 24590-QL-POA-MKEO-00001-09-10

ED FOR: *Rev doc*  
**DIVERSIFIED METAL  
PRODUCTS INC**

ED BY: **GForce**<sup>inc</sup>  
engineering & technology

HLW-2  
WELDMENTS & DETAILS  
HOP-WESP-0002

BLDG. NO. N/A	DWG. NO. DMP 4145-M-403	REV 1
SHOWING	TRANSMITTAL NO.	SHEET 1 of 2



# In Progress 24590-WTP-NCR-MGT-24-0236

Press F5 To refresh  
Responsible Individual Creates Conditional Releases  
and Dispositions

Attach ...



View Full PDF

 New Interim Disposition

 New Disposition

 Add Notes

## In Progress 24590-WTP-NCR-MGT-24-0236

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New Interim Disposition



New Disposition



Add Notes

kdasher@bechtel.us

1

Diversified Metal Products Inc

**Contract Number / Purchase Order****Quality Level****Custody Currently With**

24590-QL-POA-MKE0-00001

Q

Construction

**ASME Code Stamped Component or Assembly****Suspect/Counterfeit?****Commissioning Breakdown Structure**

Yes

No

HLW/PTF

**Nonconformance Description**

This NCR aims to consolidate the currently open issues with the HLW Wet Electrostatic Precipitators (WESPs) into one Nonconformance. This NCR has been created in accordance with Section 6.10 and Attachment 5 of 24590-HLW-GPP-RACN-FE-7104, HLW Nonconformance Reporting and Control. The HLW HOP WESP scope of the NCRs and CRs listed below are either superseded or closed by this NCR.

Note: This NCR only partially closes/supersedes all except Letter E and J

B) CA) CR 2013-00761:HLW-HOP Procurement Related Issues.

Action 7: Obtain documented determination from Electrical AHJ for removal of the UL requirements for cables rated over 35kV.

Action 33: Provide closure response for 8 RVP items listed in CCN 261879 indicated in the documents section titled, CR13-00761 #3 mech carryover items.pdf.

**Condition Adverse to Quality:**

RVP HOP-13-005 – The following Specifications and Drawings are outdated in MR 24590-QL-MRA-MKE0-00001 Rev 6 with no justification recorded within the MR or REM Report for the MR. See RVP for more information and full list of documents.

RVP HOP-13-023 – PARS Expediting Report for 24590-QL-POA-MKE0-00001, run on 12-17-2012, identified 4 issues with vendor submittals such as not receiving any submittals for some G-321E categories or incomplete submittals. See RVP for more information and full list of documents.

RVP HOP-13-032 – Vendor Submittal 24590-QL-POA-MKE0-00001-27-00001 Rev A was issued as document Category 8.0 – Analysis and Design Report, which is inline with Form 15EX, but should also have been issued as document Category 34.0 since it addresses the requirements referenced in form G-321V Category 34.0 – Factory Acceptance Test (FAT) Report, of the MR.

RVP HOP-13-033 – Vendor Submittal 24590-QL-POA-MKE0-00001-14-01 Rev B is assigned to incorrect Document Category 1.2 in PATS Report for 24590-QL-POA-MKE0-00001, which indicates it is incorrectly logged in as Category 1.2 in InfoWorks since the PARS report is generated from InfoWorks. The correct Document Category for this vendor Submittal is Category 1.2 per Forms 15EX and Form G-321E of the MR.

Affected Items: HOP-WESP-00001

Original CR and its attachments can be found in Attachment Folder "CR 2013-00761".

B) CR 2014-00036: Issues identified against HLW Vessels HOP-WESP-00001 and HOP-WESP-00002 during HLW Black Cell and Hard-to-Reach Vessel Assessment, Documented in Report 24590-HLW-ES-ENG-13-001 Rev.0

Action 3: Revise vendor calculations on HOP-WESP-00001 and 00002 to address many issues.

**Condition Adverse to Quality:**

Vessel weight is inconsistent across multiple documents. Code Calculations did not address nozzle neck analysis according to given specification. Disagreement of weld type between a calculation and drawing. Incorrect nozzle loads used in vendor nozzle neck analysis. Calculation is not in alignment with NQA-1 requirements and WTP Calculation requirements. WESP "top hats" require analysis for ASME pressure boundary including weld sizing justification, flat plate(head) thickness checking and bolt sizing. Fatigue assessment required.

Affected Items: HOP-WESP-00001

Original CR can be found in Attachment Folder "CR 2014-0036".

C) CR 2018-00116: Equipment Penetrating Fire Barriers a Shielded Hatch Requirement Not Met [RVP]-HLW Split Actions 24, 25, 29 & 32 from PIER 10-00129

Action 4: Fire Barriers in the HLW Facility

## In Progress 24590-WTP-NCR-MGT-24-0236

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and Dispositions

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New Interim Disposition



New Disposition



Add Notes

Condition Adverse to Quality: Fatigue analysis not completed or unsatisfactory for HLW components listed in Attachment A of 24590-WTP-PL-ENG-07-0005 Rev.3 and issue associated documentation (for example, calculation(s) addressing fatigue assessment).

Affected Items: HOP-WESP-00001

Original CR and its attachments can be found in Attachment Folder "CR 2020-00485".

E) NCR-CON-13-0157: Vendor Submittals for Vessel Not Reviewed By Independent Group

Description: The vendor submittals reviewed in this CDR (NCR) deal with seismic analysis of equipment. These reports were required to be reviewed by an independent group such as Equipment Seismic Qualification (ESQ) group or C/S/A engineering group in accordance with DOE standard 1020. However, this requirement was not followed and the reports were given approval Code Level 1. Therefore, a PIER was generated(24590-WTP-CRPT-QA-08-0406-B, "Inadequate Review of the Supplier Seismic Calc"). The PIER required that the ESQ group review these reports and prepare comments on Comment Resolution Forms (CRFs) and issue CDRs (NCRs) for resolving the comments. These forms are attached listing the deficiencies in the report. These forms also provide suggestions for resolution.

Additional Information: It is required that after the final disposition of this CDR (NCR), the document be sent to ESQ group for concurrence. ESQ group personnel dealing with CRPT08-0406 are located in the San Francisco office and they report to ESQ – Project Engineer located in the Richland office. The deficiencies are reported on the attached CRF's EQ Log 3842.

Nonconformance: Seismic Analysis was not reviewed by independent organization.

Recommended Disposition: Engineering to resolve the subject documentation deficiencies.

Affected Items: HOP-WESP-00001

Original NCR and its attachments can be found in Attachment Folder "NCR-CON-13-0157".

F) NCR-CON-13-0188: Vendor Submittals for Vessel Not Reviewed By Independent Group

Description: The vendor submittals reviewed in this CDR (NCR) deal with seismic analysis of equipment. These reports were required to be reviewed by an independent group such as Equipment Seismic Qualification (ESQ) group or C/S/A engineering group in accordance with DOE standard 1020. However, this requirement was not followed and the reports were given approval Code Level 1. Therefore a PIER was generated(24590-WTP-CRPT-QA-08-0406-B, "Inadequate Review of the Supplier Seismic Calc"). The PIER required that the ESQ group review these reports and prepare comments on Comment Resolution Forms (CRFs) and issue CDRs (NCRs) for resolving the comments. These forms are attached listing the deficiencies in the report. These forms also provide suggestions for resolution.

Additional Information: It is required that after the final disposition of this CDR (NCR), the document be sent to ESQ group for concurrence. ESQ group personnel dealing with CRPT08-0406 are located in the San Francisco office and they report to ESQ – Project Engineer located in the Richland office. The deficiencies are reported on the attached CRF's Log 3841, CRF's Log 3841A and CRF Log 3842.

Nonconformance: Seismic Analysis was not reviewed by independent organization.

Recommended Disposition: Engineering to resolve the subject documentation deficiencies.

Affected Items: HOP-WESP-00001

Original NCR and its attachments can be found in Attachment Folder "NCR-CON-13-0188".

G) NCR-CON-14-0018: HLW Wet Electrostatic Precipitator Internals Not Procured Under NQA-1  
Description: HLW Wet Electrostatic Precipitators (WESP) contain internals such as electrodes, collector tube bundles, and insulators as well as the power supplies that were procured as commercial items per the MR 24590-QL-MRA-MKE0-00001. These items are required to perform an air permit function which requires these items to be procured under an NQA-1 program – which did not occur. These items must be dedicated or shown to be able to meet their air permit function as is.

Additional Information: reference 24590-WTP-CRPT-QA-07-336, Action 17 this NCR is to track the resolution of the Non-conformance of the HLW items separately from the LAW and partially superseded 24590-WTP-NCR-CON-08-0119.

Nonconformance: Items not procured under NQA-1 as they should have due to air permit.

Recommended Disposition: Design Engineering to evaluate a provide final disposition, This NCR is similar to 24590-WTP-NCR-CON-08-0119, Reference notes and work already completed in order to resolve this NCR.

Affected Items: 24590-HLW-EK-LVE-PSUP-30004, HOP-WESP-00001, HOP-WESP-00001-SUB0010

Original NCR and its attachments can be found in Attachment Folder "NCR-CON-14-0018".



## In Progress 24590-WTP-NCR-MGT-24-0236

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and Dispositions

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New Interim Disposition



New Disposition



Add Notes

Nonconformance: WESPs were incorrectly designed to SC-III instead of SC-I.

Recommended Disposition: Route to Engineering for evaluation and disposition.

Affected Items: HOP-WESP-00001

Original NCR can be found in Attachment Folder "NCR-CON-14-0022".

I) NCR-MGT-19-0796: HLW Corroded and Rusted Electrodes for HOP-WESP-00001 and HOP-WESP-00002

Description: Found 182 out of the 184 electrodes corroded and/or rusted during a storage surveillance, see attached pictures.

Nonconformance: Corrosion found on most electrodes.

Affected Items: HOP-WESP-00001-SUB0010

Original NCR and its attachments can be found in Attachment Folder "NCR-MGT-19-0796".

J) NCR-MGT-20-0086: HLW – Secondary doc Review Issues for HOP-WESP-00001 (NCR-CON-13-0045)

Description: This NCR supersedes 24590-WTP-NCR-CON-13-0045 for dispositions # 000, 110, 348, 396, 592, 752, and 838 for HLW scope ONLY. Disposition # 836 for LAW impacting is closed. Migration from CAIS to NCD.

A review of the quality verification documentation (QVD) package for the subject vessel was performed (Reference: 24590-WTP-PIER-MGT-11-0836-C, 24590-WTP-GPG-PSQ-5002, and MRR-0017737 Rev 0).

(Note: 24590-WTP-GPG-PSQ-5002 was cancelled on 9/16/2014; current procedure is 24590-WTP-GPP-RAPS-SQ-1043, REVIEW OF QUALITY VERIFICATION DOCUMENTATION, Revision 1 effective date 9/23/2019.)

1) The purpose of the review was to determine conformance of the QVD with the purchase order and specified requirements. It was found that the QVD submittal did not conform to all requirements as detailed below.

2) The review addressed 100 percent of the documentation required to be submitted under the G-321-V Form for activities including welding, nondestructive examinations (NDE), hydrostatic testing, positive materials identification (PMI), and material certifications and application as shown on the drawings. Related scope included record requirements such as legibility, SQR stamp, G-321-V form completion, PO revision, and correct DCN category.

3) The unsatisfactory and indeterminate findings are detailed in a combined PDF attachment to this NCR consisting of the following individual documents:

4) Review Result Summary for HOP-WESP-000015) Review Checklist for HOP-WESP-000016) See Notes below for details on how findings are identified and traceable to the QVD records.

#### Additional Information:

Note 1: Findings are identified by Document Category Number (DCN), description, and review checklist item number(s). Further detail may be found on the review checklist (CL) prepared during the review to tabulate and correlate the data.

Note 2: The HOP-WESP-00001 document package was paginated consecutively within the DCN category. References to these page numbers on the CL provide traceability to the relevant data.

Nonconformance: QVD submittal did not conform to all requirements.

Affected items: HOP-WESP-00001, Sub items see "Attachment1 (1)" from the Attachment Folder below.

Original NCR and its attachments can be found in Attachment Folder "NCR-MGT-20-0086".

K) NCR-MGT-20-0100: HLW – Vendor UT weld exams have indeterminate quality due to questionable procedure, HLW HOP vessels (NCR-CON-15-0035)

Description: This NCR supersedes 24590-WTP-NCR-CON-15-0035 for HLW ONLY. Disposition # 673 for LAW is complete. Migration from CAIS to NCD. Diversified Metal Fab Ultrasonic Testing (UT) Examination Procedure 24590-QL-POA-MKE0-00001-03-05, Rev. 00A, was submitted to BNI on, or about, March 24 2003. This procedure was reviewed by the Responsible Engineer (RE) and an NDE Level III, and designated Code 2, with comments by the NDE Level III indicating that the procedure required demonstration and the addition of the acceptance criteria to the procedure. On, or about, November 17, 2003 DMP submitted UT Examination Procedure Rev 00B to BNI with only one of the two original comments satisfied. This submittal was code 1 by the RE without all of the appropriate requirements being added into this revision. This leaves High Nickel material welds which were examined with the above submittal (N5) indeterminate.

## In Progress 24590-WTP-NCR-MGT-24-0236

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and Dispositions

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New Interim Disposition



New Disposition



Add Notes

Description: This NCR supersedes 24590-WTP-NCR-CON-14-0040 for the HLW & MHF facility only. Disposition #376 for LAW has been completed. Migration from CAIS to NCD. These seismic related vendor submittals were required to be reviewed by an independent group such as Equipment Seismic Qualification (ESQ) group, or CSA engineering, in accordance with DOE standard 1020. However, this requirement was not followed and the reports were given approval with code level 1. A PIER was thus generated (24590-WTP-CRPT-QA-08-0406-B, "Inadequate Review of the Supplier Seismic Calc"). The PIER requires that the ESQ group review these reports, prepare comments on Comment Resolution Forms (CRFs), and issue CDRs/NCRs for resolving the comments. Until these reports are reviewed & the comments resolved, it is indeterminate whether this equipment can withstand the required seismicload.

Additional Information: The ESQ group personnel dealing with CRPT 08-0406 are located in the San Francisco office and they report to the EQ Project engineer located in the Richlandoffice.

Nonconformance: Vendor Seismic Analysis not reviewed by independent group as required.

Disposition # 00004: This disposition partially supersedes disposition #002. Forward to engineering to evaluate HOP-WESP-00001 and HOP-WESP-00002Affected Items: HOP-WESP-00001Original NCR and its attachments can be found in Attachment Folder "NCR-MGT-20-0110".

M) NCR-MGT-23-0129: HLW – HOP-WESP-00001 & HOP-WESP-00002 RT film deficiencies

Description: RT film is not compliant with ASME Section V, Article 2 per 24590-HLW-FIR-CON-16-00124and the discussion in the main CR description of CR 2017-01393. Some of the issues relate to required film density and the use/visibility of the image quality indicator (penetrometer).

Disposition: Route to Engineering for Disposition.

Affected Items: HOP-WESP-00001Original NCR can be found in Attachment Folder "NCR-MGT-23-0129".

**Additional Information**

NCRs MGT-22-0489 and MGT-22-0490 also pertain to the WESPs, however, work and/or dispositions have been completed so they have not been included in this compilation. CR 2016-01856 Action 2 is tied to these two NCRs and as such is not included in this compilation for the same reasons.

		EQUIPMENT PENETRATING FIRE BARIERS	
24590-WTP-3PS-MVB2-T0001	004	ENGINEERING SPECIFICATION FOR WELDING OF PRESSURE VESSELS, HEAT EXCHANGERS AND BOILERS	FOR LETTER J, REVISION FROM NCR-CON-13-0045, REV 001 FOR LETTER J
24590-WTP-3PS-MV00-T0002	001	ENGINEERING SPECIFICATION FOR SEISMIC QUALIFICATION CRITERIA FOR PRESSURE VESSELS	FOR LETTERS E, F
24590-WTP-3PS-MKE0-T0001	005	ENGINEERING SPECIFICATION FOR WET ELECTROSTATIC PRECIPITATORS	FOR LETTER B, REV 004 FOR LETTER F
24590-WTP-3PS-FB01-T0001	007	ENGINEERING SPECIFICATION FOR STRUCTURAL DESIGN LOADS FOR SEISMIC CATEGORY III AND IV EQUIPMENT AND TANKS	FOR LETTER I, rEV 001 FOR LETTERS E, G
24590-WTP-3PS-EVR2-T0001	004	ENGINEERING SPECIFICATION FOR WET ELECTROSTATIC PRECIPITATOR (WESP) POWER SUPPLY	FOR LETTER I
24590-QL-POA-MKE0-00001-18-00002	00A	DATA SHEET - APPENDIX D - HLW - VENDOR DATA SHEET PRELIMINARY	FOR LETTER B
24590-QL-POA-MKE0-00001-09-14	00F	DRAWING - HLW-1 VESSEL SUBASSEMBLY HOP-WESP-0001	FOR LETTER B, K, SEE NOTE 15 ON DRAWING
24590-QL-POA-MKE0-00001-07-10	00D	CALCULATIONS - HLW-1 WESP PRESSURE VESSEL SKIRT DESIGN CALCULATIONS, DMP-4145-CALC-022	FOR LETTER B, L, LOG 3841A (FOR ESQ USE)
24590-QL-POA-MKE0-00001-07-08	00A	CALCULATIONS - HLW-1 WESP ANALYSIS OF LIFTING TRUNNIONS, DMP-4145-CALC-023	FOR LETTER B
24590-QL-POA-MKE0-00001-07-07	00C	CALCULATIONS - HLW-1 WESP PRESSURE VESSEL DESIGN	FOR LETTER L, LOG 3841A (FOR ESQ USE)
24590-HLW-FIR-CON-16-00124	NA	HOP-WESP-00001 AND 00002	FOR LETTER M

Applicable Items

Item Number	Parent ID	Item Description	Item Location	Item Quantity
24590-HLW-EK-LVE-PSUP-30004	LVE-PSUP-30004	HLW WET ELECTROSTATIC PRECIPITATOR, MELTER 1, POWER SUPPLY	JOBSITE	
HOP-WESP-00001	HOP-WESP-00001	HLW MELTER 1 OFFGAS WET ELECTROSTATIC PRECIPITATOR (WESP)	JOBSITE	1
HOP-WESP-00001-SUB0010	HOP-WESP-00001	ELECTRODES FOR HLW-1	JOBSITE	91

Condition Reports Associated with this NCR

2013-00761, 2014-00036, 2018-00116, 2020-00485

Validator

Andrews, Paul

Validation Date

11/12/2024

Validate and Screen

Step 1: Is the NCR valid?

Yes

NCR Title

HLW - HOP-WESP-00001 Open Issues



In Progress 24590-WTP-NCR-MGT-24-0236

Press F5 To refresh  
Responsible Individual Creates Conditional Releases  
and Dispositions

Attach ...

 View Full PDF

 New Interim Disposition

 New Disposition

 Add Notes

Supplier

Step 4: Stop Work?

No

Occurrence Reporting

No

Is this NCR related to an electrical item?

Yes

Step 5. Please check each WTP Area that is affected by this NCR.

HLW

Step 6. Select the Disposition Approval Authority to notify.

Skiffington, Mark

Step 7. Select the RQO to notify.

Andrews, Paul✕

Condition Reports

Condition Reports Associated with this NCR

Are there any Condition Reports associated with this CR? If applicable, identify any Condition Reports associated to this NCR in the Condition Report section below.

If there are no associated Condition Reports, please enter N/A.

Condition Reports Associated to this NCR

Condition Report Number

2013-00761



Remove

2014-00036



Remove

2018-00116



Remove

2020-00485



Remove

Add CR Number

Standing/Shift Order Numbers

Enter a Standing/Shift Order Number:

If not applicable please enter N/A.

N/A

In Progress 24590-WTP-NCR-MGT-24-0236

Press F5 To refresh

Responsible Individual Creates Conditional Releases and Dispositions

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 New Interim Disposition

 New Disposition

 Add Notes

All Tags Removed or Accounted For?

False

Conditional Releases

Interim Dispositions

Dispositions

Disposition #001 - [View](#) Status: In Progress NOT Ready for Implementation

Recommended Disposition Type	Marked for Final	Submitted Date	Submitted By	Process Status
Other	No	12/19/2024 5:57 PM	Homberger, Brian	Active

Process Task

Engineer Submits Final Disposition, Final Disposition

Is this a superseded Disposition?

☐ Check this box to hide this Disposition until closure

Currently Active Users

Welsch, Brandon

VA Concurrence Date	DAA Approval Date	Work Orders/Work Requests	Recommended Disposition
-	-	Engineering to provide final disposition.	

Final Disposition Type	Submitted Date	Submitted By
-	-	-

Final Disposition

Disposition #002 - [View](#) Status: In Progress NOT Ready for Implementation

Recommended Disposition Type	Marked for Final	Submitted Date	Submitted By	Process Status
Other	No	2/18/2025 7:18 PM	Anarwala, Farhan	Active

Process Task

Approve Disposition, Disposition Approval Authority Approves Disposition

Is this a superseded Disposition?

☐ Check this box to hide this Disposition until closure

Currently Active Users

Walling, Joe, George, Ronald, Andrews, Paul, Mccann, Adam, Benner, Michael, Deguire, Matt, Opet, Paul, Thompson, David, Rehwalt, Andrew, Nazzaro, Tony, Cowan, Chris, Lemoine, Jason, Bhatt, Ajay, Kump, Greg, Bentley, Tom, Hartsfield, Gregg, Rogers, Rich, Skiffington, Mark

VA Concurrence Date	DAA Approval Date	Work Orders/Work Requests	Recommended Disposition
-	-	HOP-WESP-0001 is being refabricated, hence, the current one is not needed. NCR is being Superseded.	

Final Disposition Type	Submitted Date	Submitted By
-	-	-

Final Disposition

In Progress 24590-WTP-NCR-MGT-24-0236

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Responsible Individual Creates Conditional Releases  
and Dispositions

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New Interim Disposition

New Disposition

Add Notes

Skiffington, Mark, Andrews, Paul, Mccann, Adam, Bentley, Tom, Walling, Joe, George, Ronald, Kump, Greg, Hartsfield, Gregg, Benner, Michael, Opet, Paul, Bhatt, Ajay, Cowan, Chris, Rogers, Rich, Rehwalt, Andrew, Lemoine, Jason, Thompson, David, Deguire, Matt, Nazzaro, Tony			
VA Concurrence Date	DAA Approval Date	Work Orders/Work Requests	Recommended Disposition
-	-	Reject HOP-WESP-00001 per project procedures. HOP-WESP-00001 is being refabricated. Supersedes all open recommended and final dispositions #001 and #002.	
Final Disposition Type	Submitted Date	Submitted By	
	-		
Final Disposition			

Attachments



## In Progress 24590-WTP-NCR-MGT-24-0236

Press F5 To refresh

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and Dispositions

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New Interim Disposition



New Disposition



Add Notes

(CR 2020-00485) CR+20-00485+Change+Actionee+and+Action+Reviewer.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:17 PM Dasher, Kyle
(NCR-CON-13-0157) CRF3842.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:17 PM Dasher, Kyle
(NCR-CON-13-0188) CRF3841.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:17 PM Dasher, Kyle
(NCR-CON-13-0188) CRF3841A.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:17 PM Dasher, Kyle
(NCR-CON-13-0188) CRF3842.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:17 PM Dasher, Kyle
(NCR-CON-14-0018) 0913_001.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:17 PM Dasher, Kyle
(NCR-CON-14-0018) 24590-LAW-FIR-CON-12-00054 Pages 1 to 2.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:17 PM Dasher, Kyle
(NCR-CON-14-0018) CCN 247827 Duane Ripplinger Email.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:17 PM Dasher, Kyle
(NCR-CON-14-0018) FW_ IGBT Driver Boards.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:25 PM Dasher, Kyle
(NCR-CON-14-0018) NCR 08-0119 Interim Disposition Table 1-13-11.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:25 PM Dasher, Kyle
(NCR-CON-14-0018) NCR 08-0119 Interim Disposition Table Updated 5 11 12 (2).pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:25 PM Dasher, Kyle
(NCR-MGT-19-0796) 20190801_102750.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:25 PM Dasher, Kyle
(NCR-MGT-19-0796) 20190801_102809.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:25 PM Dasher, Kyle
(NCR-MGT-19-0796) 20190912_151411.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:25 PM Dasher, Kyle
(NCR-MGT-19-0796) 20190912_151414.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:25 PM Dasher, Kyle
(NCR-MGT-19-0796) 20190912_152613.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:25 PM Dasher, Kyle
(NCR-MGT-20-0086) Copy of Attachment 1 (1).pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:25 PM Dasher, Kyle
(NCR-MGT-20-0100) 24590-WTP-NCR-CON-15-0035_HLD-05050_05364.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:25 PM Dasher, Kyle
(NCR-MGT-20-0100) Attachment 1.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:27 PM Dasher, Kyle
(NCR-MGT-20-0100) NCR-CON-15-0035.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:27 PM Dasher, Kyle
(NCR-MGT-20-0110) NCR-CON-14-0040 attachments.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:27 PM Dasher, Kyle
24590-WTP-NCR-CON-13-0157 Complete.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:27 PM Dasher, Kyle
24590-WTP-NCR-CON-13-0188 Complete.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:27 PM Dasher, Kyle

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New Interim Disposition

New Disposition

Add Notes

CR 2018-00116 Complete.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:27 PM Dasher, Kyle
CR 2020-00485 Complete.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:28 PM Dasher, Kyle
NCR-MGT-19-0796 Complete.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:28 PM Dasher, Kyle
NCR-MGT-20-0086 Complete.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:28 PM Dasher, Kyle
NCR-MGT-20-0100 Complete.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:28 PM Dasher, Kyle
NCR-MGT-20-0110 Complete.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:28 PM Dasher, Kyle
NCR-MGT-23-0129 Complete.pdf	<a href="#">View</a> <a href="#">Download</a> <a href="#">History</a>	11/11/2024 2:28 PM Dasher, Kyle

Attach ...

Comments



Use this section to add comments to this NCR

Add Comment



Save Comments




Routing Slip

Participants	Completed	Status	Result	Comments
Notify initiator of NCR submittal		11/11/2024 4:44 PM		
Dasher, Kyle	11/11/2024	Notified		
Validating Authority Validates NCR		11/11/2024 4:44 PM		
Andrews, Paul	11/12/2024	Completed	 NCR is Valid	
Originator Notified of Valid NCR		11/12/2024 12:40 PM		
Dasher, Kyle	11/12/2024	Notified		
RQO Notified for Hold Tags		11/12/2024 12:40 PM		
Andrews, Paul	11/12/2024	Notified		
Disposition Approval Authority Assigns Responsible Individual		11/12/2024 12:40 PM		
Cowan, Chris	12/3/2024	Completed	 Assign Responsible Individual	
Responsible Individual Creates Conditional Releases and Dispositions		12/3/2024 6:27 PM		
Homberger, Brian	-	Active		

# In Progress 24590-WTP-NCR-MGT-24-0236

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and Dispositions

-  New Interim Disposition
-  New Disposition
-  Add Notes



# In Progress 24590-WTP-NCR-MGT-24-0237

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and Dispositions

You are no longer logged in. Please login and retry the form.

24590-WTP-NCR-MGT-24-0237

NCR Header



In Progress 24590-WTP-NCR-MGT-24-0237

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and Dispositions

11/11/2024 4:45 PM			Engineering - Mechanical Systems			Dasher, Kyle		
<b>Email</b>			<b>NCR Priority</b>			<b>Supplier/SubContractor</b>		
kdasher@bechtel.us			1			Diversified Metal Products, Inc		
<b>Contract Number / Purchase Order</b>			<b>Quality Level</b>			<b>Custody Currently With</b>		
24590-QL-POA-MKE0-00001			Q			Construction		
<b>ASME Code Stamped Component or Assembly</b>			<b>Suspect/Counterfeit?</b>			<b>Commissioning Breakdown Structure</b>		
Yes			No			HLW/PTF		
<b>Nonconformance Description</b>								
<p>This NCR aims to consolidate the currently open issues with the HLW Wet Electrostatic Precipitators (WESPs) into one Nonconformance. This NCR has been created in accordance with Section 6.10 and Attachment 5 of 24590-HLW-GPP-RACN-FE-7104, HLW Nonconformance Reporting and Control. The HLW HOP-WESP-00002 scope of the NCRs and CRs listed below are either superseded or closed by this NCR. Note: This NCR only partially closes all except Letter E.</p> <p>CR 2013-00761: HLW-HOP Procurement Related Issues. Action 7: Obtain documented determination from Electrical AHJ for removal of the UL requirements for cables rated over 35kV. Action 33: Provide closure response for 8 RVP items listed in CCN 261879 indicated in the documents section titled, CR13-00761 #3 mech carryover items.pdf.</p> <p>Condition Adverse to Quality: RVP HOP-13-005 – The following Specifications and Drawings are outdated in MR 24590-QL-MRA-MKE0-00001 Rev 6 with no justification recorded within the MR or REM Report for the MR. See RVP for more information and full list of documents.</p> <p>RVP HOP-13-023 – PARS Expediting Report for 24590-QL-POA-MKE0-00001, run on 12-17-2012, identified 4 issues with vendor submittals such as not receiving any submittals for some G-321E categories or incomplete submittals. See RVP for more information and full list of documents.</p> <p>RVP HOP-13-032 – Vendor Submittal 24590-QL-POA-MKE0-00001-27-00001 Rev A was issued as document Category 8.0 – Analysis and Design Report, which is inline with Form 15EX, but should also have been issued as document Category 34.0 since it addresses the requirements referenced in form G-321V Category 34.0 – Factory Acceptance Test (FAT) Report, of the MR.</p> <p>RVP HOP-13-033 – Vendor Submittal 24590-QL-POA-MKE0-00001-14-01 Rev B is assigned to incorrect Document Category 1.2 in PATS Report for 24590-QL-POA-MKE0-00001, which indicates it is incorrectly logged in as Category 1.2 in InfoWorks since the PARS report is generated from InfoWorks. The correct Document Category for this vendor Submittal is Category 1.2 per Forms 15EX and Form G-321E of the MR. Affected Items: HOP WESP-00002</p> <p>Original CR and its attachments can be found in Attachment Folder “CR 2013-00761”.</p> <p>B) CR 2014-00036: Issues identified against HLW Vessels HOP-WESP-00001 and HOP-WESP-00002 during HLW Black Cell and Hard-to-Reach Vessel Assessment, Documented in Report 24590-HLW-ES-ENG-13-001 Rev.0 Action 3: Revise vendor calculations on HOP-WESP-00001 and 00002 to address many issues. Condition Adverse to Quality: Vessel weight is inconsistent across multiple documents. Code Calculations did not address nozzle neck analysis according to given specification. Disagreement of weld type between a calculation and drawing. Incorrect nozzle loads used in vendor nozzle neck analysis. Calculation is not in alignment with NQA-1 requirements and WTP Calculation requirements. WESP “top hats” require analysis for ASME pressure boundary including weld sizing justification, flat plate (head) thickness checking and bolt sizing. Fatigue assessment required. Affected Items: HOP-WESP-00002</p> <p>Original CR can be found in Attachment Folder “CR 2014-0036”.</p> <p>C) CR 2018-00116: Equipment Penetrating Fire Barriers a Shielded Hatch Requirement Not Met [RVP]-HLW Split Actions 24, 25, 29 &amp; 32 from PIER 10-00129 Action 4: Fire Barriers in the HLW Facility Condition adverse to quality: Based on the results of Action 18 of PIER 10-0129, complete the calculations or engineering analyses for the items identified in the HLW facility as needing further calculations or engineering analyses in CCN 183772. Affected Items: HOP-WESP-00002</p> <p>Original CR can be found in Attachment Folder “CR 2018-00116”.</p> <p>D) CR 2020-00485: Split Action 2 from CR 14-1103 info HLW CR Action 1: Complete fatigue assessment for applicable HLW components. Condition Adverse to Quality: Fatigue analysis not completed or unsatisfactory for HLW components listed in Attachment A of 24590-WTP-PL-ENG-07-0005 Rev.3 and issue</p>								

## In Progress 24590-WTP-NCR-MGT-24-0237

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Responsible Individual Creates Conditional Releases  
and Dispositions

by an independent group such as Equipment Seismic Qualification (ESQ) group or C/S/A engineering group in accordance with DOE standard 1020. However, this requirement was not followed, and the reports were given approval Code Level 1. Therefore, a PIER was generated (24590-WTP-CRPT-QA-08-0406-B, "Inadequate Review of the Supplier Seismic Calc"). The PIER required that the ESQ group review these reports and prepare comments on Comment Resolution Forms (CRFs) and issue CDRs (NCRs) for resolving the comments. These forms are attached listing the deficiencies in the report. These forms also provide suggestions for resolution.

Additional Information: It is required that after the final disposition of this CDR (NCR), the document be sent to ESQ group for concurrence. ESQ group personnel dealing with CRPT 08-0406 are located in the San Francisco office and they report to ESQ – Project Engineer located in the Richland office. The deficiencies are reported on the attached CRF's log 3841 and 3841A.

Nonconformance: Seismic Analysis was not reviewed by independent organization.  
Recommended Disposition: Engineering to resolve the subject documentation deficiencies.  
Affected Items: HOP-WESP-00002

Original NCR and its attachments can be found in Attachment Folder "NCR-CON-13-0156". NEED TO CREATE

F) NCR-CON-13-0188: Vendor Submittals for Vessel Not Reviewed By Independent Group  
Description: The vendor submittals reviewed in this CDR (NCR) deal with seismic analysis of equipment. These reports were required to be reviewed by an independent group such as Equipment Seismic Qualification (ESQ) group or C/S/A engineering group in accordance with DOE standard 1020. However, this requirement was not followed, and the reports were given approval Code Level 1. Therefore, a PIER was generated (24590-WTP-CRPT-QA-08-0406-B, "Inadequate Review of the Supplier Seismic Calc"). The PIER required that the ESQ group review these reports and prepare comments on Comment Resolution Forms (CRFs) and issue CDRs (NCRs) for resolving the comments. These forms are attached listing the deficiencies in the report.  
These forms also provide suggestions for resolution.

Additional Information: It is required that after the final disposition of this CDR (NCR), the document be sent to ESQ group for concurrence. ESQ group personnel dealing with CRPT 08-0406 are located in the San Francisco office and they report to ESQ – Project Engineer located in the Richland office. The deficiencies are reported on the attached CRF's Log 3841, CRF's Log 3841A and CRF Log 3842.

Nonconformance: Seismic Analysis was not reviewed by independent organization.  
Recommended Disposition: Engineering to resolve the subject documentation deficiencies.  
Affected Items: HOP-WESP-00002

Original NCR and its attachments can be found in Attachment Folder "NCR-CON-13-0188".

G) NCR-CON-14-0018: HLW Wet Electrostatic Precipitator Internals Not Procured Under NQA-1  
Description: HLW Wet Electrostatic Precipitators (WESP) contain internals such as electrodes, collector tube bundles, and insulators as well as the power supplies that were procured as commercial items per the MR 24590-QL-MRA-MKE0-00001. These items are required to perform an air permit function which requires these items to be procured under an NQA-1 program – which did not occur. These items must be dedicated or shown to be able to meet their air permit function as is.

Additional Information: reference 24590-WTP-CRPT-QA-07-336, Action 17 this NCR is to track the resolution of the Non-conformance of the HLW items separately from the LAW and partially superseded 24590-WTP-NCR-CON-08-0119.  
Nonconformance: Items not procured under NQA-1 as they should have due to air permit.

Recommended Disposition:  
Design Engineering to evaluate and provide final disposition, This NCR is similar to 24590-WTP-NCR-CON-08-0119, Reference notes and work already completed in order to resolve this NCR.  
Affected Items: 24590-HLW-EK-LVE-PSUP-30007, HOP-WESP-00002, HOP-WESP-00002-SUB0005

Original NCR and its attachments can be found in Attachment Folder "NCR-CON-14-0018".

H) NCR-CON-14-0022: Vessels Not Designed To SC-1 Criteria  
Description: Basis for Design (BOD) Section 16 requires that equipment located in Hard to Reach (HTR) areas shall be designed to SC-1 criteria. HOP-WESP-00001 and 00002 were designed to SC-III criteria. Validation that these vessels meet SC-1 criteria is required.  
Additional Information: Wet Electrostatic Precipitators HOP-WESP-00001 and 00002 were designed to seismic category SC-III criteria in accordance with the requirements at the time of delivery per 24590-QL-MRA-MKE0-00001. The WESP units are located in a Hard to Reach (HTR) area which requires analysis to the SC-I criteria per the Basis of Design section 16. The latest seismic criteria (SC-I) was revised after the WESP units were delivered. Appropriate ISRS curves must be supplied, and vessel analyzed for acceptance to the SC-I seismic criteria. Vessels are delivered and the PO has been closed out. This NCR satisfies action 16 of 24590-WTP-PIER-MGT-10-1278-B.

Nonconformance: WESPs were incorrectly designed to SC-III instead of SC-I.  
Recommended Disposition: Route to Engineering for evaluation and disposition.  
Affected Items: HOP-WESP-00002

Original NCR can be found in Attachment Folder "NCR-CON-14-0022".

I) NCR-MGT-19-0796: HLW Corroded and Rusted Electrodes for HOP-WESP-00001 and HOP-WESP-00002  
Description: Found 182 out of the 184 electrodes corroded and/or rusted during a storage surveillance, see attached pictures.  
Nonconformance: Corrosion found on most electrodes.  
Affected Items: HOP-WESP-00002-SUB0005

Original NCR and its attachments can be found in Attachment Folder "NCR-MGT-19-0796".



In Progress 24590-WTP-NCR-MGT-24-0237

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and Dispositions

or about, November 17, 2003, DMP submitted UT Examination Procedure Rev 00B to BNI with only one of the two original comments satisfied. This submittal was code 1 by the RE without all of the appropriate requirements being added into this revision. This leaves High Nickel material welds which were examined with the above submittal (N5) indeterminate.

Additional Information: This NCR is generated as a result of PIER 24590-WTP-PIER-MGT-14-1311-C.

Affected Items: HOP-WESP-00002, See attachments "24590-WTP-NCR-CON-15-0035\_HLD-05050\_05364.pdf" and "Attachment 1" from the Attachment Folder below.

Original NCR and its attachments can be found in Attachment Folder "NCR-MGT-20-0100".

K) NCR-MGT-20-0110: HLW – Vendor Submittals For Equipment Not Reviewed By Independent Group (NCR-CON-14-0040)

Description: This NCR supersedes 24590-WTP-NCR-CON-14-0040 for the HLW & MHF facility only. Disposition #376 for LAW has been completed. Migration from CAIS to NCD.

These seismic related vendor submittals were required to be reviewed by an independent group such as Equipment Seismic Qualification (ESQ) group, or CSA engineering, in accordance with DOE standard 1020. However, this requirement was not followed and the reports were given approval with code level 1. A PIER was thus generated (24590-WTP-CRPT-QA-08-0406-B, "Inadequate Review of the Supplier Seismic Calc"). The PIER requires that the ESQ group review these reports, prepare comments on Comment Resolution Forms (CRFs), and issue CDRs/NCRs for resolving the comments. Until these reports are reviewed & the comments resolved, it is indeterminate whether this equipment can withstand the required seismic load.

Additional Information: The ESQ group personnel dealing with CRPT 08-0406 are located in the San Francisco office and they report to the EQ Project engineer located in the Richland office.

Nonconformance: Vendor Seismic Analysis not reviewed by independent group as required.

Disposition # 00004: This disposition partially supersedes disposition #002. Forward to engineering to evaluate HOP-WESP-00001 and HOP-WESP-00002

Affected Items: HOP-WESP-00002

Original NCR and its attachments can be found in Attachment Folder "NCR-MGT-20-0110".

L) NCR-MGT-23-0129: HLW – HOP-WESP-00001 & HOP-WESP-00002 RT film deficiencies

Description: RT film is not compliant with ASME Section V, Article 2 per 24590-HLW-FIR-CON-16-00124 and the discussion in the main CR description of CR 2017-01393. Some of the issues relate to required film density and the use/visibility of the image quality indicator (penetrometer).

Disposition: Route to Engineering for Disposition.

Affected Items: HOP-WESP-00002

Original NCR can be found in Attachment Folder "NCR-MGT-23-0129".

Additional Information

NCRs MGT-22-0489 and MGT-22-0490 also pertain to the WESPs, however, work and/or dispositions have been completed so they have not been included in this compilation. CR 2016-01856 Action 2 is tied to these two NCRs and as such is not included in this compilation for the same reasons.

Drawing/Specification References:

Document Number	Rev	Document Title	Sections	Comments
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Applicable Items

Item Number	Parent ID	Item Description	Item Location	Item Quantity
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Condition Reports Associated with this NCR

2013-00761, 2014-00036, 2018-00116, 2020-00485

Validator

Andrews, Paul

Validation Date

11/12/2024

Validate and Screen

You are no longer logged in. Please login and retry the form.

Step 2: Are hold tags required?

Yes

Comments for Hold Tags

BPS Holds to be used for items not on site.

Step 3: Select the NCR Category

Supplier

Step 4: Stop Work?

No

Occurrence Reporting

No

Is this NCR related to an electrical item?

Yes

Step 5. Please check each WTP Area that is affected by this NCR.

HLW

Step 6. Select the Disposition Approval Authority to notify.

Skiffington, Mark

Step 7. Select the RQO to notify.

Andrews, Paul

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Condition Reports

Condition Reports Associated with this NCR

Are there any Condition Reports associated with this CR? If applicable, identify any Condition Reports associated to this NCR in the Condition Report section below.

If there are no associated Condition Reports, please enter N/A.

Condition Reports Associated to this NCR

Condition Report Number

2013-00761

2014-00036

2018-00116

2020-00485

Standing/Shift Order Numbers

Enter a Work Order/Work Request Number:

If not applicable please enter N/A.

N/A

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Responsible Individual Creates Conditional Releases  
and Dispositions

Related Processes	^
Conditional Releases	
Interim Dispositions	
Dispositions	
Attachments	



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Comments

Use this section to add comments to this NCR

Routing Slip

Participants	Completed	Status	Result	Comments
Notify initiator of NCR submittal		11/11/2024 4:45 PM		
Dasher, Kyle	11/11/2024	Notified		
Validating Authority Validates NCR		11/11/2024 4:45 PM		
Andrews, Paul	11/12/2024	Completed	NCR is Valid	
Originator Notified of Valid NCR		11/12/2024 12:42 PM		
Dasher, Kyle	11/12/2024	Notified		
RQO Notified for Hold Tags		11/12/2024 12:42 PM		
Andrews, Paul	11/12/2024	Notified		
Disposition Approval Authority Assigns Responsible Individual		11/12/2024 12:42 PM		
Cowan, Chris	12/3/2024	Completed	Assign Responsible Individual	
Responsible Individual Creates Conditional Releases and Dispositions		12/3/2024 6:28 PM		
Homberger, Brian	-	Active		

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