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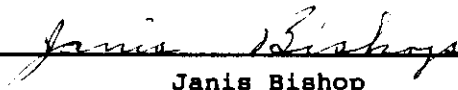
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7. Abstract

A management plan was developed for Westinghouse Hanford Company (WHC) and Pacific Northwest Laboratories (PNL) to work together on a program to provide characterization data to support removal, conditioning and subsequent dry storage of the spent nuclear fuels stored at the Hanford K Basins. The program initially supports gathering data to establish the current state of the fuel in the two basins. Data collected during this initial effort will apply to all SNF Project objectives. N Reactor fuel has been degrading with extended storage resulting in release of material to the basin water in K East and to the closed canisters in K West. Characterization of the condition of these materials and their responses to various conditioning processes and dry storage environments are necessary to support disposition decisions. Characterization will utilize the expertise and capabilities of WHC and PNL organizations to support the Spent Nuclear Fuels Project goals and objectives. This Management Plan defines the structure and establishes the roles for the participants providing the framework for WHC and PNL to support the Spent Nuclear Fuels Project at Hanford.

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**CHARACTERIZATION PROGRAM MANAGEMENT PLAN FOR  
HANFORD K BASIN SPENT NUCLEAR FUEL**

October 1995

Westinghouse Hanford Company  
and  
Pacific Northwest Laboratories

Document Title: CHARACTERIZATION PROGRAM MANAGEMENT PLAN FOR HANFORD  
K BASIN SPENT NUCLEAR FUEL

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## EXECUTIVE SUMMARY

A management plan was developed for Westinghouse Hanford Company (WHC) and Pacific Northwest Laboratories (PNL) to work together on a program to provide characterization data to support removal, conditioning and subsequent dry storage of the spent nuclear fuels stored at the Hanford K Basins. The program initially supports gathering data to establish the current state of the fuel in the two basins. Data collected during this initial effort will apply to all SNF Project objectives. N Reactor fuel has been degrading with extended storage resulting in release of material to the basin water in K East and to the closed canisters in K West. Characterization of the condition of these materials and their responses to various conditioning processes and dry storage environments are necessary to support disposition decisions. Characterization will utilize the expertise and capabilities of WHC and PNL organizations to support the Spent Nuclear Fuels Project goals and objectives. This Management Plan defines the structure and establishes the roles for the participants providing the framework for WHC and PNL to support the Spent Nuclear Fuels Project at Hanford.

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**CHARACTERIZATION PROGRAM MANAGEMENT PLAN FOR  
HANFORD K BASIN SPENT NUCLEAR FUEL**

**1.0 INTRODUCTION**

Westinghouse Hanford Company (WHC) has responsibility for management of the characterization program, including cost and schedule, and disposition of technical information to the project. Pacific Northwest Laboratories (PNL) has responsibility for managing the technical work at the laboratories needed to support the objectives identified by WHC, and responsibility to serve as a technical advisor to WHC. Characterization work supports resolution of the Hanford Spent Nuclear Fuel (SNF) Project Path Forward storage issues.

N Reactor fuel has been stored for extended periods of time in the Hanford K Basins. This fuel is degrading with continued storage resulting in release of material to the basin water in K East basin and to the closed storage canisters in K West basin. Information on the condition of the fuel will support decisions for the removal, transport, conditioning, storage, and ultimate future disposal of the materials in both the open and closed storage canisters. The fuel must be placed in a safe interim storage condition for an extended period before ultimate disposal in a waste repository.

The characterization activity for the Hanford SNF will address the identified issues related to the condition of the fuel, which are continued degradation, fuel conditioning, and interim storage for an extended period of time.

The characterization activities are structured to support design decisions for the path to interim storage, the Environmental Impact Statement (EIS) and corresponding Record of Decision (ROD), and the safety analysis reports. However, due to the aggressive schedule of the SNF program, the design, EIS preparation and safety analysis functions are proceeding in parallel with characterization. Consequently, characterization data will also confirm key decisions and assumptions while providing bases for subsequent process refinements.

This Program Management Plan (PMP) defines the scope and objectives of characterization, the program management organization, areas of responsibility, and communications, reporting, and schedule requirements.

## 2.0 SCOPE AND OBJECTIVES

### 2.1 SCOPE

The scope of this PMP initially focuses on the K Basin fuel and sludge and the N Reactor fuel and Single Pass Reactor (SPR) fuel temporarily stored in PUREX.

Characterization activities will be planned to obtain key information needed to support Path Forward decisions, in the shortest period of time. Detailed characterization plans will be structured using the Data Quality Objective (DQO) process to support Path Forward project decisions (Lawrence 1994).

### 2.2 OBJECTIVES

The following objectives were established for the SNF Path Forward project characterization activities:

1. Provide a guiding methodology for identification, collection, and reporting characterization data.
2. Support Multi-Canister Overpack (MCO) design decisions for transport and interim dry storage within regulatory compliance.
3. Develop a data base to support fuel conditioning for transition from current configurations to interim dry storage.
4. Support development of the safety envelope for process selection and implementation.
5. Support issuance of the EIS/ROD.
6. Provide data to support interim storage and monitoring.

### 3.0 PROGRAM MANAGEMENT AND ORGANIZATION

Westinghouse Hanford Company has responsibility for defining the envelope of requirements for characterization to support the SNF project, for conducting in-situ characterization in the basins, for preparation and shipments of materials to the hot cells for examinations, for requests for information from the hot cell examinations, and for interpretation of the results for the SNF Project. Westinghouse Hanford Company is also responsible for supplying characterization information to support other project objectives.

Pacific Northwest Laboratories has responsibility for planning and technical direction of the hot cell fuel and sludge examinations, for preparation and operation of PNL facilities to carry out examination work, and for evaluation of data gained from characterization activities for technical significance and quality. Pacific Northwest Laboratories will also provide expert technical advice to WHC on characterization matters.

#### 4.0 WORK BREAKDOWN STRUCTURE

The Work Breakdown Structure (WBS) for the characterization program will be fully integrated and consistent with the WBS for the SNF Project. Characterization will use the WBS developed by the SNF Project for the Multi-Year Program Plan (MYPP). U.S. Department of Energy, Richland Operations Office (RL) of Spent Nuclear Fuels and Special Programs EM-37, as a starting point.

The WBS for the current version of the MYPP is included as Table 1.

Table 1. Work Breakdown Structure for Spent Nuclear Fuel Characterization.

1.4.1.02.01.04	Characterization
1.4.1.02.01.04.01	Program Management
1.4.1.02.01.04.01.01	Management Plan
1.4.1.02.01.04.01.02	Characterization Plan
1.4.1.02.01.04.02	Video/Borosopic Fuel Examinations
1.4.1.02.01.04.02.01	Video/Borosopic Examinations Second K West Shipment
1.4.1.02.01.04.02.02	Video/Borosopic Examinations K East Shipment
1.4.1.02.01.04.03	Canister G/L Sampling
1.4.1.02.01.04.03.01	Evaluate K West Data
1.4.1.02.01.04.03.02	DQO for Basin Survey
1.4.1.02.01.04.03.03	Basin Survey
1.4.1.02.01.04.03.04	Evaluate/Report Survey Data
1.4.1.02.01.04.04	Fuel Shipment to Hot Cells
1.4.1.02.01.04.04.01	Second K West Shipment to Hot Cells
1.4.1.02.01.04.04.02	Preparation for Shipment from K East
1.4.1.02.01.04.04.03	Fuel Selection, Shipment from K East
1.4.1.02.01.04.05	K West Fuel Laboratory Examinations
1.4.1.02.01.04.05.01	DE First Shipment
1.4.1.02.01.04.05.02	Drying/Conditioning, Testing First Shipment
1.4.1.02.01.04.05.03	Ignition Testing First Shipment
1.4.1.02.01.04.05.04	DQO for Dry Storage Testing First Shipment
1.4.1.02.01.04.05.05	Develop Dry Storage Testing Capability
1.4.1.02.01.04.05.06	Initial Dry Storage Monitoring of First Shipment
1.4.1.02.01.04.05.07	Dry Storage Monitoring after 1 Year
1.4.1.02.01.04.05.08	Preparation and Receipt of Second Shipment
1.4.1.02.01.04.05.09	DQO for Second Shipment
1.4.1.02.01.04.05.10	NDE of Second Shipment
1.4.1.02.01.04.05.11	DE Second Shipment
1.4.1.02.01.04.05.12	Drying/Conditioning Testing Second Shipment
1.4.1.02.01.04.05.13	Ignition Testing for Second Shipment
1.4.1.02.01.04.05.14	Six Month Dry Storage Monitoring for Second Shipment
1.4.1.02.01.04.05.15	One Year Dry Storage Monitoring for Second Shipment
1.4.1.02.01.04.05.16	Install TGA
1.4.1.02.01.04.05.17	Degradation Effects in Dry Storage (K West)

Table 1. Work Breakdown Structure for Spent Nuclear Fuel Characterization.

1.4.1.02.01.04.06	K East Fuel Laboratory Examinations
1.4.1.02.01.04.06.01	Preparation and Receipt of Fuel
1.4.1.02.01.04.06.02	DQOs for Fuel Shipment
1.4.1.02.01.04.06.03	NDE of Fuel
1.4.1.02.01.04.06.04	DE of Fuel
1.4.1.02.01.04.06.05	Drying/Conditioning Testing
1.4.1.02.01.04.06.06	Ignition Testing
1.4.1.02.01.04.06.07	Six Month Dry Storage Monitoring
1.4.1.02.01.04.06.08	Degradation Effects in Dry Storage (K East)
1.4.1.02.01.04.07	Sludge Sampling
1.4.1.02.01.04.07.01	K West Canister Sludge Sampled/Sent to Laboratories
1.4.1.02.01.04.07.02	K East Canister Sludge Sampled/Sent to Laboratories
1.4.1.02.01.04.07.03	K West Floor/Pit Sludge Sampled
1.4.1.02.01.04.08	K East Floor/Pit Sludge Laboratory Examination
1.4.1.02.01.04.08.01	Composition and Quantity
1.4.1.02.01.04.08.02	Transport Properties
1.4.1.02.01.04.08.03	Reactivity
1.4.1.02.01.04.08.04	Tank Acceptability
1.4.1.02.01.04.09	Canister Sludge Laboratory Examination
1.4.1.02.01.04.09.01	Removal Characteristics
1.4.1.02.01.04.09.02	Drying Behavior
1.4.1.02.01.04.09.03	Six Month Dry Storage Behavior
1.4.1.02.01.04.09.04	One Year Dry Storage Behavior
1.4.1.02.01.04.09.05	Tank Waste Acceptability
1.4.1.02.01.04.09.06	Reactivity
1.4.1.02.01.04.09.07	Composition
1.4.1.02.01.04.10	K West Floor/Pit Sludge Laboratory Examination
1.4.1.02.01.04.10.01	Composition
1.4.1.02.01.04.10.02	Reactivity
1.4.1.02.01.04.10.03	Tank Waste Acceptability
1.4.1.02.01.04.11	Waste Management and Hot Cell Facility Restoration
1.4.1.02.01.04.11.01	Waste and SNF
1.4.1.02.01.04.11.02	Facility Cleanup and Restoration
1.4.1.02.01.04.11.03	Provide Canister for Fuel Return

## **5.0 PROGRAM ELEMENT AREAS OF RESPONSIBILITY**

### **5.1 PLAN FOR CHARACTERIZATION OF K BASIN SPENT NUCLEAR FUEL AND SLUDGE**

The Plan for Characterization of K Basin SNF and Sludge outlines the data needed to support the SNF and sludge Path Forward decisions (Lawrence 1995). Westinghouse Hanford Company has the responsibility for preparation and maintenance of the Plan, and for any revisions that are prepared as work progresses and data are obtained with corresponding increases in understanding of the material characteristics and conditions in the K Basin. The planning process is a team effort between WHC, RL, and PNL.

### **5.2 IN-SITU K BASIN CHARACTERIZATION**

The characterization activities at K Basin include a detailed review of historical records to establish parameters for the materials stored in the K Basins, in-situ examinations of the materials stored in the Basins, development of a data base on the initial conditions of the fuel canisters, and sludge, in both K Basins, and evaluations of the data collected during the in-situ examinations. Westinghouse Hanford Company has responsibility for characterization activities at K Basin recognizing WHCs primary responsibility for the K Basins operations and surveillance activities. PNL will provide expert advice for K Basin characterization activities.

### **5.3 TRANSPORTATION**

Materials will be transported between the K Basin and the various on-site laboratories and hot cells for examinations as part of characterization. Westinghouse Hanford Company will have the primary responsibility for all aspects of the movement of materials from one location to another. Once material has been transported to a PNL facility, it will become the responsibility of PNL until it is returned to WHC. Pacific Northwest Laboratories will be responsible for all material movements within and between their facilities, for preparation of the return shipment of SNF sample remains to K Basins and for sending test residuals to Central Waste.

### **5.4 HOT CELL UPGRADES**

Selected hot cell upgrades will be necessary to implement characterization. Pacific Northwest Laboratories will be responsible for these upgrades recognizing PNLs primary responsibility for operation of these facilities. PNL will manage the upgrades to be fully responsive to the SNF Project requirements and schedules for characterization.

## 5.5 DATA QUALITY OBJECTIVES DEVELOPMENT

In its simplest form, the DQO Process asks the program participants to address three key questions: What data are required to answer the question(s) posed, what new data are required, and how will the newly obtained data be used to answer the question(s) posed? The SNF Project is fully committed to utilizing the DQO approach to define characterization needs (Lawrence 1994). The DQO process will govern the development of the individual test plans and instructions prepared for each logically identified series or group of examinations or measurements.

## 5.6 QUALITY ASSURANCE

The Quality Assurance (QA) for the characterization activities and data management will be in full compliance with the QA plans and requirements of the Office of Civilian Radioactive Waste Management (OCRWM) Quality Assurance Requirements and Description (QARD), RW-033P, (Sellers 1995). The characterization activities and data management will comply with the individual WHC and PNL company QA requirements. The QA impact levels for the various aspects of characterization activities and data management will be defined by the SNF Project QA Manager with concurrence from the performing organizations.

## 5.7 HOT CELL EXAMINATIONS

Hot cell examinations of samples of complete and partial fuel elements, and samples of the sludge, water, and gas contained within the shipping canisters, may all be necessary parts of characterization. PNL will be responsible for the examinations within the test facilities. WHC will provide expert assistance where appropriate.

## 5.8 WASTE MANAGEMENT

A Waste Management Plan was prepared by WHC and PNL that describes, in detail, the pathway for disposal of all wastes generated from characterization activities (Chastain 1994). WHC will have responsibility for all wastes designated as SNF, and all wastes generated at K Basins. PNL will have responsibility for disposal of all test residuals generated in their facilities, via WHC Central Waste Management.

## 5.9 DATA MANAGEMENT

A centralized controlled repository of reviewed and pedigree data is a necessary part of the characterization activities. A data library will provide ready access to a consistent set of data for all program participants which will be utilized by different individuals for a variety of analysis. The data library will include as much historical data as practical, the test plans and corresponding test instructions, as well as all the raw and reviewed data.



Data management and development of the centralized data library is a WHC responsibility. Satellite libraries may be created as necessary for operational efficiency.

#### **5.10 DATA INTERPRETATION**

Data interpretation is a central part of the plan for characterizing SNF and sludge, and will be a shared WHC and PNL activity. Individual teams may be formed capitalizing on expertise within each organization for interpretation of individual types of data as well as groups of data addressing specific questions such as extent of fuel oxidation and hydriding, etc. Interpretations and conclusions reached will be conveyed to the SNF Project through the WHC Management Point of Contact (Section 7.1). WHC is responsible for the resolution, to the satisfaction of RL, of all differences of opinion.

#### **5.11 NATIONAL SNF PROGRAM**

The Hanford SNF Project recognizes there is a National SNF Program addressing the issues related to the materials within the RL complex. The Hanford SNF Project will participate in the National Program, as authorized by the WHC Management Point of Contact. PNL will continue to participate in National SNF Program Meetings representing its interest as a National Laboratory, but will not represent the SNF Project unless asked to.

## **6.0 PROGRAM INTERFACES AND COMMUNICATIONS**

### **6.1 MANAGEMENT POINTS OF CONTACT**

The Management Point of Contact for WHC is R. P. Omberg, Manager of the SNF Characterization Program.

The Management Point of Contact for PNL is D. K. Kreid, Manager of the Hanford SNF Technical Support Project.

The Management Point of Contact for RL is Jian-Shun Shuen, Characterization Program Staff Engineer.

The Management Points of Contact are the formal interfaces between the three organizations. They are responsible for the program interfaces and communications for their respective organizations.

A change in responsibilities for any of these individuals will require written notification to the Management Points of Contact for each of the other organizations.

### **6.2 COGNIZANT ENGINEERS, PRINCIPAL INVESTIGATORS, AND TASK TEAM LEADERS**

Cognizant engineers, principal investigators, and task team leaders will be appointed from the WHC and PNL organizations to fully utilize expertise within each organization for specific activities within the characterization program. These individuals will be identified by the Management Points of Contact within the respective organizations. Appointments to a specific task or activity will be communicated to all interested parties within both organizations. These individuals will act as the single points of contact for that specific task or activity within the characterization program.

### **6.3 INTERFACE WITH SNF PROJECTS**

The WHC Management Point of Contact will be the interface and communications link to the SNF Project.

### **6.4 INTERFACES WITH OTHER HANFORD PROJECTS**

Single point of contact interfaces will be defined by the RL Management Point of Contact for other Hanford Projects as appropriate.

## 7.0 MEETINGS

### 7.1 PERIODIC ACTIVITY MEETINGS

Periodic activity meetings will be held with appropriate activity participants, as necessary to maintain activities on-schedule. Meetings will be called by the respective cognizant engineer, principle investigator, task team leader, or Management Point of Contact. Weekly meetings on timely activities are encouraged. Meeting minutes are required for all meetings, and are the responsibility of the person calling the meeting. The minutes shall be brief and shall be transmitted to all participants and designated management within all organizations no later than two working days after the meeting.

### 7.2 TECHNICAL REVIEWS

Technical reviews will be the responsibility of the WHC Management Point of Contact and will be held, at least annually, to cover technical progress. The timing, locations and agenda for the reviews will be established by the Management Points of Contact. Attendance will be by invitation and may include off-site as well as on-site SNF Program participants. The intent of the technical reviews is to obtain timely peer reviews of significant progress and results.

## **8.0 REPORTS AND DOCUMENTATION**

### **8.1 PERIODIC REPORTS TO THE PROJECT AND RL**

The WHC Management Point of Contact will provide a bi-weekly technical progress report and monthly financial report to the RL Management Point of Contact.

The Management Points of Contact may be required to report separately to the RL Management Point of Contact on specific activities within their respective organizations.

### **8.2 TOPICAL REPORTS AND OPEN LITERATURE PUBLICATIONS**

Timely reports at the completion of an activity are required of the organization with the primary responsibility or lead for that activity. Preparation of topical reports are encouraged, however, letter reports may be acceptable on a limited basis for small activities or for timely distributions of results. Open literature publications within the appropriate forum are encouraged. Open literature publications must have SNF Project approval prior to release from the respective organizations.

### **8.3 PLAN, REQUIREMENTS, ROUTINE CORRESPONDENCE**

Examination plans, data requirements, and routine correspondence generated within the characterization activities will be made available to all interested parties. In order to expedite the document approval process, early drafts and parallel reviews will occur without regard to organization. The intent is to provide free and timely exchanges of information to all interested parties.

## **9.0 SCHEDULES AND COMMITMENTS**

### **9.1 OVERALL PROJECT SCHEDULES**

The overall project schedules are structured around the SNFP Path Forward strategy for removal of fuel and sludge from the K Basins. A key element in this is the integrated schedule for K Basin activities and projects. Also included are completion of the EIS/ROD, completion of the safety analysis reports, completion of conditioning, drying, and interim storage of the fuel, and removal of the sludge.

### **9.2 CHARACTERIZATION PROGRAM SCHEDULE AND MILESTONES**

Activity and milestone schedules have been established in the MYPP and in the Plan for Characterization of K Basin SNF and Sludge. These schedules are fully responsive to the overall project schedules. Task schedules will be reconciled by the Management Points of Contact to satisfy the overall project milestones and deliverables, and will be made available to all the Management Points of Contact and to the working level organizations to fully integrate activities to meet established milestones.

## 10.0 FUNDING

The identification and allocation of funds for characterization activities will be provided through the SNF Project MYPP Documentation.

## 11.0 PROGRAM MANAGEMENT PLAN REVISIONS

The intent of this PMP is to set the framework for the plan to characterize the SNF and sludge at Hanford with initial focus on the K Basins. If there is a significant revision in the Project work scope and the defined responsibilities of WHC and PNL, a revision to this PMP will be prepared. The decision to prepare a revision will be made by the RL Management Point of Contact for characterization (Section 7.1) or the SNF Project Director. Changes to the PMP and associated plans will be managed through formal change control and reference baseline management documents.

## 12.0 REFERENCES

- Lawrence, L. A., and S. C. Marschman, 1995 "Plan for Characterization of K Basin Spent Nuclear Fuel and Sludge," WHC-SD-SNF-PLN-007, Rev. 0, Westinghouse Hanford Company, Richland, Washington.
- Lawrence, L. A., K. S. Redus, and T. A. Thornton, 1994 "Spent Nuclear Fuels Project Characterization Data Quality Objectives Strategy," WHC-EP-0795, Westinghouse Hanford Company, Richland, Washington.
- Chastain, S. A., and R. L. Spinks, 1994, "Waste Management Plan for Hanford Spent Nuclear Fuel Characterization Activities," WHC-SD-SNF-PLN-001, Rev. 0, Westinghouse Hanford Company, Richland, Washington.
- Sellers, E. D., Letter to President WHC, 1995, "Office of Civilian Radioactive Waste Management (OCRWM)," Quality Assurance Requirements and Description (QARD), RW-033P, 95-SFD-098, Westinghouse Hanford Company, Richland, Washington.