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TITLE

Waste Disposal-Failure of T Plant Underground
Metal Waste Line from Section 9.

AUTHOR

V.R. Chapman

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July 15, 1947

To: R. S. Ball
"S" Department

By Authority of H. F. Carroll

From: V. R. Chapman

By S. D. Smiley

SUBJECT: Waste Disposal - Failure of T Plant
Underground Metal Waste Line From
Section 9

On June 23, 1947, a hole was discovered in the earthen fill near the T Plant R-19 stairwell directly above the path followed by the underground waste lines from the canyon. Jetting of all canyon wastes to the 241 Buildings was stopped and the canyon process shut down.

Subsequent close inspection and radiation survey of the cavity and the soil surface nearby disclosed the following:

1. Radiation levels of 15 mrep were obtained with a probe at a depth of 5 feet in the cavity.
2. The earthen fill showed cracks caused by settling up and down the path of the underground waste lines for a distance of approximately 20 feet.
3. A small void existed beneath the surface of the soil, slanting downward and to the west to a depth of 5 feet from the opening at the surface.
4. No soil contamination was evident on soil removed from the base of the cavity.

Under very close survey by H.I., an excavation was made the following day in the cave in to a depth of 7 - 8 feet where radiation levels of 20,000 mr. were found, but no soil contamination. A sample of soil obtained by pushing a pipe to a depth of 2 feet below the bottom of the hole (9 - 10 ft.) gave radiation readings of 20,000 mrep. Since the excavation served no further purpose, it was again backfilled.

To determine definitely which of four lines in active service was leaking, a program of testing all lines running from the canyon to the 151-T and

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152-T diversion boxes was outlined. Details of the method used follow under the section titled "Testing Underground Waste Lines".

When the 152-T diversion box was last opened approximately one year ago, work was performed around it with considerable difficulty due to radiation levels of approximately 10R at the top of the open box. In an attempt to reduce these readings before opening the box for the present job, a 2,000# wash with 10% citric acid solution preceded and followed by a 5,000# wash with 10% soda ash solution was pumped through the 152-T diversion box sprays. Upon opening the box, a maximum reading of 150 mr at the box opening was obtained, indicating that this treatment is quite effective in removing by-product contamination.

The final line tested hydrostatically was the metal waste line from 9-1 to 151-T diversion box. When an attempt to build pressure on this line was made, there was more settling of the ground at the cave in near R-19 and very little build up of pressure on the line evident. It was obvious that a quite sizable leak existed in the line.

At the completion of the tests, which established that all underground waste lines, including the 10-1 to 153-T diversion box, were intact, except the 9-1 to 153-T diversion box line, the call and diversion box piping was reinstalled according to the second procedure which follows, titled "Re-assembling and Testing of T Plant Waste System". This procedure includes the activation of the 10-1 tank for receiving, neutralization and disposal of metal waste from the 8-3 catch tank. Reassembly of piping and activation of 10-1 were completed on June 28, 1947 and the Plant placed in operation again the same day.

A meeting was held on July 8, 1947, with members of the "S" Department, H. I. Group, Project Engineering Group, Maintenance Department and Transportation Department for the purpose of discussing the necessary corrective measures to be taken as a result of the above failure. The decisions reached in this meeting are outlined in an attached letter titled "T Canyon Waste Line Incident - Corrective Action to be Taken".

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221-1041

June 25, 1947

TESTING UNDERGROUND WASTE LINES

It is necessary to test the following underground waste lines at the rear of 221-T canyon, in connection with the cave in at R-19, in the order listed:

- 1) 15-9 to 152-T diversion box.
- 2) 5-9 and stack drain to 152-T diversion box.
- 3) 15-8 to 152-T diversion box.
- 4) 10-1 to 151-T diversion box.
- 5) 9-1 to 151-T diversion box.

In general, the test will be made by filling the line with water from the diversion box to the canyon cell wall stub from which the connector has been removed and a wall stub blank installed, building the line pressure to approximately 100 lbs. and seeing if the line will hold the pressure for a period of thirty minutes after being shut in. At the time the line is being filled and the pressure maintained, the area back of the canyon from section 15 to 19 over the waste lines will be observed for evidence of settling or other signs of underground leakage.

The testing will be supervised by the 221-T Senior Supervisor, with the 224-T Senior Supervisor assisting. The 221-T Senior Supervisor will be stationed at the diversion boxes and direct opening of diversion boxes, installation of the special piping arrangement for the introduction of water to the line and the operation of valves during testing. The 224-T Supervisor will be stationed in the crane cab during the filling of the line and until the connector has been pulled up tight. Then he will be stationed in the Dispatcher's office during the time pressure is being applied to the line, keeping in communication with the supervisor at the diversion box, the inspectors at the rear of the canyon and, if necessary, with the crane operator. (Communication with personnel at the rear of the canyon will be carried on through the house phone system by means of an extension plugged in at a convenient entrance to the canyon; communication with the supervisor at the diversion boxes will be carried through the outside phone system.)

A temporary Danger Zone will be established about the diversion boxes and roped off before the boxes are opened. Entrance to this Danger Zone will be by S.P. and will require coveralls, rubbers and rubber gloves as minimum protective equipment. Full protective equipment (hood, rubbers and rubber suit) for acid work will be required when breaking water lines tied in with the diversion box stubs.

All work done on the diversion boxes or in the temporary Danger Zones at the rear of the canyon will be covered by SWP's. When a canyon cell is opened, all extended canyon permits, except that for operation of the crane become void and remain void until the cell is closed and it is established by H. I. that air conditions are safe.

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During the filling of the waste lines for testing and the application of pressure, an operator will be stationed at waste sections 5, 9, 10 and 15 to observe the wt. factors on the waste tanks in those sections for evidence of filling which would indicate an error in the testing installations. These operators and the observers at the rear of the canyon will be in communication with the Dispatcher, or Supervisor, through the conference jack on the inter-communication system.

Safety

1. A water truck will be located at the diversion box for use in case of emergency resulting from special hazards.
2. Requirements of the locking and tagging procedure will be fulfilled.
3. Constant monitoring will be supplied by H. I. An Operations Supervisor and Supervision from the Servicing Groups involved will be present at all times when work is being performed around the diversion boxes.
4. Coveralls, rubbers and rubber gloves are the minimum requirement in protective equipment by those actually engaged in the work around the diversion boxes. In addition, a complete acid suit and hood will be required for anyone breaking the testing lines at the box during the removal of the connectors.
5. Before each step of the job, the procedure to be followed in executing that step will be reviewed by H. I., Operations and all Servicing Groups concerned. This conference will serve to emphasize the precautions to be taken from the Safety and Special Hazards standpoint.
6. Froped off area to be established around diversion box so that 8 hr. time limit is available any place outside the area and no possibility of spray reaching ropes.

Equipment

1. Special blank connector with bail attached to be used for the cell wall connectors.
2. Water truck.
3. Mobile crane equipped with hook and impact wrench.
4. Control box for impact wrench.
5. Portable flood lights for diversion box and rear of canyon.
6. Water addition equipment:
 - a. Piping from 241-T fire hydrant.

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- b. Water addition assembly consisting of a water meter with guard valves, by-pass and bleed, control valves and check valves.
 - c. Funnel mounted on wall type connector head.
 - d. Special connector with water inlet and a drain to funnel.
7. SWP supplies and disposal facilities.
8. Drinking water supply.

Installations for Testing

Line will be tested in the sequence shown below. Data for special installations in cells and diversion boxes are indicated.

1. 15-9 to 152-T

Cell 15-1: Remove: Conn 11-12
Blank : Conn 11

Div. Box 152-T Remove: Conn 4U - 4L
Conn 5U - 10L
Conn 6U - 6L
Test Conn 4U
Funnel Conn 4L

2. 5-9 and Stack Drain to 152-T*

Cell 5-L Remove: Conn 11-12
Blank : Conn 11
Close : Stack Drain

Div. Box 152-T Test Conn 4U
Funnel Conn 4L

3. 15-8 to 152-T

Cell 15-2: Remove: Conn: 53-54
Blank : Conn: 53

Div. Box 152-T Test Conn: 5U
Funnel : 4L

4. 10-1 to 151-T

Cell 10-L: Remove: Conn. 40-42
Blank : Conn. 42

Div. Box 151-T Remove: Conn. 3U - 4L
Test Connection: Conn 3-U
Funnel : None

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5. 9-1 to 151-T

Call 9-L: Remove conn 40-42
Blank conn 42

Div. Box 151-T Remove 4U - 6L
Test Connection 4U
Furnel 5L

Procedure

Lines will be tested in the sequence indicated above using the following general procedure:

1. Remove covers from the diversion box as required and place so that they will not interfere with work, or use for shielding as required. Blocks to be set on tar paper covered planks.
2. Remove diversion box connector as specified above.
3. Install the funnel on the lower connector as specified above. (In testing 10-1 line, water will be drained to floor of the diversion box.)
4. Install water adapter to the upper connector as specified above. Make this up to the water control and metering assembly which had previously been hooked to a fire hydrant, keeping control valves and meter well out of range of radiation from the box (outside roped boundary of Danger Zone) and locating blocks for shielding as required.
5. In the meantime, the necessary connector in the canyon cell will have been removed, set aside in the cell and the wall connector blank placed but impacted loosely to hold in place and yet allow water to leak through freely.
6. With the blank on the wall connector of the cell, the area around the cave in and the weight factor meters on tanks in Sections 5, 9, 10 and 15 all under observation, add water to the line as follows:
 - a. Close the drain valve on the connector in the diversion box and the metering assembly outside.
 - b. Take reading of the water meter, record and then open the necessary valves to start flow of water to the waste line. Regulate the flow at such a rate that excessive amounts of water will not be spilled into the cells before the blank is tightened on the wall connector and that excessive amounts will not escape from possible leaks in the line. Add water until it is observed coming from around the cell connector blank, or evidence of leakage is noted at the cave in, or evidence of misdirection is noted in waste section tanks, or a maximum of 1500 gals. is added.

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7. When the line is full, close the main inlet water control valve and the valves on either side of the water meter. Impact the cell connector blank.
8. Open valves in the water supply system carefully and allow the line pressure to build up to 100 lbs. Close valves back of pressure gage noting any drop in line pressure.
9. Open fire hose bleeder very carefully under constant monitoring by H. I. When the pressure has been relieved through this bleeder line back to the diversion box, open the valve wide and observe end of bleeder for leakage. If there is leakage, correct by tightening valves.
10. If the line pressure holds without appreciable loss for a period of thirty minutes, it will be assumed that there is no leak.

Note: The blank on the cell connector is to be closely observed for leaks during pressure testing. The cave in area is to be observed for evidence of leaks during water addition to the line and until pressure testing is complete.

11. Wearing full acid protective equipment, drain the line to the funnel by carefully opening the drain valve at the special connector in the diversion box. When the gage shows that pressure is off the line, loosen the blank on the cell connector to allow air to bleed in.
12. When the line has drained completely, disconnect the testing equipment and place on the next connector to be tested. This step is to be performed with all the caution required in breaking lines under pressure. Full acid protective equipment is required for those doing the job. Connector on diversion box stub to be loosened before pipe above ground is disconnected.

* Note: In testing the 5-9 and stack drain to 152-T diversion box, the following steps are required.

- a. Close stack drain.
- b. Remove cell connector and diversion box connectors.
- c. Hook up water addition equipment.
- d. Fill line through to cell.
- e. Impact cell connector blank.
- f. Open stack drain and add 150 gal. water.
- g. Close stack drain and pressure test.
- h. As pressure is built on line, determine that there is no leakage through the stack drain valve by checking vibration through extension handle by touch and listening.
- i. Open stack drain valves and lock open when pressure has been released and line is draining.

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June 27, 1947

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REASSEMBLING AND TESTING OF T PLANT WASTE SYSTEM

Following is the procedure to be used for reassembly of the waste disposal system and placing 10-1 tank in service for neutralization and disposal of metal waste.

Reinstallation of Diversion Box Jumpers (152-T)

1. The U-4 to L-4 jumper (5-9 and stack to 241) will be regasketed with GX, have a bail installed and be reinstalled in the U-4 to L-4 position of diversion box 152-T.
2. The U-6 to L-6 jumper (15-9 to 241) will be regasketed with GX, have a bail installed and be reinstalled in the U-6 to L-6 position of diversion box 152-T.
3. The U-5 to L-10 jumper (15-8 to 241) has a bail and is too hot to regasket. An inspection should be made of both heads of this jumper to see that gaskets appear in good condition and then reinstalled in the U-5 to L-10 position.
4. All jumpers which are excess lying in the bottom of the 152-T diversion box are to be removed, placed on boards covered with tar paper out of the way, covered up so that wind will not blow contaminated dust from them and then roped off as a Danger Zone from all other areas. These will be buried next week.

Note: Two excess jumpers removed to Danger Zone. There is one remaining without a bail in the bottom.

5. Leave the diversion box open for testing.

Reinstallation of Diversion Box Jumpers (151-T)

1. All jumpers now lying in the bottom of 151-T diversion box are to be removed and placed on tar paper covered boards, covered, roped off in a special Danger Zone and held until next week for disposal.

Note: Two jumpers in bottom. Surveyed at ground level in box. Both greater than 20,000 mrep. Put back in bottom of box.

2. A new "T" jumper will be brought in and fitted on the U-5 to L-8 to see that it fits. Care should be taken to see that it touches only these two clean stubs.
3. If the jumper fits properly in step 2, install in the U-3 to L-6 position and impact.
4. Leave the diversion box open for testing.

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Reinstallation of Cell Connector Piping

The gaskets in the following cell connectors are to be inspected to see that they are in good condition and then the connectors are to be reinstalled. (On hot connectors which it would be impossible to regasket, the connectors will be reinstalled if there appears to be a chance for the wall connector to hold. If the gasket is bad on those where it is feasible to change gaskets, regasketing should be performed.)

Cell 5-L	Conn 11-12	5-9 stack to 241-T
Cell 10-L	Conn 40-42	10-1 to 241-T
Cell 15-L	Conn 11-12	15-9 to 241-T
Cell 15-R	Conn 53-54	15-8 to 241-T

If any of these connectors have already been reinstalled, the cell must be checked to see that they are in place. Also, wrench must be placed on the connectors to try them for tightness.

Testing 5-9 and Stack Drain to 241-T

1. After the 11-12 conn has been installed in Cell 5-L and the U-4 to L-4 jumper has been installed in the 152-T diversion box, jet 1500# water from 5-7 to 5-9 tank.
2. Inspect diversion box 152-T for condition, then move back from it.
3. While watching the 11-12 conn in 5-L from the crane, jet water to 241-T from 5-9. Stop if leaks appear on the 11-12 conn and tighten. Then complete jetting.
4. After jetting is complete and air is shut off at gang valve, inspect the U-4 on L-4 stubs in 152-T box for evidence of leaks.

Testing 15-9 to 241-T

1. After the 11-12 conn has been installed in 15-L and the U-6 to L-6 jumper has been installed in the 152-T diversion box, add 1500# of water to the 15-9 tank.
2. Inspect diversion box 152-T for condition and then move back from it.
3. While watching conn 11-12 in 15-L from the crane, jet water to 241-T from 15-9. Stop if leaks appear on the 11-12 conn and tighten. Then complete jetting.
4. After jetting is complete and air is shut off at gang valve, inspect the U-6 to L-6 stubs in 152-T box for evidence of leaks.

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Testing 15-8 to 241-T

1. After the 53-54 conn has been installed in 15-R and the U-5 to L-10 jumper has been installed in the 152-T diversion box, add 1500# of water to the 15-8 tank. (Connector from U canyon installed)
2. Inspect diversion box 152-T for condition and then move back from it.
3. While watching conn. 53-54 in 15-R from the crane, jet water to 241-T from 15-8. Stop if leaks appear on the 53-54 conn and tighten. Then complete jetting.
4. After jetting is complete and air is shut off at gang valve, inspect the U-6 to L-6 stubs in 152-T box for evidence of leaks.

Placing 10-1 Tank in Service

1. Before adding water to 10-1 for testing, the following piping must be in place as determined by visual inspection from the crane.

<u>Call</u>	<u>Connector</u>	<u>Purpose</u>
8-R	72-73	8-3 to 10-1 tank
10-L	4	8-3 to 10-1 tank
10-L	40-42	10-1 to pipe trench
Sect. 10 pipe trench	42-101	Pipe trench to 241-U
151-T div. box	U-3 to L-6	151-T to Tie line

2. The following blanks must be installed in pipe gallery conns. before any jetting:

<u>Call</u>	<u>Conn. No.</u>	<u>Purpose</u>
8	76	Steam to 8-3 to 9-1 jet
9	40	Steam to 9-1 to 241-T jet
10	2	Steam to 10-1 to 10-2 (Supplied by same gang valve as 10-1 to 241)

3. The following blanks must be removed from pipe gallery wall connectors before any jetting.

<u>Section</u>	<u>Conn. No.</u>	<u>Purpose</u>
8	73	Steam to 8-3 to 10-1 jet
10	40	Steam to 10-1 to 241 jet

4. When all piping for use of 10-1 as metal waste neutralization tank is in place and blanks have been installed properly, add 1500# of water to 10-1 tank. (Instruments should then be working on Section 10 board, especially the 10-1 and 10-2 and 10-3 wt. ftr. meters.)

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5. With blocks off 10-R, jet 500# water from 10-1 to 241. Inspect the 40-42 conn from crane for leaks during jetting.
6. With blocks off trench, jet remaining 1000# water from 10-1 to 241. From crane, inspect the Section 10 trench 42 to 101 pipe for leaks while jetting.
7. As soon as jetting of water is complete, inspect the 151-T box for evidence of leaks from the U-3 to L-6 jumper.
8. If above tests show no leaks, or any leaks that do appear are repaired successfully, the 10-1 tank is ready for metal waste.
9. Open Cell 8-R and jet 1000# of metal waste to 10-1 while inspecting the 72-73 connector for leaks. If no leaks appear, close this cell and complete jetting of first half of MW to 10-1.
10. When jetting is complete, open 10-1 and inspect conn. 4 for evidence of leak.
11. If no leaks are evident, continue operation of 10-1 in standard manner for metal waste section after everything is closed.

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July 9, 1947

TO: R. S. BELL

FROM: S. D. SMILEY

T CANYON WASTE LINE INCIDENT
CORRECTIVE ACTION TO BE TAKEN

A meeting was held on July 8, 1947, with members of the "S" Department, H. I. Group, Project Engineering Group, Maintenance Department and Transportation Department for the purpose of discussing the necessary corrective measures to be taken as a result of the failure of the metal waste line opposite R-19 at the 221-T Building.

1. One test hole has been installed directly over the waste line at a point approximately 120' down stream from the point at which the cavity over the leak appeared. This was done by excavating a hole to within one foot of the lines under constant HI monitoring. A four inch pipe was then set in the excavation to provide a test well and the excavation backfilled. No contamination was encountered at this point.
2. A second test well will be similarly provided directly over the waste lines at a point about eighty feet up stream from the point at which the cavity appeared. This well will be directly opposite the R-17 Stairwell and will give assurance that contamination has not spread into that area which will have to be excavated in case additional waste facilities are provided. Constant monitoring by the H.I. Group will be provided during the excavation.
3. It is desirable to limit the permanent Danger Zone about the contaminated area so that the use of the road between 221-T and 224-T and the use of the R-19 and R-17, 221-T Stairwells will not be interfered with. Four test wells will be driven on each side of the waste lines. These wells will be located about thirty feet from the waste lines and parallel to the lines. They will be spaced approximately forty feet apart. The wells will be driven to the same depth as the waste lines and will be encased with 4" pipe.

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R. S. Fell

July 9, 1947

During the process of driving the 4" pipe, it will be necessary to pull out the driving tool at various depths to permit H.I. to check the tool and take soil samples. This will give assurance that gross contamination is not being encountered during the work. A soil sample will also be taken at the bottom of each well.

4. When the contaminated area has been defined by the above test wells, it will be enclosed by means of a permanent climb proof fence and posted as a Danger Zone.
5. The fenced area, including the test wells, will be monitored once each week by members of the "S" Department and once each month by the H.I. Group. The "S" Department Area Supervisor will revise the "S" Department manual of Standard Practices, 221-311, "Routine Special Hazard Surveys" to include this listing.

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