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3. Information  
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(See Approval Designator for required signatures)
ACCEPTANCE TEST REPORT FOR WASTE TANK SAMPLE VESSEL H-2-826-1 ASSEMBLY

C. G. Linschooten
Westinghouse Hanford Company, Richland, WA 99352
U.S. Department of Energy Contract DE-AC06-87RL10930

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Key Words: vessel, tank waste, privatization, assembly, vitrification

Abstract: See ATR for information.

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A-6400-073 (10/95) GEF321
Acceptance Test Report
for
Homogenizer Waste Tank Sample Vessel
H-2-826884 - 1 Assembly

WHC-SD-WM-ATR-180
Revision 0

Prepared by:
C. G. Linschooten

July 1996
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Acceptance Test Report
for
Homogenizer Waste Tank Sample Vessel
H-2-826884 - 1 Assembly

1.0 Introduction

This acceptance test will be performed to check for leakage of the welds. The maximum pressure the vessel's heating /cooling jacket will experience is 2.3 PSIG, at no flow.

The vessel will be exposed to water from the shop with the building's water pressure, approximately 40/80 PSIG. This will be far in excess of the one and a half times the maximum operating pressure for hydraulic pressure testing.

2.0 Objective

The completed ATP will verify that the vessel assembly will not leak.

3.0 Scope

The ATP performance, with this procedure, will verify and record on all four vessels, any leakage or deformation of parts of the tested assembly.

4.0 Description of test

4.1 Test Item

The test item is an assembled vessel, H-2-826884-1 Assembly.

4.2 Test Environment

The testing will be done in a shop environment with ambient temperature and humidity.

4.3 Test Procedure

The test procedure is described in 5.0.

4.4 Record of Approval

The record of approval of the vessels will be by part number, date of manufacture and serial number and will be kept with the work package. The Serial Number sequence is 96-01; 96-02; 96-03 and 96-04 and on, if necessary in the future. "96" being the year in which the assembly was made and 01 and 02 etc. being the sequence in which the assemblies are completed.
5.0 Test Procedure

5.1 Part Number

Record assembly part number: H-2-826884-00
Record serial number: SN-1, 96-01 UNIT 1
Manufacturing date: 7-11-96

Witness QC: [Signature] Date: 7-11-96
Cognizant Engineer: [Signature] Date: 7-11-96

5.2 Leak test

The building's water will be hooked-up to one inlet of the vessel's water jacket and the other inlet/outlet will be capped-off. Hold the pressure for 5 minutes, no leakage shall occur. Check for deformation.

Record Leakage: NONE OBSERVED

Record deformation: NONE

QC Witness: [Signature] Date: 7-11-96
Cognizant Engineer: [Signature] Date: 7-11-96

Fill the vessel with water, approximately 1/2 gallons and check if the 3/4 inch ball valve operates properly and does not leak in the closed position.

Operation of 3/4 inch ball valve: OPEN THEN CLOSE

Record leakage of ball valve: NONE

QC witness: [Signature] Date: 7-11-96
Cognizant Engineer: [Signature] Date: 7-11-96

6.0 Quality Assurance

Q.C. will witness the ATP

7.0 Organization and Function Responsibilities.

The engineer with the help of the organization building the vessel will perform the test with QC present. QC will sign off when the vessel(s) have passed the test. The manufacturing shop will keep the data with the work package.

QC INSPECTION RECORD
ATR Appendix A: Conclusions and Test Report Sheets for Units 2, 3 and 4

1.0 Introduction

The four Waste Tank Sample Vessels H-2-826884-1 Assembly were tested per WHC-SD-WM-ATP-180. The four units passed the test with satisfactory results.

2.0 General

The test was only a leak test to check the welds and valve assembly and valve operation.
5.0 Test Procedure

5.1 Part Number

Record assembly part number: 14-2-824884-40
Record serial number: SN-2 96-02 UNIT 2
Manufacturing date: 7-11-96

Witness QC: [Signature] Date: 7-11-96
Cognizant Engineer: [Signature] Date: 7-11-96

5.2 Leak test

The building's water will be hooked-up to one inlet of the vessel's water jacket and the other inlet/outlet will be capped-off. Hold the pressure for 5 minutes, no leakage shall occur. Check for deformation.

Record Leakage: NONE
Record deformation:

QC Witness: [Signature] Date: 7-11-96
Cognizant Engineer: [Signature] Date: 7-11-96

Fill the vessel with water, approximately 1/4 gallons and check if the 3/4 inch ball valve operates properly and does not leak in the closed position.

Operation of 3/4 inch ball valve: OPEN THEN CLOSE

Record leakage of ball valve: NONE

QC witness: [Signature] Date: 7-11-96
Cognizant Engineer: [Signature] Date: 7-11-96

6.0 Quality Assurance

Q.C. will witness the ATP

7.0 Organization and Function Responsibilities.

The engineer with the help of the organization building the vessel will perform the test with QC present. QC will sign off when the vessel(s) have passed the test. The manufacturing shop will keep the data with the work package.
5.0 Test Procedure

5.1 Part Number

Record assembly part number: 1 H-2-876884-90
Record serial number: 5N-3 96-03 UNIT 3
Manufacturing date: 7-2-96

Witness QC: [Signature] Date: 7-2-96
Cognizant Engineer: [Signature] Date: 7-2-96

5.2 Leak Test

The building's water will be hooked-up to one inlet of the vessel's water jacket and the other inlet/outlet will be capped-off. Hold the pressure for 5 minutes, no leakage shall occur. Check for deformation.

Record Leakage: 0
Record deformation: NONE

QC Witness: [Signature] Date: 7-2-96
Cognizant Engineer: [Signature] Date: 7-2-96

Fill the vessel with water, approximately 1 ½ gallons and check if the 3/4 inch ball valve operates properly and does not leak in the closed position.

Operation of 3/4 inch ball valve: OK
Record leakage of ball valve: 0

QC witness: [Signature] Date: 7-2-96
Cognizant Engineer: [Signature] Date: 7-2-96

6.0 Quality Assurance

Q.C. will witness the ATP

7.0 Organization and Function Responsibilities.

The engineer with the help of the organization building the vessel will perform the test with QC present. QC will sign off when the vessel(s) have passed the test. The manufacturing shop will keep the data with the work package.
5.0 Test Procedure

5.1 Part Number

Record assembly part number: H-2-826884-010
Record serial number: SN-4-96-04-UNIT 4
Manufacturing date: 7-11-96

Witness QC: [Signature] Date: 7-11-96
Cognizant Engineer: [Signature] Date: 7-11-96

5.2 Leak test

The building's water will be hooked-up to one inlet of the vessel's water jacket and the other inlet/outlet will be capped-off. Hold the pressure for 5 minutes, no leakage shall occur. Check for deformation.

Record Leakage: none visible

Record deformation: none

QC Witness: [Signature] Date: 7-11-96
Cognizant Engineer: [Signature] Date: 7-11-96

Fill the vessel with water, approximately 1/4 gallons and check if the 3/4 inch ball valve operates properly and does not leak in the closed position.

Operation of 3/4 inch ball valve: open then close

Record leakage of ball valve: none observed

QC witness: [Signature] Date: 7-11-96
Cognizant Engineer: [Signature] Date: 7-11-96

6.0 Quality Assurance

Q.C. will witness the ATP

7.0 Organization and Function Responsibilities.

The engineer with the help of the organization building the vessel will perform the test with QC present. QC will sign off when the vessel(s) have passed the test. The manufacturing shop will keep the data with the work package.