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4

ENGINEERING DATA TRANSMITTAL

1. EDT

Page 1 of 1
629056

2. To: (Receiving Organization) Distribution		3. From: (Originating Organization) Retrieval Engineering		4. Related EDT No.: N/A							
5. Proj./Prog./Dept./Div.: RPP/WFD		6. Design Authority/Design Agent/Cog. Engr.: HR Hopkins, 373-4148		7. Purchase Order No.: N/A							
8. Originator Remarks: Document transmitted for approval and release.				9. Equip./Component No.: N/A							
				10. System/Bldg./Facility: Tank Farms							
11. Receiver Remarks: 11A. Design Baseline Document? ☒ Yes ☐ No				12. Major Assm. Dwg. No.: N/A							
				13. Permit/Permit Application No.: N/A							
				14. Required Response Date: March 24, 2000							
15. DATA TRANSMITTED											
(A) Item No.	(B) Document/Drawing No.	(C) Sheet No.	(D) Rev. No.	(E) Title or Description of Data Transmitted	(F) Approval Designator	(G) Reason for Transmittal	(H) Originator Disposition	(I) Receiver Disposition			
1	HNF-4162	---	0	Double-Shell Tank Transfer Pump Subsystem Specification	ESQ	1,2	1				
16. KEY											
Approval Designator (F) E, S, Q, D or N/A (see WHC-CM-3-5, Sec. 12.7)		Reason for Transmittal (G) 1. Approval 2. Release 3. Information 4. Review 5. Post-Review 6. Dist. (Receipt Acknow. Required)			Disposition (H) & (I) 1. Approved 2. Approved w/comment 3. Disapproved w/comment 4. Reviewed no/comment 5. Reviewed w/comment 6. Receipt acknowledged						
17. SIGNATURE/DISTRIBUTION (See Approval Designator for required signatures)											
(G) Reason	(H) Disp.	(J) Name	(K) Signature	(L) Date	(M) MSIN	(G) Reason	(H) Disp.	(J) Name	(K) Signature	(L) Date	(M) MSIN
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18. GA Leshikar Signature of EDT Originator 3/23/00 Date		19. RS Popielarczyk Authorized Representative for Receiving Organization 3/24/00 Date		20. TJ Conrads Design Authority/Cognizant Manager 3/27/00 Date		21. DOE APPROVAL (if required) Ctrl. No. N/A ☐ Approved ☐ Approved w/comments ☐ Disapproved w/comments					

BD-7400-172-2 (10/97)

BD-7400-172-1

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Double-Shell Tank Transfer Pump Subsystem Specification

Prepared for the U.S. Department of Energy
Assistant Secretary for Environmental Management

CH2MHILL

Hanford Group, Inc.

Richland, Washington

Contractor for the U.S. Department of Energy
Office of River Protection under Contract DE-AC06-99RL14047

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Double-Shell Tank Transfer Pump Subsystem Specification

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U.S. Department of Energy Contract DE-AC06-99RL-14047

EDT/ECN: 629056 UC: 721
Org Code: 6N100 Charge Code: 110300
B&R Code: Total Pages: 67

Key Words: privatization, double-shell tank, waste feed delivery, subsystem, specification, level 2, transfer pump

Abstract:

This specification establishes the performance requirements and provides references to the requisite codes and standards to be applied to the Double-Shell Tank (DST) Transfer Pump Subsystem which supports the first phase of Waste Feed Delivery.

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HNF-4162
Revision 0

Double-Shell Tank Transfer Pump Subsystem Specification

G. A. Leshikar

Date Published
March 2000

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Richland, Washington

Contractor for the U.S. Department of Energy
Office of River Protection under Contract DE-AC06-99RL14047

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1.0 SCOPE

1.1 DESCRIPTION

This specification establishes the performance requirements and provides the references to the requisite codes and standards to be applied during the design of the Double-Shell Tank (DST) Transfer Pump Subsystem that supports the first phase of waste feed delivery (WFD). The DST Transfer Pump Subsystem consists of a pump for supernatant and/or slurry transfer for the DSTs that will be retrieved during the Phase 1 WFD operations. This system is used to transfer low-activity waste (LAW) and high-level waste (HLW) to designated DST staging tanks. It also will deliver blended LAW and HLW feed from these staging tanks to the River Protection Project (RPP) Privatization Contractor facility where it will be processed into an immobilized waste form.

This specification is intended to be the basis for new projects/installations (W-521, etc.). This specification is not intended to retroactively affect previously established project design criteria without specific direction by the program.

1.2 CLASSIFICATION

Transfer pumps may be classified into the following four types:

Type	Criterion
1.	Where the individual tank mission may require variable-level suction features
2.	Where the individual tank mission may require simultaneous operation with mixer pumps
3.	Where the transfer pumps must satisfy <u>both</u> criterion 1 and criterion 2
4.	Where the transfer pumps require neither criterion 1 nor criterion 2.

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2.0 APPLICABLE DOCUMENTS

Design requirements applicable to the DST Transfer Pump Subsystem come from government and non-government source documents and various codes and standards. Each document (of the exact revision identified) in this section is invoked by one or more requirements of this specification and represents a part of this specification to the extent specified.

2.1 GOVERNMENT DOCUMENTS

U.S. Department of Energy (DOE) orders and regulatory documents, including those promulgated by the Federal Government and Washington State, constitute a part of this specification to the extent specified herein. The regulatory documents that form a part of this specification are listed in Table 2-1.

Table 2-1. Government Documents.

Document Number	Title
40 CFR 265, Subpart J, 1999	"Interim Status TSD Facility Standards," "Tank Systems," <i>Code of Federal Regulations</i> , as amended.
DOE Order 6430.1A, 1989	<i>General Design Criteria</i> , U. S. Department of Energy, Washington, D.C.
DOE/RL-92-36, 1993	<i>Hanford Site Hoisting and Rigging Manual</i> , U.S. Department of Energy, Richland Operations Office, Richland, Washington.
DOE/RL-96-109, Rev. 2, 1999	<i>Hanford Radiological Control Manual</i> , U.S. Department of Energy, Richland Operations Office, Richland, Washington.
WAC 173-303-640, 1999	"Dangerous Waste Regulations", <i>Washington Administrative Code</i> , as amended.

2.2 NON-GOVERNMENT DOCUMENTS

National codes, standards, and the Hanford Site documents listed in Table 2-2 constitute a part of this specification to the extent specified herein. Note: The RPP-PRO procedures implement Federal and state regulations and DOE orders. In addition, it should be noted that some requirements are based on the existing authorization basis documents (e.g., *Tank Waste Remediation System Final Safety Analysis Report*, HNF-SD-WM-SAR-067, and *Tank Waste Remediation System Technical Safety Requirements*, HNF-SD-WM-TSR-006). The authorization basis requirements may be changed, if necessary, after the analysis and justification of the resulting risk have been outlined in a final safety analysis report amendment and approval is obtained from the DOE Office of River Protection.

Table 2-2. Non-Government Documents. (3 sheets)

Document Number	Title
API 610, 7 th Edition, 1989	<i>Centrifugal Pumps for Petroleum, Heavy Duty Chemical and Gas Industry Services</i> , American Petroleum Institute, Washington, D.C.
ASME NQA-1, 1994	<i>Quality Assurance Requirements for Nuclear Facility Applications</i> , American Society of Mechanical Engineers, New York, New York.
<i>Best-Basis Inventory</i> (database), 2000	<i>Best-Basis Inventory</i> , Tank Characterization Database, at http://twins.pnl.gov:8001/twins.htm .
H-2-90185, Rev. 2, 1991	<i>Male Nozzle 2" PUREX</i> , Westinghouse Hanford Company.
H-2-90186, Rev. 1, 1989	<i>Male Nozzle 3" PUREX</i> , Westinghouse Hanford Company.
HNF-2004, Rev. 1, 1999	<i>Estimated Dose to In-Tank Equipment and Ground-Level Transfer Equipment During Pressurization</i> , COGEMA Engineering Corporation for Lockheed Martin Hanford Corporation, Richland, Washington.
HNF-2962, Rev. 0, 1998	<i>A List of Electromagnetic Interference (EMI) and Electromagnetic Compatibility (EMC) Requirements</i> , Numatec Hanford Corporation for Fluor Daniel Hanford, Inc., Richland, Washington.
HNF-4164, Rev. 0, (draft) 2000	<i>Double-Shell Tank Mixer Pump Subsystem Specification</i> , CH2M HILL Hanford Group, Inc., Richland, Washington.
HNF-4553, Rev. 0, 1999	<i>Operations and Maintenance Philosophy Document</i> , Lockheed Martin Hanford Corporation for Fluor Daniel Hanford, Inc., Richland, Washington.
HNF-IP-0842, Vol. II, Section 6.1, Rev. 0A, 1999	<i>RPP Administration</i> , Lockheed Martin Hanford Corporation, Richland, Washington.
HNF-IP-0842, Vol. IV, Section 4.23, Rev. 0, 1999	<i>RPP Administration</i> , Lockheed Martin Hanford Corporation, Richland, Washington.
HNF-IP-0842, Vol. XI, Section 1.0, Rev. 2, 1999	<i>RPP Administration</i> , Lockheed Martin Hanford Corporation, Richland, Washington.
HNF-IP-1266, Chapter 5.16, Rev. 2, 1999	<i>Tank Farms Operations Administrative Controls</i> , DE&S Hanford, Incorporated, for Fluor Daniel Hanford, Inc., Richland, Washington.

Table 2-2. Non-Government Documents. (3 sheets)

Document Number	Title
HNF-SD-GN-ER-501, Rev. 1, 1998	<i>Natural Phenomena Hazards, Hanford Site Washington</i> , Numatec Hanford Corporation for Fluor Daniel Hanford, Inc., Richland, Washington.
HNF-SD-WM-HSP-002, Rev. 3B, 1999	<i>Tank Farms Health and Safety Plan</i> , Lockheed Martin Hanford Corporation for Fluor Daniel Hanford, Inc., Richland, Washington.
HNF-SD-WM-SAR-067, Rev. 1, 1999	<i>Tank Waste Remediation System Final Safety Analysis Report</i> , Lockheed Martin Hanford Corporation for Fluor Daniel Hanford, Inc., Richland, Washington.
HNF-SD-WM-SP-012, Rev. 1, 1999	<i>Tank Waste Remediation System Operation and Utilization Plan to Support Waste Feed Delivery</i> , Numatec Hanford Corporation, Lockheed Martin Hanford Corporation, and COGEMA Engineering Corporation for Fluor Daniel Hanford, Inc., Richland, Washington.
HNF-SD-WM-TSR-006, Rev.1, 1999	<i>Tank Waste Remediation System Technical Safety Requirements</i> , Fluor Daniel Hanford, Inc., Richland, Washington.
Hydraulic Institute Standards, 1994	Pump Standards 1.1 through 2.6, <i>Hydraulic Institute Standards</i> , Hydraulic Institute, Cleveland, Ohio.
NEMA ICS 6, 1993	<i>Industrial Controls and Systems</i> , National Electrical Manufacturers Association, Arlington, Virginia.
NEMA MG-1, 1993	<i>Motors and Generators</i> , National Electrical Manufacturers Association, Arlington, Virginia.
NFPA 70, 1999	<i>National Electric Code</i> , National Fire Protection Association, Quincy, Massachusetts.
RPP-5346, Rev. 0, (draft), 2000	<i>Waste Feed Delivery Transfer System Analysis</i> , Numatec Hanford Corporation for CH2M HILL Hanford Group, Inc., Richland, Washington.
RPP-PRO-097, Rev. 0, 1999	<i>Engineering Design and Evaluation</i> , CH2M HILL Hanford Group, Inc., Richland, Washington.
RPP-PRO-222, Rev. 0, 1999	<i>Quality Assurance Records Standards</i> , CH2M HILL Hanford Group, Inc., Richland, Washington.

Table 2-2. Non-Government Documents. (3 sheets)

Document Number	Title
RPP-PRO-224, Rev. 0, 1999	<i>Document Control Program Standards</i> , CH2M HILL Hanford Group, Inc., Richland, Washington.
RPP-PRO-700, Rev. 0, 1999	<i>Safety Analysis and Technical Safety Requirements</i> , CH2M HILL Hanford Group, Inc., Richland, Washington.
RPP-PRO-702, Rev. 0, 1999	<i>Safety Analysis Process - Facility Change or Modification</i> , CH2M HILL Hanford Group, Inc., Richland, Washington.
RPP-PRO-703, Rev. 0, 1999	<i>Safety Analysis Process - New Project</i> , CH2M HILL Hanford Group, Inc., Richland, Washington.
RPP-PRO-704, Rev. 0, 1999	<i>Hazard and Accident Analysis Process</i> , CH2M HILL Hanford Group, Inc., Richland, Washington.
RPP-PRO-709, Rev. 0, 1999	<i>Preparation and Control Standards for Engineering Drawings</i> , CH2M HILL Hanford Group, Inc., Richland, Washington.
RPP-PRO-1622, Rev. 0, 1999	<i>Radiological Design Review Process</i> , CH2M HILL Hanford Group, Inc., Richland, Washington.
RPP-PRO-1819, Rev. 0, 1999	<i>Engineering Requirements</i> , CH2M HILL Hanford Group, Inc., Richland, Washington.
WHC-SD-WM-DGS-006, Rev. 0, 1997	<i>Tank Farms Pump Critical Characteristic and Specification Guide</i> , ARES Corporation, Lockheed Martin Hanford Corporation for Fluor Daniel Hanford, Inc., Richland, Washington.

3.0 REQUIREMENTS

3.1 SUBSYSTEM/COMPONENT DEFINITION

The DST System provides safe storage of waste products, serves as a waste processing system for waste pretreatment, and provides a staging system for delivery of waste feed to the RPP Privatization Contractor facility for waste treatment/immobilization.

The DST System includes six tank farms containing a total of 28 DSTs. Five of the DST farms are located in the 200 East Area (241-AN, 241-AP, 241-AW, 241-AY, and 241-AZ), and one is located in the 200 West Area (241-SY). The four tanks in the 241-AY and 241-AZ tank farms are designed to store high heat or "aging" waste and have a design storage capacity of 3,800 m³ (1 Mgal) each. Each of the other DSTs has a design capacity of 4,390 m³ (1.16 Mgal) per tank. Tank 241-AN-107, with a capacity of 4,390 m³ (1.16 Mgal), could be used as an aging waste storage tank. The planned usage of the DSTs during Phase 1 Waste Feed Delivery is detailed in the *Tank Waste Remediation System Operation and Utilization Plan to Support Waste Feed Delivery*, HNF-SD-WM-SP-012. This specification's requirements are based on the Case 3, Project Planning, DST usage scenario documented therein. Notice that Case 3S6D, 2006 Hot Start, will be documented in Revision 2 of HNF-SD-WM-SP-012 and will serve as the baseline case for the Readiness to Proceed-2 (RTP-2) RPP milestone. Case 3S6D incorporates changes to Case 3 to resolve feed staging tank issues, reflect changes in the assumptions, and include additional programmatic constraints, as directed by DOE ORP. Preliminary quantitative and qualitative assessments were performed to determine the impacts of these changes to the DST subsystem requirements. Generally, the DST subsystem requirements were determined to be insensitive to the aforementioned changes; that is, the fundamental system-level requirements remained constant between Cases 3 and 3S6D (e.g., the need to prepare and transfer AN Farm tank waste to the vitrification facility). In instances where quantitative assessments were performed, the enveloping case was selected to develop the DST subsystem requirements.

The DST System specification (*System Specification for the DST System*, HNF-SD-WM-TRD-007) identifies several second-tier functions (Figure 3-1). The Transfer Waste to LAW Staging Tanks function has been further decomposed as shown. Other decompositions are shown as third- and fourth-tier functions in Figure 3-1. *Functional Analysis for Double-Shell Tank Subsystems*, HNF-5136, allocates the shaded third- and fourth-tier functions of Figure 3-1 to the DST Transfer Pump Subsystem. Section 3.2.1 of this specification is organized to accommodate these shaded functions.

The Monitor Position of Transfer Pump Suction Intake and Monitor Transfer Pump Operation functions cannot be fully allocated to a subsystem. Therefore, these functions have been decomposed into the subfunctions identified in Table 3-1.

Figure 3-1. Double-Shell Tank Transfer Pump Subsystem Functional Hierarchy for Waste Transfers.

Table 3-1. Decomposition of Monitor Position of Transfer Pump Suction Intake and Monitor Transfer Pump Operations Functions.

Monitor Position of Transfer Pump Suction Intake	Monitor Transfer Pump Operation
Measure Position of Transfer Pump Suction Intake	Measure Transfer Pump Operations Parameters
Transmit Transfer Pump Suction Intake	Transmit Transfer Pump Operations Parameters
Receive Transfer Pump Suction Intake Position	Receive Transfer Pump Operations Parameters
Display Transfer Pump Suction Intake Position	Display Transfer Pump Operations Parameters
Record Transfer Pump Suction Intake Position	Record Transfer Pump Operations Parameters

The "Measure" functions listed above are performed by the DST Transfer Pump Subsystem; therefore, the functional and performance requirements for these functions are defined herein (see Section 3.2.1). The balance of the above listed functions is performed by the DST Monitor and Control Subsystem and will be defined in the DST Monitor and Control Subsystem specification.

The DST System consists of the 12 subsystems identified in Figure 3-2. Five of these subsystems (electrical, raw water, potable water, service air, and instrument air) will be collected into the DST utilities specification. Several of these subsystems have been further subdivided to identify lower level subsystem/components. Subsystem specifications will be prepared for the subsystems/components shaded in Figure 3-2, because they will be constructed or modified in support of Phase 1 Waste Feed Delivery.

Figure 3-2. Double-Shell Tank System Architecture Tree.

The primary interfaces between DST subsystems/components are shown in Figures 3-3 and 3-4. Figure 3-3 shows the primary DST mechanical system interfaces for eight subsystems. Different materials going between the subsystems are shown as different types of lines. For waste preparation, the mixer pump moves waste within the waste confinement subsystem (i.e., the tanks) at a high velocity to suspend undissolved solids and/or to mix supernatant. Once waste preparation is complete, waste is removed from the DST Confinement Subsystem source tank by the transfer pump, is routed by the valving subsystem through the piping subsystem toward its destination (i.e., another DST or the RPP Privatization Contractor facility). If the destination is

another DST, the valving subsystem will direct the waste into the receiving DST. If the destination is the processing plant, the plant's waste receipt piping will route the waste into the plant.

Figure 3-3. Subsystem for Double-Shell Tank Mechanical System Interfaces.

The DST Confinement Subsystem must confine the tank waste during both in-tank waste processing (e.g., mixing, diluent addition) and in static storage. In either case, the DST Ventilation Subsystem draws air in from, and exhausts air out to, the external atmosphere to cool and to maintain confinement of the DST Confinement Subsystem vapors. Before exhausting the air, the DST Ventilation Subsystem removes radioactive particulates and hazardous and toxic gases (primary only) from the confinement subsystem's primary and annulus vapor space.

The DST Raw Water Subsystem receives water from the Site Raw Water Distribution System, where it is strained to remove large particulates before being used by the DST Diluent and Flush Subsystem. The DST Diluent and Flush Subsystem chemically adjusts the water for dilution or for flushing. The degree of chemical adjustment of diluent will depend on the batch of waste being transferred. The raw water is heated to match the waste temperature (see *Waste Feed Delivery Technical Basis*, HNF-1939, Volume II, Revisions 0a [Addendum 1-1], 0b [Addendum 2-1], and 0c [Addendum 3-1]).

Diluent is routed by the valving subsystem either to the transfer pump for in-line dilution of the waste or to the confinement subsystem for in-tank dilution. When a transfer is complete, the transfer pump, valving, and piping subsystems are flushed with water.

The DST Raw Water Subsystem filters water to remove small particles before being piped directly to the mixer pump and transfer valving subsystems. Filtered water is routed to the confinement subsystem via the transfer valving subsystem. Filtered water also can be routed to the mixer pump, the transfer pump, and the valve pit via the DST Maintenance and Recovery Subsystem for infrequent needs. Infrequent needs may include filling a mixer pump drive shaft and providing water to the pump seals.

The DST Maintenance and Recovery Subsystem will be used for many other infrequent needs that were not shown on the diagram for reasons of clarity. For example, raw water will be used to decontaminate the pumps when they are removed from the tanks. It also will be used in decontaminating the valve and pump pits.

Figure 3-4 generically shows how the DST Monitor and Control Subsystem interfaces with other systems. All of the subsystems shown in Figure 3-3 provide instrument data signals to the DST Monitor and Control Subsystem. The DST Monitor and Control Subsystem transmits selected data to the Master Monitor and Control System. The DST Monitor and Control Subsystem also receives data and control signals from the Master Monitor and Control System. Based on the data and control signals received, the DST Monitor and Control Subsystem sends control signals to the multiple DST subsystems.

Figure 3-4. Interfaces for Double-Shell Tank Monitor and Control Subsystem.

3.1.1 Subsystem/Component Diagrams

Major subsystems for the DST Transfer Pump Subsystem were chosen based on the subsystem's functional requirements and the DST System architecture. Figure 3-5 shows the architectural decomposition of the DST Transfer Pump Subsystem. The major subsystems that have been identified are:

- Motor
- Pump
- Pump Instrumentation
- Pump Suction Level Adjustment.

Figure 3-5. Architectural Decomposition of the Double-Shell Tank Transfer Pump Subsystem.

To support Phase 1 WFD, new transfer pumps will be installed. Pump selection may be different for each tank, depending on whether it is to be operated concurrently with mixer pumps; the waste type being pumped (supernatant, dissolved salts, or suspended solids); and the depth from which the waste must be pumped (Type 1). Dilution water will be added, as required, at the suction to achieve the rheological properties defined in Section 3.2.5.2.5, ensuring pumpability. Pump pits provide access to the risers to mount the pumps and provide containment for process leakage. Figure 3-6 depicts the general configuration and physical interfaces of the DST Transfer Pump Subsystem.

3.1.2 Interface Definition

This section identifies the major interfaces of the DST Transfer Pump Subsystem with other systems. The interface descriptions that follow are intended to help define the subsystem boundaries. These interface relationships are illustrated in Figure 3-7. This section discusses the inputs from these interfacing systems and facilities. Outputs from the DST Transfer Pump Subsystem to other systems and facilities are discussed in Section 3.2.1.

3.1.2.1 Functional Interfaces

3.1.2.1.1 Double-Shell Tank Transfer Valving Subsystem. This section describes the routing of process fluids to the transfer pump by the DST Transfer Valving Subsystem. By definition, the pump pit is part of the DST Valving Subsystem.

- a. The DST Transfer Pump Subsystem shall be provided water at a pressure of 7.2 kPa (150 lbf/in²) and flow rate of 8.8 L/s (140 gal/min) <TBR>.
- b. The DST Transfer Pump Subsystem shall accept 8.8 L/s (140 gal/min) <TBR> backflush of water through the discharge of the pump, without damaging the pump.

Figure 3-6. System Schematic for the Double-Shell Tank Transfer Pump Subsystem.

V ac = volts alternating current.

3.1.2.1.2 Double-Shell Tank Electrical Power Subsystem. The DST Electrical Power Subsystem provides electrical power to the DST Transfer Pump Subsystem.

- a. DST transfer pumps shall operate with 480 V ac, 3-phase, 60 Hz, electric power.

3.1.2.1.3 Double-Shell Tank Confinement Subsystem. The DST Confinement Subsystem provides the following functions to the DST Transfer Pump Subsystem.

- a. The DST Transfer Pump Subsystem shall be physically supported by the DST Confinement Subsystem.
- b. The DST Transfer Pump Subsystem shall be capable of moving waste out of the DST Confinement Subsystem as required.

Figure 3-7. Major Interfaces of the Double-Shell Tank Transfer Pump Subsystem.

3.1.2.1.4 Double-Shell Tank Maintenance and Recovery Subsystem. The DST Maintenance and Recovery Subsystem provides the equipment to perform installation and removal of transfer pumps, including the following:

- Cranes, harnesses, spreader bars, and other lifting devices required to handle a transfer pump
- Flexible receivers or other devices required to confine waste and waste vapors during pump removal
- High-pressure external water wash systems for decontamination of the transfer pump as it is retracted from the tank in preparation for final waste packaging

- Connectors that mate to the transfer pump discharge, dilution, and flush ports, to allow internal cavity decontamination water flush of the transfer pump as it is retracted from the tank
- A laydown area for contaminated pumps after removal.

3.1.2.1.5 Double-Shell Tank Monitor and Control Subsystem. The DST Monitor and Control Subsystem provides signals and logic for operating the DST Transfer Pump Subsystem and is used to monitor equipment status indicators attributable to the transfer pump.

- a. The DST Transfer Pump Subsystem shall be designed to operate using industry standard control signals.

3.1.2.2 Physical Interfaces

Detailed physical interface definition and requirements associated with the DST Transfer Pump Subsystem are captured in interface control documents that are application specific and are (to be) developed by line item project organizations responsible for the design of DST subsystems, as directed by the WFD Program Office.

3.1.3 Major Component List

Major components of the DST Transfer Pump Subsystem are listed in Section 3.1.1.

3.1.4 Government-Furnished Property List

Not applicable.

3.1.5 Government-Loaned Property Lists

Not applicable.

3.2 CHARACTERISTICS

This section contains the minimum requirements related to performance characteristics, physical characteristics, reliability, maintainability, environmental conditions, transportability, and flexibility and expansion. Minimum requirements are identified by SHALL statements, while design goals are identified by SHOULD statements. If a requirement with a "should" statement cannot be satisfied, justification of an alternative design shall be submitted to the Design Authority for approval. The source documents that provide the basis for each requirement are identified in Appendix A.

3.2.1 Performance Characteristics

This section contains all requirements related to the functionality and performance capabilities for the DST Transfer Pump Subsystem.

3.2.1.1 Pump Waste/Diluent

The DST Transfer Pump Subsystem shall be capable of removing supernatant, dissolved salts, and suspended solids from source tanks and transferring them to destination tanks.

- a. Transfer pump hydraulic performance design shall be based on newtonian fluid properties after in-line dilution and mixing at the transfer pump suction.
- b. The transfer pump shall be capable of delivering 10.1 L/s (160 gal/min) <TBR> (2.16 m/s [7.1 ft/s] <TBR> in 80 mm [3 in.] schedule 40 pipe) at heads ranging from 195 m (640 ft) <TBR> down to 15 m (50 ft), as measured at the pump discharge above the mounting flange.
- c. The transfer pump shall have a continuously rising head/capacity curve from the rated capacity to shutoff.
- d. The shutoff head of the transfer pump shall not exceed 268 m (880 ft) <TBR> as measured at the pump discharge above the mounting flange.
- e. The transfer pump shall be able to remove waste to within 25.4 cm (10 in.) of the tank bottom.
- f. The transfer pump shall deliver rated head and flow at a minimum net positive suction head available (NPSH_a) of 4.6 m (15 ft) <TBR>.

3.2.1.2 Position Transfer Pump Suction Intake (Types 1 and 3)

Missions that require the transfer pump to decant waste above the solids layer shall employ a system capable of taking suction at a wide range of heights.

- a. The system shall be capable of adjusting the pump intake from 6.1 m (20 ft) <TBR> above the bottom of the tank to the level defined by Section 3.2.1.1.e for an empty tank.
- b. The system shall be capable of starting to within 117 cm (46 in.) <TBR> of the tank bottom.

3.2.1.3 Measure Position of Transfer Pump Suction Intake (Types 1 and 3)

Missions that require the transfer pump to decant waste above the solids layer shall monitor the position of the transfer pump suction.

3.2.1.4 Confine Waste in Transfer Pump

The DST Transfer Pump Subsystem shall confine waste within the transfer pump casing and associated nozzles, flanges, and other pressure boundary connections.

- a. The DST Transfer Pump Subsystem pressure boundaries shall have a design pressure rating no less than the maximum pressure of the pump at shutoff when it is pumping fluid of the highest specific gravity specified herein.

3.2.1.5 Carry Diluent/Flush Water to Transfer Pump Suction

The DST Transfer Pump Subsystem shall accept and route diluent to the pump suction intake.

- a. The DST Transfer Pump Subsystem shall be capable of routing water to the pump suction at 6.3 L/s (100 gal/min) <TBR>.

3.2.1.6 Measure Transfer Pump Operation

The DST Transfer Pump Subsystem shall measure pump equipment parameters including the following:

- a. Pump speed (if variable speed drive is utilized)
- b. Motor amperage or power indication
- c. Any other parameter, if required by design.

3.2.2 Physical Characteristics

This section contains all requirements related to physical characteristics (maximum/minimum physical size, weight, shape, etc.).

- a. The transfer pump nozzles shall be of the Plutonium-Uranium Extraction (PUREX)-type design in accordance with drawings H-2-90185 and H-2-90186.
- b. Transfer pump components below the riser flange shall be designed to fit within the riser and to be capable of being removed from the tank. Said components shall have a maximum insertion diameter of 2.54 cm (1 in.) less than the nominal diameter of the riser in which the transfer pump is to be installed.
- c. Lifting bails shall be provided that enable handling of the transfer pump in the horizontal and vertical positions, while allowing straight vertical insertion of the system into the DST.
- d. The DST Transfer Pump Subsystem shall provide fixed, nonrotating, environmentally protected field terminations that comply with applicable *National Electric Code* (NFPA 70) requirements for all power and signal connections and grounding lug.

- e. Electrical equipment enclosures shall meet National Electrical Manufacturers Association (NEMA) Standards.
- f. The DST Transfer Pump Subsystem shall be designed to preclude leakage above the pump mounting plate. Seals, if used, shall direct any potential leakage back into the tank.
- g. The DST Transfer Pump Subsystem shall be provided with an adapter flange capable of mating to a bag-out assembly for retracting the transfer pump into a "flexible receiver" during pump removal operations.
- h. The electric motor shall conform to NEMA MG-1 standards.
- i. The transfer pump design shall be self-venting.

3.2.3 Reliability

This section contains the requirements and other features that promote reliability.

- a. The DST Transfer Pump Subsystem shall have a minimum design life of 5,000 hours of operation over a 10-year period.
- b. Transfer pump manufacturers shall provide written recommendations of operational practices such as bumping and flushing to maximize the pump's useful life.

3.2.4 Maintainability

The design shall consider the maintainability factors peculiar to the specific equipment to be used in the DST Transfer Pump Subsystem.

- a. The DST Transfer Pump Subsystem shall be designed for 5 years without maintenance that would require removal of the pump pit cover blocks.
- b. The transfer pump shall tolerate reverse rotation or shall be provided with an anti-reverse rotation device if reverse rotation is unacceptable.
- c. The DST Transfer Pump Subsystem design shall minimize the accumulation of solids where process lubricated bearings and mechanical seals are used. The pump should have the capability of flushing such areas.
- d. Whenever possible, instruments that can be operated without calibration or maintenance throughout the design life of the system or component should be selected.
- e. Motors for line-shaft driven transfer pumps shall be provided with a manual pump shaft/impeller rotation device and shall be installed such that manual shaft rotation can be performed without removing the pump pit cover blocks.

- f. The equipment design shall minimize the time required to physically disconnect, remove, and replace the transfer pump.
- g. The equipment design shall allow access to maintainable components for repair and/or troubleshooting.

3.2.5 Environmental Conditions

This section provides design requirements relevant to natural and induced environmental conditions.

3.2.5.1 Natural Environments

This section defines the natural conditions (e.g., weather).

- a. The subsystem shall be designed for the natural environmental conditions specified in HNF-SD-GN-ER-501.
- b. The subsystem shall be designed to withstand the natural phenomena hazards as specified in RPP-PRO-097. The system does not have to operate after a design-basis earthquake; it only needs to be removable.

3.2.5.2 Induced Environments

This section defines the induced environment impinging on the subsystem including waste chemistry, radiation, impingement loads, thermal, and fluid rheology.

3.2.5.2.1 Chemistry. The subsystem components shall be designed to perform their intended function in the chemical environment defined in *Best-Basis Inventory* (database).

3.2.5.2.2 Radiation. The subsystem shall be designed for the 1,000 rad/h radiation environment for direct contact with tank waste as defined in HNF-2004.

3.2.5.2.3 Impingement Loads. The DST Transfer Pump Subsystem shall withstand external loads.

- a. The transfer pump shall remain removable from the tanks following a gas release rollover event and crust impact.
- b. Transfer pumps Types 2 and 3 shall operate while under the loads induced by the mixer pump described in HNF-4164.

3.2.5.2.4 Thermal. The transfer pump subsystem shall withstand the following induced temperature conditions and loads.

- a. The in-tank temperature range for transfer pump design is 10 to 104 °C (50 to 220 °F).

- b. The transfer pump shall be able to withstand the thermal shock of a 38 °C (100 °F) temperature difference, corresponding to insertion of a cold pump in a hot tank and the use of cold flush/dilution water into a hot pump.

3.2.5.2.5 Fluid Rheology. The transfer pump shall be designed to pump fluids with the range of properties defined in RPP-5346, Table 5-1.

3.2.6 Transportability

Steps shall be taken to ensure that equipment is not damaged during transportation.

3.2.7 Flexibility and Expansion

Not applicable.

3.3 DESIGN AND CONSTRUCTION

The subsystem shall comply with the general design guidelines provided in DOE Order 6430.1A, Sections 1300-7 and 1323.

3.3.1 Materials, Processes, and Parts

This section defines transfer pump requirements governing the use of materials and processes.

- a. All transfer pumps shall meet the applicable design, fabrication, and testing requirements contained in API 610. The highest degree of dynamic balancing shall be specified.
- b. Welding shall be performed and inspected in accordance with American Welding Society and/or American Society of Mechanical Engineers requirements.

3.3.2 Electromagnetic Radiation

The subsystem shall comply with electromagnetic radiation emission requirements set forth in HNF-2962.

3.3.3 Nameplates and Product Marking

This section defines marking and nameplate requirements of the various assemblies and subassemblies that make up the DST Transfer Pump Subsystem.

- a. The subsystem shall label new equipment and/or modifications to existing equipment in a standardized format in accordance with the tank farm labeling program as specified in HNF-IP-0842, Volume II, Section 6.1.

- b. Transfer pumps shall be provided with a manufacturer's nameplate securely attached to the top of the mounting/adapter flange. The nameplate shall be stamped with the following information, at the minimum:
 - Purchase order number
 - Manufacturer's size and model #
 - Pump serial number
 - Capacity
 - Pumping head
 - Casing hydrostatic test pressure
 - Rated speed
 - Rated power (if pump has submersible-type motor)
 - Bearing part number identification
 - Assembly weight (dry).
- c. Non-submersible electric motors shall be provided with permanently attached nameplates in accordance with NEMA MG-1.
- d. Pump rotation arrows shall be marked on the top of the motor bell housing. This does not apply if a submerged motor pump is selected.

3.3.4 Workmanship

Reserved. The requirements for workmanship are to be addressed in lower level project design documentation (drawings, procurement specifications, etc.).

3.3.5 Interchangeability

All like equipment and parts shall be interchangeable/standardized to the maximum extent practical.

3.3.6 Safety

The subsystem shall be designed to protect the public, environment, workers, and equipment in accordance with the requirements of this section.

3.3.6.1 Personnel Safety

Personnel shall be protected from work place hazards in accordance with the following requirements:

- a. The radiological design review process of RPP-PRO-1622 shall be used to keep personnel exposures ALARA.
- b. The system shall incorporate design features that comply with the requirements of HNF-SD-WM-HSP-002 and other applicable safety and health requirements.

3.3.6.2 Equipment Protection

The subsystem shall be designed to avoid damage to other components.

- a. Dome load evaluation shall be performed in accordance with HNF-IP-1266, Chapter 5.16.

3.3.6.3 Environmental Safety

The DST Transfer Pump Subsystem shall be designed to protect the public and environment in accordance with the following requirements:

- a. The DST Transfer Pump Subsystem and components shall be designed in accordance with the safety classification for each. The safety classification shall be determined using the process described in RPP-PRO-700, RPP-PRO-702, RPP-PRO-703, and RPP-PRO-704, based on the guidelines in HNF-SD-WM-SAR-067, Section 3.0. Preliminary safety classifications are provided for reference in Appendix B.
- b. All equipment installed in areas in and around the tank that are subject to ignition controls shall be designed to meet the requirements of HNF-SD-WM-TSR-006, Section 5.10, "Ignition Controls." Areas requiring controls are delineated in HNF-SD-WM-SAR-067, Appendix K. The Flammable Gas Equipment Advisory Board shall be consulted whenever the application or interpretation of the requirement is unclear.

3.3.7 Human Performance/Human Engineering

The subsystem shall be designed for ease of operation.

- a. Subsystem design shall comply with DOE Order 6430.1A, Section 1300.12, "Human Factors Engineering."

3.3.8 Decontamination and Decommissioning

This section defines features found to enhance decontamination at the end of the DST Transfer Pump Subsystem's life.

- a. All components that may become contaminated with radioactive or other hazardous materials under normal or abnormal operating conditions shall be designed to incorporate measures to simplify future decontamination and decommissioning in accordance with DOE Order 6430.1A, Section 1300-11.
- b. Designs should simplify cut-up, dismantlement, removal, and packaging of contaminated pumps.
- c. The complete pump assembly column shall be self-draining.
- d. The system design shall provide a means of flushing the pump internals to enable reducing the internal contamination levels before and during pump removal from the tank.
- e. Internal and external cracks, crevices, and hold-up points shall be minimized to facilitate pump cleanup for disposal.

3.4 DOCUMENTATION

This section defines the procedures that will control various documents associated with the DST Transfer Pump Subsystem.

- a. Records, documents, and drawing control pertinent to design functions shall be in accordance with RPP-PRO-222 and RPP-PRO-224. Drafting standards for drawings and interface control shall be in accordance with RPP-PRO-709.
- b. All DST Transfer Pump Subsystem structures, systems, and components (SSC) shall be incorporated into the master equipment list in accordance with HNF-IP-0842, Vol. II, Section 6.1.
- c. Vendor information shall be managed in accordance with HNF-IP-0842, Volume IV, Section 4.23.

3.5 LOGISTICS

This section identifies maintenance infrastructure support requirements.

3.5.1 Maintenance

Facility design shall provide for routine preventive maintenance/calibration, where required, and maintenance, repair, or replacement of equipment subject to failure. The subsystem shall be designed to be maintained in accordance with the following requirements:

- a. Transfer pumps shall be designed to require no routine “hands-on” maintenance.

3.5.2 Supply

The subsystem shall use readily available commercial parts and components to the greatest extent practical.

- a. A minimum number of spares for like components shall be determined based on mean time between failure and number of like components installed.

3.5.3 Facility and Facility Equipment

Not applicable.

3.6 PERSONNEL AND TRAINING

Not applicable.

3.7 CHARACTERISTICS OF SUBELEMENTS

The major elements of the DST Transfer Pump Subsystem are as follows:

- Motor
- Pump
- Pump instrumentation
- Pump suction level adjustment.

3.7.1 Motor

The pump motor provides the motive force to rotate the pump shaft.

3.7.2 Pump

A pump transports liquids by converting mechanical energy into work on the liquid. The transfer pump provides the motive force to move the waste from one tank to another through pipes and fittings.

3.7.3 Pump Instrumentation

Pump instrumentation provides equipment status data for evaluating pump operating performance. The type and extent of the supervisory instrumentation suitable for a given pump installation are based on the pump application, the pump design and size, experience with similar equipment, and the vendor recommendations.

3.7.4 Pump Suction Level Adjustment

Pump suction level adjustment provides the capability to draw fluid into the pump from an operator-specified tank elevation.

3.8 PRECEDENCE

Except in those instances where Washington State has been granted regulatory authority by the Federal Government, the hierarchical relationship among requirements specified in Section 3.0 is as follows:

- Federal requirements (e.g., *Code of Federal Regulations*, DOE orders)
- State requirements (e.g., Revised Code of Washington, as specified in the *Washington Administrative Code*)
- Local ordinances
- RPP procedures
- National consensus codes and standards.

The hierarchy is useful in establishing the relative order of precedence of the requirements documents levied in this specification.

3.9 SECURITY

The subsystem shall be designed such that access controls to radiation and high-radiation areas meet the requirements of DOE/RL-96-109.

3.10 COMPUTER RESOURCE RESERVE CAPACITY

Not applicable.

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4.0 QUALITY ASSURANCE PROVISIONS

Quality assurance for the DST Transfer Pump Subsystem shall be performed in accordance with HNF-IP-0842, Volume XI, Section 1.0.

4.1 GENERAL

Quality assurance provisions, as defined in Section 4.2, shall be conducted during the design and development of the DST Transfer Pump Subsystem to provide assurance of compliance with the requirements of this specification. Field verification, which takes place during the construction/turnover life-cycle phase, is not addressed in this specification. Field verification is addressed at the construction project level in operational test plans/procedures and acceptance test plans/procedures.

4.1.1 Responsibility

The design agent shall be responsible for the performance and documentation of all design verifications (see Section 4.2) for each subsystem developed in accordance with this specification. Design verifications shall be conducted at the design agent's facilities or the facilities of the design agent's choice with the approval of the sponsor organization. The sponsor organization reserves the right to witness the specified design verifications.

4.1.2 Special Tests

The following design verification qualification testing requirements apply to the qualification tests of the DST Transfer Pump Subsystem components. These test requirements correlate to the qualification testing of the design to the requirements of Section 3.0 of this specification. The design agent is responsible for planning and executing the required qualification tests.

- a. Each transfer pump shall be tested for hydraulic and mechanical performance, in accordance with *Hydraulic Institute Standards* and API 610.
- b. Electrical materials and equipment shall be qualification tested unless they are Underwriters Laboratories, Inc. (UL) listed, or factory mutual tested, with label attached, and for the purpose intended, whenever such products are available. Where no UL or factory mutual listed products are available, testing and certification by another nationally recognized testing agency may be acceptable, as long as the design agent documents the acceptance of the testing agency.
- c. It shall be demonstrated that the transfer pump assembly, when suspended, hangs plumb such that it can be inserted into or removed from the tank riser without interference with the riser.

- d. Pump insertion into and removal from the tank shall be demonstrated for each Type 1, 2, 3, and 4 design.
- e. Transfer pumps that have been stored for 1 year or longer shall be subjected to a run-in test before they are inserted in the waste tank, unless waived by the RPP Design Authority or the RPP project manager.

4.2 DESIGN VERIFICATION

Design verification shall be performed on the DST Transfer Pump Subsystem, as represented in design drawings, prototypes, engineering models, etc., for the purposes of verifying that the design meets the requirements of this specification. Design verification is subject to the procedure identified in RPP-PRO-1819, Section 2.9.1. Inspection of the subsystem design to ensure compliance with the requirements of Section 3.0 shall be performed by one or more of the following methods: qualification testing, reviews, and/or alternate calculations. The verification method(s) that apply to each specification requirement is identified in Appendix A. Definitions of qualification testing, reviews, and alternate calculations are as follows.

- a. Qualification testing is a design verification method consisting of tests on hardware representative of the design being verified. Qualification testing can be subdivided into methods that consist of checking functional operation (Demonstration) and methods that consist of measuring specific hardware inputs/outputs (Test) to verify compliance of the design with requirements.
 - i. Demonstration is a subcategory of the “qualification testing” design verification method. Demonstration is limited to readily observable functional operation to determine compliance with requirements. Demonstration does not require the use of special equipment or sophisticated instrumentation.
 - ii. Test is another subcategory of the “qualification testing” design verification method. Test employs technical means including, but not limited to, the evaluation of functional characteristics by use of special equipment or instrumentation and the application of established principles and procedures to determine compliance with requirements. The evaluation of data derived from test is an integral part of Test.
- b. Review is a design verification method that consists of an investigation of the existing design information. This can be done via a simple review of the design media (Examination) or a rigorous analysis of the design, as represented in the design media (Analysis).
 - i. Examination is a subcategory of the “review” design verification method. Examination consists of investigation without the use of special laboratory equipment or procedures to determine compliance with requirements. Examination can be performed on design media such as drawings, design reports, etc.
 - ii. Analysis is a subcategory of the “review” design verification method. Analysis takes the form of processing accumulated results and conclusions, intended to provide

proof that verification of a requirement has been accomplished. The analytical results may comprise a compilation/interpretation of existing information or may be obtained from lower level examination, tests, demonstrations, or analyses.

- c. Alternate calculation is a verification of a calculation or analysis using alternate methods or procedures.

Field verification of DST Transfer Pump Subsystem performance/design features and acceptance inspection of construction is called out in Section 2.9.2 of RPP-PRO-1819.

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5.0 PREPARATION FOR DELIVERY

Safety-class and safety-significant SSCs will require special packaging to protect against corrosion, contamination, physical damage, or any effect that would lower the quality or cause the items to deteriorate during the time they are shipped and handled. Packaging, receipt, and storage requirements will depend on the classification level of the items shown in ASME NQA-1, Subpart 2.2, Section 3-2. Lower level specifications (e.g., procurement specifications) will establish the specific packaging requirements for all SSCs.

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6.0 NOTES

6.1 DEFINITIONS

General Service (GS) SSC—Structures, systems, and components (SSC) not classified as either safety class or safety significant.

RPP Design Authority—A qualified engineer responsible for implementation of authorization basis requirements into the facility design.

Safety-Class (SC) SSC—An SSC that prevents or mitigates releases to the public that would otherwise exceed the offsite radiological risk guidelines, or that prevents a nuclear criticality. Those SSCs that support the safety function of an SC SSC also are SC. Nuclear facility structures, systems, or components including primary environmental monitors and portions of process systems, whose failure could adversely affect the environment or safety and health of the public as identified by safety analyses. [DOE 5480.30]

Safety-Significant (SS) SSC—An SSC that prevents or mitigates releases of radiological materials to onsite workers and toxic chemicals to the offsite public and onsite workers. Safety Significant also describes worker safety SSCs that protect the facility worker from serious injury (or fatality) caused by hazards not controlled by institutional safety programs. Those SSCs that support the safety function of an SS SSC also are SS.

- a. Nuclear facility structures, systems, or components not designated as Safety Class SSCs but whose preventative or mitigative function is a major contributor to defense in depth (i.e., prevention of uncontrolled hazardous material release) and/or worker safety as determined from hazard analysis. [DOE-STD-3009-94]
- b. Non-nuclear facility structures, systems, or components whose preventive or mitigative function is a major contributor to defense in depth (i.e., prevention of uncontrolled hazardous material release) and/or worker safety.

NOTE: Safety Significant SSC distinguishes a specific category of SSCs other than Safety Class SSCs. It should not be confused with the generic modifier "safety significant" used in DOE orders (e.g., DOE 5480.23).

Self-Venting Pump—A pump with characteristics that passively allow any vapors trapped within its internal running cavities to exit upon pump startup.

Shall—Denotes a requirement.

Should—Denotes a recommendation. If a "should" requirement cannot be satisfied, justification of an alternative design shall be submitted to the Design Authority for approval.

Tank Opening—Tank risers and pits with an open path to the tank.

TBD—To be determined. A study and/or calculation needs to be performed to provide a sufficient technical basis for the requirement.

TBR—To be refined. A “soft” basis for the requirement has been identified. However, a further study and/or calculation needs to be performed to solidify the requirement’s technical basis.

Transfer-Associated Structure—Pump pits, valve pits, diversion boxes, or cleanout boxes.

6.2 LIST OF TERMS

ALARA	as low as reasonably achievable
API	American Petroleum Institute
ASME	American Society of Mechanical Engineers
ASNT	American Society for Nondestructive Testing
AWS	American Welding Society
DOE	U.S. Department of Energy
DST	double-shell tank
GS	General Service
HLW	high-level waste
Hz	hertz
LAW	low-activity waste
NEMA	National Electrical Manufacturers’ Association
NPSH _a	net positive suction head available
PUREX	plutonium-uranium extraction
RPP	River Protection Project
SC	safety class
SS	safety significant
SSC	structures, systems, and components
TBD	to be determined
TBR	to be refined
UL	Underwriters Laboratories, Inc.
V ac	volts alternating current
WAC	<i>Washington Administrative Code</i>
WFD	waste feed delivery

7.0 REFERENCES

- DOE Order 5480.23, *Nuclear Safety Analysis Reports*, U.S. Department of Energy, Washington, D.C.
- DOE Order 5480.30, *Nuclear Reactor Safety Design Criteria*, U.S. Department of Energy, Washington, D.C.
- DOE-STD-3009-94, *DOE Standard, Preparation Guide for U.S. Department of Energy Nonreactor Nuclear Facility Safety Analysis Reports*, U.S. Department of Energy, Washington, D.C.
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				E x a m p l e	D e m o	T e s t	A n a l
3.1.2.1.1.a	The DST Transfer Pump Subsystem shall be provided water at a pressure of 7.2 kPa (150 lbf/in ²) and flow rate of 8.8 L/s (140 gal/min) <TBR>.	HNF-4716, Appendix C (draft)	The required water pressure and flow must be provided by the DST Diluent and Flush Subsystem			X	X
3.1.2.1.1.b	The DST Transfer Pump Subsystem shall accept 8.8 L/s (140 gal/min) <TBR> backflush of water through the discharge of the pump, without damaging the pump.	HNF-4716, Appendix C (draft)				X	X
3.1.2.1.2.a	DST transfer pumps shall operate with 480 V ac, 3-phase, 60 Hz, electric power.	WHC-SD-WM-DGS-006, Section 4.6.5		X			
3.1.2.1.3.a	The DST Transfer Pump Subsystem shall be physically supported by the DST Confinement Subsystem.			X			
3.1.2.1.3.b	The DST Transfer Pump Subsystem shall be capable of moving waste out of the DST Confinement Subsystem as required.			X			
3.1.2.1.5.a	The DST Transfer Pump Subsystem shall be designed to operate using industry standard control signals.	HNF-4553, Section 5.2		X			
3.2.1.1.a	Transfer pump hydraulic performance design shall be based on newtonian fluid properties after in-line dilution and mixing at the transfer pump suction.	RPP-5346 (Draft)	Extensive search for and study of property and rheological data to support the hydraulic analysis of RPP-5346 indicated that the waste exhibits newtonian behavior once it has been mobilized. Addition of diluent will ensure that the transfer pump is always moving a newtonian fluid.				X

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				E x a m p l e	D T A	N / A	
3.2.1.1.b	The transfer pump shall be capable of delivering 10.1 L/s (160 gal/min) <TBR> (2.16 m/s [7.1 ft/s] <TBR> in 80 mm [3 in.] schedule 40 pipe) at heads ranging from 195 m (640 ft) <TBR> down to 15 m (50 ft), as measured at the pump discharge above the mounting flange.	RPP-5346 (DRAFT)	RPP-5346 is under management review. Because of the importance of this document in establishing basic criteria for transfer operations, the values in this specification will remain TBR until RPP-5346 is finalized and approved.		X		
3.2.1.1.c	The transfer pump shall have a continuously rising head/capacity curve from the rated capacity to shutoff.	API 610			X		
3.2.1.1.d	The shutoff head of the transfer pump shall not exceed 268 m (880 ft) <TBR> as measured at the pump discharge above the mounting flange.	RPP-5346 (DRAFT)	Decision in the RPP-5346 evaluation is to limit head (pressure) rise to 37% from the transfer pump best efficiency point (BEP) to shutoff. A small margin between the required head (pressure) developed by the transfer pump and the waste transfer line design pressure rating is desired. Pumps with a steeply rising head/capacity curve would have to be "de-rated" in their sizing to ensure that they did not exceed transfer line pressure limits in a shutoff condition, such that the transfer pump would no longer be capable of satisfying some expected transfer conditions. The 37% head rise limit is reasonable for pumps of the radial-vane area or Francis-vane area impeller design; however, some vertical turbine pumps of the mixed flow area (open) impeller design (including many existing tank farm transfer pumps) are effectively ruled out as a result.		X		

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				E x a m p l e	D e m o	T e s t	A n a l
3.2.1.1.e	The transfer pump shall be able to remove waste to within 25.4 cm (10 in.) of the tank bottom.	HNF-SD-WM-SP-012, Section 3.5	WFD process planning goal.			X	X
3.2.1.1.f	The transfer pump shall deliver rated head and flow at a minimum net positive suction head available (NPSH _a) of 4.6 m (15 ft) <TBR>.	HNF-4716, Appendix C (DRAFT)	NPSH _a value is based on 0 m (0 ft) submergence at a waste temperature of 85 °C (185 °F). Waste property data (vapor pressure and density) per RPP-5585.			X	X
3.2.1.2	Missions that require the transfer pump to decant waste above the solids layer shall employ a system capable of taking suction at a wide range of heights.	HNF-SD-WM-SP-012; Letter 73600-99-006			X		
3.2.1.2.a	The system shall be capable of adjusting the pump intake from 6.1 m (20 ft) <TBR> above the bottom of the tank to the level defined by Section 3.2.1.1.e for an empty tank.	HNF-SD-WM-SP-012; HNF-4716, Appendix C (DRAFT)	Low intake level capability High intake level capability		X		
3.2.1.2.b	The system shall be capable of starting to within 117 cm (46 in.) <TBR> of the tank bottom.	HNF-4716, Appendix C (DRAFT)	Process requires multiple batch transfers. Decision made is that the pump shall be capable of starting to remove the last batch of HLW from a tank.		X	X	
3.2.1.3	Missions that require the transfer pump to decant waste above the solids layer shall monitor the position of the transfer pump suction.	Letter 73600-99-006	Using the current process strategy, the system operator needs only a general indication where the intake is located, as a starting point, and feedback on the direction (up, down) of intake movement. Lower level project design documentation shall define monitoring accuracy commensurate with the particular design.		X	X	

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3.2.1.4.a	The DST Transfer Pump Subsystem pressure boundaries shall have a design pressure rating no less than the maximum pressure of the pump at shutoff when it is pumping fluid of the highest specific gravity specified herein.	ASME B31.3	Standard Design Code	X		X	
3.2.1.5.a	The DST Transfer Pump Subsystem shall be capable of routing water to the pump suction at 6.3 L/s (100 gal/min) <TBR>.		An open process strategy issue is whether to use the transfer pump or the flush/diluent pump to provide the motive force to flush the waste transfer line.			X	X
3.2.1.6.a	Pump speed (if variable speed drive is utilized)	WHC-SD-WM-DGS-006, Section 4.2.2		X			
3.2.1.6.b	Motor amperage or power indication	WHC-SD-WM-DGS-006, Section 4.2.2		X			
3.2.1.6.c	Any other parameter, if required by design	WHC-SD-WM-DGS-006, Section 4.2.2		X			
3.2.2.a	The transfer pump nozzles shall be of the Plutonium-Uranium Extraction (PUREX)-type design in accordance with drawings H-2-90185 and H-2-90186.	H-2-90185; H-2-90186	Ensures compatibility with existing connector heads.	X			
3.2.2.b	Transfer pump components below the riser flange shall be designed to fit within the riser and to be capable of being removed from the tank. Said components shall have a maximum insertion diameter of 2.54 cm (1 in.) less than the nominal diameter of the riser in which the transfer pump is to be installed.	WHC-SD-WM-DGS-006; HNF-4553		X			
3.2.2.c	Lifting bails shall be provided that enable handling of the transfer pump in the horizontal and vertical positions, while allowing straight vertical insertion of the system into the DST.	WHC-SD-WM-DGS-006, Section 4.1.5		X			

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				E x a m p l e	D e m o	T e s t	A n a l
3.2.2.d	The DST Transfer Pump Subsystem shall provide fixed, nonrotating, environmentally protected field terminations that comply with applicable <i>National Electric Code</i> (NFPA 70) requirements for all power and signal connections and grounding lug.	WHC-SD-WM-DGS-006, Section 4.2.2 (NFPA 70)		X			
3.2.2.e	Electrical equipment enclosures shall meet National Electrical Manufacturers Association (NEMA) Standards.	NEMA ICS 6	Standard Design Code	X			
3.2.2.f	The DST Transfer Pump Subsystem shall be designed to preclude leakage above the pump mounting plate. Seals, if used, shall direct any potential leakage back into the tank.	WHC-SD-WM-DGS-006, Section 4.1.6	Good ALARA practice.	X	X		
3.2.2.g	The DST Transfer Pump Subsystem shall be provided with an adapter flange capable of mating to a bag-out assembly for retracting the transfer pump into a "flexible receiver" during pump removal operations.		Design must accommodate pump removal	X		X	
3.2.2.h	The electric motor shall conform to NEMA MG-1 standards.	WHC-SD-WM-DGS-006, Section 4.2.1; NEMA MG-1		X			
3.2.2.i	The transfer pump design shall be self-venting.	HNF-4553	Lesson learned from Tank 241-C-106 sluicing project	X		X	
3.2.3.a	The DST Transfer Pump Subsystem shall have a minimum design life of 5,000 hours of operation over a 10-year period.	WHC-SD-WM-DGS-006, Section 4.1.9	Design life values are conclusion of pump expert committee after study of all aspects (retrieval plans, history, cost/benefit, manufacturing achievability, judgment, etc.).	X	X	X	X
3.2.3.b	Transfer pump manufacturers shall provide written recommendations of operational practices such as bumping and flushing to maximize the pump's useful life.	HNF-3218; WHC-SD-WM-DGS-006, Section 4.2.3		X			

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				E x a m o	D e m o	T e s t	A n a l	N / A
3.2.4.a	The DST Transfer Pump Subsystem shall be designed for 5 years without maintenance that would require removal of the pump pit cover blocks.	WHC-SD-WM-DGS-006, Section 4.2.3		X			X	
3.2.4.b	The transfer pump shall tolerate reverse rotation or shall be provided with an anti-reverse rotation device if reverse rotation is unacceptable.	WHC-SD-WM-DGS-006, Section 4.1.4; API 610	In past some pumps have had shaft couplings unscrew when rotated in reverse	X				
3.2.4.c	The DST Transfer Pump Subsystem design shall minimize the accumulation of solids where process lubricated bearings and mechanical seals are used. The pump should have the capability of flushing such areas.	WHC-SD-WM-DGS-006, Sections 4.1.10.2 and 4.1.10.3; HNF-3218	Shaft seizure is the leading mode of pump failure. Solids crystallization between close tolerance bearing surfaces is the hypothesized cause. Also want to avoid abrasive particles in these areas.	X	X			
3.2.4.d	Whenever possible, instruments that can be operated without calibration or maintenance throughout the design life of the system or component should be selected.	HNF-4553	States a preference.	X				
3.2.4.e	Motors for line-shaft driven transfer pumps shall be provided with a manual pump shaft/impeller rotation device and shall be installed such that manual shaft rotation can be performed without removing the pump pit cover blocks.	HNF-4553; WHC-SD-GN-DGS-30011, Section 3.4		X	X			
3.2.4.f	The equipment design shall minimize the time required to physically disconnect, remove, and replace the transfer pump.	WHC-SD-GN-DGS-30011		X	X			
3.2.4.g	The equipment design shall allow access to maintainable components for repair and/or troubleshooting.	DOE 6430.1A, Section 1300-12		X				
3.2.5.1.a	The subsystem shall be designed for the natural environmental conditions specified in HNF-SD-GN-ER-501.	HNF-SD-GN-ER-501, Rev 1	"Above the cover block" conditions.				X	

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				E x a m p l e	D e t a i l	T e s t	N / A
3.2.5.1.b	The subsystem shall be designed to withstand the natural phenomena hazards as specified in RPP-PRO-097. The system does not have to operate after a design-basis earthquake; it only needs to be removable.	RPP-PRO-097, Section 5.1; RPP-PRO-1819	Details design loads due to natural phenomena.				X
3.2.5.2.1	The subsystem components shall be designed to perform their intended function in the chemical environment defined in <i>Best-Basis Inventory</i> (database).	<i>Best-Basis Inventory</i>	"Best available" chemical environment per CH2M HILL Hanford Group, Inc., process engineering.	X			
3.2.5.2.2	The subsystem shall be designed for the 1,000 rad/h radiation environment for direct contact with tank waste as defined in HNF-2004.	HNF-2004		X			X
3.2.5.2.3.a	The transfer pump shall remain removable from the tanks following a gas release rollover event and crust impact.	WHC-SD-WM-DGS-006, Section 4.1.7	Loads determined during safety analyses and/or design.				X
3.2.5.2.3.b	Transfer pumps Types 2 and 3 shall operate while under the loads induced by the mixer pump described in HNF-4164.	HNF-4164	Loads determined during design.	X			X
3.2.5.2.4.a	The in-tank temperature range for transfer pump design is 10 to 104 °C (50 to 220 °F).	WHC-SD-WM-DGS-006, Section 4.4.4					
3.2.5.2.4.b	The transfer pump shall be able to withstand the thermal shock of a 38 °C (100 °F) temperature difference, corresponding to insertion of a cold pump in a hot tank and the use of cold flush/dilution water into a hot pump.		ΔT per engineering judgment				X
3.2.5.2.5	Fluid Rheology. The transfer pump shall be designed to pump fluids with the range of properties defined in RPP-5346, Table 5-1.	RPP-5346 (DRAFT)	Waste property ranges "best available" per CH2M HILL process engineering			X	X
3.2.6	Steps shall be taken to ensure that equipment is not damaged during transportation.	Not applicable.					X

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3.3.1.a	All transfer pumps shall meet the applicable design, fabrication, and testing requirements contained in API 610. The highest degree of dynamic balancing shall be specified.	API 610	Standard Design Code.	X		X	X
3.3.1.b	Welding shall be performed and inspected in accordance with American Welding Society and/or American Society of Mechanical Engineers requirements.	RPP-PRO-097, Table B-1	Standard Design Code.	X			
3.3.2	The subsystem shall comply with electromagnetic radiation emission requirements set forth in HNF-2962.	HNF-2962		X			X
3.3.3.a	The subsystem shall label new equipment and/or modifications to existing equipment in a standardized format in accordance with the tank farm labeling program as specified in HNF-IP-0842, Volume II, Section 6.1.	HNF-IP-0842, Volume II, Section 6.1		X			
3.3.3.b	Transfer pumps shall be provided with a manufacturer's nameplate securely attached to the top of the mounting/adaptor flange. The nameplate shall be stamped with the following information, at the minimum: <ul style="list-style-type: none"> • Purchase order number • Manufacturer's size and model # • Pump serial number • Capacity • Pumping head • Casing hydrostatic test pressure • Rated speed • Rated power (if pump has submersible-type motor) • Bearing part number identification • Assembly weight (dry) 	API 610, Section 2.12		X			

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				E x a m o t	D e m o t	T e s t	A n a l	N / A
3.3.3.c	Non-submersible electric motors shall be provided with permanently attached nameplates in accordance with NEMA MG-1.	NEMA MG-1		X				
3.3.3.d	Pump rotation arrows shall be marked on the top of the motor bell housing. This does not apply if a submerged motor pump is selected.	HNF-IP-0842, Volume II, Section 6.1		X				
3.3.4	Reserved. The requirements for workmanship are to be addressed in lower level project design documentation (drawings, procurement specifications, etc.).	Not applicable.						X
3.3.5	All like equipment and parts shall be interchangeable/standardized to the maximum extent practical.	HNF-4553		X				
3.3.6.1.a	The radiological design review process of RPP-PRO-1622 shall be used to keep personnel exposures ALARA.	RPP-PRO-1622; WHC-SD-GN-DSG-30011					X	
3.3.6.1.b	The system shall incorporate design features that comply with the requirements of HNF-SD-WM-HSP-002 and other applicable safety and health requirements.	HNF-SD-WM-SAR-067 Section 11.3.1.2		X				
3.3.6.2.a	Dome load evaluation shall be performed in accordance with HNF-IP-1266, Chapter 5.16.	HNF-IP-1266, Chapter 5.16					X	
3.3.6.3.a	The DST Transfer Pump Subsystem and components shall be designed in accordance with the safety classification for each. The safety classification shall be determined using the process described in RPP-PRO-700, RPP-PRO-702, RPP-PRO-703, and RPP-PRO-704, based on the guidelines in HNF-SD-WM-SAR-067, Section 3.0. Preliminary safety classifications are provided for reference in Appendix B.	RPP-PRO-700; RPP-PRO-702; RPP-PRO-703; RPP-PRO-704; HNF-SD-WM-SAR-067, Section 3.0					X	

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3.3.6.3.b	All equipment installed in areas in and around the tank that are subject to ignition controls shall be designed to meet the requirements of HNF-SD-WM-TSR-006, Section 5.10, "Ignition Controls." Areas requiring controls are delineated in HNF-SD-WM-SAR-067, Appendix K. The Flammable Gas Equipment Advisory Board shall be consulted whenever the application or interpretation of the requirement is unclear.	HNF-SD-WM-TSR-006, Section 5.10		X		X	
3.3.7.a	Subsystem design shall comply with DOE Order 6430.1A, Section 1300.12, "Human Factors Engineering."	DOE Order 6430.1A, Section 1300.12	"Human Factors Engineering"	X			
3.3.8.a	All components that may become contaminated with radioactive or other hazardous materials under normal or abnormal operating conditions shall be designed to incorporate measures to simplify future decontamination and decommissioning in accordance with DOE Order 6430.1A, Section 1300-11.	DOE Order 6430.1A, Sections 0110-99.0.1, 0205-2, and 1300-11; WHC-SD-GN-DGS-30011, Section 3.4		X			
3.3.8.b	Designs should simplify cut-up, dismantlement, removal, and packaging of contaminated pumps.	DOE Order 6430.1A, Section 1300-11.2; RPP-PRO-1622	"Decommissioning"	X			
3.3.8.c	The complete pump assembly column shall be self-draining.	WHC-SD-WM-DGS-006, Section 4.3.3; WHC-SD-GN-DGS-30011, Section 3.4		X			
3.3.8.d	The system design shall provide means of flushing the pump internals to enable reducing the internal contamination levels before and during pump removal from the tank.	WHC-SD-WM-DGS-006, Section 4.1.8; WHC-SD-GN-DGS-30011, Section 3.4		X			

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3.3.8.e	Internal and external cracks, crevices, and hold-up points shall be minimized to facilitate pump cleanup for disposal.	WHC-SD-WM-DGS-006, Section 4.3.3; WHC-SD-GN-DGS-30011, Section 3.4		X			
3.4.a	Records, documents, and drawing control pertinent to design functions shall be in accordance with RPP-PRO-222 and RPP-PRO-224. Drafting standards for drawings and interface control shall be in accordance with RPP-PRO-709.	RPP-PRO-222; RPP-PRO-224; RPP-PRO-709		X			
3.4.b	All DST Transfer Pump Subsystem structures, systems, and components (SSC) shall be incorporated into the master equipment list in accordance with HNF-IP-0842, Vol. II, Section 6.1.	HNF-IP-0842, Vol. II, Section 6.1					X
3.4.c	Vendor information shall be managed in accordance with HNF-IP-0842, Volume IV, Section 4.23.	HNF-IP-0842, Volume IV, Section 4.23					X
3.5.1.a	Transfer pumps shall be designed to require no routine "hands-on" maintenance.	WHC-SD-WM-DGS-006, Section 4.2.3; HNF-4553	Access to below-the-coverblock components may be limited because of contamination. Maintenance frequency per Section 3.2.4.a.	X			
3.5.2.a	A minimum number of spares for like components shall be determined based on mean time between failure and number of like components installed.	HNF-4553		X		X	
3.5.3	Facility and Facility Equipment	Not applicable.					X
3.6	Personnel and Training	Not applicable.					X
3.7.1	Motor	Not applicable.					X
3.7.2	Pump	Not applicable.					X
3.7.3	Pump instrumentation	Not applicable.					X
3.7.4	Pump suction level adjustment	Not applicable.					X

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3.8	<p>Except in those instances where Washington State has been granted regulatory authority by the Federal Government, the hierarchical relationship among requirements specified in Section 3.0 is as follows:</p> <ul style="list-style-type: none"> Federal requirements (e.g., <i>Code of Federal Regulations</i>, DOE orders) State requirements (e.g., Revised Code of Washington, as specified in the <i>Washington Administrative Code</i>) Local ordinances RPP procedures National consensus codes and standards. 	Not applicable.						X
3.9	The subsystem shall be designed such that access controls to radiation and high-radiation areas meet the requirements of DOE/RL-96-109.	Not applicable.						X
3.10	Computer Resource Reserve Capacity	Not applicable.						X
4.0	Quality assurance for the DST Transfer Pump Subsystem shall be performed in accordance with HNF-IP-0842, Volume XI, Section 1.0.	HNF-IP-0842, Volume XI, Section 1.0; HNF-SD-WM-SAR-067, Section 14.3.1						X
4.1.2.a	Each transfer pump shall be tested for hydraulic and mechanical performance, in accordance with <i>Hydraulic Institute Standards</i> and API 610.	<i>Hydraulic Institute Standards</i> , API 610	Standard Design Codes			X		

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4.1.2.b	Electrical materials and equipment shall be qualification tested unless they are Underwriters Laboratories, Inc. (UL) listed, or factory mutual tested, with label attached, and for the purpose intended, whenever such products are available. Where no UL or factory mutual listed products are available, testing and certification by another nationally recognized testing agency may be acceptable, as long as the design agent documents the acceptance of the testing agency.	DOE Order 6430.1A, Section 1605-1	"Electrical – General"			X		
4.1.2.c	It shall be demonstrated that the transfer pump assembly, when suspended, hangs plumb such that it can be inserted into or removed from the tank riser without interference with the riser.	WHC-SD-WM-DGS-006	Required to demonstrate vertical insertion capability of each pump.			X		
4.1.2.d	Pump insertion into and removal from the tank shall be demonstrated for each Type 1, 2, 3, and 4 design.	WHC-SD-WM-DGS-006, Section 4.1.5	"First-of-a-kind" demonstration that design can be satisfactorily inserted and removed from the tank.			X		
4.1.2.e	Transfer pumps that have been stored for 1 year or longer shall be subjected to a run-in test before they are inserted in the waste tank, unless waived by the RPP Design Authority or the RPP project manager.	HNF-3218	Historical evidence shows that pump run-in testing has been very effective in preventing "dead-on-arrival" failures.			X		
4.2	Design Verification	RPP-PRO-1819, Sections 2.9.1 and 2.9.2						X

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APPENDIX B

PRELIMINARY SAFETY CLASSIFICATIONS

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APPENDIX B**PRELIMINARY SAFETY CLASSIFICATION**

The preliminary safety classifications for the Double-Shell Tank Transfer Pump Subsystem major components were derived from the *Tank Waste Remediation System Final Safety Analysis Report*, HNF-SD-WM-SAR-067. See Table B-1 below.

Table B-1. Safety Classification of Double-Shell Tank Transfer Pump Subsystem Components.

Component	GS	SS	SC
Transfer pump motor	✓		
Transfer pump	✓		
Transfer pump instrumentation	✓		
Transfer pump suction level adjustment	✓		

GS = general service.
 SC = safety class.
 SS = safety significant

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