Revised Analyses of Decommissioning for the Reference Boiling Water Reactor Power Station

Effects of Current Regulatory and Other Considerations on the
Financial Assurance Requirements of the Decommissioning Rule
and on Estimates of Occupational Radiation Exposure

Appendices

Draft Report for Comment

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ABSTRACT

On June 27, 1988, the U. S. Nuclear Regulatory Commission (NRC) published in the Federal Register (53 FR 24018) the final rule for the General Requirements for Decommissioning Nuclear Facilities. With the issuance of the final rule, owners and operators of licensed nuclear power plants are required to prepare, and submit to the NRC for review, decommissioning plans and cost estimates. The NRC staff is in need of updated bases documentation that will assist them in assessing the adequacy of the licensee submittals, from the viewpoint of both the planned actions, including occupational radiation exposure, and the probable costs. The purpose of this reevaluation study is to update the needed bases documentation.

This report presents the results of a review and reevaluation of the PNL 1980 decommissioning study of the Washington Public Power Supply System's Washington Nuclear Plant Two (WNP-2) which is a boiling water reactor (BWR), located at Richland, Washington, including all identifiable factors and cost assumptions which contribute significantly to the total cost of decommissioning the plant for the DECON, SAFSTOR, and ENTOMB decommissioning alternatives. These alternatives now include an initial 5-7 year period during which time the spent fuel is stored in the spent fuel pool prior to beginning major disassembly or extended safe storage of the plant.

This report also includes consideration of the NRC requirement that decontamination and decommissioning activities leading to termination of the nuclear license be completed within 60 years of final reactor shutdown, consideration of packaging and disposal requirements for materials whose radionuclide concentrations exceed the limits for Class C low-level waste (i.e., Greater-Than-Class C). Costs for labor, materials, transport, and disposal activities are given in 1993 dollars. Sensitivities of the total license termination cost to the disposal costs at different low-level radioactive waste disposal sites, to different depths of contaminated concrete surface removal within the facilities, and to different transport distances are also examined. Although not considered as a decommissioning expense under the current NRC regulatory framework, an estimate of the costs for demolition of the non-radioactive structures and for restoration of the site to a natural state is included in this report for informational purposes.

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APPENDIX A

STUDY CONTACTS

APPENDIX A

STUDY CONTACTS

Those many individuals who contributed information that subsequently led to the completeness of this study are greatly appreciated and specially acknowledged in this appendix.

Special thanks are expressed to the following individuals who gave so willingly of their time and expertise: Chris Alexander of Advanced Engineering Services, for providing information on the removal of the cranes from the reference plant; Daniel S. McGarvey of Johnson & Higgins of Arizona, Inc., for providing nuclear insurance information associated with decommissioning; William N. Lampson, Paul R. Parish, and Russel J. Rutherford of Neil F. Lampson, Inc., for their help concerning the removal of cranes and the turbine generator removal and transport estimate presented in this report; and, J. Bradley Mason and Dave Schneidmiller of Pacific Nuclear, for the information on current practices associated with the chemical decontamination of light-water reactor systems.

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APPENDIX B

COST ESTIMATING BASIS

APPENDIX B

COST ESTIMATING BASES

The cost information developed in this reevaluation study is based on unit cost data presented in this appendix. Categories for which basic unit cost data are given include: salaries, waste packaging, cask rental, transport, waste disposal, special equipment, and services and supplies. Reactor-specific cost data also are provided concerning taxes, insurance, and license termination survey costs. In addition, the impact on decommissioning costs resulting from cascading costs and contingency allowance is discussed. The bases for the estimated decommissioning costs for specialized decommissioning tasks such as removal of the reactor pressure vessel, the turbine and condenser, and systems chemical decontamination are contained in Appendices E, F, and G, respectively, and are not repeated here. The cost data presented in this appendix are all early-1993 costs.

A decommissioning cost estimating computer program (CECP) developed at Pacific Northwest Laboratory (PNL) for the U.S. Nuclear Regulatory Commission (NRC) is utilized in this boiling water reactor (BWR) reevaluation study. The CECP, designed for use on an IBM personal computer or equivalent, was developed for estimating the cost of decommissioning light-water reactor power stations to the point of license termination. Such costs include component, piping and equipment removal costs; packaging costs; decontamination costs; transportation costs; burial volumes and costs; and manpower staffing costs. Using equipment and consumables costs, inventory data, and labor rates supplied by the user, the CECP calculates unit cost factors and then combines these factors with transportation and burial cost algorithms to produce a complete report of decommissioning costs. In addition to costs, the CECP also calculates person-hours, crew-hours, radiation exposure person-hours, and cumulative radiation dose associated with decommissioning. Inventories of process system components, piping, and valves for the WNP-2 plant (the reference BWR plant) were used to develop and test the CECP. The CECP, the

inventories, and the base unit cost factors developed for use in this study are described in greater detail in Appendix C.

The cost data presented in this appendix, together with the CECF, can be used to develop cost estimates for other decommissioning projects, based upon appropriate consideration of the key assumptions given in Section B.1. These data should be carefully examined to ascertain their applicability to the facility under consideration, and may require significant adjustments for a specific situation.

B.1 BASES AND ASSUMPTIONS

The following major bases and assumptions apply to this reevaluation of the decommissioning cost estimates for the reference BWR:

- The cost estimates in this reevaluation study, just as in NUREG/CR-0672,⁽¹⁾ take into consideration only those costs for decommissioning that affect the public health and safety - i.e., costs to reduce the residual radioactivity in a facility to a level that permits the facility to be released for unrestricted use and the NRC license to be terminated. Hence, the cost estimates in this study do not include such items as the cost to remove clean materials and equipment nor to restore the land to a "green field," which would require additional demolition and site restoration activities. Although these additional costs for site restoration may be needed from the viewpoint of public relations or site resale value, they are not related to health and safety and therefore were considered to be outside of NRC's area of responsibility.
- The cost estimate is site-specific for the reference BWR (WNP-2) analyzed in this reevaluation study to account for the unique features of the nuclear steam supply system, electric power generation systems, site location, and site buildings and structures.
- Labor rates for each craft and salaried worker representative of the WNP-2 location are used in this development of a site-specific decommissioning cost estimate. Washington Public Power Supply System (WPPSS), the operator of the WNP-2 plant, provided typical craft labor rates and salary data for utility personnel from utility records.
- Pre-decommissioning engineering services for such items as writing decommissioning activity specifications and procedures, detailed activation analyses, structural modifications, etc. are assumed to be provided by a Decommissioning Operations Contractor (DOC). It

is further assumed that the licensee contracts with the DOC for subsequent management of the decommissioning program(s).^(a)

- Material and equipment costs for conventional demolition and/or construction activities were taken from R. S. Means Construction Cost Data⁽²⁾ and Means Estimating Handbook.⁽³⁾
- The waste disposal costs presented in this study were specifically developed for the reference BWR, which is located within the Northwest Compact, assuming disposal at the U.S. Ecology site in Richland, Washington. To provide additional information, the costs also were estimated for shipping and disposal of the reference BWR wastes at the Barnwell site in Barnwell, South Carolina.
- At the direction of the NRC, consideration of the use of a radwaste broker's services were excluded from this reevaluation study.
- Heavy-lift rigging and overland transport costs for selected large components are based on information provided by a qualified vendor of these services, who has handled the overland transport and installation of NSSS components for several plants.
- This study does not address the removal or disposal of spent fuel from the site. The costs for such activities are assumed to be covered by U.S. Department of Energy's 1 mill/kWh surcharge. However, the study does include consideration of the constraints that the presence of spent fuel onsite may impose on other decommissioning activities and on schedules.
- This study does not address the removal or disposal of mixed waste from the site. The costs for such activities are assumed to be operational costs covered by an active (and continued in force) Resource Conservation and Recovery Act (RCRA) permit for the facility. However, the study does include consideration of the constraints that the presence of mixed waste onsite may impose on decommissioning alternatives and on schedules.
- The study presumes the installation of spent fuel dry storage modules such that decommissioning operations can proceed with minimum impact (i.e., all fuel is transferred to the dry storage compound within 5 years following shutdown). Separate, distinct funding for post-shutdown activities associated with the spent nuclear fuel (SNF) are delineated in 10 CFR Part 50.54(bb), "Conditions of Licenses." All such costs associated with the SNF are considered to be operational costs in this re-evaluation study, not decommis-

(a) Although a potential cost savings exists in keeping the decommissioning work in-house, many utilities do not have the workforce available and in some instances, the expertise to manage this type of activity. Consequently, the potential savings from using the in-house workforce, with the attendant lower overhead costs, could easily be negated if the licensee had to temporarily augment its permanent staff to manage the decommissioning program.

sioning costs. Therefore, neither the disposition of the SNF nor the cost of the dry storage modules has been included within this decommissioning cost estimate. (See Appendix D for additional details.)

- The utility's staffing requirements during decommissioning vary with the level of effort associated with the various phases of on-site storage of SNF. Consequently, the staff size required to support and maintain wet storage (i.e., the spent fuel pool) following final shutdown is substantially greater than that required to monitor the independent spent fuel storage installation (ISFSI).

B.2 MANPOWER COSTS

Salary data for the decommissioning staff positions used in this study are given in Table B.1. The labor costs shown in Table B.1 are representative of labor costs for this particular decommissioning project at the reference BWR, which is the WNP-2 plant, located at Richland, Washington. The utility overhead positions and overhead rates data^(b) shown in the table were supplied by the Washington Public Power Supply System, the operator of the WNP-2 plant.

It is acknowledged in this study that overhead rates applied to direct staff labor are expected to be significantly higher for subcontracting organizations (e.g., the DOC) than for operating utilities, because of the larger ratio of supervisory and support personnel to direct labor that usually exists in subcontracting organizations. Having personnel in the field rather than in the home office also increases the overhead costs, because of travel and living expenses for many of the personnel. In view of these factors, an overhead rate on direct staff labor of 110%, plus 15% DOC profit on labor, is assumed to be applicable to all DOC personnel in this study.

Because regional labor costs can deviate significantly from those used in this study, care should be used in the application of these data to other decommissioning projects.

(b) Since overhead rates may vary for similar job codes, selected averages were used for some job positions shown in Table B.1.

TABLE B.1. Labor Costs for Decommissioning^(a)

<u>Utility Overhead Position</u>	<u>Base Pay (\$/yr)</u>	<u>Assumed Over- Head Rate (%)</u>	<u>Cost (\$/yr)</u>
Plant Manager	113,580	59	180,592
Assistant Plant Manager	96,497	58	152,465
Secretary	25,103	100.8	50,407
Clerk Typist	21,653	85	40,058
Accountant	45,738	107	94,678
Contracts/Procurement Specialist	46,307	99.5	92,382
Industrial Safety Specialist	52,494	109	109,712
Planning/Scheduling Engineer	55,046	71	94,129
Radioactive Ship. Specialist	68,019	60	108,830
Chemistry Supervisor	62,098	53	95,010
Chemistry Technician	43,950	58	69,441
Quality Assurance Manager	74,518	83	136,368
Quality Assurance Engineer	60,085	89.3	113,741
Quality Assurance Technician	41,992	88.3	79,071
Health Physics Supervisor	62,098	60	99,357
Sr. Health Physics Technician	56,899	63	92,745
Health Physics/ALARA Planner	56,899	63	92,745
Health Physics Technician	43,950	61	70,760
Nuclear Records Specialist	52,490	71	89,758
Building Services Supervisor	62,098	53	95,010
Training Manager	62,098	147	153,382
Operations Manager	87,955	58	138,969
Administration Manager	74,518	71	127,426
Operations Supervisor	65,286	60.5	104,784
Control Operator	48,318	58	76,342
Plant Equipment Operator	43,950	58	69,441
Plant Engineer	62,098	58	98,115
Maintenance Manager	80,875	53	123,739
Maintenance Supervisor	74,518	53	114,013
Licensing Specialist (Lawyer)	61,224	227	200,202
Craftsman	43,950	53	67,244
Custodian	30,742	53	47,035
Security Manager	74,518	60	119,229
Security Shift Supervisor	41,992	60	67,187
Security Patrolman	33,342	60	53,347
<u>DOC Overhead Position^(b,c)</u>			
Project Manager	91,210	141.5	220,272
Assistant Project Manager	73,820	141.5	178,275
Secretary/Clerk	19,805	141.5	47,829
Industrial Safety Specialist	47,600	141.5	114,954
Planning/Scheduling Engineer	52,630	141.5	127,101
Radioactive Shipment Specialist	55,950	141.5	135,119
<u>Utility Overhead Position^(d)</u>			
Lawyer/Financial Administrator	62,420	141.5	150,744
Contracts/Accounting Supervisor	62,420	141.5	150,744
Contracts Specialist/Buyer ^(d)	48,600	141.5	117,369
Procurement Specialists	44,200	141.5	106,743
Accountant	48,600	141.5	117,369
Operations Supervisor	61,140	141.5	147,653
Health Physics Supervisor	61,550	141.5	148,643
Health Physics/ALARA Planner ^(d)	51,440	141.5	124,228
Engineering Supervisor	61,140	141.5	147,653
D&D Operations Supervisor	61,140	141.5	147,653
Engineers	50,890	141.5	122,899
Drafting Specialist ^(d)	28,080	141.5	67,813
Quality Assurance Supervisor	61,140	141.5	147,653

TABLE B.1. (contd)

<u>Utility Overhead Position</u>	<u>Base Pay (\$/yr)</u>	<u>Assumed Over- Head Rate (%)</u>	<u>Cost (\$/yr)</u>
Quality Assurance Engineer	34,710	141.5	83,825
Quality Assurance Technician	31,710	141.5	76,580
Sr. Health Physics Technician	51,440	141.5	124,228
Health Physics Technician	31,710	141.5	76,580
Protective Equipment Technician	31,770	141.5	76,725
Tool Crib Attendant	31,770	141.5	76,725
Protective Clothing Attendant	31,770	141.5	76,725
Licensing Engineer	50,890	141.5	122,899
Safety Consultant ^(d)	242,200	---	242,200
<u>Dedicated Decontamination Workers</u>			
Crew Leader	47,230	141.5	114,060
Craftsman	42,810	141.5	103,386
Laborer	22,710	141.5	54,845
Utility Operator	36,470	141.5	88,075

(a) Salary rates are in 1993 dollars, assuming 2080 hours per person-year.

(b) Salary rates include 110% overhead, plus 15% Decommissioning Operations Contractor (DOC) profit on labor.

(c) The DOC staff costs are maintained consistent with those used in the PWR reevaluation study.⁽⁴⁾

(d) Study estimate.

B.3 MOBILIZATION AND DEMOBILIZATION COSTS

There are significant costs associated with a contractor establishing its presence at the work site. These costs, called mobilization and demobilization costs, will vary with the size and complexity of the job. These costs include temporary office facilities, obtaining the required special equipment, and assembling the work force. Similarly, there are costs associated with closing down a work site. For the dismantlement of a large nuclear power plant, these costs were previously estimated by an engineer experienced in estimating costs for utility construction projects to be about \$1.25 million (without contingency) in 1978 dollars.^(5,6) Applying an escalation factor of 2.11, based on the Implicit Price Deflator,⁽⁷⁾ brings the mobilization and demobilization costs to \$2.64 million, without contingency, in 1993 dollars.

B.4 CASK CHARGES

Some of the waste material shipped to a burial site is sufficiently radioactive to require transport in reusable shielded casks. In general, it is most economical to rent such casks. The casks assumed to be used in this study for shipping highly radioactive materials are listed in Table B.2, together with their application and their estimated rental charges.

TABLE B.2. Shielded Casks for Shipment of Radioactive Materials

<u>Cask Description(a)</u>	<u>Application</u>	<u>Daily Rental (\$)</u>
NAC-LWT; 51,200 lb COC No. 9225/B(U)F(b)	Transport of greater-than-class-C (GTCC) LLW waste	3,130 ^(c)
TN-8 OWT; 79,200 lb COC No. 9015B	Transport of greater-than-class-C LLW waste	3,340 ^(c)
NuPac No. 10-142; 68,000 lb COC No. 9208	Transport of high-integrity container or 55-gal drums	1,250
NuPac No. 14/210H; 58,400 lb COC No. 9176	Transport of high-integrity container or 55-gal drums	1,250
CNS No. 8-120B; 59,320 lb COC No. 9168	Transport of radioactive material in the form of activated reactor components	1,250

(a) NAC-LWT = Nuclear Assurance Corporation-Legal Weight Truck Cask; TN-8 OWT = Transnuclear, Inc. Over Weight Truck Cask; CNS = Chem-Nuclear Systems, Inc.; NuPac = Pacific Nuclear.

(b) COC No. means Certificate of Compliance Number as listed in Reference 8.

(c) The daily rental rate is predicated on a sliding scale, according to risk, with spent nuclear fuel being the highest risk cargo and the GTCC material assumed at the same rate in this study.

B.5 RADIOACTIVE WASTE PACKAGING COSTS

The shipping containers assumed to be used for packaging radioactive waste materials for disposal are listed in Table B.3, together with brief descriptions, burial volumes, probable applications, and unit costs, for each type of container.

TABLE B.3. Packaging for Radioactive Materials

<u>Description</u>	<u>Burial Volume (ft³)</u>	<u>Application</u>	<u>Estimated Unit Cost (\$)</u>
Steel cask liner for 8-120B cask; 62 in. OD x 72 in. high; 2,000 lb empty	126	Shallow-land burial of activated RPV internals	4,695
Steel cask liner for 8-120B cask; 62 in. OD x 32 in. high; 1,500 lb empty	56	Shallow-land burial of activated RPV	3,200
Steel cask liner for NAC-LWT cask; 13 in. OD x 178 in. long; 700 lb empty	13.7	Jet pump components	1,000
Canister; 9-in. square x 178-in. high; 300 lb empty	8.4	Deep geologic disposal of GTCC LLW core components	520
Special Steel Boxes:			
4 ft x 4 ft x 3 ft, 400 lb	48	RPV head segments	430
4 ft x 4 ft x 2.5 ft, 350 lb	40	RPV head flange segments	400
4 ft x 4 ft x 1.5 ft, 250 lb	24	RPV lower flange segments	365
4 ft x 8 ft x 1.5 ft, 400 lb	48	Shroud supports, studs, nuts	730
6.7 x 8.9 x 14 ft, 2,800 lb	835	Spent fuel racks (10)	4,510
6.1 x 8.9 x 14 ft, 2,642 lb	760	Spent fuel racks (2)	4,106
6.7 x 7.3 x 14 ft, 2,438 lb	685	Spent fuel rack (1)	3,700
4 x 10 x 14 ft, 2,114 lb	560	Spent fuel rack (1)	3,025
4.5 x 7.3 x 14 ft, 1,860 lb	460	Spent fuel rack (1)	2,485
5 x 5 x 38 ft, 4,300 lb	950	Reheater tube bundles	4,500
10 x 10 x 25 ft, 6,500 lb	2,500	Moist. Sep. tube bundles	6,000
94 x 115 x 26 in., 1,000 lb	162.7	Sacrificial shield seg- ments, form-fitted (60)	1,050
High-Integrity Container (HIC); 75.5 in. dia. x 78 in high; 900 lb empty	200	Dewatered, solids, or solidified water meeting LSA requirements	5,750 - 9,900 ^(a)
Maritime container (Sea-Van) 8 x 8.5 x 20 ft; 4,180 lb	1360	Shallow-land burial of LLW	3,650
Modified Maritime containers 8 x 4 x 20 ft; 3,000 lb	640	Shallow-land burial of LLW	4,965
8 x 2 x 20 ft; 2,500 lb	320	Shallow-land burial of LLW	4,600
8 x 1 x 20 ft; 2,000 lb	160	Shallow-land burial of LLW	4,000
DOT 17-H steel drum; 55-gal; 51 lb empty	7.4	Shallow-land burial of LLW	26.95

(a) Depending upon the inserts used, the estimated cost of HICs is believed to fall within the range shown. For the purpose of this study, a mid-range value of \$7,825/unit is used.

B.6 TRANSPORTATION COSTS

The radioactive materials resulting from decommissioning are assumed to be shipped in exclusive-use^(c) trucks to a low-level waste disposal site (at Richland, WA, or Barnwell, SC), or, in the case of highly activated reactor components, to the federal geologic repository or other such disposal facility as the NRC may approve.

Rates for shipping radioactive wastes were provided by Tri-State Motor Transit Co. and from its published tariffs for this type of cargo.⁽¹⁰⁾

Costs of transporting low-level waste to the disposal site are calculated using the CECF. The algorithms contained in the CECF utilize the TROJAN reactor as the reference reactor site and the U.S. Ecology site in Richland, WA, as the reference disposal site, use ratios of study distance/reference distance to adjust the reference costs to the study conditions. The CECF data base (see Appendix C) contains great-circle distances from all commercial reactor sites to the postulated geologic repository at Yucca Mountain and to the low-level disposal sites at Barnwell, SC (Chem-Nuclear) and Richland, WA (U.S. Ecology). For convenience, the location of the supplier of transport casks is defined as Barnwell, SC. While not strictly true, the possible error is only about 200 miles out of about 2700 miles for those casks not based at Barnwell.

To calculate transportation costs, the CECF employs a different cost formula for each cask (CNS 8-120B, NuPac 14/210H, NAC-LWT, and TN-8) that is postulated to be used in decommissioning. These formulas, based on data supplied in Reference 10, are given below.

Round-Trip Cost for Using the CNS 8-120B Cask, U.S. Ecology, WA, Site

$$\text{Cost} = R1 \times d1/d10 + R2 \times d2/d20 + n \times (R3 \times w/w0 \times d/d0 + OW1 + P) + (n - 1) \times (R4 \times d/d0 + OW2),$$

where

R1 = cost of transporting empty cask from cask supplier (Barnwell, SC) to reference reactor site (TROJAN), \$11,855.99,

(c) Exclusive use, as defined in 49 CFR 173.401(i),⁽⁹⁾ is also referred to as "sole use" or "full load." In any case, it means the sole use of a conveyance by a single consignor and for which all initial, intermediate, and final loading and unloading are carried out in accordance with the direction of the consignor or consignee. Specific instructions for the maintenance of exclusive-use shipment controls must be issued in writing and included with the shipping paper information provided to the carrier by the consignor.

d1 = distance between study reactor site (WNP-2) and the cask supplier, 2,659 miles,
 d10 = distance between reference reactor site (TROJAN) and the cask supplier, 2,799 miles,
 R2 = cost of transporting empty cask from the reference burial site (U.S. Ecology, WA)
 to supplier (Barnwell, SC) = \$10,122.75,
 d2 = distance between study burial site (U.S. Ecology, WA) and cask supplier, 2,674 miles,
 d20 = distance between reference burial site (U. S. Ecology, WA) and cask supplier, 2,674 miles,
 n = number of casks to be shipped to the burial site,
 R3 = cost of transporting fully loaded cask from reference reactor site (TROJAN) to reference burial
 site (U.S. Ecology, WA), \$2,456.80,
 w = weight of study loaded cask, in pounds,
 w0 = weight of fully loaded cask, 74,000 pounds,
 d = distance between study reactor site (WNP-2) and study burial site (U.S. Ecology, WA), 15 miles,
 d0 = distance between reference reactor site (TROJAN) and reference burial site (U.S. Ecology, WA),
 297 miles,
 R4 = cost of transporting empty cask from reference burial site (U. S. Ecology, WA) to reference
 reactor site (TROJAN) = \$1,216.06,
 OW1 = overweight charges, \$219.05,
 OW2 = overweight charges, \$69.37, and
 P = permit cost, \$120.00.

Round-Trip Cost for Using the CNS 8-120B Cask, Barnwell, SC, Site

$$\text{Cost} = n \times (R1 \times d/d0) + n \times (R2 \times d/d0 \times w/w0 + OW + P),$$

where

R1 = cost of transporting empty cask from Barnwell, SC, to reference reactor site (TROJAN),
 \$11,855.99,
 d = distance between Barnwell, SC, and study reactor site (WNP-2), 2,659 miles,
 d0 = distance between Barnwell, SC, and reference reactor site (TROJAN), 2,799 miles,
 R2 = cost of transporting fully loaded cask from reference reactor site (TROJAN) to Barnwell, SC,
 \$14,185.80,
 n = number of casks to be shipped to the burial site,
 w = weight of loaded cask, in pounds,
 w0 = weight of fully loaded cask, 74,000 pounds,
 OW = overweight and other charges, \$1,531.67 and
 P = permit cost, \$125.00.

Round-Trip Cost for Using the 14/-210H Cask, U.S. Ecology, WA, Site

$$\text{Cost} = R1 \times d1/d10 + R2 \times d2/d20 + n \times (R3 \times d/d0 + OW + P) + (n - 1) \times (R4 \times d/d0) + n \times R5 \times d1/d10,$$

where

R1 = cost of transporting empty cask from cask supplier (Barnwell, SC) to reference reactor site
 (TROJAN), \$5,150.16,
 d1 = distance between study reactor site (WNP-2) and the cask supplier, 2,659 miles,
 d10 = distance between reference reactor site (TROJAN) and the cask supplier, 2,799 miles,

R2 = cost of transporting empty cask from the reference burial site (U.S. Ecology, WA) to supplier, \$4,412.10,
 d2 = distance between study burial site (U.S. Ecology, WA) and cask supplier (Barnwell, SC), 2,674 miles,
 d20 = distance between reference burial site (U.S. Ecology, WA) and cask supplier (Barnwell, SC), 2,674 miles,
 n = number of casks to be shipped to the burial site,
 R3 = cost of transporting fully loaded cask from reference reactor site (TROJAN) to reference burial site (U.S. Ecology, WA), \$964.65,
 d = distance between study reactor site (WNP-2) and study burial site (U.S. Ecology, WA), 15 miles,
 d0 = distance between reference reactor site (TROJAN) and reference burial site (U.S. Ecology, WA), 297 miles,
 R4 = cost of transporting empty cask from reference burial site (U.S. Ecology, WA) to reference reactor site (TROJAN), \$914.76,
 OW = overweight charges, \$242.70,
 P = permit cost, \$120.00, and
 R5 = cost of transporting HIC from supplier to reference reactor site (TROJAN), \$4,210.50.

Round-Trip Cost for Using the 14/-210H Cask, Barnwell, SC, Site

$$\text{Cost} = n \times (R1 \times d/d0) + n \times (R2 \times d/d0 + OW + P) + n \times (R3 \times d/d0)$$

where

R1 = cost of transporting empty cask from Barnwell, SC, to reference reactor site (TROJAN), \$5,150.16,
 d = distance between Barnwell, SC, and study reactor site (WNP-2), 2,674 miles,
 d0 = distance between Barnwell, SC and reference reactor site (TROJAN), 2,799 miles,
 R2 = cost of transporting fully loaded cask from reference reactor site (TROJAN) to Barnwell, SC, \$5,235.45,
 n = number of casks to be shipped to the burial site,
 OW = overweight and other charges, \$1849.91,
 P = permit cost, \$125.00, and
 R3 = cost of transporting HIC from supplier to the reference reactor site (TROJAN), \$4,210.50.

Round-Trip Cost for Using the NAC-LWT to the Geologic Repository

$$\text{Cost} = R1 \times d1/d10 + R2 \times d2/d20 + n \times (R3 \times w/w0 \times d/d0 + OW + P) + (n - 1) \times (R4 \times d/d0 + OW)$$

where

R1 = cost of transporting empty cask from cask supplier to reference reactor site (TROJAN), \$9,264.56,
 d1 = distance between study reactor site (WNP-2) and the cask supplier, 2,659 miles,
 d10 = distance between reference reactor site (TROJAN) and the cask supplier = 2,799 miles,
 R2 = cost of transporting empty cask from the repository to cask supplier, \$6,279.36,
 d2 = distance between study repository and cask supplier, 2,070 miles,
 d20 = distance between reference repository and cask supplier, 2,070 miles,
 n = number of casks to be shipped to the repository,

R3 = cost of transporting fully loaded cask from reference reactor site (TROJAN) to reference repository, \$3,102.24,
 w = weight of study loaded cask, in pounds,
 w0 = weight of fully loaded cask, 55,200 pounds,
 d = distance between study reactor site (WNP-2) and repository, 793 miles,
 d0 = distance between reference reactor site (TROJAN) and reference repository, 907 miles,
 R4 = cost of transporting empty cask from reference repository to reference reactor site (TROJAN), \$2,406.40,
 OW = overweight charges, \$268.00, and
 P = permit cost, \$120.00.

Round-Trip Cost for Using the TN-8 Cask to the Geologic Repository

$$\text{Cost} = R1 \times d1/d10 + R2 \times d2/d20 + n \times (R3 \times w/w0 \times d/d0 + OW + P) + (n - 1) \times (R4 \times d/d0 + OW + P),$$

where

R1 = cost of transporting empty cask from cask supplier to reference reactor site (TROJAN), \$18,790.61,
 d1 = distance between study reactor site and cask supplier, 2,659 miles,
 d10 = distance between reference reactor site (TROJAN) and the cask supplier, 2,799 miles,
 R2 = cost of transporting empty cask from the reference repository to cask supplier, \$13,551.44,
 d2 = distance between study repository and cask supplier, 2,070 miles,
 d20 = distance between reference repository and cask supplier, 2,070 miles,
 n = number of casks to be shipped to the repository,
 R3 = cost of transporting fully loaded cask from reference reactor site (TROJAN) to reference repository, \$5,286.12,
 w = weight of loaded cask, in pounds,
 w0 = weight of fully loaded cask, 84,040 pounds,
 d = distance between study reactor site (WNP-2) and study repository, 793 miles,
 d0 = distance between reference reactor site (TROJAN) and reference repository, 907 miles,
 R4 = cost of transporting empty cask from reference repository to reference reactor site (TROJAN), \$4,165.95,
 OW = overweight charges, \$365.00, and
 P = permit cost, \$120.00.

For non-cask truck shipments, the calculations are much simpler. For cargo consisting of 55-gallon drums, assorted metal boxes, or maritime containers, the round-trip truck transportation charges are:

Round-Trip Legal-Weight Truck Shipment Cost for Low Level Waste, U.S. Ecology, WA, Burial Site

$$\text{Cost} = R \times D/D0 + PC$$

where

R = the round-trip cost between reference reactor site (TROJAN) and reference disposal site (U.S. Ecology, WA), \$1,211.82,
 D = distance between study reactor site (WNP-2) and U.S. Ecology, WA, 15 miles,
 D0 = distance between the reference reactor site (TROJAN) and U.S. Ecology, WA, 297 miles,

PC = permit cost, \$120,
for cargoes not exceeding 40,000 pounds.

Round-Trip Legal-Weight Truck Shipment Cost for Low Level Waste, Barnwell, SC, Burial Site

$$\text{Cost} = R \times D/DO + PC$$

where

R = the round-trip cost between reference reactor site (TROJAN) and reference disposal site (Barnwell, SC), \$4,226.49,
D = distance between study reactor site (WNP-2) and Barnwell, SC, 2,659 miles
DO = distance between reference reactor site (TROJAN) and Barnwell, SC, 2,799 miles,
PC = permit cost, \$95,

for cargoes not exceeding 40,000 pounds.

For the same type of cargo as above, but exceeding 40,000 pounds, the truck transportation charges are calculated as follows:

Round-Trip Over-Weight Truck Shipment Cost for Low Level Waste, U.S. Ecology, WA, Burial Site

$$\text{Cost} = R \times D/DO \times W/WO + PC + OWP$$

where

R = the round-trip cost between reference reactor site (TROJAN) and reference disposal site (U.S. Ecology, WA), \$1,211.82,
D = distance between study reactor site (WNP-2) and U.S. Ecology, WA, 15 miles,
DO = distance between reference reactor site (TROJAN) and U.S. Ecology, WA, 297 miles,
W = cargo weight, assumed to be greater than 40,000 pounds,
WO = reference weight, 40,000 pounds,
PC = permit cost, \$120,
OWP = overweight permit cost, \$95.

Round-Trip Over-Weight Truck Shipment for Low Level Waste, Barnwell, SC, Burial Site

$$\text{Cost} = R \times D/DO \times W/WO + 0.4 \times D + PC + OWP$$

where

R = the round-trip cost between reference reactor site (TROJAN) and reference disposal site (Barnwell, SC), \$4,226.49,
D = distance between study reactor site (WNP-2) and Barnwell, SC, 2,659 miles,
DO = distance between reference reactor site (TROJAN) and Barnwell, SC, 2,799 miles,
W = cargo weight, assumed to be greater than 40,000 pounds,
WO = reference weight, 40,000 pounds,
PC = permit cost, \$95,
OWP = overweight permit cost, \$543.

For the specific case of the reference BWR, trucks are used to transport equipment and material to the disposal sites. No rail transportation is used.

B.7 WASTE DISPOSAL COSTS

As previously mentioned, most radioactive materials resulting from decommissioning are assumed to be shipped for disposal to a burial site (U.S. Ecology, Inc., at Richland, WA), or, in the case of highly activated reactor components, to a geologic repository or other such disposal facility as the NRC may approve. In addition, there is a third type of waste that a licensee may have to consider during decommissioning - mixed waste. The unit costs for all three cases of waste disposal are discussed in the following subsections.

B.7.1 Costs for Shallow-Land Burial

The primary shallow-land burial costs used in this study are presented in Table B.4. They are the February 9, 1993, schedule of charges from U.S. Ecology, Inc., which operates the burial site at Richland, Washington. However, because sensitivity of the total license termination cost to the disposal costs at different low-level radioactive waste disposal sites is also examined in this report, the January 1, 1993, schedule of charges from Chem-Nuclear Systems, Inc., which operates the burial site at Barnwell, South Carolina, is presented in Table B.5.

B.7.2 Costs for Geologic Disposal

Based upon discussions with an industry expert, a nominal unit cost value of approximately \$6,500 per cubic foot (\$229,540 per cubic meter) is estimated for use in this study for geologic repository disposal costs. Thus, for the canisters presently considered for geologic disposal (0.24-m³ burial volume) in this study, the disposal charge is \$55,090/canister. It should be recognized that the cost presented here is quite speculative, since a geologic repository or other such disposal facility as the NRC may approve does not presently exist.

TABLE B.4. U.S. Ecology Shallow-Land Burial Costs at Hanford

US ECOLOGY
WASHINGTON NUCLEAR CENTER
DISPOSAL CHARGES
SCHEDULE A
EFFECTIVE FEBRUARY 9, 1993

A. DISPOSAL CHARGES

1. Packages (except as noted in Section 2)

<u>R/HR AT CONTAINER SURFACE</u>	<u>PRICE PER CU. FT.</u>
0.00 - 0.20	\$35.92
0.201 - 1.00	37.70
1.01 - 2.00	39.10
2.01 - 5.00	40.60
5.01 - 10.00	44.50
10.01 - 20.00	53.20
20.01 - 40.00	61.40
Greater than 40.00	$\$56.90 + (\$0.541 \times \text{R/HR in excess of } 40)$

2. Disposal Liners Removed From Shield (Greater Than 12.0 Cu.Ft. Each)

<u>R/HR AT CONTAINER SURFACE</u>	<u>SURCHARGE PER LINER</u>	<u>PRICE PER CU. FT.</u>
0.00 - 0.20	No Charge	\$35.92
0.21 - 1.00	263.50	35.92
1.01 - 2.00	592.90	35.92
2.01 - 5.00	999.20	35.92
5.01 - 10.00	1,592.00	35.92
10.01 - 20.00	2,086.00	35.92
20.01 - 40.00	2,393.40	35.92
Greater than 40.00	$2,619.40 + (\$22.96 \times \text{R/HR in excess of } 40)$	35.92

B. Surcharge for Curies (per load)

Less than 50 curies	No Charge
50 - 100 curies	\$1,097.90
101 - 300 curies	2,195.80
301 - 500 curies	2,744.90
501 - 1,000 curies	3,293.90
1,001 - 5,000 curies	3,842.80
5,001 - 10,000 curies	5,599.50
10,001 - 15,000 curies	7,905.20
Greater than 15,000 curies	$8,959.20 + (\$0.426 \times \text{curies in excess of } 15,000)$

C. Minimum Charge Per Shipments

All shipments will be subject to a minimum charge of \$1,000 per generator per shipment.

TABLE B.4. (contd)

US ECOLOGY
WASHINGTON NUCLEAR CENTER
SURCHARGES AND OTHER SPECIAL CHARGES
SCHEDULE B
EFFECTIVE FEBRUARY 9, 1993

SURCHARGES AND OTHER SPECIAL CHARGES

A. CASK HANDLING FEES

1. Truck Casks

a. Remains on Vehicle During Unloading	\$1,000 each
b. Removed from Vehicle During Unloading	\$25,000 each

2. Rail Cask

\$50,000 each plus outside riggers' charges

B. POLY HICS IN ENGINEERED CONCRETE BARRIERS

1. Large Barrier - \$9,520 plus other applicable costs herein
2. Small Barrier - \$8,325 plus other applicable costs herein

C. SURCHARGE FOR HEAVY OBJECTS (NON-CASK SHIPMENTS)

Less than 5,000 pounds	No Charge
5,001 -10,000	\$ 500.00
10,001 -15,000	1,000.00
15,001 -20,000	2,500.00
20,001 -25,000	5,000.00
Over -25,000	10,000.00

D. SURCHARGE FOR SPECIAL NUCLEAR MATERIAL

Greater than 5 grams per shipment	\$10.00 per gram
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E. DECONTAMINATION SERVICES (IF REQUIRED)

Per Hour	\$150.00
Supplies	Cost Plus 25%

F. OTHER SERVICES (IF REQUIRED)

Rates shown on Schedule A, Items A and B and Schedule B, items C and E are based on utilization of on-site personnel and equipment. If additional personnel or equipment are required for handling or disposal of waste, additional charges may be assessed.

TABLE B.4. (contd)

US ECOLOGY
WASHINGTON NUCLEAR CENTER
TAX AND FEE RIDER
SCHEDULE C
EFFECTIVE FEBRUARY 9, 1993

The rates and charges set forth in Schedule A & B shall be increased by the amount of any fee, surcharge or tax assessed on a volume or gross revenue basis against or collected by US Ecology, as listed below:

Perpetual Care and Maintenance Fee	\$1.75 per cubic foot
Business & Occupation Tax	5.5% of rates and charges
Site Surveillance Fee	\$1.99 per cubic foot
Surcharge (RCW 43.200.233)	\$6.50 per cubic foot
Commission Regulatory Fee	1.0% of rates and charges

TABLE B.5. Chem-Nuclear Shallow-Land Burial Costs at Barnwell

CHEM-NUCLEAR SYSTEMS, INC.

140 Stonewall Drive • Columbia, South Carolina 29210

BARNWELL LOW-LEVEL RADIOACTIVE
WASTE MANAGEMENT FACILITY
RATE SCHEDULE

All radwaste material shall be packaged in accordance with Department of Transportation and Nuclear Regulatory Commission Regulations in Title 49 and Title 10 of the Code of Federal Regulations, Chem-Nuclear's Nuclear Regulatory Commission and South Carolina Radioactive Material Licenses, Chem-Nuclear's Barnwell Site Disposal Criteria, and amendments thereto.

1. BASE DISPOSAL CHARGES: (Not including Surcharges, Barnwell County Business License Tax, and Cask Handling Fee)

A. Standard Waste	\$59.00/ft ³
B. Biological Waste	\$61.00/ft ³
C. Special Nuclear Material (SNM)	\$59.00/ft ³

Note 1: Minimum charge per shipment, excluding Surcharges and specific other charges is \$1,000.

Note 2: Base Disposal Charge includes:

Extended Care Fund	\$ 2.30/ft ³
South Carolina Low-Level Radioactive Waste Disposal Tax	\$ 6.00/ft ³
Southeast Regional Compact Fee	\$.99/ft ³

2. SURCHARGES:

A. Weight Surcharges (Crane Loads Only)

<u>Weight of Container</u>	<u>Surcharge Per Container</u>
0 - 1,000 lbs.	No Surcharge
1,001 - 5,000 lbs.	\$ 675.00
5,001 - 10,000 lbs.	\$1,200.00
10,001 - 20,000 lbs.	\$1,625.00
20,001 - 30,000 lbs.	\$2,170.00
30,001 - 40,000 lbs.	\$3,125.00
40,001 - 50,000 lbs.	\$4,125.00
greater than 50,000 lbs.	By Special Request

Effective January 1, 1993

TABLE B.5. (contd)

Barnwell Rate Schedule

Effective January 1, 1993

B. Curie Surcharges For Shielded Shipments:

<u>Curie Content Per Shipment</u>	<u>Surcharge Per Shipment</u>
0 - 5	\$ 4,150.00
> 5 - 15	\$ 4,710.00
> 15 - 25	\$ 6,235.00
> 25 - 50	\$ 9,405.00
> 50 - 75	\$11,460.00
> 75 - 100	\$13,525.00
> 100 - 150	\$18,630.00
> 150 - 250	\$24,955.00
> 250 - 500	\$31,290.00
> 500 - 1,000	\$37,375.00
> 1,000	By Special Request

C. Curie Surcharges for Non-Shielded Shipments Containing Tritium and Carbon 14:

<u>Curie Content Per Shipment</u>	<u>Surcharge Per Shipment</u>
0 - 100	No Surcharge
greater than 100	By Special Request

D. Class B/C Waste Polyethylene High Integrity Container Surcharge

<u>Curie Content Per Shipment</u>	<u>Large Liners with Maximum Dimension of 82" Diameter and 79" Height</u>	<u>Overpacks with Maximum Dimension of 33" Diameter and 79" Height</u>	<u>55-Gallon Drum size with Max. Dimension of 25.5" Diameter and 36" Height</u>
0 - 25	\$29,325	These containers will be assessed charges the same as other containers in accordance with this rate schedule plus \$2,900 per overpack and \$750 per drum	
> 25 - 50	\$30,760		
> 50 - 75	\$32,775		
> 75 - 100	\$35,300		
>100 - 150	\$38,525		
>150 - 250	\$44,965		
>250 - 500	\$52,210		
>500	Upon Request		

NOTES: 1. Class B/C poly HICs which do not conform to the above require prior approval and pricing will be provided upon request.

2. The above Large Liner charges are inclusive of the base disposal charge (l.a.), weight surcharge, curie surcharge, cask handling surcharge, disposal overpack charge, and the Barnwell surcharge.

TABLE B.5. (contd)

Barnwell Rate Schedule

Effective January 1, 1993

E. Cask Handling Fee	\$1,795.00 per cask, minimum
F. Special Nuclear Material Surcharge	\$8.15 per gram
G. Barnwell Surcharge	2.4%
3. MISCELLANEOUS:
- A. Transport vehicles with additional shielding features may be subject to an additional handling fee which will be provided upon request.
 - B. Decontamination services (if required): \$150.00 per man-hour plus supplies at current Chem-Nuclear rate.
 - C. Customers may be charged for all special services as described in the Barnwell Site Disposal Criteria.
 - D. Terms of payment are NET 30 DAYS upon presentation of invoices. A service charge per month of 1-1/2% shall be levied on accounts not paid within thirty (30) days.
 - E. Company purchase orders or a written letter of authorization in form and substance acceptable to CNSI shall be received before receipt of radioactive waste material at the Barnwell Disposal Site and shall refer to CNSI's Radioactive Material Licenses, the Barnwell Site Disposal Criteria, and subsequent changes thereto.
 - F. All shipments shall receive a CNSI allocation number and conform to the Prior Notification Plan. Additional information may be obtained at (803) 259-3577 or (803) 259-3578.
 - G. This Rate Schedule is subject to change and does not constitute an offer of contract which is capable of being accepted by any party.
 - H. A charge of \$12,650.00 is applicable to all shipments which require special site set-up for waste disposal.
 - I. Class B/C waste received with chelating agents, which requires separation in the trench, may be subject to a surcharge if Stable Class A waste is not available for use in achieving the required separation from other wastes.

TABLE B.5. (contd)

Chem-Nuclear Systems, Inc.

Attachment 1

Barnwell Low-Level Radioactive Waste Management Facility
1993 Disposal Pricing

1. Base Disposal Charges Refer to Rate Schedule effective January 1, 1993
2. Surcharges
 - A. Weight Surcharges Refer to Rate Schedule effective January 1, 1993 for weights under 50,000 lbs

<u>Weight Surcharges for Shielded Shipments >50,000 lbs</u>	<u>Weight Surcharge Per Shipment</u>
> 50,000 - 60,000	\$ 7,350.00
> 60,000 - 70,000	\$ 8,950.00
> 70,000 - 80,000	\$ 10,500.00
> 80,000 - 90,000	\$ 12,100.00
> 90,000 - 100,000	\$ 13,700.00
 - B. Curie Surcharges for Shielded Shipment
(up to 1,000 curies) Refer to Rate Schedule effective January 1, 1993

<u>Curie Content per Shielded Shipment</u>	<u>Curie Surcharge Per Shipment</u>
> 1,000 - 5,000	\$57,500.00
> 5,000 - 10,000	\$71,900.00
> 10,000 - 20,000	\$97,800.00
> 20,000 - 30,000	\$120,800.00
> 30,000 - 40,000	\$149,500.00
> 40,000 - 50,000	\$172,500.00
3. Class B/C Waste Polyethylene High Integrity Container Surcharge Refer to Rate Schedule effective January 1, 1993

TABLE B.5. (contd)

Chem-Nuclear Systems, Inc.

4. Cask Handling Fee

<u>Cask Type</u>	<u>Price</u>
NFS-4, NAC-1	\$ 11,800.00
NL 1/2 (when approved for horizontal offload)	\$ 11,800.00
AP101	\$ 11,800.00
FSV-1	\$ 14,900.00
CNS 3-5	\$ 12,600.00
TN8L	\$ 23,700.00
TN RAM	\$ 14,900.00

Cask handling fees shown above are applicable only for these casks listed. Special pricing for non-routine handling or for casks not listed is available by special request.

5.	Special Nuclear Material Surcharge	Refer to Rate Schedule effective
January 1, 1993
6.	Barnwell Surcharge	Refer to Rate Schedule effective
January 1, 1993

Additionally, Section 3 from our published rate schedule, entitled "Miscellaneous," Item H may also apply (due to the high radiation levels of the liner) if special disposal site set-up provisions must be made prior to cask off-loading and waste disposal. Disposal of low-level radioactive waste will be charged in accordance with the current Barnwell Low-Level Radioactive Waste Management Facility Rate Schedule in effect at the time of disposal.

NOTE 1: The above pricing schedule does not include the Southeast Compact Commission Access Fee of \$220.00/ft².

NOTE 2: This pricing is effective January 1, 1993; and is subject to change upon notification to Battelle by Chem-Nuclear.

B.7.3 Costs for Mixed Waste Disposal

Firm cost estimates for offsite services concerning disposal of solid mixed LLW were not obtained, since such services are not currently available in the U.S. No offsite disposal or treatment facility for mixed waste has been available since 1985. However, joint regulation by both the NRC and the EPA is expected to make the unit cost of disposing of mixed waste much higher than the cost of disposing of other low-level wastes. Utilities are finding ways to treat some of their mixed waste so that it is no longer a chemical hazard, thus making it possible to dispose of the radioactive component along with other LLW. The remainder of mixed waste, however, is currently stored onsite.^(11,12)

An August 1991 Nuclear Waste News article reported: "Complications attending mixed waste disposal are expected to yield massive disposal costs, which are likely to rise still further as generators, seeking to avoid costs as high as \$20,000 per cubic foot, cut their mixed waste output drastically, thereby pushing up costs for the remaining waste."⁽¹³⁾

For this study, the ultimate cost of disposal of mixed wastes (either liquid or solid) expected to be present on the reference BWR site at final shutdown is considered to be an operational cost, since the majority of such wastes are postulated to be generated during operation of the plant. It should be recognized, however, that regardless of when solid mixed LLW is generated, commercial treatment, storage, and disposal services for the waste are currently quite limited. Based upon the aforementioned projected disposal costs and upon the uncertainties surrounding the ultimate disposition of solid mixed wastes, it is assumed further that implementation of waste minimization techniques used during the operating years of the plant will also be used during decommissioning. Therefore, only a relatively small amount, if any, of additional solid mixed LLW is assumed to be generated during decommissioning of the reference BWR. Additional information concerning mixed wastes can be found in Appendix H.

B.8 COSTS OF SERVICES, SUPPLIES, AND SPECIAL EQUIPMENT

Various types of services and supplies are required for decommissioning the reference BWR. The estimated unit costs of the major items are discussed here. The estimated unit costs for special equipment items anticipated for use during decommissioning are summarized in Table B.6.

TABLE B.6. Special Tools and Equipment Costs

Item	Estimated Number Required	Estimated Unit Cost (\$000)
Remote manipulator for under- water, in-vessel cutting	1	1,102.5
Underwater plasma-arc cutting system	2	77.2
Cutting table, plus jigs	1	33.0
Oxyacetylene cutting system	1	3.3
Plasma-arc equipment	2	33.0
Track-mounted drive unit	4	4.4
Drum compactor	2	47.4
Closed circuit, high-resolution television	(plant equip.)	55.1(a)
High-pressure water jet	1	176.4(b)
Kelly Decontamination System	3	186.0(c)
Underwater lights, viewing windows/periscope	As required	11.0
Submersible pumps with disposable filter	3	6.6
Power-operated, mobile, scissors-type manlift (Sky Climber™, Series 47)	4	38.6
Genie Zoom-Boom™ manlift, 45-ft	1	52.9
Bobcat front-end loader (highly maneuverable, light-duty)	2	19.8
6818-kg forklift	3	99.2(d)
9100-kg mobile hydraulic crane	2	40.8
Safety nets	As required	50.7
Polyurethane foam generator	2	9.9
Wall-saw (35 h.p.) w/power unit	2	22.1
Slab-saw (35 h.p.)	2	4.4
Concrete drill with HEPA-filtered dust collection system	4	4.4
Concrete surface spaller	4	9.9
Portable ventilation enclosure	10	3.3
Vacuum cleaner (HEPA-filtered)	3	9.9
Filtered-exhaust fan unit	4	7.7
Water vacuum	4	~1.0
Core drill stand	4	16.8
Water hose (300 feet)	4	~1.0
Hydraulic hose (200 feet)	4	6.3

(a) Estimated for modifications of existing systems.

(b) System includes floor surface wand, tank interior wand, and compressor unit.

(c) Manufactured by Container Products Corporation. The unit cost shown includes 1 week of training in the use of the equipment.

(d) Assumes the availability of two forklifts from plant operations.

Energy Costs

Electricity - A principal services cost item is electric power. Based upon discussions with WPPSS personnel, it is estimated that electrical replacement power costs would probably be provided to WNP-2 by the Bonneville Power Administration at the preferred customer rate of \$0.027/kWh, or \$27/MWh.

During an 11-month outage that ended in February 1992, with about 1,000 people onsite, a Northwest PWR (Trojan) was reported to have an average site electricity consumption of about 5 MW. A significant portion of the electricity was used for heating, air conditioning, lights, etc. A similar inquiry to Trojan on October 7, 1993, 11 months after permanent shutdown of the plant, concerning their average site consumption for their current possession-only status (i.e., with less than 300 people onsite and all fuel stored in their fuel pool) revealed an average site consumption of about 4 MW.

For this study, the estimated electrical usage at the reference BWR, during periods of active decommissioning, is based upon a reevaluation of the rigorous analyses concerning energy requirements conducted previously in NUREG/CR-0672.⁽¹⁾ The results of that reevaluation are given in Table B.7.

It is interesting to note that reevaluation results indicate a peak base load at the reference BWR of approximately 4 MW, revealing a good correlation to the aforementioned similar-size plant currently in a permanent shutdown condition.

By using the electricity consumption values presented in Table B.7 for periods of active decommissioning, and by following the appropriate schedule for a specific decommissioning alternative, the power usage by month after shutdown is estimated. In addition, the costs for energy used during system decontamination and draining and radioactive liquid handling are given separately in Appendix G.

Oil - At the reference BWR, fuel oil is burned in an auxiliary boiler to provide heating steam to the power block buildings. The unit cost of #2 diesel fuel for the boiler is \$1.27/gal, in 1993 dollars, based upon information provided by the supplier of the fuel to the reference plant. Based upon

TABLE B.7. Estimated Electricity Usage During Decommissioning^(a)

<u>System(s) or Equipment</u>	<u>Estimated Energy Usage (MWh/month)</u>
<u>HVAC</u>	
Main Buildings:	
Reactor/Primary Containment	366
Reactor	512
Turbine Generator	578
Radwaste & Control ^(b)	315
Control Tower ^(c)	27
Other Buildings ^(c)	169
<u>Lighting</u>	
Reactor Bldg.	84
Turbine Generator Bldg.	84
Radwaste & Control Bldg.	84
Auxiliary Bldgs. ^(d)	28
<u>Communications</u>	9
<u>Security</u>	59
<u>Fire Protection</u>	3
<u>Compressed Air</u>	55
<u>Cranes & Hoists:</u>	
Reactor/Primary Containment	34
Turbine Generator Bldg.	6
Radwaste Area	2
<u>Domestic Water</u>	379
<u>Decommissioning Equipment</u>	140
Total	2,934 (~4.1 MW load)

(a) The energy values shown in the table are based upon a reevaluation of the rigorous analyses concerning electrical requirements for DECON as delineated in NUREG/CR-0672.⁽¹⁾

(b) Radwaste area only.

(c) Includes Standby Service Water Pumphouse, Make-up Water Pumphouse, Diesel Generator Building, Service Building, Machine Shop, and Water Treatment Areas.

(d) Includes Office Building, Warehouse, Guardhouse, and Gas Bottle Storage Building.

a review of plant records, fuel oil for heating (as a supplement to reactor-generated energy used for heating) was consumed at an average rate of about 115,170 gallons/year for the period 1990 through 1992.^(d) However, during periods of active decommissioning evaluated in this study, it is postulated that the auxiliary boiler will be required for a total of 131 days per year to meet the heating requirements at the reference plant. An estimated consump-

(d) Letter, Neil D. Zimmerman, Washington Public Power Supply System, to George J. Konzek, Battelle Northwest, transmitting reference plant diesel fuel consumption at WNP-2, dated October 11, 1993.

tion rate of about 90 gallons per hour results in an annual consumption rate of 282,960 gallons (131 days x 24 hrs/day x 90 gal/hr). At \$1.27/gal, this results in an estimated annual cost of \$359,360 for fuel oil.

Protective Clothing and Equipment Services

Protective clothing and equipment services are anticipated to be provided by an offsite subcontractor, as required, at an estimated cost of \$21 per day per person, based upon discussions with industry personnel.

Hanford Site Support Services

On the Hanford site, which is controlled by the U.S. Department of Energy, contractors and subcontractors obtain services from the Operations and Maintenance contractors for the movement of large objects, such as the turbine rotors, to the low-level waste burial ground. Included in the cost of these services are road preparation and maintenance, utilities, fire protection, security, patrol, transportation, medical aid, etc. Based upon discussions with industry contacts, these services, including labor, equipment, and materials, are estimated to cost about \$132,300 per trip.

Material Costs

Material costs are a function of the size of the piping/tank/equipment being dismantled. Principal components are absorbent materials, plastic sheeting and bags, and gases for torches. The quantities and unit costs used in these analyses are listed below.

Material	Piping			Tanks
	0-2 in. dia	2-14 in. dia.	32-47 in. dia.	1/2 in. tank wall
Abs. Matl. @ \$0.32/ft ²	10 ft ² \$3.20	15 ft ² \$4.80	20 ft ² \$6.40	length x dia. x \$0.32
Plastic @ \$0.04/ft ²	25 ft ² \$1.00	37.5 ft ² \$1.50	50 ft ² \$2.00	length x dia. x \$0.04
Gases @ \$6.75/hr	0.017 hr \$0.11	0.033 hr \$0.22	0.33 hr \$2.23	Hours of cut x \$6.75
	\$4.32/cut	\$6.52/cut	\$10.63/cut	As calculated per tank
Including 15% DOC profit:	\$4.97/cut	\$7.50/cut	\$12.22/cut	1.15 x As calculated per tank

Small Tools and Minor Equipment

In decommissioning, the cost for small tools and minor equipment is often difficult to estimate. Many of these tools will become contaminated and ultimately will be disposed of by burial. The 1993 edition of R. S. Means⁽²⁾ recommends a maximum allowance of 2% of the contractor's direct labor cost. For, say, \$10 million of direct labor costs, 2% would be roughly \$200,000. Further assuming an average small tool were to cost \$1,100 (e.g., small chain hoists, saws, drills, oxyacetylene torches, sets of hand tools, etc.), the decommissioning operations contractor (DOC) would purchase approximately 180 tools for the crews.⁽¹⁴⁾ This appears to be in the appropriate range for decommissioning work. Therefore, a 2% allowance for these items is incorporated into the cost calculations for the small tools and minor equipment.

Blades Used for Cutting Concrete

The unit cost for blade material is estimated at \$0.44/in.-ft of cut.

Scaffolding

Based upon discussions with WNP-2 plant personnel, sufficient scaffolding and associated equipment is kept in several staging areas onsite, to meet their needs during reactor outages. In addition, the supply of scaffolding is replenished as required. Therefore, the reference plant's inventory of scaffolding is deemed sufficient to meet anticipated decommissioning requirements.

B.9 PROPERTY TAXATION^(e)

The Washington Public Power Supply System was organized in 1957 by Washington public utility districts under state legislation as a municipal corporation and joint operating agency to enable public utilities to finance, construct, and operate major electric generating facilities, including WNP-2. WPPSS has no taxing authority and is exempt from property taxes for WNP-2 under Washington state law. WPPSS does pay a WNP-2 generating tax in lieu of property taxes; however, these taxes will cease upon final shutdown of the plant.

(e) Property taxes are commonly referred to as collateral or undistributed costs. Such costs can extend over one or more decommissioning periods. Thus, these expenses can be expected to continue following final shutdown and during the dormancy periods of safe storage or entombment, until the possession-only license is terminated. While the property taxes will continue to be assessed after the license is terminated, these costs will no longer be considered decommissioning costs.

It should be recognized that the property tax situation described in this appendix is predicated on site-specific information. Therefore, the conclusions reached herein concerning impacts on decommissioning costs for the reference BWR may not be the same for other BWR power stations.

B.10 NUCLEAR INSURANCE COSTS

The 1978 nuclear insurance costs given in NUREG/CR-0672⁽¹⁾ were originally developed in 1975 based upon information provided by American Nuclear Insurers (ANI).^(f) Cost projections for this commitment have increased significantly since then. In addition, cost estimates in the 1978 time frame typically only included insurance premiums associated with nuclear liability policies. More recent information, obtained from industry personnel and their brokers, suggests that additional insurance coverage will be needed to limit owner liability immediately after final shutdown, during subsequent decommissioning and dismantling operations, and for a prudent period of time following termination of the possession-only license.

The estimated nuclear insurance costs used in this study are based on information provided by Johnson & Higgins of Arizona, Inc. Johnson & Higgins has indicated that "the task of estimating post-shutdown insurance costs for the reference facility is made easier by the fact that they have had several years of experience placing insurances for a commercial facility which has been shut down for decommissioning. Once actual plant dismantlement begins, however, we can only look to information which the insurers have provided for guidance. No commercial reactor of this size and type has yet undergone the complete decommissioning process."^(g)

A summary of the estimated total post-shutdown insurance costs, by stage, is presented in Table B.8. The bases for the values shown in the table are developed in subsequent sections.

(f) ANI is a voluntary unincorporated association of stock insurance companies which provides property and liability insurance protection to the nuclear energy industry. ANI is one of three pools - a pool is a group of insurance companies that together provide resources to insure risks which are beyond the financial capability of a single company.

(g) Letter, Daniel S. McGarvey, Johnson & Higgins of Arizona, Inc., to George J. Konzek, Battelle Northwest, transmitting reference plant decommissioning cost projections, dated March 16, 1993.

TABLE B.8. Summary of Estimated Post-Shutdown Insurance Costs in 1993 Dollars

Stage	Cost, Category	
	Decommissioning Cost, \$(a)	SNF Management Cost, \$(a,b)
Transition (first 1.2 years following shutdown, until receipt of Property Rule waiver)	3,195,120 ^(c)	
Following general plant layup preps and receipt of Property Rule waiver	0	1,107,600/year
Extended Safe Storage with the fuel pool empty	600,000/year	0
During periods of active decommissioning	1,198,600/year	0
After termination of the possession-only license	17,250/year	0

- (a) The number of figures shown is for computational accuracy and does not imply precision to that many significant figures.
- (b) Shown for completeness; these costs are not decommissioning costs.
- (c) Following shutdown, about 1.2 years of decommissioning activities are postulated (e.g., chemical decontamination of the selected reactor piping systems, cutting and packaging of the reactor pressure vessel internals, etc.); therefore 1.2 x \$2,662,600/year premium, or about \$3,195,120 is attributable to decommissioning operations. Following cessation of the initial decommissioning operations, all of the insurance costs are postulated to be attributable to SNF management operations until: 1) active decommissioning operations begin again in about 3.4 years or 2) extended safe storage commences.

B.10.1 Assumptions

The estimated property damage insurance and nuclear liability insurance costs presented in this study are based upon the following assumptions provided by Johnson & Higgins:

1. The reference plant is insured by ANI for primary property insurance, and carries full limits of property, liability, and business interruption coverage. This is a significant assumption, in that the reactor plant selected as the reference facility does not purchase several coverages which would typically be carried by a single unit site of reference capacity. As a quasi-governmental entity, the reference facility owner enjoys greater flexibility in risk retention than a public utility. To allow these premium projections to have broader applicability to the "typical" single unit site, the following coverage amounts and premium levels are assumed:

<u>Coverage</u>	<u>Limit</u>	<u>Annual Premium</u>
ANI Excess Property	\$800,000	\$1,450,000
NEIL I Business Interruption	\$3,500,000/week	\$1,000,000
ANI Suppliers & Transportation	\$200,000,000	\$27,000

2. For consistency of applicability, it is further assumed that the reference plant has an engineering rating factor (ERF)^(h) of 1.00, and enjoys no credit advantage through ANI's individual experience modifier.
3. The shutdown reactor is defueled completely to the spent fuel pool and is granted a waiver of Property Rule insurance limit requirements as have other decommissioning facilities to date. This waiver can be expected to require from one year to eighteen months to obtain.

Note: For this study, it is conservatively estimated to take 1.2 years, after shutdown, to receive the waiver.

4. With the waiver granted, a \$200 million limit of Property Damage insurance is determined to be sufficient to protect essential cooling, monitoring, and defueling systems. This is a conservatively high figure when viewed against those in place at current decommissioning facilities, and assumes that plant conversion or other use of site assets are not anticipated.
5. A \$300 million limit in Excess Decontamination insurance is determined to be the appropriate amount required to respond to the worst postulated post-shutdown accident. Again, this amount is conservatively selected.
6. Credits of forty percent (40%) and fifty percent (50%) are applied to ANI primary Property and Liability premiums, respectively, to recognize the permanently shutdown nature of the plant. These credits are extended fifty percent up front, and fifty percent at policy year end subject to safe plant operation and acceptable loss prevention efforts.
7. Nuclear Electric Insurance Limited, NEIL I coverage (business interruption)⁽ⁱ⁾ is immediately suspended following plant permanent shutdown. A loss recovery under NEIL I is not technically feasible for a plant which has permanently ceased power generation.
8. Immediately following plant shutdown, property insurance levels are reduced to the minimum (\$1.06 billion) required by the Property Rule (10 CFR 50.54(w)). The \$560 million first excess layer is met through NEIL

(h) The rating factor is a premium multiplier, based upon the insurance company's evaluation for rating the perceived safety and risk.

(i) Nuclear Electric Insurance Limited is an industry self-insurance corporation organized in 1980 for the purpose of providing protection for power replacement costs when a reactor has suffered an outage caused by an accident. Since then, NEIL has initiated a second type of insurance coverage (NEIL II) that provides property damage excess coverage. The NEIL II coverage provides a second layer of insurance up to a specified maximum that tracks the primary coverage that a utility has with another insurer.

II coverage versus ANI excess because it is less costly and offers dividend potential.

9. NEIL II Excess property coverage is provided at fifty percent of pre-shutdown cost following plant defueling. This is consistent with traditional NEIL shutdown credits.
10. The price per million of Excess Decontamination coverage is approximately forty percent (40%) of full Property Damage coverage, as has been recently observed.
11. A \$1 million deductible level is selected. This is consistent with current ANI minimum decommissioning deductible requirements. The reference plant has traditionally selected a higher deductible level. All premium assumptions contained herein are based upon the \$1,000,000 deductible. A \$200 million level of Suppliers' and Transporters' (S&T)^(j) coverage is maintained in anticipation of a large number of radiological shipments during preliminary decommissioning process.
12. Insurance pricing during the first few months after shutdown is not substantially reduced, save for the extension of traditional shutdown credits.
13. A full \$200 million level of Facility Form^(k) (nuclear liability) coverage, as well as participation in the Secondary Financial Protection and Worker Form programs, is required throughout the decommissioning process.
14. Scheduled reductions for Property and Liability coverages proceed according to these rough guidelines, which have been obtained over time from ANI:

Property

<u>Stage</u>	<u>Percent Reduction</u>
Shutdown for Decommissioning	20 - 40
Plant defueled offsite	50 - 67
Plant defueled onsite	40 - 50

Liability

<u>Stage</u>	<u>Percent Reduction</u>
Shutdown for Decommissioning	40 - 60
Fuel offsite (if option available)	50 - 70
Decommissioning and Decontamination Operations	20 - 40

(j) S&T is Nuclear Liability Suppliers and Transporters Form that provides third party liability protection in amounts up to \$200 million for bodily injury or property damage resulting from specific nuclear perils; S&T is generally utilized by companies who supply parts, equipment, materials, services, and transportation to owners and operators of nuclear facilities.

(k) An insurance company evaluation for rating the perceived safety and risk.

15. Finally, total pre-shutdown nuclear insurance expenses are approximately \$7 million per year.

B.10.2 Predictions for the Annual Costs of the Insurance Program for the Reference BWR Following Final Shutdown

On the basis of the aforementioned assumptions, the following predictions are made for the annual cost of the insurance program from final shutdown to Property Rule waiver receipt:

<u>Property</u>		<u>Liability</u>	
Primary Property	\$1,700,000	Facility Form	\$ 395,000
(\$500 million ANI)		S&T Policy	\$ 27,000
Excess Property	\$ 510,000	Worker Form	\$ 23,100
(\$560 million NEIL)		SFP	\$ 7,500
Program Total:			\$2,662,600/yr

Following defueling to the spent fuel pool, completion of general plant layup preparations, and receipt of the Property Rule waiver, the annual premium is projected to be:

<u>Property</u>		<u>Liability</u>	
Primary Property	\$ 490,000	Facility Form	\$ 290,000
(\$200 million ANI)		S&T Policy	\$ 27,000
Excess Property	\$ 270,000	Worker Form	\$ 23,100
(\$300 million ANI)		SFP	\$ 7,500
Program Total:			\$1,107,600/yr

From this point forward, premiums will likely fluctuate according to the level of activity onsite. During periods of active decommissioning and dismantlement, for instance, the annual insurance costs could be adjusted to:

<u>Property</u>		<u>Liability</u>	
Primary Property ⁽¹⁾	\$ 350,000	Facility Form	\$431,000
		S&T Policy ^(m)	\$ 27,000

(1) Limit would likely be lowered to account for reduction in property value and required core defueling/monitoring equipment. This example assumes coverage is lowered from \$200 to \$100 million.

(m) Assumes limit is maintained at \$200 million in anticipation of continued shipping exposure.

Excess Decontamination \$ 360,000

Worker Form
SFP

\$ 23,100
\$ 7,500

Program Total:

\$1,198,600/yr

As selected pieces of equipment are removed, the spent fuel pool defueled, the workforce reduced, and low-level waste shipments slow, a site figure of \$600,000 annually is believed to represent a good approximation of a reasonable safe storage premium level.

These figures assume a relatively conservative risk management philosophy. A utility seeking to aggressively lower plant operating expenses may opt to lower premiums more sharply by reducing the amount of coverage purchased. As can be seen from these projections, the reduction in insurance expenses for a single-unit site following planned permanent cessation of operations can be significant.

In addition, the reference BWR's premium projections are now being tempered by a number of the following stipulations and/or caveats that could further modify, or at worst, preclude premium credit consideration for any or all stages of the decommissioning and decontamination of the reactor:

- Nuclear insurance premium projections are based upon the assumption that the reference BWR's "retirement" is due to the expiration of the usual 40-year operating license and not due to an "incident" of any kind.
- Any premium credit would be contingent upon the evaluation and approval of both the NRC and nuclear liability engineering representing the insurer(s) relative to each stage of decommissioning and decontamination.
- The specific Facility Form Engineering Rating Factor of the reference BWR's retirement may differ substantially from that of a similar reactor due to the procedures involved, the number of contractor personnel onsite, whether or not spent nuclear fuel is stored onsite, etc.

It should be recognized that final ratings, with respect to a specific reactor's retirement, would be promulgated by the respective Insurance Services Office. For example, ANI has established and applied a risk assessment program to decommissioning activities at a variety of insured nuclear facilities. This risk assessment begins at the planning stages and continues

throughout the decommissioning effort. This program is primarily based upon an engineering evaluation of the adequacy of performance in the major areas of nuclear safety, quality assurance, and documentation. Thus, the results of the engineering assessment can affect the level of premium assessed and the rate of change of premium during decommissioning.

B.10.3 Summary of the Estimated Costs of Insurance Following Permanent Cessation of Operations

The total insurance costs for the first 1.2 years following shutdown of the reference BWR (i.e., the "transition period" pending receipt of a waiver of Property Rule limit requirements) are estimated to be about \$3.2 million. Following defueling to the spent fuel pool, completion of general plant layup preparations, and receipt of the Property Rule waiver, the annual premium is projected to be \$1.1 million. Subsequent premiums will likely fluctuate according to the level of activity onsite. It is postulated that the nuclear liability insurance costs covering the 3.4-year period of safe storage with concurrent SNF storage in the reactor spent fuel pool are allocated 10% to decommissioning and 90% to SNF management operations during that period. Upon reduction of the SNF inventory to zero and commencement of active decommissioning, subsequent insurance costs for the reactor facility are attributable to decommissioning operations, with a separate cost for the onsite independent spent fuel storage installation (ISFSI).

During periods of active decommissioning and dismantlement, the annual insurance costs could rise again to about \$1.2 million per year. The reduction in estimated insurance expenses for the reference BWR following a planned permanent cessation of operations is significant compared with the operating level premiums.

B.10.4 Estimated Costs of Insurance Following Termination of the Possession-Only License

For this study, \$5 million in nuclear liability insurance is postulated to be carried for 30 years following termination of the possession-only license, at an estimated annual cost of \$17,250. This lower insurance coverage for this relatively small annual premium is deemed prudent, since it

provides "discovery term"⁽ⁿ⁾ protection for the insured covering the entire life of the policy, plus 10 years after cancellation of the policy. It should be recognized, however, that liability is limited to whatever amount of insurance was in effect during the period for which a claim might be made - i.e., the period covering the operating years, the period following permanent cessation of operation, the decommissioning period, and the 30 years (in this case) following termination of the possession-only license. In summary, what this means is that upon cancellation of the policy, the clock starts ticking on the 10-year discovery term for any claims that might be made covering the lifetime of the policy (as defined above), but after the 10 years have elapsed, no claims against the policy can be made. Again, it should be recognized that any change in credit of the normal operating premium would need approval by the NRC and the nuclear liability pools.

B.11 LICENSE TERMINATION SURVEY COSTS

In order to terminate the reference BWR's license, the NRC must determine that release of the facility and site for unrestricted use (i.e., without the need for future radiological controls) will not constitute an unreasonable risk to the health and safety of the public. To make such a determination, there must be evidence to show that radiation levels of the facility, site, and adjacent environs permit release for unrestricted use.

The release criteria that the NRC has been using for license termination include those found in the following:

- Regulatory Guide 1.86, Termination of Operating Licenses for Nuclear Reactors (NRC 1974),
- Guidelines for Decontamination of Facilities and Equipment Prior to Release for Unrestricted Use or Termination of Licenses for Byproduct, Source, or Special Nuclear Materials (NRC 1987), Office of Nuclear Material Safety and Safeguards (NMSS), and

(n) Under certain bonds and policies, provision is made to give the insured a period of time after the cancellation of a contract in which to discover whether a loss has been sustained that would have been recoverable had the contract remained in force. This period varies, and the company can fix the period of time to be allowed. This period may also be determined by statute; in certain bonds, it is of indefinite duration because of such statutory requirement.

- Branch Technical Position for Disposal or Onsite Storage of Thorium or Uranium Water from Past Operations (46 FR 52061, October 23, 1981).

In addition, the decommissioning rule⁽¹⁵⁾ requires submittal of a final radiation survey plan as part of the decommissioning plan. Plans for a termination survey^(o) should be designed to provide evidence, with a high degree of assurance, that residual radioactive contamination levels will meet criteria for release for unrestricted use. A termination survey plan should also be designed so that procedures, results, and interpretations can be verified by the NRC staff.

Currently, the NRC has a draft guidance manual, NUREG/CR-5849,⁽¹⁶⁾ for conducting radiological surveys in support of license termination. This manual updates information contained in NUREG/CR-2082,⁽¹⁷⁾ and provides guidance for licensees on conducting radiological surveys of their facilities and sites to demonstrate that residual radioactive contamination levels, as derived from NUREG/CR-5512,⁽¹⁸⁾ meet NRC criteria for unrestricted use.^(p) The guidance emphasis in NUREG/CR-5849 is on the termination survey, which should demonstrate that the facility and site meet the criteria for unrestricted use.

The NRC requires that the termination survey be performed in a manner that assures the results are complete and accurate. Surveys are to be performed by trained individuals who follow standard, written procedures. Properly calibrated survey instruments, sensitive to the identified contaminants at levels specified in the NRC decommissioning criteria, should be used. The custody of samples must be tracked from collection to analysis. Data must be recorded in an orderly and verifiable way and must be reviewed for accuracy and consistency. Every step, from training of personnel to the calculation and interpretation of the results, must be documented in an auditable manner. These requirements are achieved through a formal program of quality assurance and quality control (QA/QC). The draft manual, NUREG/CR-5849, provides

(o) This survey is known by several titles, including termination survey, post remedial-action survey, final status survey and final survey. The term termination survey is used in this study.

(p) NUREG/CR-5512 provides a technical basis for translating contamination levels in buildings and land/soil to annual dose. It presents scenarios for individual exposure to residual contamination, pathway of exposure, modeling and dose calculations.

acceptable approaches for: 1) survey planning and design, 2) radiological instrumentation, 3) survey techniques, 4) laboratory procedures, 5) interpretation of survey results, and 6) survey documentation and reports.⁽¹⁹⁾

The needs of both licensee and inspector for design of their respective final surveys, having somewhat divergent objectives, should be kept in mind. One is an integral part of the other insofar as the licensee's final information is input to the inspector's final survey design for verification of the licensee's compliance. Therefore, the survey plan prepared by the licensee (or his survey contractor, as assumed in this study)^(q) should be reviewed by the certification inspector prior to initiation of the licensee's final survey. It should be anticipated that the certification inspector will emphasize review of the analytical techniques, quality assurance measures, and statistical bases for sampling. In turn, the licensee's survey contractor should carefully consider the incorporation of comments offered by the certification inspector. This early agreement should minimize the need for a completely independent survey by the certification inspector.⁽¹⁷⁾

The estimated cost of the termination survey for the reference BWR is based upon 1) the reference BWR plant facilities shown in Figures B.1 through B.4, and 2) the information in draft NUREG/CR-5849 and NUREG/CR-2082.

(q) To the extent that monitoring requires hardware (analysis equipment, calibration standards, supplies, etc.) as contrasted with services (computer programming, data storage and analysis routines, interpretation, etc.), selected elements of a quality assurance program on monitoring for compliance with decommissioning criteria--e.g., control of measuring and test equipment, control of special processes such as sampling procedures and statistical models, corrective action, etc.--may not apply to the extent that physical aspects of the monitoring program are contracted out to a specialized company with the hardware. Quality assurance of these categories then becomes the primary responsibility of the contractor or subcontractor. However, the site owner is jointly responsible for QA on the final results, namely compliance with the decommissioning criteria.⁽¹⁷⁾

FIGURE B.1. Site Layout of the Reference BWR Plant Facilities - Sheet 1

S9312044.4

FIGURE B.4. Site Layout of the Reference
BWR Plant Facilities - Sheet 4 -

S9312044.3

FIGURE B.3. Site Layout of the Reference BWR Plant Facilities - Sheet 3

S9312044.2

FIGURE B.2. Site Layout of the Reference
BWR Plant Facilities - Sheet 2

Although the latter document used a reference PWR (Trojan) as the model for development of the methodology presented therein, it proved useful in developing the cost estimate for the reference BWR's termination survey. The total estimated cost of the final termination survey for the reference BWR is about \$1.06 million, including about \$0.175 million in NRC-related costs for the confirmation survey. The elemental costs of the survey are presented in Table B.9. Brief discussions/derivations of the survey-related costs shown in the table are presented following the table.

TABLE B.9. Summary of Estimated Costs for the Termination Survey

<u>Entity</u>	<u>Cost Element</u>	<u>Estimated Cost, \$</u> ^(a)
Licensee	Labor	
	Drafting grid maps to scale	33,904
	Layout of grid networks	213,837 ^(b)
	Radiological survey	557,644 ^(c)
	Report preparation	16,125 ^(d)
	Office materials	2,500 ^(e)
	Services	
	Drilling (auger, coring, restoration)	11,484 ^(f)
	Land surveying	14,138 ^(f)
	Analytical	33,712 ^(g)
	Subtotal, Licensee	883,344
NRC	Confirmation survey	<u>175,000</u> ^(h)
Total		1,058,344

(a) The number of figures shown is for computational accuracy and does not imply precision to that many significant figures.

(b) Based on Tables B.10 and B.11.

(c) Includes the estimated direct labor costs of \$389,038, per diem costs of \$151,606 and \$17,000 in travel costs.

(d) Based on Table B.14.

(e) Exclusive of instruments and equipment.

(f) Study estimate based on information contained in Reference 17.

(g) Instrumented mobile laboratory (see text for details).

(h) Study estimate based on information provided by industry contacts.

The following preparatory work is necessary to complete the termination survey(s):

- Reference grid systems (i.e., grid drawings to scale) ^(r) are developed for subsequent use by the licensee and by the radiological contractor who will ultimately conduct the termination survey. It is estimated

(r) System of coordinates established on a site for purposes of referencing survey locations.

that this task will require two draftsmen for 13 weeks at a cost of \$33,904:

$$(13 \text{ wks} \times 40 \text{ hrs/wk} \times \$32.60/\text{hr}) \times 2 = \$33,904$$

- Using the grid drawings, layout of grid networks (i.e., identification, measurement, painting, and associated paperwork) is completed for all floors, roofs, walls and ceilings, as applicable, according to appropriate survey protocol. No radiation dose is anticipated for these tasks. Work on the upper walls and ceilings may require the use of special equipment, such as manlifts or scaffolding, while work on the floors and roofs is not anticipated to require such equipment. For the purpose of this study, it is assumed that the clean scaffoldings used for previous decommissioning operations have been left in place for layout of grid networks and for subsequent use by the survey contractor.

Table B.10 gives the postulated crew size and cost for layout of grid networks for affected and unaffected areas^(s) that are used in this study. Based upon NUREG/CR-5849, no scans are necessary for unaffected upper walls and ceilings. Only direct measurements (DMs) are taken, at the rate of one DM per 50 m² of surface area, with a minimum of 30 DMs per building recommended. Therefore, for the purpose of this study, it is estimated that a crew can accomplish grid marking of these surfaces for subsequent DMs at an average rate of 10 grid locations per hour, during an 8-hour shift.

TABLE B.10. Staffing and Labor Rates for Survey Gridding Crews

<u>Pers-hrs/crew-hr</u>	<u>Category</u>	<u>Labor Rate (\$/pers-hr)</u>	<u>Cost^(a) (\$/crew-hr)</u>
2.0	Laborer	26.37	52.74
1.0	H. P. Tech.	36.82	-- ^(b)
0.5	Crew Leader	54.84	27.42
3.5			80.16
Average labor cost, 2-shift operations			\$84.17 ^(c)

(a) Includes 110% overhead, 15% DOC profit.

(b) Part of DOC overhead staff. Labor costs appear in undistributed cost.

(c) 10% shift differential for second shift.

- (s) Affected areas are areas that have potential radioactive contamination (based on plant operating history) or known radioactive contamination (based on past or preliminary radiological surveillance). This would normally include areas where radioactive materials were used or stored, where records indicate spills or other unusual occurrences that could have resulted in spread of contamination, and where radioactive materials were buried. Areas immediately surrounding or adjacent to locations where radioactive materials were used or stored, spilled, or buried are included in this classification because of the potential for inadvertent spread of contamination. Unaffected areas are areas not classified as affected. These areas are not expected to contain residual radioactivity, based on a knowledge of site history and previous survey information.⁽¹⁶⁾

Analysis of Work Durations and Available Time

The basic assumptions about lost work time per shift are as follows:

- The crews work 8-hour shifts,
- The crew members take two 15-minute breaks per shift, together with an estimated 15 minutes each break allowed for travel time to and from the work-place, and
- The crew members devote 25 minutes per shift to work-related activities, e.g., the days' activities, industrial safety protection guidance, etc.

Thus, a total of $30 + 30 + 25 = 85$ crew-minutes are lost from each 8 hr. shift, leaving a total of $480 - 85 = 395$ crew-minutes available for productive work. These non-production time factors are:

$$[1 + (30/395) + (30/395) + (25/395)] \times 395 = 480$$

$$[1 + 0.0759 + 0.0759 + 0.0633] \times 395 = 480$$

and the non-productive time adjustment factor becomes $480/395 = 1.215$.

Worker efficiency while working on scaffolding or manlifts is assumed to be 91% of normal, or a work adjustment factor of $1.1 \times$ work duration.

Total crew-minutes per activity for:

$$\begin{aligned} (\text{floors, lower walls, and roofs}) &= \text{estimated work duration} \times \text{work difficulty} \\ &\quad \text{adjustment} \times \text{lost time adjustment} \\ &= \text{estimated work duration} \times 1.0 \times 1.215 \\ &= \text{estimated work duration} \times 1.215 \end{aligned}$$

$$\begin{aligned} (\text{upper walls and ceilings}) &= \text{estimated work duration} \times \text{work difficulty} \\ &\quad \text{adjustment} \times \text{lost time adjustment} \\ &= \text{estimated work duration} \times 1.1 \times 1.215 \\ &= \text{estimated work duration} \times 1.337 \end{aligned}$$

Based on 4 m^2 units of surface area, the gridding operations and associated time durations for the floors, lower walls, and roofs are listed below.

• Layout of grid network	1 min.
• Paperwork	1 min.
• Move to next location	1 min.

Crew-minutes for gridding of 4 m^2 (actual duration)	3 min.
--	--------

Work Difficulty Adjustments:	None required.
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Adjusted Work Duration:	1.0 x actual duration	= 3 min.
Non-productive time adjustments:		1.215
Total Work Duration per 4 m ²	1.215 x adjusted duration	= 3.645 min.
Crew-Hours per 4 m ²		0.061 hrs.
Total Labor Cost per 4 m ²	0.061 x \$84.17/crew-hr	= \$5.13

Based on 4 m² units of surface area, the gridding operations and associated time durations for the upper walls and ceilings are listed below.

- Layout of grid network 1 min.
- Paperwork 1 min.
- Move to next location 1 min.

Crew-minutes for gridding of 4 m ² (actual duration)	3 min.
Work Difficulty Adjustments:	1.1
Adjusted Work Duration:	1.1 x actual duration = 3.3 min.
Non-productive time adjustments:	1.215
Total Work Duration per 4 m ²	1.215 x adjusted duration = 4.01 min.
Crew-Hours per 4 m ²	0.067 hrs.
Total Labor Cost per 4 m ²	0.067 x \$84.17/crew-hr = \$5.62

It is assumed that the ½-inch-wide paint strips used in gridding will cost \$0.05 per 4 m², based upon R. S. Means⁽²⁾. Thus, the total gridding cost per 4 m² of surface area (floors, lower walls, and roofs) is estimated to be:

$$\$5.13 \text{ (labor)} + \$0.05 \text{ (paint)} = \$5.18/4 \text{ m}^2$$

Similarly, the total gridding cost per 4 m² of surface area (upper walls and ceilings) is estimated to be:

$$\$5.62 \text{ (labor)} + \$0.05 \text{ (paint)} = \$5.67/4 \text{ m}^2$$

Summary

Unit cost factor (floors, lower walls, and roofs)	= \$1.30/m ²
Unit cost factor (upper walls and ceilings)	= \$1.42/m ²

As described later in this section, it is postulated that the termination survey is conducted in four survey groups. The estimated schedule and costs for layout of survey grid networks for Group 1, consisting of the power

block structures -- Turbine Generator Building, Radwaste and Control Building, Reactor Building, and Primary Containment -- are presented in Table B.10.

Assuming a gridding rate of 65.84 m²/hour for the floors, lower walls, and roofs, about 527 m² can be gridded in one crew-shift (an 8-hour shift). Assuming two crews per shift, two shifts per day, it can be seen from Table B.11 that the duration of the gridding effort for the floors, lower walls, and roofs of the Group 1 structures would be about 23 days, based upon an estimated total surface area of 47,136 m².

TABLE B.11. Estimated Cost and Schedule for Layout of Survey Grid Networks for the Power Block (Group 1) Structures at the Reference BWR^(a)

	Floors, Lower Walls/Roofs			Upper Walls & Ceilings			Totals	
	Area (m ²)	Cost (\$)	Time (days)	Area (m ²)	Cost (\$)	Time (days)	Cost (\$)	Time (days)
Turbine Gen. Bldg.	26,175	34,028	12.417	37,584	53,370	19.616	87,398	32.03
Radwaste/Control Bldg.	10,559	13,727	5.009	14,909	21,171	7.781	34,898	12.79
Reactor Bldg.	9,984	12,979	4.736	15,880	22,550	8.288	35,529	13.02
Containment Vessel	418	544	0.198	3,961	5,625	2.067	6,169	2.07
Totals	47,136	61,278	22.360	72,334	102,716	37.752	163,994	60.11

(a) The number of significant figures shown for area, cost, and time is for computational accuracy and does not imply precision to that many significant figures.

In a similar manner, assuming a gridding rate of 59.85 m²/hour for the upper walls and ceilings, about 479 m² can be gridded in one crew-shift. Assuming two crews per shift, two shifts per day, it can be seen from Table B.11 that the duration of the gridding effort for the upper walls and ceilings of the Group 1 structures would be about 38 days, based upon an estimated total surface area of 72,334 m². The estimated schedule and costs for layout of survey grid networks for Group 2, consisting of the remaining structures on site (approximately 95 unaffected structures of various sizes), are presented in Table B.12.

In NUREG/CR-0672, the termination surveys for DECON were conducted intermittently over a period of about 15-1/2 months, starting with a survey of the Turbine Generator Building and ending with a survey of the support facilities and the Radwaste and Control Building. For this analysis, it is

conducting the surveys and upon segregation of the site into two classifications of areas - affected and unaffected areas. This scenario will consolidate survey activities and reduce mobilization costs for the instrumented mobile laboratory postulated to be used by the radiological contractor.

Based upon a detailed analysis of the survey areas associated with the thirteen Group 2 structures given in Table B.13, a parametric analysis of the survey requirements for the remaining miscellaneous structures on the reference site -- i.e., approximately 80 buildings, trailers and warehouses shown in Figures B.2, B.3, and B.4 -- resulted in an estimated total survey time of approximately 591 hours for those entities.

The license termination survey process is labor-intensive, requiring an estimated total of 4,682 hours of direct labor for the termination survey. This number is increased by 20% in this study to account for work breaks, and set-up and calibration checks, etc., resulting in total clock time of about 5,618 hours (see Table B.13).

Two crews, working a single shift, conduct the survey protocol. Each crew is postulated to consist of the staff listed in Table B.14.

TABLE B.14. Staffing and Labor Rates Postulated for Survey Crews

<u>Person-hrs/crew-hr</u>	<u>Category</u>	<u>Labor Rate (\$/person-hr)</u>	<u>Cost (\$/crew-hr) (a)</u>
1.0	H.P. Leader/Supervisor	70.99	70.99
5.0	H.P./Survey Technician	36.82	184.10
1.0	Laborer (b)	26.37	26.37
0.5	Radiochemist (c)	54.40	27.20
0.5	Sr. Instrument Tech. (c)	54.40	27.20
<u>0.5</u>	Secretary/Clerk	<u>22.99</u>	<u>11.50</u>
8.5			347.36

(a) Based on Table B.1, except as noted otherwise.

(b) Included as part of the survey crew(s) in preparation for accessing the surfaces of interest, as required (e.g., removing wall and floor coverings, including paint and wax or sealer, and opening drains and ducts to enable representative measurements of the contaminant).

(c) Study estimate.

The total hours of the two crews equals 136 hours per day and the combined salaries of the crews comes to \$5,557.76 per day. Based upon the total hours given in Table B.13 for the 10 survey technicians, the estimated time to complete the termination survey is derived as follows:

rate for FY 1993 is \$132 per hour (a 7% increase over FY 1992). The professional staff-hour rates through FY 1995 will be published as a Notice in the Federal Register during the first quarter of each fiscal year.

Title 10 CFR Part 171, Annual Fee for Power Reactor Operating Licenses, has been expanded to include additional regulatory costs that are attributable to power reactors other than those costs that have previously been included in the annual fee for operating power reactors. These additional costs include the costs of generic activities that provide a potential future benefit to utilities currently operating power reactors. These generic activities are associated with reactor decommissioning (emphasis added), license renewal, standardization, and Construction Permits and Operating License reviews. By modifying Part 171, the base annual fee for an operating power reactor is expected to increase from approximately \$1 million to approximately \$2.8 million. Exactly what fraction of this annual fee is attributable to the future benefits of generic activities associated with reactor decommissioning was not determined in this study, but the entire annual fee is apparently considered an operations-related cost. Thus, Part 171 fees are not applicable to reactors with possession-only licenses and these fees are not included in the decommissioning cost estimates associated with this report.

Thus, the NRC charges fees in proportion to its cost (i.e., full-cost recovery) for providing individually identifiable services to specific applicants for, and holders of, NRC licenses and approvals.

In addition, WNP-2 operates under a Site Certification Agreement (SCA) issued on May 17, 1972, by the State of Washington Energy Facility Site Evaluation Council (EFSEC). This agreement specifies the conditions of construction and operation of the plant (mostly environmental conditions such as erosion control, monitoring programs, water discharge permits, etc.). EFSEC rules provide a means of funding each state agency for the purpose of 1) compliance monitoring or 2) to provide emergency response services. Funds are paid quarterly to EFSEC, who in turn pays each agency according to an interagency contract agreement. Funding for the state compliance monitoring program is expected to continue following final shutdown of the reference BWR.

safety regulation for nuclear power plants. The NRC regulates WNP-2's operation and inspects WNP-2 to ensure that its safety requirements are followed. The NRC uses a combination of inspectors assigned to the site (Resident Inspectors), inspectors that operate out of the NRC's Regional Office in California, and technical specialists from the NRC headquarters in Maryland, to oversee WNP-2's operations.

The Omnibus Budget Reconciliation Act of 1990 (Public Law 101-508) was signed into law November 5, 1990. It requires that the NRC recover 100% of its budget authority from fees assessed against licensees for services rendered, except for the amount appropriated to the NRC from the Nuclear Waste Fund^(v) by the Department of Energy (DOE) for FYs 1991 through 1995 for purposes of licensing support to the Nuclear Waste Policy Act (NWPA) activities. Subsection (c)(3) directs the NRC to establish a schedule of annual charges that fairly and equitably allocates the aggregate amount of charges among licensees and, to the maximum extent practicable, reasonably reflects the cost of providing services to such licensees or classes of licensees. The schedule may assess different annual charges for different licensees or classes of licensees based upon the allocation of the NRC's resources among licensees or classes of licensees, so that the licensees who require the greatest expenditures of the NRC's resources will pay the greatest annual charge.

With revision to 10 CFR Part 170, Fees for Facilities and Materials Licenses and Other Regulatory Services Under the Atomic Energy Act of 1954, as Amended, the NRC has established a policy of full-cost recovery for all NRC licensing services and inspections, including those activities associated with the renewal, dismantling/decommissioning, and termination of reactor licenses. NRC licensees are now expected to provide 100% of the agency's budget through user fees. For example, 10 CFR Part 170.20, as amended, changes the cost per professional staff hour for all full cost fees from \$92 per hour for FY 1990 to \$115 per hour for FY 1991 (a 25% increase over FY 1990) and to \$123 per hour for FY 1992 (a 7% increase over FY 1991).⁽²⁰⁾ The professional staff-hour

(v) The Nuclear Waste Fund (NWF) was established by section 302(c) of the Nuclear Waste Policy Act of 1982, 42 U.S.C. 10222(c). In general, the NWF is for functions or activities necessary or incident to the disposal of high-level radioactive waste or spent nuclear fuel.

5,618 hours/80 hrs per day = ~70 work days

or,

~70 work days/5 work days per week = ~ 14 wks (or, ~ 3.2 months)

Thus, the direct labor cost is: \$5,557.76/day x ~70 work days = \$389,038.

Per diem (7 days/wk) for 17 full-time equivalent (FTE) staff, calculated using Federal Travel Rates of \$91/day, amounts to \$151,606.

Travel costs (postulated to be about \$1,000/person) add another \$17,000, resulting in a total labor cost of:

$$\$389,038 + 151,606 + 17,000 = \$557,644.$$

It is further assumed that the radiological contractor uses an instrumented mobile laboratory^(t) for the duration of the survey. Assuming a 5-year lifetime, straight-line depreciation, and a 25% utilization factor, the mobile laboratory cost of about \$156,500 would be amortized at a rate of about \$2,408/week, resulting in a total mobile laboratory cost for the survey of:

$$\$2,408/\text{wk} \times 14 \text{ wks} = \$33,712$$

After the site has been surveyed, samples collected and analyzed, the data must be evaluated and presented in a report which documents the findings of the survey. The estimated labor associated with report preparation, shown in Table B.15, is taken from Reference 17, and the labor costs are based upon the DOC costs presented previously in Table B.1.

TABLE B.15. Estimated Labor Costs for Preparation of Termination Survey Report

<u>Labor Category</u>	<u>Person-weeks</u>	<u>\$/Person-wk</u>	<u>Cost (1993 \$)</u>
Engineer	4	2,363.44	9,454
Graphic Arts	1	1,304.10	1,304
Tech. writer/editor	3	1,304.10 ^(a)	3,912
Clerical	2	919.79	1,840
Total	<u>10</u>		<u>16,510</u>

(a) Study estimate.

(t) For a large, complex site such as the reference nuclear power plant, the following instrumentation and equipment are anticipated to be required: portable survey instruments, laboratory detectors and electronics, sample analysis systems, sample preparation equipment, and miscellaneous supplies and equipment.⁽¹⁷⁾

When the licensee has completed the cleanup and documented the radiological condition of the site, the NRC (or its agent) is ready for the certification process. Based upon discussion with NRC staff and upon information provided by industry contacts, it is postulated that this confirmatory/verification survey of selected points will take about one month and is estimated to cost about \$175,000. These costs are ultimately paid by the licensee under the NRC's full-cost recovery policy.

According to 10 CFR 50.82, "Application for Termination of License," the Commission will terminate the license if it determines that 1) the decommissioning has been performed in accordance with the approved decommissioning plan and the order authorizing decommissioning; and, 2) the terminal radiation survey and associated documentation demonstrates that the facility and site are suitable for release for unrestricted use.

B.12 CASCADING COSTS

An extensive literature search revealed that cascading costs^(u) have not been given any selective or distinctive consideration in decommissioning cost estimates until recently. This is not surprising because the history of decommissioning cost estimating has been an evolutionary and iterative process. This highly subjective cost category was not considered as a separate entity in NUREG/CR-0672 in 1980. In this reevaluation of the reference BWR study, cascading costs were specifically searched for, but no significant cascading costs were identified. Thus, no cascading costs are included in the cost for decontamination and decommissioning of the reference BWR power station.

B.13 REGULATORY COSTS

The reference nuclear power plant (WNP-2) has been operating since 1984. WNP-2 is operated by Washington Public Power Supply System (WPPSS). WNP-2 was licensed to operate by the NRC. Federal law gives the NRC sole authority over

(u) Cascading costs are defined as those costs associated with the removal of noncontaminated and releasable material in support of the decommissioning process (e.g., if it is considered necessary to remove portions of the top floors or a roof to get at a bottom-floor nuclear component).

The estimated cost of this program, together with a summary of estimated regulatory costs, is given in Table B.16.

TABLE B.16. Summary of Estimated Regulatory Costs

<u>Entity</u>	<u>Cost Element</u>	<u>Estimated Cost, \$ (a)</u>
Licensee	State Compliance Monitoring: (b)	
	• Department of Health	178,000/yr (c)
	• Department of Ecology	2,000/yr (c)
	• Mixed Waste Fee (Ecology)	37,200/yr (d)
	• Department of Wildlife	14,800/yr (d)
	• Fire Protection Services Division	2,000/yr (d)
	• Labor and Industries	5,000/yr (d)
	• EFSEC Staff	5,000/yr (c)
	Resolution & Response to NRC	103,500 (c)
	Review of the Decom. Plan	
NRC	Environmental Assessment	23,230 (e)
	Decommissioning Plan (f)	230,600
	Regional Inspections during periods of safe storage:	
	• Two General Inspections/yr; 1-wk/inspection by 1 person	11,652 (g)
	• One Security Inspection/yr; 3-days by 1 person	3,532 (g)
	Resident Inspector (during periods of active decommissioning) (h)	115,300/yr
	Certification Survey (i)	175,000

-
- (a) The number of figures shown is for computational accuracy and does not imply precision to that many significant figures.
- (b) See text for details..
- (c) Study estimate based upon engineering judgment and discussions with industry contacts.
- (d) Dollar values represent budget amounts for FY-94 (July 1, 1993 to June 30, 1994) for WNP-2.
- (e) Based upon discussions with the NRC, this task is estimated to require about 1 man-month (a Period 1 cost).
- (f) Discussions with NRC staff suggest that review, evaluation, and approval of a decommissioning plan for power reactors may require about a year (a Period 1 cost).
- (g) Includes Federal Travel Rates of \$91/day/person.
- (h) Based upon discussions with the NRC, 1/2 FTE, with roughly 1/3 time actually spent onsite during periods of active decommissioning, would be a reasonable value to use for this cost element.
- (i) Already included in Table B.9, but included here for completeness.

Funding for emergency response services (i.e., Emergency Management Division, Department of Health, Department of Agriculture, and Washington State Patrol) is not anticipated to continue after final plant shutdown. (w)

(w) Letter, William A. Kiel, Washington Public Power Supply System, to George J. Konzek, Battelle Northwest, transmitting State of Washington regulatory fees, dated October 7, 1993.

B.14 CONTINGENCY

Some state utility rate commissions have expressed concerns about the size of the contingency allowances in decommissioning cost estimates. Following is a brief discussion of the nature of a contingency allowance, the variation in the size of the contingency allowance as a function of the degree of knowledge about the project, the size of the allowance generally assigned to decommissioning projects, and the size of the allowance used in this study. The discussion is derived from a report prepared by Northeast Utilities Service Company for decommissioning of the Millstone Units 1 and 2.⁽²¹⁾

A common element of engineering cost estimates is contingency. The American Association of Cost Engineers (AACE) in its Cost Engineers Notebook⁽²²⁾ defines contingency as:

The specific provision for unforeseeable elements of cost within the defined project scope; particularly important where previous experience relating estimates and actual costs has shown that unforeseeable events which will increase cost are likely to occur...

The inclusion of contingency in project estimates (construction, deconstruction or otherwise) is an industry-wide practice. In the U.S. Department of Energy Publication DOE Uniform Contractor Reporting System, Volume 1, September 1978, Form DOE533P illustrates specific use of project contingency. This form contains an item called "Management Reserve," which is defined as "Amount of Contingency...Available for Use..." As another example, the State of Connecticut's Department of Transportation employs contingency as an integral part of project estimates on budgeted construction jobs. This is done primarily to adequately allow for the "Unforeseeable Elements of Cost" such as:

- unexpected minor changes in scope
- allowance for uncertainties in estimating methods
- allowance for untried process
- unexpected job conditions.

These definitions and examples highlight the importance of including a provision for unforeseeable events that are likely to occur and that will

increase costs. Virtually every nuclear and fossil fuel facility owner, architect-engineer, consultant, construction and demolition company in the country (and probably in the world) abides by the aforementioned contingency principle, either expressed or implied. Their experience in their respective fields has led them to recognize the propriety of a contingency provision in cost estimates.⁽¹⁴⁾

Because of the varying circumstances that make a contingency necessary, a single standard rate is not appropriate for all situations. The rate could be as high as 100% of the cost for an untried process where no engineering is complete and the job is to take place in the distant future. Contingency amounts of 20 to 35% are not uncommon for projects in the proposal stages. Contingency amounts of 5% are not uncommon for projects that have been fully engineered and designed and are entering the construction phase.

Contingency size is time-related. At the initial project stages when small amounts of engineering or design work have been completed, a larger contingency is needed, since more uncertainties exist. As the job approaches completion, lesser contingency amounts are appropriate.

Considering the state of knowledge available for a decommissioning project that is to take place 20 to 30 years in the future, a contingency of 25% is considered by professionals in the field to be a reasonable and realistic value for use in developing estimates of the possible financial exposure that will result from decommissioning. Therefore, a 25% contingency is used in this study for the decommissioning of the reference BWR power station.

B.15 REFERENCES

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APPENDIX C

COST ESTIMATING COMPUTER PROGRAM

APPENDIX C

COST ESTIMATING COMPUTER PROGRAM

The Cost Estimating Computer Program (CECP), designed for use on an IBM personal computer or equivalent, was developed for estimating the cost of decommissioning light-water reactor power stations to the point of license termination. Such costs include component, piping and equipment removal costs; packaging costs; decontamination costs; transportation costs; burial volumes and costs; and manpower staffing costs. Using equipment and consumables costs and inventory data supplied by the user, the CECP calculates unit cost factors and then combines these factors with transportation and burial cost algorithms to produce a complete report of decommissioning costs. In addition to costs, the CECP also calculates person-hours, crew-hours and exposure person-hours associated with decommissioning. Data for the reference BWR were used to develop and test the CECP.

The CECP uses a data base, but it is not a commercial data base product. For this reason, data may be entered and information extracted only through the CECP program itself. The detailed and summary output files produced by the CECP are in ASCII format and may be accessed and printed using any IBM PC-compatible word processing system.

The CECP main menu is shown in Figure C.1. The first task for the user is to enter certain general data which the CECP will need later in calculating site-specific costs. This is done by selecting 1, 2, and 3 from the main menu. When the user types 1, for example, a portion of the data base is opened up permitting the user to enter labor costs, burial costs, overhead costs, consumables costs, physical constants (e.g., the density of reinforced concrete) and so on. When the user selects 1 for the first time, the default file is loaded into memory. The user may then modify whatever values he or she desires and save this new information to a file. In fact the user may save data to several files during the same session. The next time the user

FIGURE C.1. CECP Main Menu

accesses item 1 he or she will have several files to choose from: the default file (which is always available) and the files he or she created. Any of these files may be loaded into memory and used as a basis for creating a new file. Data for items 2 and 3 are entered in the same way. If the user does not supply his or her own files for 1, 2, and 3, the CECP will still have the default files available.

Having entered general information into the data base, the user must now enter site-specific data. Data for menu items A and B are entered first, in either order, then data for items C through H, in any order. When the user selects items C, D, E, F, G, or H, the CECP requests the user to specify which input files (from 1 through 3 and A and B) to use. For each of the items C through H, the CECP calculates cost and exposure information in detail and then writes the results to appropriate output files. To get a complete site summary, combining data from items A through H, the user selects item I.

The overall method for entering data is outlined in Figure C.2.

FIGURE C.2. Flow Diagram for Entering Data into the CECP

As an example of the data entry process, Figures C.3a and C.3b show the two input screens the user will see when he or she selects Item E from the main menu. These screens cover inventory information for a single system. The user enters the system name at the top and then enters information for each component in the system which will be removed in the decommissioning process. On Screen I, the user supplies the following information for each component: name, equipment category, disposal category, and quantity. On Screen II, the user supplies the following: volume, weight, radiation dose rate in millirem/hour, and, in the case of tanks, tank diameter and tank height.

MENU ITEM E: CONTAMINATED SYSTEMS COSTS				
System Name: Control Rod Drive System				
Component Description	Category	Disposal	Quantity*	
1 CRD Blade	Lg Misc.	Sea-Van	460	
2 CRD Mechanism	Lg Misc.	Sea-Van	225	
3 Direction Control Set	Sm Misc.	Sea-Van	185	
4 Scram Valve	Sm Valve	Sea-Van	370	
5 Scram Accumulator	Lg Misc.	Sea-Van	210	
6 CRD Pump	Lg Pump	Sea-Van	2	
7 Scram Discharge Volume	Lg Misc.	Sea-Van	2	
8 Pump Suction Filter	Lg Misc.	Sea-Van	2	
9 CRD Drive Water Filter	Sm Misc.	Sea-Van	2	
10 3/4 Inch Valve	Sm Valve	Sea-Van	2042	
11 1 Inch Valve	Sm Valve	Sea-Van	185	
12 2 Inch Valve	Sm Valve	Sea-Van	379	
13 4 Inch Valve	Lg Valve	Sea-Van	7	
14 2 Inch Restricting Orifice	Sm Misc.	Sea-Van	1	
15 2 Inch Flow Control Valve	Lg Misc.	Sea-Van	2	
*NOTE: For piping, Quantity refers to feet of piping. For other categories, Quantity refers to the number of items of equipment.				
Number of records: 20 File in use: BWR.BD				
F1 F2 Select System Change System Name Ctrl F10 Delete System				
↑↓← Home End PgUp PgDn Select Item ← Enter Data Insert Item				
Ctrl End Insert Item at End Delete Item Save Data to a File Alt-X Quit				

FIGURE C.3a. System Inventory Information (Screen I)

MENU ITEM E: CONTAMINATED SYSTEMS COSTS					
System Name: Control Rod Drive System					
	Volume (ft3)	Weight (lb)	Diameter*	Length*	Millirem/Hr
1	9	400	N/A	N/A	25
2	6.3	480	N/A	N/A	25
3	0.32	80	N/A	N/A	25
4	1.6	70	1	24	3
5	1.05	140	N/A	N/A	3
6	9	4000	2	6	2
7	7.85	2000	N/A	N/A	2
8	4.7	400	N/A	N/A	80
9	1.6	100	N/A	N/A	80
10	0.2	30	0.75	5	3
11	0.3	50	1	7	3
12	1	90	2	11.5	3
13	3.1	268	4	17	3
14	0.31	60	N/A	N/A	3
15	1	160	N/A	N/A	3
*NOTE: Diameters and lengths of valves and diameters of piping are in inches. Diameters and lengths of other equipment (if applicable) are in feet.					
Number of records: 20 File in use: BWR.BD					
F1 F2 Select System Change System Name Ctrl F10 Delete System					
↑↓← Home End PgUp PgDn Select Item ← Enter Data Insert Item					
Ctrl End Insert Item at End Delete Item Save Data to a File Alt-X Quit					

FIGURE C.3b. System Inventory Information (Screen II)

The equipment category and disposal category parameters require further explanation. The user selects the equipment category from the following list: Lg Pipe, Sm Pipe, Lg Valve, Sm Valve, Tank, Lg Pump, Sm Pump, Lg HX, Sm HX, Lg Misc., and Sm Misc. Lg Pipe refers to piping greater than 2.5 inches in diameter and Sm Pipe is piping 2 inches or less in diameter. The other categories are similarly defined. The equipment category parameter is important because it provides the CECP with the correct unit cost factor to be used in determining removal costs.

The disposal category parameter is either Sea-Van (maritime container) or Metal Box (B-25 container). This parameter enables the CECP to apply the proper disposal cost algorithm to each component. Other sizes of maritime containers and special steel boxes are also used by the CECP for the applications shown in Table B.3.

Examples of typical output reports are illustrated in Figures C.4 through C.6, for the reference BWR. Tables C.1 through C.4 are complete summary tables for the four cases discussed in Chapters 3 and 4. Table C.1 is the DECON Case with Hanford selected as the low-level burial site; Table C.2 is the same as C.1 but with the burial site at Barnwell. Tables C.3 and C.4 are the SAFSTOR1 and SAFSTOR2 versions of C.1.

C.1 PLANT INVENTORY

The CECP requires that the user supply information on the inventory of the plant. This includes information on building names and wall surface areas, reactor pressure vessel size, system names, number and sizes of pumps and valves, lengths and diameters of pipes, radiation levels in the vicinity of components, and so on. A discussion of the reference BWR plant inventory, which the CECP uses as the default BWR inventory, is presented below.

C.1.1 Inventories of Process System Components

Inventories of process system components and the inventory of steel piping that will have to be removed during decommissioning are compiled and presented in this section. These inventories are used in the CECP, together with appropriate unit cost factors and algorithms, to estimate the costs of

+++++
+ POTENTIALLY RADIOACTIVE SYSTEMS: PHYSICAL CHARACTERISTICS +
+++++

*** Condensate Demineralizers

Component Description	Category	Disposal	Qty	Wgt(lb)	Vol(ft3)	----- Tanks -----	
						Dia(ft)	Hgt(ft)
Filter Demineralizers	Tank	Sea-Van	6	11,675	28	7.00	10.60
Resin Trap (with basket)	Lg Misc.	Sea-Van	6	2,100	23		
Demineralizer Hold Pump	Lg Pump	Sea-Van	6	350	8		
Condensate Backwash Receiving Tank	Tank	Sea-Van	1	15,224	59	12.20	21.10
Sludge Discharge Mixing Pump	Lg Pump	Sea-Van	1	924	16		
Condensate Decant Pump	Lg Pump	Sea-Van	1	924	16		
Condensate Backwash Pump	Lg Pump	Sea-Van	1	924	16		
Condensate Phase Separator Tank	Tank	Sea-Van	2	7,001	60	15.20	17.20
34 Foot Loop Seal	Lg Pipe	Sea-Van	150	19	0		
36 Inch Flow Element	Lg Valve	Sea-Van	1	1,800	200		
20 Inch Butterfly Valve	Lg Valve	Sea-Van	2	3,900	65		
18 Inch Air Operated Butterfly Valve	Lg Valve	Sea-Van	1	3,100	61		
12 Inch Butterfly Valve	Lg Valve	Sea-Van	6	1,120	24		
12 Inch Air Operated Butterfly Valve	Lg Valve	Sea-Van	12	1,120	24		
12 Inch Flow Element	Lg Valve	Sea-Van	6	1,000	24		
8 Inch Air Operated Butterfly Valve	Lg Valve	Sea-Van	22	530	14		
8 Inch Butterfly Valve	Lg Valve	Sea-Van	2	530	15		
8 Inch Air Operated Valve	Lg Valve	Sea-Van	1	750	15		
8 Inch Check Valve	Lg Valve	Sea-Van	5	430	11		
8 Inch Flow Element	Lg Valve	Sea-Van	2	400	11		
6 Inch Air Operated Valve	Lg Valve	Sea-Van	12	375	7		
6 Inch Valve	Lg Valve	Sea-Van	2	375	7		
6 Inch Air Operated Butterfly Valve	Lg Valve	Sea-Van	21	350	7		
6 Inch Check Valve	Lg Valve	Sea-Van	3	270	6		
4 Inch Air Operated Valve	Lg Valve	Sea-Van	5	180	3		
4 Inch Check Valve	Lg Valve	Sea-Van	1	130	3		
3 Inch Air Operated Valve	Sm Valve	Sea-Van	2	130	1		
3 Inch Air Operated Butterfly Valve	Sm Valve	Sea-Van	6	120	1		
3 Inch Butterfly Valve	Sm Valve	Sea-Van	1	120	1		
3 Inch Restricting Orifice	Sm Valve	Sea-Van	1	80	1		
2 Inch Air Operated Butterfly Valve	Sm Valve	Sea-Van	6	55	1		
2 Inch Butterfly Valve	Sm Valve	Sea-Van	2	55	1		
2 Inch Valve	Sm Valve	Sea-Van	43	75	1		
2 Inch Check Valve	Sm Valve	Sea-Van	5	50	1		
2 Inch Relief Valve	Sm Valve	Sea-Van	3	65	1		
1 1/2 Inch Valve	Sm Valve	Sea-Van	1	58	1		
1 Inch Air Operated Valve	Sm Valve	Sea-Van	13	45	1		
1 Inch Valve	Sm Valve	Sea-Van	18	45	1		
1 Inch Check Valve	Sm Valve	Sea-Van	5	30	1		
1 Inch Relief Valve	Sm Valve	Sea-Van	6	42	1		
Instrument Root Valve (typ. 3/4" globe)	Sm Valve	Sea-Van	149	32	0		

*** Equipment Drain Processing

Component Description	Category	Disposal	Qty	Wgt(lb)	Vol(ft3)	----- Tanks -----	
						Dia(ft)	Hgt(ft)
Waste Demineralizer	Tank	Sea-Van	1	1,998	33	5.00	10.20
Waste Collector Filter	Lg Misc.	Sea-Van	1	3,991	138		
Waste Filter Hold Pump	Lg Pump	Sea-Van	1	700	9		
Waste Collector Tank and Eductor	Tank	Sea-Van	1	22,530	66	16.20	18.10
Waste Collector Pump	Lg Pump	Sea-Van	1	625	20		
Spent Resin Tank	Tank	Sea-Van	1	1,448	18	5.90	5.90

FIGURE C.4a. Partial CECP Output File for Contaminated Systems, Example 1

+++++ POTENTIALLY RADIOACTIVE SYSTEMS: CREW-HOURS, PERSON-HOURS, ETC. +++++

*** Condensate Demineralizers

Component Description	Category	Disposal	Qty	Crew-Hrs	Pers-Hrs	Exp Hrs	Pers-Rem	Curies
Filter Demineralizers	Tank	Sea-Van	6	100.0	549.7	349.3	0.0	0.615
Resin Trap (with basket)	Lg Misc.	Sea-Van	6	18.4	73.7	46.8	0.0	0.000
Demineralizer Hold Pump	Lg Pump	Sea-Van	6	18.4	73.7	46.8	0.0	0.071
Condensate Backwash Receiving Tank	Tank	Sea-Van	1	29.8	164.0	104.2	0.0	0.344
Sludge Discharge Mixing Pump	Lg Pump	Sea-Van	1	3.1	12.3	7.8	0.0	0.019
Condensate Decant Pump	Lg Pump	Sea-Van	1	3.1	12.3	7.8	0.0	0.019
Condensate Backwash Pump	Lg Pump	Sea-Van	1	3.1	12.3	7.8	0.0	0.019
Condensate Phase Separator Tank	Tank	Sea-Van	2	67.0	368.6	234.2	0.0	0.782
34 Foot Loop Seal	Lg Pipe	Sea-Van	150	29.7	163.2	103.7	0.0	0.079
36 Inch Flow Element	Lg Valve	Sea-Van	1	3.0	16.3	10.4	0.0	0.033
20 Inch Butterfly Valve	Lg Valve	Sea-Van	2	5.9	32.6	20.7	0.0	0.019
18 Inch Air Operated Butterfly Valve	Lg Valve	Sea-Van	1	3.0	16.3	10.4	0.0	0.008
12 Inch Butterfly Valve	Lg Valve	Sea-Van	6	17.8	97.9	62.2	0.0	0.023
12 Inch Air Operated Butterfly Valve	Lg Valve	Sea-Van	12	35.6	195.8	124.4	0.0	0.045
12 Inch Flow Element	Lg Valve	Sea-Van	6	17.8	97.9	62.2	0.0	0.023
8 Inch Air Operated Butterfly Valve	Lg Valve	Sea-Van	22	65.3	359.0	228.1	0.0	0.042
8 Inch Butterfly Valve	Lg Valve	Sea-Van	2	5.9	32.6	20.7	0.0	0.004
8 Inch Air Operated Valve	Lg Valve	Sea-Van	1	3.0	16.3	10.4	0.0	0.002
8 Inch Check Valve	Lg Valve	Sea-Van	5	14.8	81.6	51.8	0.0	0.010
8 Inch Flow Element	Lg Valve	Sea-Van	2	5.9	32.6	20.7	0.0	0.004
6 Inch Air Operated Valve	Lg Valve	Sea-Van	12	35.6	195.8	124.4	0.0	0.015
6 Inch Valve	Lg Valve	Sea-Van	2	5.9	32.6	20.7	0.0	0.002
6 Inch Air Operated Butterfly Valve	Lg Valve	Sea-Van	21	62.3	342.6	217.7	0.0	0.025
6 Inch Check Valve	Lg Valve	Sea-Van	3	8.9	48.9	31.1	0.0	0.004
4 Inch Air Operated Valve	Lg Valve	Sea-Van	5	14.8	81.6	51.8	0.0	0.003
4 Inch Check Valve	Lg Valve	Sea-Van	1	3.0	16.3	10.4	0.0	0.001
3 Inch Air Operated Valve	Sm Valve	Sea-Van	2	0.0	0.0	0.0	0.0	0.001
3 Inch Air Operated Butterfly Valve	Sm Valve	Sea-Van	6	0.0	0.0	0.0	0.0	0.002
3 Inch Butterfly Valve	Sm Valve	Sea-Van	1	0.0	0.0	0.0	0.0	0.000
3 Inch Restricting Orifice	Sm Valve	Sea-Van	1	0.0	0.0	0.0	0.0	0.000
2 Inch Air Operated Butterfly Valve	Sm Valve	Sea-Van	6	0.0	0.0	0.0	0.0	0.001
2 Inch Butterfly Valve	Sm Valve	Sea-Van	2	0.0	0.0	0.0	0.0	0.000
2 Inch Valve	Sm Valve	Sea-Van	43	0.0	0.0	0.0	0.0	0.008
2 Inch Check Valve	Sm Valve	Sea-Van	5	0.0	0.0	0.0	0.0	0.001
2 Inch Relief Valve	Sm Valve	Sea-Van	3	0.0	0.0	0.0	0.0	0.001
1 1/2 Inch Valve	Sm Valve	Sea-Van	1	0.0	0.0	0.0	0.0	0.000
1 Inch Air Operated Valve	Sm Valve	Sea-Van	13	0.0	0.0	0.0	0.0	0.001
1 Inch Valve	Sm Valve	Sea-Van	18	0.0	0.0	0.0	0.0	0.001
1 Inch Check Valve	Sm Valve	Sea-Van	5	0.0	0.0	0.0	0.0	0.000
1 Inch Relief Valve	Sm Valve	Sea-Van	6	0.0	0.0	0.0	0.0	0.000
Instrument Root Valve (typ. 3/4" globe)	Sm Valve	Sea-Van	149	0.0	0.0	0.0	0.0	0.005
				581	3,126	1,987	0	2.232

*** Equipment Drain Processing

Component Description	Category	Disposal	Qty	Crew-Hrs	Pers-Hrs	Exp Hrs	Pers-Rem	Curies
Waste Demineralizer	Tank	Sea-Van	1	14.2	78.2	49.7	0.2	0.066
Waste Collector Filter	Lg Misc.	Sea-Van	1	3.1	12.3	7.8	0.0	0.000
Waste Filter Hold Pump	Lg Pump	Sea-Van	1	3.1	12.3	7.8	0.0	0.014
Waste Collector Tank and Eductor	Tank	Sea-Van	1	35.0	192.4	122.2	0.6	0.441
Waste Collector Pump	Lg Pump	Sea-Van	1	3.1	12.3	7.8	0.0	0.023

FIGURE C.4b. Partial CECP Output File for Contaminated Systems, Example 2

+++++ POTENTIALLY RADIOACTIVE SYSTEMS: REMOVAL, TRANSPORTATION, DISPOSAL COSTS. +++++

*** Condensate Demineralizers

Component Description	Category	Disposal	Qty	Removal	Container	Transport	Disposal	Tot. Costs
Filter Demineralizers	Tank	Sea-Van	6	19,218	9,661	353	81,115	110,347
Resin Trap (with basket)	Lg Misc.	Sea-Van	6	2,571	1,738	63	14,590	18,963
Demineralizer Hold Pump	Lg Pump	Sea-Van	6	2,540	290	11	2,432	5,272
Condensate Backwash Receiving Tank	Tank	Sea-Van	1	5,791	2,100	77	17,629	25,596
Sludge Discharge Mixing Pump	Lg Pump	Sea-Van	1	427	127	5	1,070	1,629
Condensate Decant Pump	Lg Pump	Sea-Van	1	427	127	5	1,070	1,629
Condensate Backwash Pump	Lg Pump	Sea-Van	1	427	127	5	1,070	1,629
Condensate Phase Separator Tank	Tank	Sea-Van	2	12,995	1,931	70	16,214	31,211
34 Foot Loop Seal	Lg Pipe	Sea-Van	150	5,715	392	14	3,480	9,602
36 Inch Flow Element	Lg Valve	Sea-Van	1	572	248	9	2,084	2,913
20 Inch Butterfly Valve	Lg Valve	Sea-Van	2	1,143	1,076	39	9,032	11,290
18 Inch Air Operated Butterfly Valve	Lg Valve	Sea-Van	1	572	428	16	3,590	4,604
12 Inch Butterfly Valve	Lg Valve	Sea-Van	6	3,429	927	34	7,782	12,171
12 Inch Air Operated Butterfly Valve	Lg Valve	Sea-Van	12	6,859	1,854	68	15,563	24,343
12 Inch Flow Element	Lg Valve	Sea-Van	6	3,429	828	30	6,948	11,235
8 Inch Air Operated Butterfly Valve	Lg Valve	Sea-Van	22	12,574	1,608	59	13,502	27,743
8 Inch Butterfly Valve	Lg Valve	Sea-Van	2	1,143	146	5	1,227	2,522
8 Inch Air Operated Valve	Lg Valve	Sea-Van	1	572	103	4	868	1,547
8 Inch Check Valve	Lg Valve	Sea-Van	5	2,858	297	11	2,490	5,655
8 Inch Flow Element	Lg Valve	Sea-Van	2	1,143	110	4	926	2,184
6 Inch Air Operated Valve	Lg Valve	Sea-Van	12	6,859	621	23	5,211	12,713
6 Inch Valve	Lg Valve	Sea-Van	2	1,143	103	4	868	2,119
6 Inch Air Operated Butterfly Valve	Lg Valve	Sea-Van	21	12,002	1,014	37	8,511	21,564
6 Inch Check Valve	Lg Valve	Sea-Van	3	1,715	112	4	938	2,768
4 Inch Air Operated Valve	Lg Valve	Sea-Van	5	2,858	124	5	1,042	4,029
4 Inch Check Valve	Lg Valve	Sea-Van	1	572	18	1	151	741
3 Inch Air Operated Valve	Sm Valve	Sea-Van	2	0	36	1	301	338
3 Inch Air Operated Butterfly Valve	Sm Valve	Sea-Van	6	0	99	4	834	937
3 Inch Butterfly Valve	Sm Valve	Sea-Van	1	0	17	1	139	156
3 Inch Restricting Orifice	Sm Valve	Sea-Van	1	0	11	0	93	104
2 Inch Air Operated Butterfly Valve	Sm Valve	Sea-Van	6	0	46	2	382	429
2 Inch Butterfly Valve	Sm Valve	Sea-Van	2	0	15	1	127	143
2 Inch Valve	Sm Valve	Sea-Van	43	0	445	16	3,734	4,195
2 Inch Check Valve	Sm Valve	Sea-Van	5	0	34	1	289	325
2 Inch Relief Valve	Sm Valve	Sea-Van	3	0	27	1	226	254
1 1/2 Inch Valve	Sm Valve	Sea-Van	1	0	8	0	67	75
1 Inch Air Operated Valve	Sm Valve	Sea-Van	13	0	81	3	677	761
1 Inch Valve	Sm Valve	Sea-Van	18	0	112	4	938	1,054
1 Inch Check Valve	Sm Valve	Sea-Van	5	0	21	1	174	195
1 Inch Relief Valve	Sm Valve	Sea-Van	6	0	35	1	292	328
Instrument Root Valve (typ. 3/4" globe)	Sm Valve	Sea-Van	149	0	658	24	5,521	6,203
				109,552	27,752	1,013	233,198	371,515

*** Equipment Drain Processing

Component Description	Category	Disposal	Qty	Removal	Container	Transport	Disposal	Tot. Costs
Waste Demineralizer	Tank	Sea-Van	1	2,728	276	10	2,314	5,328
Waste Collector Filter	Lg Misc.	Sea-Van	1	452	550	20	4,621	5,644
Waste Filter Hold Pump	Lg Pump	Sea-Van	1	424	97	4	811	1,335
Waste Collector Tank and Eductor	Tank	Sea-Van	1	6,792	3,107	113	26,089	36,102

FIGURE C.4c. Partial CECP Output File for Contaminated Systems, Example 3

+++++
+ BUILDING COMPONENTS TO BE DECONTAMINATED +
+++++

*** Reactor Bldg

Component Description	Activity	Length (ft.)	Width (ft.)	Depth (in.)	Orientation
Drywell Head Laydown	Conc Wash	45.0	45.0	N/A	Floor
Drywell Head Laydown	Conc Rmvl	31.8	31.8	1.000	Floor
RPV Head Laydown	Conc Wash	27.0	27.0	N/A	Floor
RPV Head Laydown	Conc Rmvl	27.0	27.0	1.000	Floor
Space Frame	Conc Wash	17.3	17.3	N/A	Floor
Refueling Floor Cavities	Mtl Rmvl	134.2	134.2	0.250	Floor
Refuel Floor Alcove Pit	Conc Wash	23.7	23.7	N/A	Floor
RHR "A" Heat Exchanger Rm	Conc Wash	23.5	23.5	N/A	Floor
RHR "A" Heat Exchanger Rm	Conc Rmvl	16.6	16.6	1.000	Floor
RHR "B" Heat Exchanger Rm	Conc Wash	23.5	23.5	N/A	Floor
RHR "B" Heat Exchanger Rm	Conc Rmvl	16.6	16.6	1.000	Floor
Fuel Pool Cooling HX/Pump	Conc Wash	27.1	27.1	N/A	Floor
Fuel Pool Cooling HX/Pump	Conc Rmvl	24.2	24.2	1.000	Floor
RWCU Heat Exchanger Rm	Conc Wash	39.7	39.7	N/A	Floor
RWCU Heat Exchanger Rm	Conc Rmvl	21.7	21.7	1.000	Floor
Standby Liquid Control	Conc Wash	25.1	25.1	N/A	Floor
Instrument Rack Trough (9)	Conc Wash	11.7	11.7	N/A	Floor
RWCU Pump Rm	Conc Wash	17.5	17.5	N/A	Floor
RWCU Pump Rm	Conc Rmvl	17.5	17.5	1.000	Floor
CRD HCU Area East	Conc Wash	33.7	33.7	N/A	Floor
CRD HCU Area East	Conc Rmvl	15.1	15.1	1.000	Floor
CRD HCU Area West	Conc Wash	32.0	32.0	N/A	Floor
CRD HCU Area West	Conc Rmvl	14.3	14.3	1.000	Floor
Scram Discharge Volume Area	Conc Wash	14.4	14.4	N/A	Floor
Recirc HPU Area (2)	Conc Wash	12.6	12.6	N/A	Floor
CRD Repair Room	Conc Wash	31.4	31.4	N/A	Floor
CRD Repair Room	Conc Rmvl	31.4	31.4	1.000	Floor
TIP Room	Conc Wash	15.0	15.0	N/A	Floor
TIP Room	Conc Rmvl	11.6	11.6	1.000	Floor
Main Steam Tunnel	Conc Wash	24.4	24.4	N/A	Floor
Main Steam Tunnel	Conc Rmvl	24.4	24.4	1.000	Floor
Drywell Floor	Conc Wash	63.6	63.6	N/A	Floor
Drywell Floor	Conc Rmvl	63.6	63.6	1.000	Floor
Under Vessel CRD Area	Conc Wash	15.9	15.9	N/A	Floor
Under Vessel CRD Area	Conc Rmvl	15.9	15.9	1.000	Floor
Instrument Racks (8 racks)	Conc Wash	7.5	7.5	N/A	Floor
North Valve Room	Conc Wash	14.5	14.5	N/A	Floor
South Valve Room	Conc Wash	15.8	15.8	N/A	Floor
Wetwell Floor	Conc Wash	70.8	70.8	N/A	Floor
Wetwell Floor	Conc Rmvl	70.8	70.8	1.000	Floor
Control Rod Drive Pump Rm	Conc Wash	39.8	39.8	N/A	Floor
Control Rod Drive Pump Rm	Conc Wash	30.8	30.8	N/A	Floor
RCIC Pump Rm	Conc Wash	29.2	29.2	N/A	Floor
RCIC Pump Rm	Conc Rmvl	16.0	16.0	1.000	Floor
RHR "A" Pump Room	Conc Wash	34.6	34.6	N/A	Floor
RHR "A" Pump Room	Conc Rmvl	10.9	10.9	1.000	Floor
RHR "B" Pump Room	Conc Wash	40.0	40.0	N/A	Floor
RHR "B" Pump Room	Conc Rmvl	12.6	12.6	1.000	Floor
RHC "C" Pump Room	Conc Wash	30.4	30.4	N/A	Floor
LPCS Pump Room	Conc Wash	24.2	24.2	N/A	Floor
HPCS Pump Room	Conc Wash	24.2	24.2	N/A	Floor

FIGURE C.5a. Partial CECF Output File for Building Decontamination, Example 1

+++++
+ BUILDING DECONTAMINATION: TIMES AND EXPOSURES +
+++++

*** Reactor Bldg

Component Description	Activity	Time	Exposure		Man Rem
		(hours)	Pers-hours	Pers-hours	
Drywell Head Laydown	Conc Wash	8.4	33.7	8.4	0.01
Drywell Head Laydown	Conc Rmvl	121.3	424.7	242.7	0.40
RPV Head Laydown	Conc Wash	3.0	12.1	3.0	0.00
RPV Head Laydown	Conc Rmvl	87.4	305.7	174.7	0.29
Space Frame	Conc Wash	1.2	5.0	1.2	0.00
Refueling Floor Cavities	Mtl Rmvl	54.1	297.3	188.9	0.31
Refuel Floor Alcove Pit	Conc Wash	2.3	9.3	2.3	0.00
RHR "A" Heat Exchanger Rm	Conc Wash	2.3	9.2	2.3	0.00
RHR "A" Heat Exchanger Rm	Conc Rmvl	33.0	115.5	66.0	0.11
RHR "B" Heat Exchanger Rm	Conc Wash	2.3	9.2	2.3	0.00
RHR "B" Heat Exchanger Rm	Conc Rmvl	33.0	115.5	66.0	0.11
Fuel Pool Cooling HX/Pump	Conc Wash	3.1	12.3	3.1	0.01
Fuel Pool Cooling HX/Pump	Conc Rmvl	70.6	247.0	141.1	0.23
RWCU Heat Exchanger Rm	Conc Wash	6.6	26.3	6.6	0.01
RWCU Heat Exchanger Rm	Conc Rmvl	56.8	198.7	113.5	0.19
Standby Liquid Control	Conc Wash	2.6	10.5	2.6	0.00
Instrument Rack Trough (9)	Conc Wash	0.6	2.3	0.6	0.00
RWCU Pump Rm	Conc Wash	1.3	5.1	1.3	0.00
RWCU Pump Rm	Conc Rmvl	37.0	129.4	73.9	0.12
CRD HCU Area East	Conc Wash	4.7	18.9	4.7	0.01
CRD HCU Area East	Conc Rmvl	27.3	95.4	54.5	0.09
CRD HCU Area West	Conc Wash	4.3	17.1	4.3	0.01
CRD HCU Area West	Conc Rmvl	24.6	86.1	49.2	0.08
Scram Discharge Volume Area	Conc Wash	0.9	3.5	0.9	0.00
Recirc HPU Area (2)	Conc Wash	0.7	2.7	0.7	0.00
CRD Repair Room	Conc Wash	4.1	16.4	4.1	0.01
CRD Repair Room	Conc Rmvl	118.1	413.3	236.2	0.39
TIP Room	Conc Wash	0.9	3.8	0.9	0.00
TIP Room	Conc Rmvl	16.2	56.6	32.4	0.05
Main Steam Tunnel	Conc Wash	2.5	9.9	2.5	0.00
Main Steam Tunnel	Conc Rmvl	71.3	249.4	142.5	0.23
Drywell Floor	Conc Wash	16.9	67.5	16.9	0.03
Drywell Floor	Conc Rmvl	486.0	1,701.0	972.0	1.59
Under Vessel CRD Area	Conc Wash	1.1	4.2	1.1	0.00
Under Vessel CRD Area	Conc Rmvl	30.5	106.7	61.0	0.10
Instrument Racks (8 racks)	Conc Wash	0.2	0.9	0.2	0.00
North Valve Room	Conc Wash	0.9	3.5	0.9	0.00
South Valve Room	Conc Wash	1.0	4.2	1.0	0.00
Wetwell Floor	Conc Wash	20.9	83.5	20.9	0.03
Wetwell Floor	Conc Rmvl	601.3	2,104.7	1,202.7	1.97
Control Rod Drive Pump Rm	Conc Wash	6.6	26.4	6.6	0.01
Control Rod Drive Pump Rm	Conc Wash	4.0	15.9	4.0	0.01
RCIC Pump Rm	Conc Wash	3.5	14.2	3.5	0.01
RCIC Pump Rm	Conc Rmvl	30.6	107.1	61.2	0.10
RHR "A" Pump Room	Conc Wash	5.0	19.9	5.0	0.01
RHR "A" Pump Room	Conc Rmvl	14.4	50.4	28.8	0.05
RHR "B" Pump Room	Conc Wash	6.7	26.7	6.7	0.01
RHR "B" Pump Room	Conc Rmvl	19.2	67.2	38.4	0.06
RHC "C" Pump Room	Conc Wash	3.9	15.4	3.9	0.01
LPCS Pump Room	Conc Wash	2.5	9.8	2.5	0.00
HPCS Pump Room	Conc Wash	2.5	9.8	2.5	0.00

FIGURE C.5b. Partial CECF Output File for Building Decontamination, Example 2

+++++
+ BUILDING DECONTAMINATION: COSTS +
+++++

*** Reactor Bldg

Component Description	Activity	Removal	Container	Transport	Disposal
Drywell Head Laydown	Conc Wash	1,163	0	0	2,527
Drywell Head Laydown	Conc Rmvl	17,278	545	60	7,258
RPV Head Laydown	Conc Wash	419	0	0	910
RPV Head Laydown	Conc Rmvl	12,437	392	43	5,224
Space Frame	Conc Wash	173	0	0	375
Refueling Floor Cavities	Mtl Rmvl	10,383	25,889	945	217,364
Refuel Floor Alcove Pit	Conc Wash	322	0	0	700
RHR "A" Heat Exchanger Rm	Conc Wash	316	0	0	687
RHR "A" Heat Exchanger Rm	Conc Rmvl	4,697	148	16	1,973
RHR "B" Heat Exchanger Rm	Conc Wash	316	0	0	687
RHR "B" Heat Exchanger Rm	Conc Rmvl	4,697	148	16	1,973
Fuel Pool Cooling HX/Pump	Conc Wash	423	0	0	920
Fuel Pool Cooling HX/Pump	Conc Rmvl	10,048	317	35	4,221
RWCU Heat Exchanger Rm	Conc Wash	906	0	0	1,969
RWCU Heat Exchanger Rm	Conc Rmvl	8,083	255	28	3,395
Standby Liquid Control	Conc Wash	362	0	0	786
Instrument Rack Trough (9)	Conc Wash	79	0	0	173
RWCU Pump Rm	Conc Wash	177	0	0	385
RWCU Pump Rm	Conc Rmvl	5,263	166	18	2,211
CRD HCU Area East	Conc Wash	652	0	0	1,417
CRD HCU Area East	Conc Rmvl	3,880	122	13	1,630
CRD HCU Area West	Conc Wash	590	0	0	1,282
CRD HCU Area West	Conc Rmvl	3,504	111	12	1,472
Scram Discharge Volume Area	Conc Wash	120	0	0	260
Recirc HPU Area (2)	Conc Wash	92	0	0	200
CRD Repair Room	Conc Wash	566	0	0	1,230
CRD Repair Room	Conc Rmvl	16,814	530	58	7,063
TIP Room	Conc Wash	129	0	0	281
TIP Room	Conc Rmvl	2,303	73	8	967
Main Steam Tunnel	Conc Wash	342	0	0	742
Main Steam Tunnel	Conc Rmvl	10,147	320	35	4,263
Drywell Floor	Conc Wash	2,329	0	0	5,063
Drywell Floor	Conc Rmvl	69,200	2,183	239	29,068
Under Vessel CRD Area	Conc Wash	146	0	0	318
Under Vessel CRD Area	Conc Rmvl	4,341	137	15	1,824
Instrument Racks (8 racks)	Conc Wash	32	0	0	70
North Valve Room	Conc Wash	121	0	0	262
South Valve Room	Conc Wash	144	0	0	312
Wetwell Floor	Conc Wash	2,882	0	0	6,264
Wetwell Floor	Conc Rmvl	85,623	2,701	295	35,967
Control Rod Drive Pump Rm	Conc Wash	911	0	0	1,980
Control Rod Drive Pump Rm	Conc Wash	547	0	0	1,189
RCIC Pump Rm	Conc Wash	489	0	0	1,062
RCIC Pump Rm	Conc Rmvl	4,358	137	15	1,830
RHR "A" Pump Room	Conc Wash	688	0	0	1,495
RHR "A" Pump Room	Conc Rmvl	2,049	65	7	861
RHR "B" Pump Room	Conc Wash	920	0	0	1,999
RHR "B" Pump Room	Conc Rmvl	2,734	86	9	1,149
RHC "C" Pump Room	Conc Wash	531	0	0	1,155
LPCS Pump Room	Conc Wash	338	0	0	735
HPCS Pump Room	Conc Wash	338	0	0	735

FIGURE C.5c. Partial CECP Output File for Building Decontamination, Example 3

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+++++
+ SUMMARY OF BUILDING DECONTAMINATION COSTS (ALL COSTS IN DOLLARS) +
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*** Reactor Bldg

Concrete Washing--

Surface Area:	30,537 ft2
Decon Costs:	17,562
Crew Hours:	127
Pers-Hours:	509
Pers-Rem:	0.21

Metal Washing--

Surface Area:	33,906 ft2
Decon Costs:	22,497
Crew Hours:	163
Pers-Hours:	653
Pers-Rem:	0.27

Concrete Removal--

Surface Area:	15,653 ft2
Weight Removed:	187,840 lb
Removal Costs:	267,457
Container Costs:	8,437
Shipping Costs:	922
Burial Costs:	112,348
Burial Volume:	2,317 ft3
Number of Drums:	313.07
Crew Hours:	1,878
Pers-Hours:	6,574
Pers-Rem:	6.15

Metal Removal--

Surface Area:	51,926 ft2
Weight Removed:	540,900 lb
Removal Costs:	31,769
Container Costs:	74,599
Shipping Costs:	2,723
Burial Costs:	626,342
Burial Volume:	9,616 ft3
Number of Vans:	15.02
Crew Hours:	165
Pers-Hours:	910
Pers-Rem:	0.95

FIGURE C.5d. Partial CECP Output File for Building Decontamination, Example 4

COSTS (IN DOLLARS) FOR REACTOR PRESSURE VESSEL AND INTERNALS

REACTOR PRESSURE VESSEL	CUTTING	CONTAINERS	TRANSPORT	DISPOSAL	TOTAL
Insulation	0	7,300	181	131,906	139,387
Upper Flange	7,404	4,300	604	33,928	46,235
Upper Head	6,136	2,800	317	17,306	26,559
Lower Flange	5,454	4,000	604	30,048	40,106
Non-Act. RPV Wall	28,585	25,550	3,171	174,659	231,965
Act. RPV Wall	48,492	86,400	111,040	138,411	384,343
Lower Head	11,862	6,020	1,268	69,864	89,014
Nozzles	11,999	19,860	725	166,747	199,330
Studs & Nuts	0	4,380	362	20,357	25,099
Skirt, Base Ring, & Collar	11,453	19,860	725	166,747	198,785
TOTALS FOR RPV	131,385	180,470	118,998	949,971	1,380,823

RPV INTERNAL COMPONENTS	CUTTING	CONTAINERS	TRANSPORT	DISPOSAL	TOTAL
Core Shroud	63,577	13,000	418,233	1,365,000	1,859,811
Top Fuel Guide	167,607	2,080	87,668	218,400	475,755
Shroud Support	20,280	6,570	544	30,535	57,928
Jet Pumps & Support Ring	64,962	16,695	145,651	663,367	890,676
Core Support Plate	83,476	14,085	36,757	36,804	171,122
Orif. Fuel Supports	0	4,695	29,347	14,783	48,825
CRD Guides	239,478	9,390	32,436	36,921	318,225
Limiters, Housings, Inst. Guides	89,506	14,895	544	125,060	230,004
Steam Separator	149,956	33,945	37,142	241,798	462,841
Steam Dryer	12,060	14,895	544	125,060	152,559
TOTALS FOR RPV INTERNALS	890,902	130,250	788,867	2,857,727	4,667,746

RPV Internals

Crew Hours	Pers Hours	Exposure Hours	Pers-Rem
4,113.24	37,019.13	2,613.62	209.09

PRESSURE VESSEL

Crew Hours	Pers Hours	Exposure Hours	Pers-Rem
606.59	5,459.35	385.44	39.57

FIGURE C.6. CECP Output File for RPV Internals

TABLE C.1. DECON Case for Reference BWR, Hanford Burial Site

Final Summary Report for DECON

PERIOD 1: Planning and Preparation (Year -2.5000 to Year 0.0000)

	Costs (dollars)										
Undistributed Costs	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
Utility Staff	0	0	0	0	0	851,203	851,203	0	0	0	0.00
DOC Staff	0	0	0	0	0	4,827,733	4,827,733	0	0	0	0.00
Regulatory Costs	0	0	0	0	0	357,330	357,330	0	0	0	0.00
Special Tools and Equipment	0	0	0	0	0	3,422,975	3,422,975	0	0	0	0.00
Totals	0	0	0	0	0	9,459,241	9,459,241	0	0	0	0.00
Totals for PERIOD 1	0	0	0	0	0	9,459,241	9,459,241	0	0	0	0.00

PERIOD 2: Defuel and Layup (Year 0.0000 to Year 1.2000)

	Costs (dollars)										
Removal of NSSS	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
RPV Internals	0	890,902	130,250	788,867	2,857,727	0	4,667,746	8,500	4,113	37,019	209.09
Chemical Decontamination	13,250,000	0	0	0	466,302	0	13,716,302	4,600	1,408	8,448	45.70
RFC & D/S Pool Decon Costs	6,628	0	0	0	0	0	6,628	0	48	192	0.10
Totals	13,256,628	890,902	130,250	788,867	3,324,029	0	18,390,676	13,100	5,569	45,660	254.89

	----- Costs (dollars) -----										
Dry Active Waste Costs for this Period	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
Dry Active Waste	0	0	9,381	830	126,602	0	136,813	2,611	0	0	0.00

	Costs (dollars)										
Undistributed Costs	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
Utility Staff	0	0	0	0	0	16,660,453	16,660,453	0	0	169,728	169.73
Regulatory Costs	0	0	0	0	0	431,160	431,160	0	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	58,324	58,324	0	0	0	0.00
Laundry Services	0	0	0	0	0	565,392	565,392	0	0	0	0.00
Small Tools and Minor Equipment	0	0	0	0	0	17,818	17,818	0	0	0	0.00
Chemical Decontamination Energy	0	0	0	0	0	238,000	238,000	0	0	0	0.00
Plant Power Usage	0	0	0	0	0	1,135,296	1,135,296	0	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	3,195,120	3,195,120	0	0	0	0.00
Totals	0	0	0	0	0	22,301,563	22,301,563	0	0	169,728	169.73
Totals for PERIOD 2	13,256,628	890,902	139,631	789,697	3,450,631	22,301,563	40,829,051	15,711	5,569	215,388	424.61

TABLE C.1. (contd)

PERIOD 3: Spent Fuel Pool Operations (Year 1.2000 to Year 4.6000)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Undistributed Costs										
Utility Staff	0	0	0	0	0	1,435,261	0	0	12,022	10.27
DOC Staff	0	0	0	0	0	965,545	0	0	0	0.00
Regulatory Costs	0	0	0	0	0	86,761	0	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	16,524	0	0	0	0.00
Laundry Services	0	0	0	0	0	31,559	0	0	0	0.00
Plant Power Usage	0	0	0	0	0	18,361	0	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	2,040,000	0	0	0	0.00
Totals	0	0	0	0	0	4,594,011	0	0	12,022	10.27
Totals for PERIOD 3	0	0	0	0	0	4,594,011	0	0	12,022	10.27

PERIOD 4: Deferred Dismantlement (Year 4.6000 to Year 6.3000)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Removal of NSSS										
Reactor Pressure Vessel and Insulation	0	131,385	180,470	118,998	949,971	0	13,152	607	5,459	39.57
Sacrificial Shield	0	750,000	63,000	10,872	1,112,261	0	9,759	720	3,600	24.95
Recirculation Pumps	0	16,224	0	600	252,852	0	5,214	33	180	1.87
RCS Piping	0	1,041,231	475,837	18,744	2,846,048	0	33,102	5,397	29,683	261.59
RCS Piping Insulation	0	0	23,175	1,151	418,753	0	8,635	0	0	0.00
Main Turbine	0	243,372	476,640	21,681	4,001,921	0	61,440	1,280	7,040	2.37
Main Turbine Condenser	28,927	465,637	283,250	13,180	4,799,854	0	85,800	2,315	12,564	4.36
Moisture Separator Reheaters	3,099	116,362	60,860	2,476	524,469	0	7,960	635	3,456	1.20
Feed Water Heaters	17,453	48,674	8,000	5,328	1,512,736	0	27,680	384	1,920	0.67
Turbine Feed Pumps	4,363	9,126	5,465	1,521	275,883	0	5,074	80	392	0.14
Structural Beams, Plates, & Cable Trays	0	440,350	151,800	5,980	863,555	0	10,560	2,316	12,738	4.42
Spent Fuel Racks	0	826,875	79,579	3,241	727,988	0	11,717	444	4,000	1.09
Spent Fuel Pool Decon Costs	5,539	0	0	0	0	0	0	40	161	0.04
Spent Fuel Pool Water Treatment Costs	450,000	0	23,475	18,988	40,554	0	600	432	2,592	1.20
Totals	509,382	4,089,236	1,831,551	222,760	18,326,843	0	280,693	14,682	83,785	343.47

TABLE C.1. (contd)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Removal of Contaminated Plant Systems										
Control Rod Drive System	0	419,204	66,566	2,429	578,814	0	1,067,013	8,580	3,037	12,178
Feed and Condensate	0	67,607	181,919	6,639	1,527,412	0	1,783,578	23,450	343	1,812
Chemical Waste Processing	0	65,141	17,552	641	147,372	0	230,706	2,263	357	1,858
Containment Instrument Air	0	10,399	2,133	78	17,911	0	30,522	275	73	303
Fuel Pool Cooling and Cleanup	0	61,276	9,251	338	77,892	0	148,756	1,192	327	1,751
Condensate Demineralizers	0	109,552	27,752	1,013	233,198	0	371,515	3,577	581	3,126
Equipment Drain Processing	0	72,531	15,988	584	134,238	0	223,341	2,061	384	2,066
Extraction Steam	0	34,293	35,137	1,282	295,017	0	365,729	4,529	178	979
High/Low Pressure Core Spray	0	17,009	20,381	744	171,124	0	209,258	2,627	94	474
Miscellaneous Drains	0	9,721	2,321	85	19,484	0	31,610	299	51	278
Main Steam and MS Leakage Control	0	100,597	80,604	2,942	676,761	0	860,904	10,390	587	2,826
Radioactive Floor Drain Processing	0	61,567	9,496	347	79,727	0	151,136	1,224	329	1,758
Turbine & Rad Waste Bldg. Drains	0	16,834	2,990	109	25,105	0	45,038	385	99	482
Offgas	0	68,596	19,982	729	167,772	0	257,079	2,576	372	1,956
Reactor Building Closed Cooling Water	0	40,021	12,704	464	106,668	0	159,857	1,638	216	1,140
Reactor Core Isolation Cooling	0	21,223	6,607	241	55,471	0	83,542	852	120	609
Residual Heat Removal	0	80,949	93,087	3,397	781,948	0	959,382	11,999	426	2,286
Misc. Recirculation System Components	0	3,429	10,120	369	84,971	0	98,890	1,305	18	98
Reactor Water Cleanup	0	51,655	14,435	527	121,198	0	187,815	1,861	279	1,475
Reactor Building Equipment & Floor Drains	0	27,878	2,769	101	23,245	0	53,992	357	152	796
Sample System	0	11,682	349	13	2,930	0	14,973	45	68	337
Standby Gas Treatment	0	10,974	12,328	450	103,510	0	127,263	1,589	73	303
Heater Vents and Drains	0	126,994	60,138	2,195	504,925	0	694,252	7,752	660	3,632
Miscellaneous Items	0	235,156	31,884	1,164	275,090	0	543,294	4,110	1,425	6,735
Other Piping	0	3,719,826	233,902	8,537	2,258,891	0	6,221,156	30,151	19,314	106,229
Totals	0	5,444,112	970,397	35,416	8,470,674	0	14,920,599	125,086	29,563	155,486
	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Decontamination of Site Buildings										
Reactor Bldg	40,059	299,227	83,036	3,644	738,689	0	1,164,656	11,933	2,334	8,647
Rad Waste/Control Bldg	13,363	81,733	4,701	354	51,810	0	151,961	971	667	2,406
Turbine Generator Bldg	5,503	27,504	2,990	167	29,031	0	65,195	502	229	845
Waste Water Solidification Costs	141,560	0	31,300	28,589	49,442	0	250,891	808	389	1,167
Removal of HVAC Ducts	0	289,831	40,150	1,993	761,531	0	1,093,505	14,960	3,443	10,330
Removal of HVAC Equipment	0	68,351	61,410	4,143	1,138,636	0	1,272,540	22,096	363	1,813
Building Cranes	72,399	131,622	10,950	544	221,821	0	437,336	4,080	588	3,132
Floor Drains	0	378,911	12,077	848	97,137	0	488,973	1,797	2,613	7,840
Totals	272,884	1,277,179	246,614	40,282	3,088,099	0	4,925,057	57,147	10,627	36,180
	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Dry Active Waste Costs for this Period										
Dry Active Waste	0	0	92,425	8,177	1,247,350	0	1,347,953	25,721	0	0

TABLE C.1. (contd)

Site Termination Survey	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
Termination Survey Costs	0	0	0	0	0	1,058,344	1,058,344	0	0	0	0.00
----- Costs (dollars) -----											
Undistributed Costs	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
Utility Staff	0	0	0	0	0	4,897,730	4,897,730	0	0	29,328	16.01
DOC Staff	0	0	0	0	0	11,271,449	11,271,449	0	0	69,888	38.16
Consultant/Other Staff	0	0	0	0	0	121,100	121,100	0	0	0	0.00
DOC Mobilization/Demobilization Costs	0	0	0	0	0	2,640,000	2,640,000	0	0	0	0.00
Regulatory Costs	0	0	0	0	0	610,810	610,810	0	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	82,625	82,625	0	0	0	0.00
Laundry Services	0	0	0	0	0	983,500	983,500	0	0	0	0.00
Small Tools and Minor Equipment	0	0	0	0	0	219,914	219,914	0	0	0	0.00
Plant Power Usage	0	0	0	0	0	1,608,336	1,608,336	0	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	2,037,620	2,037,620	0	0	0	0.00
Totals	0	0	0	0	0	24,473,084	24,473,084	0	0	99,216	54.18
Totals for PERIOD 4	782,266	10,810,527	3,140,987	306,635	31,132,967	25,531,428	71,704,809	488,648	54,872	374,667	527.60
=====											
GRAND TOTALS	14,038,894	11,701,429	3,280,618	1,096,332	34,583,597	61,886,243	126,587,112	504,359	60,441	602,077	962.48
GRAND TOTALS with 25% contingency	17,548,617	14,626,787	4,100,772	1,370,415	43,229,496	77,357,803	158,233,890	504,359	60,441	602,077	962.48

Listed below are the fractions of the total cost that are attributable to labor and materials (A), energy and transportation (B), and waste burial (C). Property taxes and nuclear liability insurance are not included.

Cost Category	Cost Fraction	Costs (Dollars) w/o Contingency	Costs (Dollars) with 25% Contingency
A (labor and materials):	0.676	80,634,451	100,793,063
B (energy and transportation):	0.034	4,096,324	5,120,406
C (waste burial):	0.290	34,583,597	43,229,496
A + B + C (\$)		119,314,372	149,142,965
Taxes and Insurance (\$)		7,272,740	9,090,925
Grand Totals (\$)		126,587,112	158,233,890

TABLE C.2. DECON Case for Reference BWR, Barnwell Burial Site

Final Summary Report for BARNWELL

PERIOD 1: Planning and Preparation (Year -2.5000 to Year 0.0000)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Undistributed Costs										
Utility Staff	0	0	0	0	0	851,203	851,203	0	0	0.00
DOC Staff	0	0	0	0	0	4,827,733	4,827,733	0	0	0.00
Regulatory Costs	0	0	0	0	0	357,330	357,330	0	0	0.00
Special Tools and Equipment	0	0	0	0	0	3,422,975	3,422,975	0	0	0.00
Totals	0	0	0	0	0	9,459,241	9,459,241	0	0	0.00
Totals for PERIOD 1	0	0	0	0	0	9,459,241	9,459,241	0	0	0.00

PERIOD 2: Defuel and Layup (Year 0.0000 to Year 1.2000)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Removal of NSSS										
RPV Internals	0	890,902	130,250	1,327,288	5,388,107	0	7,736,547	8,500	4,113	37,019
Chemical Decontamination	13,250,000	0	0	0	2,105,580	0	15,355,580	4,600	1,408	8,448
RFC & D/S Pool Decon Costs	6,628	0	0	0	0	0	6,628	0	48	192
Totals	13,256,628	890,902	130,250	1,327,288	7,493,687	0	23,098,755	13,100	5,569	45,660

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Dry Active Waste Costs for this Period										
Dry Active Waste	0	0	9,381	18,824	732,061	0	760,267	2,611	0	0.00

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Undistributed Costs										
Utility Staff	0	0	0	0	0	16,660,453	16,660,453	0	0	169,728
Regulatory Costs	0	0	0	0	0	431,160	431,160	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	58,324	58,324	0	0	0.00
Laundry Services	0	0	0	0	0	565,392	565,392	0	0	0.00
Small Tools and Minor Equipment	0	0	0	0	0	17,818	17,818	0	0	0.00
Chemical Decontamination Energy	0	0	0	0	0	238,000	238,000	0	0	0.00
Plant Power Usage	0	0	0	0	0	1,135,296	1,135,296	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	3,195,120	3,195,120	0	0	0.00
Totals	0	0	0	0	0	22,301,563	22,301,563	0	0	169,728
Totals for PERIOD 2	13,256,628	890,902	139,631	1,346,112	8,225,748	22,301,563	46,160,585	15,711	5,569	215,388

TABLE C.2. (contd)

PERIOD 3: Spent Fuel Pool Operations (Year 1.2000 to Year 4.6000)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Ren
	Decon	Remove	Package	Ship	Bury	Undist				
Undistributed Costs										
Utility Staff	0	0	0	0	0	1,435,261	0	0	12,022	10.27
DOC Staff	0	0	0	0	0	965,545	0	0	0	0.00
Regulatory Costs	0	0	0	0	0	86,761	0	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	16,524	0	0	0	0.00
Laundry Services	0	0	0	0	0	31,559	0	0	0	0.00
Plant Power Usage	0	0	0	0	0	18,361	0	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	2,040,000	0	0	0	0.00
Totals	0	0	0	0	0	4,594,011	0	0	12,022	10.27
Totals for PERIOD 3	0	0	0	0	0	4,594,011	0	0	12,022	10.27

PERIOD 4: Deferred Dismantlement (Year 4.6000 to Year 6.3000)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Ren
	Decon	Remove	Package	Ship	Bury	Undist				
Removal of NSSS	0	131,385	180,470	1,110,607	4,489,266	0	5,911,728	13,152	607	5,459
Reactor Pressure Vessel and Insulation	0	750,000	63,000	246,605	2,927,680	0	3,987,285	9,759	720	3,600
Sacrificial Shield	0	16,224	0	31,279	1,462,089	0	1,509,592	5,214	33	180
Recirculation Pumps	0	1,041,231	475,837	425,160	9,611,720	0	11,553,948	33,102	5,397	29,683
RCS Piping	0	0	23,175	26,096	2,425,678	0	2,474,949	8,635	0	0
RCS Piping Insulation	0	243,372	476,640	778,628	17,693,874	0	19,192,514	61,440	1,280	7,040
Main Turbine	28,927	465,637	283,250	463,341	24,440,743	0	25,681,898	85,800	2,315	12,564
Main Turbine Condenser	3,099	116,362	60,860	63,125	2,277,516	0	2,520,963	7,960	635	3,456
Moisture Separator Reheaters	17,453	48,674	8,000	303,898	7,971,515	0	8,349,541	27,680	384	1,920
Feed Water Heaters	4,363	9,126	5,465	50,112	1,458,656	0	1,527,722	5,074	80	392
Turbine Feed Pumps	0	440,350	151,800	135,633	3,066,298	0	3,794,081	10,560	2,316	12,738
Structural Beams, Plates, & Cable Trays	0	826,875	79,579	105,067	3,344,534	0	4,356,055	11,717	444	4,000
Spent Fuel Racks	5,539	0	0	0	0	0	5,539	0	40	161
Spent Fuel Pool Decon Costs	450,000	0	23,475	30,239	224,280	0	727,993	600	432	2,592
Spent Fuel Pool Water Treatment Costs										
Totals	509,382	4,089,236	1,831,551	3,769,789	81,393,850	0	91,593,808	280,693	14,682	83,785

TABLE C.2. (contd)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Removal of Contaminated Plant Systems										
Control Rod Drive System	0	419,204	66,566	55,104	2,448,810	0	2,989,684	8,580	3,037	12,178
Feed and Condensate	0	67,607	181,919	150,595	6,692,397	0	7,092,518	23,450	343	1,812
Chemical Waste Processing	0	65,141	17,552	14,530	645,713	0	742,936	2,263	357	1,858
Containment Instrument Air	0	10,399	2,133	1,766	78,479	0	92,777	275	73	303
Fuel Pool Cooling and Cleanup	0	61,276	9,251	7,658	340,310	0	418,494	1,192	327	1,751
Condensate Demineralizers	0	109,552	27,752	22,974	1,020,952	0	1,181,230	3,577	581	3,126
Equipment Drain Processing	0	72,531	15,988	13,235	588,167	0	689,922	2,061	384	2,066
Extraction Steam	0	34,293	35,137	29,087	1,292,623	0	1,391,140	4,529	178	979
High/Low Pressure Core Spray	0	17,009	20,381	16,872	749,784	0	804,047	2,627	94	474
Miscellaneous Drains	0	9,721	2,321	1,921	85,369	0	99,332	299	51	278
Main Steam and MS Leakage Control	0	100,597	80,604	66,725	2,965,246	0	3,213,173	10,390	587	2,826
Radioactive Floor Drain Processing	0	61,567	9,496	7,861	349,326	0	428,249	1,224	329	1,758
Turbine & Rad Waste Bldg. Drains	0	16,834	2,990	2,475	109,997	0	132,296	385	99	482
Offgas	0	68,596	19,982	16,541	735,097	0	840,216	2,576	372	1,956
Reactor Building Closed Cooling Water	0	40,021	12,704	10,517	467,369	0	530,612	1,638	216	1,140
Reactor Core Isolation Cooling	0	21,223	6,607	5,469	243,048	0	276,347	852	120	609
Residual Heat Removal	0	80,949	93,087	77,058	3,424,451	0	3,675,546	11,999	426	2,286
Misc. Recirculation System Components	0	3,429	10,120	8,378	372,304	0	394,231	1,305	18	98
Reactor Water Cleanup	0	51,655	14,435	11,950	531,033	0	609,073	1,861	279	1,475
Reactor Building Equipment & Floor Drains	0	27,878	2,769	2,292	101,848	0	134,786	357	152	796
Sample System	0	11,682	349	289	12,836	0	25,156	45	68	337
Standby Gas Treatment	0	10,974	12,328	10,206	453,533	0	487,042	1,589	73	303
Heater Vents and Drains	0	126,994	60,138	49,783	2,212,343	0	2,449,258	7,752	660	3,632
Miscellaneous Items	0	235,156	31,884	26,394	1,172,949	0	1,466,383	4,110	1,425	6,735
Other Piping	0	3,719,826	233,902	193,627	8,604,744	0	12,752,099	30,151	19,314	106,229
Totals	0	5,444,112	970,397	803,307	35,698,729	0	42,916,545	125,086	29,563	155,486
	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Decontamination of Site Buildings										
Reactor Bldg	40,059	299,227	83,036	82,663	3,393,971	0	3,898,957	11,933	2,334	8,647
Rad Waste/Control Bldg	13,363	81,733	4,701	8,032	273,808	0	381,636	971	667	2,406
Turbine Generator Bldg	5,503	27,504	2,990	3,792	142,088	0	181,877	502	229	845
Waste Water Solidification Costs	141,560	0	31,300	82,244	293,300	0	548,404	808	389	1,167
Removal of HVAC Ducts	0	289,831	40,150	45,211	2,487,658	0	2,862,850	14,960	3,443	10,330
Removal of HVAC Equipment	0	68,351	61,410	78,351	6,230,757	0	6,438,869	22,096	363	1,813
Building Cranes	72,399	131,622	10,950	12,330	1,151,137	0	1,378,439	4,080	588	3,132
Floor Drains	0	378,911	12,077	19,239	526,501	0	936,727	1,797	2,613	7,840
Totals	272,884	1,277,179	246,614	331,863	14,499,221	0	16,627,760	57,147	10,627	36,180
	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Dry Active Waste Costs for this Period										
Dry Active Waste	0	0	92,425	185,468	7,212,671	0	7,490,564	25,721	0	0.00

TABLE C.2. (contd)

Site Termination Survey Termination Survey Costs	Costs (dollars)							Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist	Total				
	0	0	0	0	0	1,058,344	1,058,344	0	0	0	0.00
Undistributed Costs	Costs (dollars)							Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist	Total				
Utility Staff	0	0	0	0	0	4,897,730	4,897,730	0	0	29,328	16.01
DOC Staff	0	0	0	0	0	11,271,449	11,271,449	0	0	69,888	38.16
Consultant/Other Staff	0	0	0	0	0	121,100	121,100	0	0	0	0.00
DOC Mobilization/Demobilization Costs	0	0	0	0	0	2,640,000	2,640,000	0	0	0	0.00
Regulatory Costs	0	0	0	0	0	610,810	610,810	0	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	82,625	82,625	0	0	0	0.00
Laundry Services	0	0	0	0	0	983,500	983,500	0	0	0	0.00
Small Tools and Minor Equipment	0	0	0	0	0	219,914	219,914	0	0	0	0.00
Plant Power Usage	0	0	0	0	0	1,608,336	1,608,336	0	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	2,037,620	2,037,620	0	0	0	0.00
Totals	0	0	0	0	0	24,473,084	24,473,084	0	0	99,216	54.18
Totals for PERIOD 4	782,266	10,810,527	3,140,987	5,090,427	138,804,470	25,531,428	184,160,105	488,648	54,872	374,667	527.60
GRAND TOTALS	14,038,894	11,701,429	3,280,618	6,436,540	147,030,218	61,886,243	244,373,941	504,359	60,441	602,077	962.48
GRAND TOTALS with 25% contingency	17,548,617	14,626,787	4,100,772	8,045,674	183,787,772	77,357,803	305,467,426	504,359	60,441	602,077	962.48

Listed below are the fractions of the total cost that are attributable to labor and materials (A), energy and transportation (B), and waste burial (C).
Property taxes and nuclear liability insurance are not included.

Cost Category	Cost Fraction	Costs (Dollars)	
		w/o Contingency	with 25% Contingency
A (labor and materials):	0.340	80,634,451	100,793,063
B (energy and transportation):	0.040	9,436,532	11,795,665
C (waste burial):	0.620	147,030,218	183,787,772
A + B + C (\$)		237,101,201	296,376,501
Taxes and Insurance (\$)		7,272,740	9,090,925
Grand Totals (\$)		244,373,941	305,467,426

TABLE C.3. SAFSTOR Case for Reference BWR, Hanford Burial Site

Final Summary Report for SSI

PERIOD 1: Planning and Preparation (Year -2.5000 to Year 0.0000)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Undistributed Costs										
Utility Staff	0	0	0	0	0	851,203	851,203	0	0	0.00
DOC Staff	0	0	0	0	0	4,827,733	4,827,733	0	0	0.00
Regulatory Costs	0	0	0	0	0	357,330	357,330	0	0	0.00
Special Tools and Equipment	0	0	0	0	0	3,422,975	3,422,975	0	0	0.00
Totals	0	0	0	0	0	9,459,241	9,459,241	0	0	0.00
Totals for PERIOD 1	0	0	0	0	0	9,459,241	9,459,241	0	0	0.00

PERIOD 2: Defuel and Layup (Year 0.0000 to Year 1.2000)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Removal of NSSS										
RPV Internals	0	890,902	130,250	788,867	2,857,727	0	4,667,746	8,500	4,113	37,019
Chemical Decontamination	13,250,000	0	0	0	466,302	0	13,716,302	4,600	1,408	8,448
RFC & D/S Pool Decon Costs	6,628	0	0	0	0	0	6,628	0	48	192
Totals	13,256,628	890,902	130,250	788,867	3,324,029	0	18,390,676	13,100	5,569	45,660

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Dry Active Waste Costs for this Period										
Dry Active Waste	0	0	9,381	830	126,602	0	136,813	2,611	0	0.00

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Undistributed Costs										
Utility Staff	0	0	0	0	0	16,660,453	16,660,453	0	0	169,728
Regulatory Costs	0	0	0	0	0	431,160	431,160	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	58,324	58,324	0	0	0.00
Laundry Services	0	0	0	0	0	565,392	565,392	0	0	0.00
Small Tools and Minor Equipment	0	0	0	0	0	17,818	17,818	0	0	0.00
Chemical Decontamination Energy	0	0	0	0	0	238,000	238,000	0	0	0.00
Plant Power Usage	0	0	0	0	0	1,135,296	1,135,296	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	3,195,120	3,195,120	0	0	0.00
Totals	0	0	0	0	0	22,301,563	22,301,563	0	0	169,728
Totals for PERIOD 2	13,256,628	890,902	139,631	789,697	3,450,631	22,301,563	40,829,051	15,711	5,569	215,388

TABLE C.3. (contd)

PERIOD 3: Spent Fuel Pool Operations (Year 1.2000 to Year 4.6000)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Undistributed Costs										
Utility Staff	0	0	0	0	0	1,435,261	1,435,261	0	0	12,022
Regulatory Costs	0	0	0	0	0	86,761	86,761	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	16,524	16,524	0	0	0.00
Laundry Services	0	0	0	0	0	31,559	31,559	0	0	0.00
Plant Power Usage	0	0	0	0	0	18,361	18,361	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	2,040,000	2,040,000	0	0	0.00
Totals	0	0	0	0	0	3,628,466	3,628,466	0	0	12,022
Totals for PERIOD 3	0	0	0	0	0	3,628,466	3,628,466	0	0	12,022

PERIOD 4: Extended Safe Storage (Year 4.6000 to Year 58.3000)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Layup Spent Fuel Pool										
Spent Fuel Pool Decon Costs	5,539	0	0	0	0	0	5,539	0	40	161
Spent Fuel Pool Water Treatment Costs	450,000	0	23,475	18,988	40,554	0	533,018	600	432	2,592
Totals	455,539	0	23,475	18,988	40,554	0	538,557	600	472	2,753
Dry Active Waste Costs for this Period										
Dry Active Waste	0	0	795	70	10,734	0	11,600	221	0	0.00
Undistributed Costs										
Utility Staff	0	0	0	0	0	62,719,126	62,719,126	0	0	223,392
DOC Staff	0	0	0	0	0	965,548	965,548	0	0	0.00
Regulatory Costs	0	0	0	0	0	14,168,423	14,168,423	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	2,609,981	2,609,981	0	0	0.00
Laundry Services	0	0	0	0	0	593,630	593,630	0	0	0.00
Maintenance Allowance	0	0	0	0	0	933,252	933,252	0	0	0.00
Plant Power Usage	0	0	0	0	0	478,467	478,467	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	32,220,000	32,220,000	0	0	0.00
Totals	0	0	0	0	0	114,688,427	114,688,427	0	0	223,392
Totals for PERIOD 4	455,539	0	24,270	19,059	51,288	114,688,427	115,238,583	821	472	226,145

TABLE C.3. (contd)

PERIOD 5: Deferred Dismantlement (Year 58.3000 to Year 58.6100)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rm
	Decon	Remove	Package	Ship	Bury	Undist				
Removal of NSSS										
Reactor Pressure Vessel and Insulation	0	131,385	180,470	118,998	942,394	0	1,373,246	13,152	607	5,459
Sacrificial Shield	0	750,000	63,000	10,872	1,112,261	0	1,936,133	9,759	720	3,600
Totals	0	881,385	243,470	129,870	2,054,654	0	3,309,379	22,911	1,327	9,059
	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rm
	Decon	Remove	Package	Ship	Bury	Undist				
Undistributed Costs										
Utility Staff	0	0	0	0	0	1,150,656	1,150,656	0	0	5,803
DOC Staff	0	0	0	0	0	2,245,926	2,245,926	0	0	14,186
Consultant/Other Staff	0	0	0	0	0	75,082	75,082	0	0	0
DOC Mobilization/Demobilization Costs	0	0	0	0	0	2,640,000	2,640,000	0	0	0
Regulatory Costs	0	0	0	0	0	111,383	111,383	0	0	0
Environmental Monitoring Costs	0	0	0	0	0	15,067	15,067	0	0	0
Laundry Services	0	0	0	0	0	76,251	76,251	0	0	0
Small Tools and Minor Equipment	0	0	0	0	0	17,628	17,628	0	0	0
Plant Power Usage	0	0	0	0	0	293,285	293,285	0	0	0
Nuclear Liability Insurance	0	0	0	0	0	371,566	371,566	0	0	0
Totals	0	0	0	0	0	6,996,844	6,996,844	0	0	19,989
Totals for PERIOD 5	0	881,385	243,470	129,870	2,054,654	6,996,844	10,306,223	22,911	1,327	29,048
GRAND TOTALS	13,712,167	1,772,287	407,371	938,625	5,556,573	157,074,540	179,461,564	39,443	7,368	482,603
GRAND TOTALS with 25% contingency	17,140,209	2,215,359	509,214	1,173,282	6,945,716	196,343,175	224,326,955	39,443	7,368	482,603

Listed below are the fractions of the total cost that are attributable to labor and materials (A), energy and transportation (B), and waste burial (C). Property taxes and nuclear liability insurance are not included.

Cost Category	Cost Fraction	Costs (Dollars) w/o Contingency	Costs (Dollars) with 25% Contingency
A (labor and materials):	0.939	132,976,272	166,220,339
B (energy and transportation):	0.022	3,102,034	3,877,542
C (waste burial):	0.039	5,556,573	6,945,716
A + B + C (\$)		141,634,878	177,043,598
Taxes and Insurance (\$)		37,826,686	47,283,357
Grand Totals (\$)		179,461,564	224,326,955

TABLE C.4. SAFSTOR2 Case for Reference BWR, Hanford Burial Site

Final Summary Report for SS2

PERIOD 1: Planning and Preparation (Year -2.5000 to Year 0.0000)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Undistributed Costs										
Utility Staff	0	0	0	0	0	851,203	851,203	0	0	0.00
DOC Staff	0	0	0	0	0	4,827,733	4,827,733	0	0	0.00
Regulatory Costs	0	0	0	0	0	357,330	357,330	0	0	0.00
Special Tools and Equipment	0	0	0	0	0	3,422,975	3,422,975	0	0	0.00
Totals	0	0	0	0	0	9,459,241	9,459,241	0	0	0.00
Totals for PERIOD 1	0	0	0	0	0	9,459,241	9,459,241	0	0	0.00

PERIOD 2: Defuel and Layup (Year 0.0000 to Year 1.2000)

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Removal of NSSS										
RPV Internals	0	890,902	130,250	788,867	2,857,727	0	4,667,746	8,500	4,113	37,019
Chemical Decontamination	13,250,000	0	0	0	466,302	0	13,716,302	4,600	1,408	8,448
RFC & D/S Pool Decon Costs	6,628	0	0	0	0	0	6,628	0	48	192
Totals	13,256,628	890,902	130,250	788,867	3,324,029	0	18,390,676	13,100	5,569	45,660

Dry Active Waste Costs for this Period
Dry Active Waste

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Dry Active Waste	0	0	9,381	830	126,602	0	136,813	2,611	0	0.00

	Costs (dollars)						Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
	Decon	Remove	Package	Ship	Bury	Undist				
Undistributed Costs										
Utility Staff	0	0	0	0	0	16,660,453	16,660,453	0	0	169,728
Regulatory Costs	0	0	0	0	0	431,160	431,160	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	58,324	58,324	0	0	0.00
Laundry Services	0	0	0	0	0	565,392	565,392	0	0	0.00
Small Tools and Minor Equipment	0	0	0	0	0	17,818	17,818	0	0	0.00
Chemical Decontamination Energy	0	0	0	0	0	238,000	238,000	0	0	0.00
Plant Power Usage	0	0	0	0	0	1,135,296	1,135,296	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	3,195,120	3,195,120	0	0	0.00
Totals	0	0	0	0	0	22,301,563	22,301,563	0	0	169,728
Totals for PERIOD 2	13,256,628	890,902	139,631	789,697	3,450,631	22,301,563	40,829,051	15,711	5,569	215,388

TABLE C.4. (contd)

PERIOD 3: Spent Fuel Pool Operations (Year 1.2000 to Year 4.6000)

	Costs (dollars)										
	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
Undistributed Costs											
Utility Staff	0	0	0	0	0	1,435,261	1,435,261	0	0	12,022	10.27
Regulatory Costs	0	0	0	0	0	86,761	86,761	0	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	16,524	16,524	0	0	0	0.00
Laundry Services	0	0	0	0	0	31,559	31,559	0	0	0	0.00
Plant Power Usage	0	0	0	0	0	18,361	18,361	0	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	2,040,000	2,040,000	0	0	0	0.00
Totals	0	0	0	0	0	3,628,466	3,628,466	0	0	12,022	10.27
Totals for PERIOD 3	0	0	0	0	0	3,628,466	3,628,466	0	0	12,022	10.27

PERIOD 4: Extended Safe Storage (Year 4.6000 to Year 58.3000)

	Costs (dollars)										
	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
Layup Spent Fuel Pool											
Spent Fuel Pool Decon Costs	5,539	0	0	0	0	0	5,539	0	40	161	0.04
Spent Fuel Pool Water Treatment Costs	450,000	0	23,475	18,988	40,554	0	533,018	600	432	2,592	1.20
Totals	455,539	0	23,475	18,988	40,554	0	538,557	600	472	2,753	1.24
Dry Active Waste Costs for this Period											
Dry Active Waste	0	0	795	70	10,734	0	11,600	221	0	0	0.00
Undistributed Costs											
Utility Staff	0	0	0	0	0	63,349,716	63,349,716	0	0	223,392	121.99
DOC Staff	0	0	0	0	0	1,931,092	1,931,092	0	0	0	0.00
Regulatory Costs	0	0	0	0	0	14,168,423	14,168,423	0	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	2,609,981	2,609,981	0	0	0	0.00
Laundry Services	0	0	0	0	0	593,630	593,630	0	0	0	0.00
Maintenance Allowance	0	0	0	0	0	933,252	933,252	0	0	0	0.00
Plant Power Usage	0	0	0	0	0	478,467	478,467	0	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	32,220,000	32,220,000	0	0	0	0.00
Totals	0	0	0	0	0	116,284,561	116,284,561	0	0	223,392	121.99
Totals for PERIOD 4	455,539	0	24,270	19,059	51,288	116,284,561	116,834,717	821	472	226,145	123.23

TABLE C.4. (contd)

PERIOD 5: Deferred Dismantlement (Year 58.3000 to Year 60.0000)

	Costs (dollars)											
	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem	
Removal of NSSS												
Reactor Pressure Vessel and Insulation	0	131,385	180,470	118,998	942,394	0	1,373,246	13,152	607	5,459	0.03	
Sacrificial Shield	0	750,000	63,000	10,872	1,112,261	0	1,936,133	9,759	720	3,600	0.02	
Recirculation Pumps	0	16,224	0	600	252,852	0	269,676	5,214	33	180	0.00	
RCS Piping	0	1,041,231	475,837	18,744	2,846,048	0	4,381,861	33,102	5,397	29,683	0.22	
RCS Piping Insulation	0	0	23,175	1,151	418,753	0	443,078	8,635	0	0	0.00	
Main Turbine	0	243,372	476,640	21,681	4,001,921	0	4,743,613	61,440	1,280	7,040	0.00	
Main Turbine Condenser	28,927	465,637	283,250	13,180	4,799,854	0	5,590,848	85,800	2,315	12,564	0.00	
Moisture Separator Reheaters	3,099	116,362	60,860	2,476	524,469	0	707,266	7,960	635	3,456	0.00	
Feed Water Heaters	17,453	48,674	8,000	5,328	1,512,736	0	1,592,191	27,680	384	1,920	0.00	
Turbine Feed Pumps	4,363	9,126	5,465	1,521	275,883	0	296,359	5,074	80	392	0.00	
Structural Beams, Plates, & Cable Trays	0	440,350	151,800	5,980	863,555	0	1,461,685	10,560	2,316	12,738	0.00	
Spent Fuel Racks	0	826,875	79,579	3,241	727,988	0	1,637,683	11,717	444	4,000	0.00	
Totals	53,843	4,089,236	1,808,076	203,772	18,278,712	0	24,433,639	280,093	14,210	81,033	0.29	
	Costs (dollars)											
	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem	
Removal of Contaminated Plant Systems												
Control Rod Drive System	0	419,204	66,566	2,429	558,894	0	1,047,093	8,580	3,037	12,178	0.01	
Feed and Condensate	0	67,607	181,919	6,639	1,527,412	0	1,783,578	23,450	343	1,812	0.00	
Chemical Waste Processing	0	65,141	17,552	641	147,372	0	230,706	2,263	357	1,858	0.00	
Containment Instrument Air	0	10,399	2,133	78	17,911	0	30,522	275	73	303	0.00	
Fuel Pool Cooling and Cleanup	0	61,276	9,251	338	77,669	0	148,533	1,192	327	1,751	0.00	
Condensate Demineralizers	0	109,552	27,752	1,013	233,013	0	371,330	3,577	581	3,126	0.00	
Equipment Drain Processing	0	72,531	15,988	584	134,238	0	223,341	2,061	384	2,066	0.00	
Extraction Steam	0	34,293	35,137	1,282	295,017	0	365,729	4,529	178	979	0.00	
High/Low Pressure Core Spray	0	17,009	20,381	744	171,124	0	209,258	2,627	94	474	0.00	
Miscellaneous Drains	0	9,721	2,321	85	19,484	0	31,610	299	51	278	0.00	
Main Steam and MS Leakage Control	0	100,597	80,604	2,942	676,761	0	860,904	10,390	587	2,826	0.00	
Radioactive Floor Drain Processing	0	61,567	9,496	347	79,727	0	151,136	1,224	329	1,758	0.00	
Turbine & Rad Waste Bldg. Drains	0	16,834	2,990	109	25,105	0	45,038	385	99	482	0.00	
Offgas	0	68,596	19,982	729	167,772	0	257,079	2,576	372	1,956	0.00	
Reactor Building Closed Cooling Water	0	40,021	12,704	464	106,668	0	159,857	1,638	216	1,140	0.00	
Reactor Core Isolation Cooling	0	21,223	6,607	241	55,471	0	83,542	852	120	609	0.00	
Residual Heat Removal	0	80,949	93,087	3,397	781,566	0	958,999	11,999	426	2,286	0.00	
Misc. Recirculation System Components	0	3,429	10,120	369	84,971	0	98,890	1,305	18	98	0.00	
Reactor Water Cleanup	0	51,655	14,435	527	121,198	0	187,815	1,861	279	1,475	0.03	
Reactor Building Equipment & Floor Drains	0	27,878	2,769	101	23,245	0	53,992	357	152	796	0.00	
Sample System	0	11,682	349	13	2,930	0	14,973	45	68	337	0.00	
Standby Gas Treatment	0	10,974	12,328	450	103,510	0	127,263	1,589	73	303	0.00	
Heater Vents and Drains	0	126,994	60,138	2,195	504,925	0	694,252	7,752	660	3,632	0.00	
Miscellaneous Items	0	235,156	31,884	1,164	267,703	0	535,907	4,110	1,425	6,735	0.00	
Other Piping	0	3,719,826	233,902	8,537	1,963,869	0	5,926,134	30,151	19,314	106,229	0.03	
Totals	0	5,444,112	970,397	35,416	8,147,556	0	14,597,481	125,086	29,563	155,486	0.09	

TABLE C.4. (contd)

	Costs (dollars)										
	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
Decontamination of Site Buildings											
Reactor Bldg	40,059	299,227	83,036	3,644	738,689	0	1,164,656	11,933	2,334	8,647	0.01
Rad Waste/Control Bldg	13,363	81,733	4,701	354	51,810	0	151,961	971	667	2,406	0.00
Turbine Generator Bldg	5,503	27,504	2,990	167	29,031	0	65,195	502	229	845	0.00
Waste Water Solidification Costs	141,560	0	31,300	28,589	49,442	0	250,891	808	389	1,167	0.32
Removal of HVAC Ducts	0	289,831	40,150	1,993	761,531	0	1,093,505	14,960	3,443	10,330	4.38
Removal of HVAC Equipment	0	68,351	61,410	4,143	1,138,636	0	1,272,540	22,096	363	1,813	2.81
Building Cranes	72,399	131,622	10,950	544	221,821	0	437,336	4,080	588	3,132	0.16
Floor Drains	0	378,911	12,077	848	97,137	0	488,973	1,797	2,613	7,840	1.66
Totals	272,884	1,277,179	246,614	40,282	3,088,099	0	4,925,057	57,147	10,627	36,180	9.33
	Costs (dollars)										
Dry Active Waste Costs for this Period	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
Dry Active Waste	0	0	91,630	8,106	1,236,616	0	1,336,353	25,500	0	0	0.00
	Costs (dollars)										
Site Termination Survey	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
Termination Survey Costs	0	0	0	0	0	1,058,344	1,058,344	0	0	0	0.00
	Costs (dollars)										
Undistributed Costs	Decon	Remove	Package	Ship	Bury	Undist	Total	Cu Ft	C-Hrs	Pers-Hrs	Pers-Rem
Utility Staff	0	0	0	0	0	5,841,789	5,841,789	0	0	29,328	0.01
DOC Staff	0	0	0	0	0	11,271,449	11,271,449	0	0	69,888	0.03
Consultant/Other Staff	0	0	0	0	0	121,100	121,100	0	0	0	0.00
DOC Mobilization/Demobilization Costs	0	0	0	0	0	2,640,000	2,640,000	0	0	0	0.00
Regulatory Costs	0	0	0	0	0	610,810	610,810	0	0	0	0.00
Environmental Monitoring Costs	0	0	0	0	0	82,625	82,625	0	0	0	0.00
Laundry Services	0	0	0	0	0	976,274	976,274	0	0	0	0.00
Small Tools and Minor Equipment	0	0	0	0	0	219,914	219,914	0	0	0	0.00
Plant Power Usage	0	0	0	0	0	1,608,336	1,608,336	0	0	0	0.00
Nuclear Liability Insurance	0	0	0	0	0	2,037,620	2,037,620	0	0	0	0.00
Totals	0	0	0	0	0	25,409,917	25,409,917	0	0	99,216	0.05
Totals for PERIOD 5	326,727	10,810,527	3,116,717	287,576	30,750,983	26,468,261	71,760,791	487,827	54,400	371,914	9.77
GRAND TOTALS	14,038,894	11,701,429	3,280,618	1,096,332	34,252,902	178,142,091	242,512,266	504,359	60,441	825,469	567.88
GRAND TOTALS with 25% contingency	17,548,617	14,626,787	4,100,772	1,370,415	42,816,128	222,677,614	303,140,332	504,359	60,441	825,469	567.88

TABLE C.4. (contd)

Listed below are the fractions of the total cost that are attributable to labor and materials (A), energy and transportation (B), and waste burial (C). Property taxes and nuclear liability insurance are not included.

Cost Category	Cost Fraction	Costs (Dollars) w/o Contingency	Costs (Dollars) with 25% Contingency
A (labor and materials):	0.809	164,191,833	205,239,791
B (energy and transportation):	0.023	4,574,791	5,718,489
C (waste burial):	0.169	34,252,902	42,816,128
		-----	-----
A + B + C (\$)		203,019,526	253,774,407
Taxes and Insurance (\$)		39,492,740	49,365,925
		=====	=====
Grand Totals (\$)		242,512,266	303,140,332

The inventories of system components for each system and the stainless steel piping inventory are presented in Table C.5. The weights of the valves listed are based on typical 600 psig service-rated gate valves. For most of the valves, which are in systems rated for 150 psig service, these estimates are conservative. For the limited number of valves associated with the primary coolant system and the steam system, these estimates are non-conservative. On the average, the estimated weights should be conservative. The volumes of the valves are estimated using a crude approximation to calculate the space occupied by the valve body and the valve stem and operator. Again, the estimates are considered to conservatively overestimate the actual volumes occupied by the valves.

TABLE C.5. Reference BWR System Components and Piping Inventories

Chemical Waste Processing System

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
2	Chemical Waste Tank	11066	Cyl 18.1 x 12.2 dia	2125
2	Detergent Drain Tank	4039	Cyl 7.9 x 6 dia	219
2	Detergent Drain Pump	385	3.3 x 1.3 x 1.7	7.2
2	Concentrator Feed Pump	559	3.6 x 1 x 2	7.2
2	Chemical Waste Pump	1054	4.3 x 1.3 x 1.7	9.3
1	Detergent Drain Filter	2495	Cyl 3 x 1 dia	2.3
2	Chemical Addition Tank	500	Cyl 4 x 2.6 dia	16.6
2	Tank Agitators	80	Cyl 8 x .4 dia	1
2	Chemical Addition Pump	385	3.3 x 1.3 x 1.7	7.2
2	Distillate Tank	11066	Cyl 18.1 x 12.2 dia	2125
2	Distillate Tank Pump	508	4 x 1 x 1.3	5.2
1	Dist. Polishing Demin.	999	Cyl 7.9 x 10.2 dia	651
2	Decon Sol. Concentrator	7500	Cyl 15.2 x 4 dia	187
2	Decon Sol. Conc. Tank	1566	Cyl 5.6 x 5.6 dia	139
2	Decon Conc. Recycle Pump	1857	5.6 x 2 x 3.6	40.3
2	Decon Concentrator Condensor	5078	Cyl 11.2 x 2.6 dia	61.4
2	Decon Concentrator Pre Heater	6923	Cyl 15.2 x 3 dia	105
1	Decon Concentrator Waste Pump	559	3.6 x 1.3 x 1.7	7.9
2	Chemical Waste Stream Mixer	245	1.8 x .8 x .8	1.1
2	Condensate Receiver Tank	2093	Cyl 10.2 x 3.8 dia	115.7
2	Cond Receiver Tk. Pump	225	3.6 x 1.3 x 1.3	6.3
2	8 in air operated valve	340		144.2
2	6 in MOV	180		7.0
3	6 in valve	180		7.0
4	4 in MOV	100		2.9
5	4 in valve	100		2.9
2	4 in check valve	80		2.3
2	4 in flow element	80		2.3
2	3 in MOV	65		1.2
15	3 in air operated valve	65		1.2
14	3 in valve	65		1.2
5	3 in check valve	60		1.0
1	3 in restricting orifice	60		1.0
1	3 in flow element	60		1.0
8	2 in air operated valve	40		.9
25	2 in valve	40		.9
7	2 in check valve	35		.7
2	2 in relief valve	40		.8
3	2 in flow element	35		.7

TABLE C.5. (contd)

Chemical Waste Processing System (contd)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
3	1-1/2 in air operated	35		.8
31	1-1/2 in valve	35		.8
8	1-1/2 in check valve	30		.4
4	1-1/2 in restricting orifice	30		.4
7	1 in air operated valve	30		.4
23	1 in valve	30		.4
12	1 in check valve	25		.4
6	1 in restricting orifice	25		.4
96	Instr. root (typ. 3/4" globe)	32		.3

Containment Instrument Air

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
3	3/4 in valve	32		.3
48	1/2 in valve	20		.3
2	3/4 in relief valve	25		.3
62	1 1/4 in three way valve	55		1.1
4	1 1/4 in four way valves	60		1.2
2	2 in check valve	35		.8
100	2 in valve	40		1.0
1	2 in relief valve	42		.9
1	6 in check valve	150		6.2
1	6 in valve	180		7.2
22	Instrument air accumulators	285	Cyl 4.5 x .8 dia	2.3

Control Rod Drive System

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
460	CRD Blade	400	Cyl-16.5 x 10 in Dia	9.0
225	CRD Mechanism	480	Cyl-18 x 8 in Dia	6.3
185	Direction Control set	80	Parallel piped 1x.8x.4	.32
370	Scram valve	70	Cyl-2 x 1 Dia	1.6
210	Scram accumulator	140	Cyl-3 x 8 in Dia	1.05
2	CRD Pump	4000	6 x 2 x 2	24.0
2	Scram Discharge Volume	2000	Cyl 10 x 1 dia	7.9
2	Pump Suction Filter	400	Cyl 6 x 1 dia	4.7
2	CRD drive water filter	100	Cyl 2 x 1 dia	1.6
2042	3/4 inch valve	30		.2
185	1 inch valve	50		.3
379	2 inch valve	90		1
7	4 inch valve	268		3.1

TABLE C.5. (contd)

Control Rod Drive System (contd)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
1	2 inch restricting orifice	60	Cyl .4 x .5 dia	.31
2	2 inch flow control valve	160		1
1	1 inch air operated vent	90		.7
1	2 inch air operated drain	145		.8
2	2 inch flow element	50		.35
1	1 inch flow element	30		.25
39	instrument root valve	8		.02

Condensate Demineralizers

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
6	Filter demineralizers	11,675	Cyl 10.6 x 7 dia	400
6	Resin trap (w/ basket)	2100	Cyl 4.1 x 2.7 dia	22.9
6	Demin hold pump	350	3.6 x 1.3 x 1.6	7.7
1	Cond bk wash rcvng tank	15,224	Cyl 21.1 x 12.2 dia	2471
1	Sludge disc Mixing pump	924	4.9 x 2 x 1.7	16.2
1	Condensate decant pump	924	4.9 x 2 x 1.7	16.2
1	Cond bk wash transfer pump	924	4.9 x 2 x 1.7	16.2
2	Cond phase separator Tank	7001	Cyl 17.2 x 15.2 dia	3113
2	34 bf loop seal (6 in pipe)			
1	36 in flow element	1180		
2	20 in butterfly valve	3900		
1	18 in air oper butterfly	3100		
6	12 in butterfly valve	1120		
12	12 in air oper butterfly	1120		
6	12 in flow element	1000		
22	8 in air oper butterfly	530		14.0
2	8 in butterfly	530		14.6
1	8 in air operated valve	750		14.6
5	8 in check valve	430		10.9
2	8 in flow element	400		10.9
12	6 in air oper valve	375		7.2
2	6 in valve	375		7.2
21	6 in air oper butterfly	350		
3	6 in check valve	270		6.0
5	4 in air operated valve	180		3.1
1	4 in check valve	130		2.5
2	3 in air oper valve	130		1.4
6	3 in air oper butterfly	120		1.4
1	3 in butterfly valve	120		1.2

TABLE C.5. (contd)

Condensate Demineralizers (contd)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
1	3 in rest. orifice	80		1.1
6	2 in air oper bttfly	55		1
2	2 in butterfly	55		
43	2 in valve	75		1
5	2 in check valve	50		.8
3	2 in relief valve	65		.9
1	1-1/2 in valve	58		.9
13	1 in air operated valve	45		.5
18	1 in valve	45		.5
5	1 in check valve	30		.5
6	1 in relief valve	42		.5
149	Inst root (typ 3/4" globe)	32		.3

Equipment Drain Processing

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
1	Waste demineralizer	1998	Cyl 10.2 x 5 dia	197
1	Waste collector filter	3991	Cyl 11.2 x 4 dia	138
1	Waste filter hold pump	700	3.3 x 1.6 x 1.6	9
1	Waste collector tank & eductor	22,530	Cyl 18.1 x 16.2 dia	373
1	Waste collector pump	625	4.6 x 1.6 x 2.6	20.1
1	Spent resin tank	1,448	Cyl 5.9 x 5.9 dia	165
1	Spent resin pump	224	3.6 x 1.3 x 1.6	7.9
1	Waste surge tank & eductor	40,269	Cyl 20.1 x 25 dia	9,945
1	Waste surge pump	625	4.6 x 1.6 x 2.6	20.1
2	Waste sample Tank & eductor	15,330	Cyl 14.5 x 15 dia	2,515
2	Waste sample pump	508	4.3 x 1.6 x 2.3	16.4
1	8 in air operated valve	320		14.2
1	6 in Air Operated Valve	180		7.0
2	6 in check valve	150		5.7
1	6 in flow element	150		5.7
1	6 in flow site glass	120		5.0
27	4 in air operated valve	100		2.9
14	4 in valve	100		2.9
13	4 in check valve	80		2.3
1	4 in resin strainer	80		2.7
7	4 in restricting orifice	80		2.2
1	4 in flow element	80		2.2
5	4 in Resin Screen	70		1.1
4	3 in air operated valve	65		1.1

TABLE C.5. (contd)

Equipment Drain Processing (contd)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
7	3 in valve	65		1.1
2	3 in check valve	60		.9
1	3 in restricting orifice	60		.9
1	3 in flow element	60		.9
4	2 in air operated valve	40		.8
14	2 in valve	40		.8
2	2 in check valve	35		.7
1	2 in relief valve	40		.8
3	2 in flow element	35		.7
2	1-1/2 in air operated	35		.8
5	1-1/2 in valve	35		.8
3	1-1/2 in check valve	30		.4
4	1 in air operated valve	30		.4
6	1 in valve	30		.4
10	1 in check valve	25		.3
1	1 in flow element	25		.3
55	Inst root (typ 3/4" globe)	32		.3

Extraction Steam

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
6	24 in MOV	7,100		88.6
6	24 in stop check	5,690		70.9
10	20 in MOV	5,800		76.9
10	20 in stop check	4,640		61.3
5	18 in MOV	4,900		60.5
5	18 in stop check	3,920		48.4
2	16 in MOV	4,230		50.2
2	16 in stop check	3,384		40.2
6	8 in AOV	1125		14.6
4	6 in MOV	588		7.2
4	4 in AOV	268		3.1
10	2 in AOV	75		1
12	2 in restricting orifice	55		.8
85	Inst root (typ 3/4" globe)	32		.3

TABLE C.5. (contd)

Feed and Condensate

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
2	Turbine and Feed pump	120,750	31.3 x 13.2 x 12.2 (skid)	5,045
3	Condensate booster pump	26,444	18.2 x 6.0 x 6.0 (skid)	642
3	Condensate pump	48,200	Cyl 19.5 x 8.6 dia	1,128
1	Gland Exhaust condenser	8,880	Cyl 10.2 x 2.6 dia	55.8
2	Air ejector cond & ejectors	14,568	19.1 x 5.0 x 9.9	945
1	Off Gas condensor	1975	Cyl 15.5 x 4.6 dia	260
2	#6 Feedwater heater	161,660	Cyl 41.3 x 8 dia	2038
2	#5 Feedwater heater	151,681	Cyl 42.2 x 8 dia	2082
3	#4 Feedwater heater	77,836	Cyl 46.2 x 6 dia	1280
3	#3 Feedwater heater	110,767	Cyl 48.2 x 6.9 dia	1818
3	#2 Feedwater heater	112,763	Cyl 48.2 x 6.9 dia	1818
3	#1 Feedwater heater	138,710	Cyl 51.2 x 6 dia	1419
2	Condensate storage tanks	111,179	Cyl 44 x 45 dia	7063
2	Seal steam evaporator	29,627	Cyl 35.3 x 6 dia	978
2	Seal steam evap blwdn cooler	470	Cyl 3.5 x 1 dia	2.8
16	24 in MOV	15750		88.6
3	24 in valve	15750		88.6
2	24 in stop-check valve	9450		80
1	24 in air operated check	10000		81
4	24 in flow element	9200		80
14	20 in MOV	9000		78
8	20 in valve	9000		78
6	20 in check valve	5400		72
1	20 in air operated check	6000		73
3	20 in flow element	5400		72
2	18 in MOV	10140		60.5
2	18 in valve	10140		60.5
3	16 in MOV	6000		44
1	16 in air control valve	6000		44
1	16 in air operated check	3900		40
2	16 in flow element	3600		40
3	16 in valve	6000		44
1	16 in check	3600		40
2	12 in air operated valve	3200		24.2
3	12 in valve	3000		24.2
1	12 in flow element	1800		21
1	10 in air operated valve	1640		18.2
10	10 in valve	1610		18.2
3	10 in flow element	880		14.0

TABLE C.5. (contd)

Feed and Condensate (contd)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
2	8 air operated control	1125		14.6
1	8 in valve	1125		14.6
3	6 in air operated	640		10.2
1	3 in air operated valve	153		1.4
4	3 in valve	153		1.4
1	3 in flow element	100		1.1
5	2-1/2 MOV	120		1.2
5	2-1/2 in valve	120		1.2
4	2-1/2 in check valve	70		1
5	2 in air operated valve	75		1
21	2 in valve	75		1
16	1-1/2 in valve	62		.9
3	1-1/2 in relief valve	50		.7
2	1 in MOV	50		.5
3	1 in air operated valve	50		.5
79	1 in valve	50		.5
2	1 in check valve	38		.5
20	1 in relief valve	42		.5
2	1 in restricting orifice	38		.5
7	3/4 in relief valve	40		.5
3	1/2 in valve	25		.3
3	1/2 in check	15		.2
3	1/2 in restricting orifice	18		.2
119	Inst root (typ 3/4" globe)	32		.3

Fuel Pool Cooling and Cleanup

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
2	FPCC pumps	1161	5 x 2 x 2	20
2	FPCC demin	3450	Cyl 13.2 x 3 dia	91.5
2	Skimmer Surge Tank	11,793	Cyl 25 x 5.9 dia	695
1	Resin Eductor	80	Cyl 1.6 x .6 dia	.5
2	FPCC Heat Exchanger	4490	Cyl 20.1 x 2 dia	62
1	Supp. Pool Cleanup Pmp	1161	5 x 2 x 2	19.4
2	Resin Tank Agitator	80	Cyl 8 x .4	3.2
1	Fuel Pool Precoat Pump	625	4 x 1.6 x 2	12.7
1	(Precoat) Dust Evacuator	230	1.8 x 1.2 x 1.2	2.6
2	FPCC hold pump	429	3.6 x 1 x 1.7	5.9
2	FPCC Output Diffusers (120 feet of 8 in pipe with holes)			
1	FPCC Precoat Tank	500	Cyl 4 x 2.6 dia	16.6

TABLE C.5. (contd)

Fuel Pool Cooling and Cleanup (contd)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
1	FPCC Resin Tank	500	Cyl 4 x 2.6 dia	16.6
2	10 in valve (no internals)	305		17.6
4	10 in valve	500		17.6
3	10 in check valve	370		13.8
3	10 in flow element	370		13.8
2	8 in MOV	320		14.2
5	8 in valve	320		14.2
1	8 in check valve	240		10.6
10	6 in MOV	180		7.0
14	6 in valve	180		7.0
3	6 in check valve	150		5.8
9	6 in AOV	180		5.8
1	6 in flow element	150		5.8
1	4 in air operated valve	100		2.9
1	4 in check valve	80		2.3
1	4 in flow element	80		2.3
2	3 in air operated valve	65		1.3
1	3 in valve	65		1.3
2	3 in check valve	60		1.0
3	2 in air operated valve	40		.9
5	2 in valve	40		.9
1	2 in check valve	35		.7
1	2 in relief valve	45		.8
1	1-1/2 in valve	35		.8
10	1 in valve	35		.4
1	1 in check valve	30		.4
2	1 in relief valve	38		.4
1	1 in flow element	30		.4
75	Inst root (typ 3/4" globe)	32		.3

High Pressure Core Spray

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
2	24" Suction strainer	378.4		12.56
1	18" MOV	4900		60.5
1	24" Check Valve	7,100		88.6
1	3" Valve	153		1.4
1	3" Check Valve	100		1.4
1	14" MOV	2,760		31.1
1	20" Check Valve	6,000		70.0

TABLE C.5. (contd)

High Pressure Core Spray (contd)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
1	12 x 24" pump	60,374	4.9 dia. x 14.1	1071
1	16" Check Valve	1,600		31.1
1	2" Valve	90		1.0
1	1 x 2" Pump	181	4.9 x 1.9 x 1.9	18.9
1	1" Check Valve	50		0.3
1	1" Valve	50		0.3
1	1 1/2 x 2" Relief Valve	90		2.0
2	6" Valve	588		7.2
3	12" Valve	2240		20.6
1	10" MOV	1610		16.1
2	12" MOV	2240		20.6
42	3/4" Valve	90		0.2

Low Pressure Core Spray

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
2	24" Suction Strainer	378.4		12.56
1	Vent Strainer	94.6		3.14
28	3/4" Valve	30		0.2
1	24" MOV	7,100		88.6
1	3/4" Check valve	30		0.2
4	1 1/2" Valve	62		0.6
1	14 x 24 pump	21,200	11.8 x 3.8 dia	134
1	Pump pit	400	5.0 x 3.0 x 0.25	3.75
1	16" check valve	1600		31.1
1	12" MOV	2240		21.0
2	12" Valve	2240		21.0
1	16" Flow control valve	4030		45.0
1	6" Flow Control Valve	588		7.2
1	6" Valve	588		7.2
1	1 x 2" Pump	181	4.9 x 1.9 x 1.9	18.9
1	1 1/2" Check Valve	50		0.3
1	3" Valve	153		1.4
1	12" Check Valve	1200		14.6
1	3/4" AOV	30		0.2

TABLE C.5. (contd)

Miscellaneous Drains

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
1	Misc. Drain Tank #1	1073	8.9 x 4.0 dia	112
1	Misc. Drain Tank #2 w/ pumps	1441	15.1 x 5.6 dia	372
2	6 in valve	588		7.2
5	4 in valve	268		3.1
8	3 in MOV	153		1.4
3	3 in air operated valve	153		1.4
3	3 in valve	153		1.4
2	3 in check valve	100		1.1
8	3 in strainer	130		1.2
4	3 in restricting orifice	100		1.1
2	3 in flow element	100		1.1
1	2 in MOV	75		1
11	2 in air operated valve	75		1
11	2 in valve	75		1
26	2 in restricting orifice	55		.8
3	1-1/2 in air operated	62		.9
2	1-1/2 in valve	62		.9
8	1 in air operated valve	50		.5
7	1 in valve	50		.5
2	1 in steam trap	90		.75
47	Inst root (typ 3/4" globe)	32		.3
14	1/2 in valve	90		.75
2	2 1/2 in AOV	131		1.2
3	2 1/2 in valve	131		1.2

Main Steam

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
1	72 in MOV	100,000		2300
6	Stop Valves	40,000		1800
6	Interceptor Valves	10,000		1000
8	30 in MSIV	1,400		170
1	24 in MOV	7,100		88.6
4	24 in relief valve	9,230		90.1
2	20 in relief valve	7,700		86.1
1	16 in MOV	4,230		50.2
2	16 in check valve	3,380		40.1
2	14 in check valve	2,220		29.4
2	14 in MOV	2,760		31.1
2	12 in MOV	2,500		28.0

TABLE C.5. (contd)

Main Steam (cont)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
2	12 stop check	1,970		31.1
4	30 in flow restrictor	3,000		51.6
18	8 in AO SRV	2,030		29.0
36	10 in vacuum breakers	900		15.0
18	24 x 12 in quenchers	1,650	7.0 x 8.0 x 8.0	448
8	10 in MOV	1610		18.2
2	10 in valve	1610		18.2
5	8 in valve	1125		14.6
1	8 in check valve	740		10.9
9	6 in MOV	588		7.2
2	6 in valve	588		7.2
1	6 in check valve	420		6.0
4	6 in relief valve	500		7.0
2	4 in MOV	268		3.1
2	4 in valve	268		3.1
11	3 in MOV	153		1.4
6	3 in air operated valve	153		1.4
4	3 in valve	153		1.4
2	3 in flow element	100		1.1
2	2 in MOV	75		1
5	2 in air operated valve	75		1
393	2 in valve	75		1
7	1-1/2 in air operated	62		.9
4	1-1/2 in valve	62		.9
7	1 in air operated valve	50		.5
75	1 in valve	50		.5
195	Inst root (typ 3/4" globe)	32		.3
163	1/2 in valve	25		.4
35	1 in steam traps	90		.75
2	RFW turbine	40,000		1000
1	Moisture Separator	2,000		200
4	2 in strainer	95		1.2
2	4 in strainer	220		4.0
2	8 in relief valve	1,029		14.6
4	8 in strainer	520		4.5
1	Gland steam condenser	4,000		200
2	Ejector Condenser	4,000		200
1	HP Turbine			
2	LP Turbine			

TABLE C.5. (contd)

Main Steam (cont)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
1	Bypass Valve Assy.	11,600	17.3 x 3.0 x 11.0	571
2	Moisture Separator Reheater	459,000	12.7 dia. x 92.8	11,755
2	Steam evaporator	29,674	5.9 dia. x 35	3809
8	28 in HOV Governor valves	8000		

Main Steam Leakage Control

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
8	1/2 in valve	25		.3
28	3/4 in valve	32		.3
2	1 in flow element	38		.5
14	1 in valve	50		.5
4	1 in check valve	38		.5
4	1 1/2 in flow element	46		.5
20	1 1/2 in MOV	50		.5
2	1 1/2 in check valve	46		.5
2	MSLC Fan (3 inch)	450		8
4	MSLC Heater	125		2.4

Offgas (Augmented) System

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
2	Catalytic recombiner vessel	999	Cyl 6.9 x 4.6 dia	116
2	Preheater heat exchanger	1185	Cyl 12.2 x 4 dia	150
1	Offgas condenser	1976	Cyl 15.5 x 4.6 dia	260
1	Water separator	598	Cyl 5.6 x 1 dia	4.3
2	Lab vacuum pump (P-11/1,2)	<100	.8 x .8 x .8	.5
2	Lab vacuum pump (P-14/1, 4/1)	<100	.8 x .8 x .8	.5
2	Water separator	2994	Cyl 6 x 1 dia	4.6
8	Charocoal ads. vessel	8,980	Cyl 22.8 x 4 dia	281
2	Cooler condenser	1995	Cyl 7.9 x 2 dia	24.4
5	Seal water trap			
2	Pre-filter vessel	2495	Cyl 10.6 x 3 dia	73
2	After-filter vessel	2495	Cyl 10.6 x 3 dia	73
4	Dessicant dryers	1371	Cyl 4 x 3.3 dia	28
2	Dryer heater	7984	10.2 x 8.9 x 5.9	54
2	Dryer chiller	4990	12.2 x 1.7 x 18.2	366
2	Regen. blower	1400	2.2 x 2.6 x 3.6	20.6
9	6 in air operated valve	180		6.8
18	6 in valve	180		6.8
2	4 in MOV	100		2.9

TABLE C.5. (contd)

Offgas (Augmented) System (cont)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
4	4 in air operated valve	100		2.9
2	3 in air operated valve	65		1.2
6	3 in valve	65		1.2
4	2 in air operated valve	40		.8
10	2 in valve	40		.8
3	1-1/2 in air operated	35		.7
4	1-1/2 in valve	35		.7
1	1-1/2 in relief valve	37		.7
2	1-1/2 in flow element	30		.4
16	1 in air operated valve	30		.4
30	1 in valve	30		.4
2	1 in relief valve	32		.4
89	Inst root (typ 3/4" globe)	32		.3

Turbine Bldg. and Rad Waste Bldg. Drains

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
4	EDR Sump Pump	1289	Cyl 7.9 x 1.7 dia	16.9
4	FDR Sump Pump	1065	Cyl 7.9 x 1.7 dia	16.9
1	Chemical Drain Sump Pump	1467	Cyl 7.9 x 1.7 dia	16.9
2	EDR Sump Pump	1289	Cyl 7.9 x 1.7 dia	16.9
3	FDR Sump Pump	1065	Cyl 7.9 x 1.7 dia	16.9
19	6 in restricting orifice	150		5.7
6	3 in valve	65		1.2
6	3 in check valve	60		.9
3	2 in MOV	40		.8
8	2 in valve	40		.8
8	2 in check valve	35		.6
22	Inst root (typ 3/4" globe)	32		.3

Radioactive Floor Drain Processing

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
1	Floor Drain Demineralizer	1997	Cyl 10.2 x 5 dia	19.6
1	Floor Drain Sample Tank	15,330	Cyl 14.5 x 14.9 dia	2511
1	Floor Drain Sample Pump	508	4.3 x 1.7 x 2.3	16.9
1	Floor Drain Filter Aid Pump	260	2.2 x 1.3 x 1.3	3.7
1	Floor Drain Filter Hold Pump	699	3.3 x 5 x 5	8.1
1	Floor Drain Filter	3991	Cyl 11.2 x 4 dia	13.8
1	Floor Drain Collector Pump	625	4.6 x 1.7 x 2.6	20.6
1	Floor Drain Collector Tank	22,530	Cyl 18.1 x 16.2 dia	37.2

TABLE C.5. (contd)

Radioactive Floor Drain Processing (cont)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
1	Waste Decant Pump	224	3.6 x 1.3 x 1.7	8.1
1	Waste Sludge Dsch Mixing Pump	634	4.6 x 1.6 x 1.7	12.5
1	Waste Sludge Phase Sep Tank	12,093	Cyl 11.2 x 14.2 dia	1771
2	Eductor (Internal to two of the tanks, included in the tank volume and mass)			
2	8 in air operated valve	320		9.9
3	6 in air operated valve	180		5.4
2	6 in check valve	150		5.4
1	6 in flow site glass	100		1.2
1	4 in MOV	100		2.8
21	4 in air operated valve	100		2.8
18	4 in valve	100		2.8
11	4 in check valve	80		2.2
4	4 in restricting orifice	80		2.2
1	4 in Resin Strainer	250	2.3 x 1.6 x .5	1.8
5	3 in air operated valve	65		1.2
3	3 in valve	65		1.2
3	3 in check valve	60		1.0
1	3 in flow element	55		.9
2	3 in flow site glass	40		.7
4	2 in air operated valve	40		.9
9	2 in valve	40		.9
3	2 in check valve	35		.7
1	2 in relief valve	40		.8
1	2 in stop check	40		.7
2	2 in Flow Site Glass	30		.4
1	2 in Restricting Orifice	35		.7
2	1-1/2 in air operated	35		.8
1	1-1/2 in valve	35		.8
1	1 in relief valve	30		.6
1	1-1/2 in flow element	30		.4
4	1 in air operated valve	30		.4
3	1 in check valve	25		.4
1	1 in Solenoid valve	30		.4
1	1 in ball valve	30		.4
1	1 in flow site glass	20		.4
50	Inst root (typ 3/4" globe)	15		.2
2	1/2 in solenoid	15		.2
5	1/2 in check	15		.2

TABLE C.5. (contd)

Reactor Bldg. Closed Cooling Water

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
3	RBCCW Heat Exchanger	16432	Cyl 35.3 x 3 dia	245
2	RBCCW Pump	3518	5.3 x 2 x 2.6	27.6
1	RBCCW Surge Tank	1170	Cyl 6 x 4 dia	75
5	Drywell Cooler & fans	1640	2.4 x 4 x 3	28.8
1	14 in MOV	990		26
3	12 in valve	730		23
7	10 in MOV	550		17.5
6	10 in valve	550		17.5
4	10 in check valve	370		13.5
1	10 in flow element	370		13.5
5	8 in MOV	340		13.5
2	8 in valve	340		13.5
2	8 in air operated valve	340		10.4
4	8 in flow element	240		10.4
6	6 in valve	210		7.0
4	6 in check valve	150		5.8
1	6 in air operated valve	210		6.8
1	6 in flow element	150		5.8
7	4 in MOV	120		2.9
1	4 in air operated valve	120		2.9
3	4 in valve	120		2.9
9	3 in valve	80		1.2
3	3 in electro-hydraulic valve	80		1.0
1	2 in air operated valve	45		.8
10	2 in valve	45		.8
1	2 in relief valve	48		.7
6	1 in valve	30		.4
7	1 in relief valve	32		.4
149	Inst root (typ 3/4" globe)	32		.3

Reactor Core Isolation Cooling

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
1	Pelton wheel turbine/pump	13790	10.2 x 3.9 x 3.9	158
1	Barometric condenser	1219	Cyl 6.9 x .66 dia	2.3
1	Condenser pump	1496	Cyl 2 x 1 dia	1.5
1	Water leg pump	876	4.9 x 2 x 2	19
1	Vacuum pump	999	Cyl 2 x .66 dia	.7
1	Vacuum tank	898	2 x 2 x 3	11.8
1	Steam condensate drip pot	240	Cyl 2.5 x .7 dia	1

TABLE C.5. (contd)

Reactor Core Isolation Cooling (contd)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
2	8 in suction strainers	145	Cyl 1.6 x 1 dia	1.3
4	3/4 inch steam trap	55		.5
1	10 in exhaust drip chamber	680	Cyl 2 x 1 dia	1.6
1	Turbine exhaust sparger	530	Cyl 3 x 1 dia	2.4
3	10 in MOV	1610		18.2
1	10 in check valve	880		14.0
2	8 in MOV	1125		14.6
1	8 in valve	1125		14.6
2	8 in check valve	740		10.9
3	6 in MOV	588		7.2
2	6 in valve	588		7.2
1	6 in check valve	420		6.0
2	6 in air operated check	490		6.3
2	6 in restricting orifice	420		6.0
3	4 in MOV	268		3.1
1	4 in Hydraulic control valve	450		6.2
2	3 in restricting orifice	100		1.1
4	2 in MOV	75		1
1	2 in air operated valve	75		1
4	2 in valve	75		1
6	2 in check valve	55		.8
1	2 in relief valve	64		.9
2	2 in restricting orifice	55		.8
1	1-1/2 in MOV	62		.9
2	1-1/2 in valve	62		.9
1	1-1/2 in check valve	46		.5
1	1-1/2 in relief valve	50		.7
1	1-1/2 in restricting orifice	46		.5
5	1 in air operated valve	50		.5
1	1 in pressure control valve	60		.6
5	1 in valve	50		.5
9	1 in restricting orifice	38		.5
1	3/4 in air solenoid	32		.3
2	3/4 in pressure control valve	50		.5
8	Dragon valve (excess flow check)	50		.5
204	Inst root (typ 3/4" globe)	32		.3

TABLE C.5. (contd)

Residual Heat Removal

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
3	RHR pump	17,164	Cyl 12.2 x 5 dia	235
1	Water leg pump	875	5 x 2 x 2	19.4
1	Drywell upper spray ring header	18,860	135 Ft of 12 in Class I pipe	144.5
1	Drywell lower spray ring header	28,774	206 Ft of 12 in Class I pipe	220.4
1	Wetwell spray ring header	11,778	260 Ft of 6 in Class I pipe	62.4
6	Supression pool suction strnrs	430	Cyl 2.7 x 2.3 dia	11.2
2	RHR heat exchanger	64,295	Cyl 29.4 x 5 dia	565.8
3	24 in MOV	15,750		88.6
2	20 in MOV	9,000		78
1	20 in valve	9,000		78
11	18 in MOV	10,140		60.5
8	18 in valve	10,140		60.5
5	18 in check	6084		54.5
3	18 in flow element	6084		54.5
2	18 in restricting orifice	6084		54.5
4	16 in MOV	6000		44
4	14 in MOV	3400		34
2	14 in valve	3400		34
3	14 in air operated check	2140		31
2	14 in restricting orifice	2080		31
3	12 in MOV	2240		25
3	12 in valve	2240		25
3	12 in air operated check	1280		22
1	12 in restricting orifice	1200		22
2	10 in valve	1610		18.2
1	10 in check valve	880		14.0
2	8 in MOV	1125		14.6
1	8 in air operated control valve	740		10.9
3	6 in MOV	588		7.2
3	6 in valve	588		7.2
4	6 in check valve	420		6.0
3	6 in ganged restricting orifice	680		8.0
2	6 in restricting orifice	400		6.0
2	6 in relief valve	500		7.0
1	6 in flow element	420		6.0
4	4 in MOV	268		3.1
2	4 in valve	268		3.1
1	4 in check valve	180		2.5
3	3 in MOV	153		1.4

TABLE C.5. (contd)

Residual Heat Removal (contd)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
11	3 in valve	153		1.4
1	3 in check valve	100		1.1
1	2-1/2 in AOV	90		1.3
1	2 in MOV	75		1
8	2 in valve	75		1
4	2 in check valve	55		.8
2	2 in relief valve	64		.9
2	1-1/2 in MOV	62		.9
3	1-1/2 in valve	62		.9
3	1-1/2 in check valve	46		.5
2	1-1/2 in stop check	50		.7
1	1-1/2 in restricting orifice	46		.5
2	1 in MOV	50		.5
8	1 in valve	50		.5
1	1 in check valve	38		.5
8	1 in relief valve	42		.5
4	Dragon valve (excess flow check)	50		.5
4	3/4 in solenoid valve	40		.5
227	Inst root (typ 3/4" globe)	32		.3

Recirculation

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
2	Recirculation pump w/motor	96,072	10.7 x 11.9 x 20.5	2607.
2	Seal water inj. heat exchanger	(Included in the motor assembly)		
2	24 in HOV	10,500		88.6
4	24 in MOV	10,500		88.6
2	3/4 in check valv	25		.3
76	3/4 in valve	32		.3
28	3/4 restricting orifice	25		.3
12	3/4 in flow element	25		.3
2	3/4 in relief valve	27		.3
2	3/4 in MOV	32		.3
92	1 in valve	50		.5
10	1 in restricting orifice	38		.8
4	2 in valve	75		1.2
30	Dragon Valve (excess flow check)	50		.5

TABLE C.5. (contd)

Reactor Water Cleanup System

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
2	RWCU Pump	1300	5 x 2 x 2	20
2	Clean up hold pump	1177	4.3 x 1.6 x 2.3	15.9
1	Clean up precoat pump	1000	4.3 x 1.3 x 2.3	12.9
1	Sludge discharge pump	625	4 x 1.6 x 2	12.7
1	Decant pump	225	3.6 x 1.3 x 1.3	6.3
2	Non-regenerative HX	9000	Cyl 26 x 2.7 dia	149
3	Regenerative HX	9100	Cyl 21 x 2.7 dia	120
2	Filter demineralizer	7000	Cyl 8.9 x 3 dia	62.9
1	Batch tank	500	Cyl 4 x 2.6 dia	16.6
2	Phase separator tank	4500	Cyl 8.9 x 10.2 dia	73.2
1	Precoat agitator	60	Cyl 8 x .4 dia	1
7	6 in MOV	588		7.2
2	6 in valve	588		7.2
1	6 in check valve	588		7.2
2	6 in flow element	588		7.2
1	6 in restricting orifice	588		7.2
6	4 in MOV	268		3.1
16	4 in air operated valve	268		3.1
1	4 in flow element	268		3.1
11	4 in valve	268		3.1
4	4 in check valves	268		3.1
1	4 in relief valve	268		3.1
1	4 in restricting orifice	268		3.1
16	3 in air operated valve	153		1.4
4	3 in valve	153		1.4
2	3 in check valve	153		1.4
2	3 in flow element	153		1.4
6	2 in air operated valve	90		1
10	2 in valve	90		1
1	2 in check valve	90		1
1	1 in air operated valve	50		.3
21	1 in valve	50		.3
5	1 in relief valve	50		.3
3	Excess flow check valve	35		.2
129	Inst root (typ 3/4" globe)	30		.2
2	1/2 in air operated valve	20		.1
2	1/2 in valve	20		.1
2	1/2 inch check valve	15		.1

TABLE C.5. (contd)

Reactor Building Equipment and Floor Drains

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
4	Drain Sump Pump	1153	Cyl 9.9 x 1.7 dia	21.2
3	Drain Sump Pump	1432	Cyl 10.2 x 1.7 dia	21.9
1	Equipment Drain Heat Exchanger	1496	Cyl 7.9 x 1 dia	60.8
1	Drywell Equipment Drain HX	1496	Cyl 7.9 x 1 dia	60.8
4	6 in Air Operated Valve	180		5.6
24	6 in restricting orifice	150		5.6
7	4 in valve	100		2.9
1	4 in check valve	80		2.3
6	4 in restricting orifice	80		2.3
18	3 in air operated valve	65		1.2
9	3 in valve	65		1.2
5	2 in valve	40		.8
5	2 in check valve	35		.7
1	1-1/2 in air operated	35		.7
1	1-1/2 in valve	35		.7
1	1-1/2 in restricting orifice	25		.5
1	1-1/2 in flow element	25		.5
4	1 in valve	28		.5
2	1 in flow element	20		.5
12	Inst root (typ 3/4" globe)	16		.3

Sample Systems

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
4	Sample rack	180	Typical: 2 x 1 x 6	12
4	Fume hood with sink	260	Typical: 2 x 3 x 3	18
4	Constant temperature bath	140	Typical: 2 x 1 x 2	4
1	1 in air operated valve	40		.4
4	3/4 in sloenoid valve	30		.4
2	1/2 in air operated valve	25		.3

Standby Gas Treatment

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
42	2" Check Valve	55		0.8
2	18" Valves	4,900		60.5
14	18" Damper, MOV	1,240		88.6
2	18" Damper, AOV	1,240		88.6
2	SGT Filter Unit	19,600	6.08 x 46.25	
8	3/4" valve	30		0.2
4	Blower	4,500		121

TABLE C.5. (contd)

Heater Vents and Drains

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
2	Steam Evap Drain Tk (5A&B)	1,977	4.0 x 3.0 dia.	28.3
2	Heater Drain Tk. (4A&B)	13,820	7.9 x 4.0 dia.	99.3
2	Moisture Separator Drain Tk	3,777	8.9 x 4.6 dia.	147.9
4	Reheater Drain Tk	2,497	7.8 x 3.0 dia.	55.1
4	Reheater Drain Tk	13,820	7.9 x 4.0 dia.	99.3
2	20 in valve	5,800		76.6
1	18 in AOV	4,900		60.5
2	18 in Flow Element	4,160		50.8
2	18 in valve	4,900		76.6
5	16 in flow element	2,791		33.1
4	16 in check valve	2,791		33.1
5	16 in MOV	4,230		50.2
9	16 in AOV	4,230		50.2
7	16 in valve	4,230		50.2
7	12 in AOV	2,500		28.0
12	12 in MOV	2,500		28.0
6	12 in valve	2,500		28.0
2	12 in flow elements	2,100		23.5
9	10 in MOV	1610		18.2
13	10 in AOV	1610		18.2
6	8 in MOV	1125		14.6
2	8 in AOV	1125		14.6
8	8 in check valve	740		10.9
6	8 in flow element	740		10.9
6	6 in MOV	588		7.2
4	6 in valve	588		7.2
2	6 in check valve	420		6.0
13	6 in AOV	588		7.2
4	6 in flow element	420		6.0
12	4 in MOV	268		3.1
8	4 in air operated valve	268		3.1
6	4 in valve	268		3.1
1	4 in flow element	180		2.5
12	3 in MOV	153		1.4
8	3 in air operated valve	153		1.4
10	3 in valve	153		1.4
1	3 in restricting orifice	100		1.1
4	3 in flow element	100		1.1
2	2 in air operated valve	75		1

TABLE C.5. (contd)

Heater Vents and Drains (cont)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
152	2 in valve	75		1
319	1 in valve	50		.5
160	Inst root (typ 3/4" globe)	32		.3
2	1/2 in valve	25		.4
3	2 1/2 in valve	131		1.2
1	1 1/2 in MOV	62		.9
2	1 1/2 in valve	62		.9
1	1 1/2 in check valve	50		.7

Miscellaneous Items from Partial Systems

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
5	TIP Drive Unit	796	4 x 2.6 x 3	31
8	TIP Indexing Unit	20	Cyl 2.5 x .8 dia	1.3
5	TIP Ball Valve	50		.9
5	Explosive Shear Valve	50		.9
5	TIP Shield Pig	340	Cyl 1.5 x .8 dia	.8
1 set	TIP Tubing	650	Bent and crushed	45
2	Hogger (mechanical vacuum pump)	6,985	2. x 2.6 x 2.6	13.8
1	Refueling Bridge	54,886		800
1	Reactor Service Platform	11,475	3.5 x 23 dia.	728
2	Refueling mast	650	Cyl 21 x 2 dia.	.22
1	CRD removal turntable	5489	20 x 8 x 2	160
1	CRD Removal Trolley	380	1.8 x 2 x 16	40
1	Incore instrument grapple	80	Cyl 2.8 x .7 dia	1.1
1	Fuel support piece grapple	90	1.5 x 1 x 1	1.5
1	Control Blade Grapple	130	Cyl 14 x .5 plus cyl 3 x .9 dia	4.7
1	Spent Fuel Pool Work Table	980	Stainless table 3 x 20 x .3	25
2	Fuel Prep Machine	840		30
1	Channel Measurement Machine	930	2.2 x 3 x 22	25
185	Blade Guide (aluminum)	160	5 x .5 x 14	7
1	In Core Instrument Strongback	220	Cyl 18 x .9 dia	11.5
1	Manipulators, crows feet, etc.	300	1.5 x 1.5 x 2	4.5
20	In-vessel manipulator poles	30	Cyl 15 x .2 dia	.5
9	Drywell Recirculation Fan	560	Cyl 2.4 x 2.8 dia	14.8
4	Stud Tensioner	2300	Cyl 3.2 x 1.5 dia	5.6
1	RPV Head Strongback	4700	3 x 10 x 10	8
1	Dryer/Separator Strongback	1333		15
18	SRV Tailpipe and Sparger	--	2761 Ft of 10" pipe	
84	24" Suppression Pool Downcomer	--	47 Ft each of 24" pipe	

TABLE C.5. (contd)

Miscellaneous Items from Partial Systems (cont)

<u>Number</u>	<u>Component</u>	<u>Weight (lb ea.)</u>	<u>Physical Dimensions (ft)</u>	<u>Volume ft³ (ea.)</u>
18	28" Suppression Pool Downcomer	--	47 Ft each of 28" pipe	
1	Portions of Rx Head Space Frame	1240		18
1	Upper Drywell Spray Header	--	147 Ft of 12" pipe	
1	Lower Drywell Spray Header	--	222 Ft of 12" pipe	
1	Suppression Pool Spray Header	--	267 Ft of 6" pipe	

Piping from RCS and Other Systems

<u>Piping Size</u>	<u>Total Length (ft)</u>	<u>Total Weight (lb)</u>
1/2 - 2"	66,160	150,279
3 - 10"	41,515	848,576
12 - 16"	9,757	697,113
18 - 24"	13,419	2,412,700
26 - 30"	2,933	883,745
36 - 72"	2,159	582,664

C.2 UNIT COST FACTORS AND WORK DIFFICULTY FACTORS

The average time required to perform a particular decommissioning task will almost always be longer than expected because of unavoidable external factors: reduced efficiency while working in respiratory equipment or working on scaffolding; the number and length of each work break; and radiation protection/ALARA activities. Each of these work difficulty factors may be expressed as a percent increase in time. Thus, a 20% factor for working in a respirator means that

$$\text{work duration in respirator} = 1.2 \times \text{work duration not in respirator}$$

The CECF permits the user to change work difficulty factors for any activity or to simply use the default values.

Using labor costs, equipment and consumables costs, and the work difficulty factors, the CECF calculates the unit cost factor for each decommissioning activity. Unit cost factors are in dollars per unit (e.g., dollars per cut in the case of piping). The unit cost factor is thus defined as the estimated amount of money required to perform some operation on one unit of a

component or material. The CECF calculates unit cost factors for removing, decontaminating, transporting, and disposing of a variety of equipment and material.

General work difficulty factors are presented in Section C.2.1. Labor rates, crew staffing levels and consumables costs for the cutting and packaging crews are discussed in Section C.2.2. In Sections C.2.3 through C.2.20, the assumptions of C.2.1 and C.2.2 are applied to specific system components to arrive at the reference BWR unit cost factors.

C.2.1 Analysis of Work Durations and Available Time

The basic assumptions about lost work time per shift are as follows:

- The crews work 8-hour shifts,
- The crew members take two 15-minute breaks per shift,
- The crew members suit-up or un-suit in anti-contamination clothing 8 times per shift, @ 15 minutes each time, including travel time to and from the work-place, and
- The crew members devote 25 minutes per shift to ALARA-related activities, e.g., radiation protection guidance, etc.

Thus, a total of $30 + 120 + 25 = 175$ crew-minutes are lost from each 8 hr. shift, leaving a total of $480 - 175 = 305$ crew-minutes available for productive work. These non-production time factors are:

$$\begin{aligned} & [1 + (30/305) + (120/305) + (25/305)] \times 305 = 480 \\ & [1 + 0.098 + 0.393 + 0.082] \times 305 = 480 \end{aligned}$$

and the non-productive time adjustment factor becomes $480/305 = 1.574$. Worker efficiency while working in respiratory equipment is assumed to be 83% of normal, or a work adjustment factor of $1.2 \times$ work duration. Worker efficiency while working on scaffolding is assumed to be 91% of normal, or a work adjustment factor of $1.1 \times$ work duration. These default factors may be changed if the CECF user so desires.

Radiation Exposure time = estimated work duration x 1.3

The postulated staffing for crews engaged in cutting and packaging piping and tanks within the reference BWR is given below, together with appropriate labor rates for each type of crew member. Multiplying the hourly rate for each labor type by the number of crew members of that type and summing over all labor types yields the labor rate per crew hour.

Pers-hrs/crew-hr	Category	Labor Rate (\$/pers-hr)	Cost (a) (\$/crew-hr)
3.0	Laborer	26.37	79.11
1.5	Crafts	49.70	74.55
0.5	H. P. Tech.	36.82	--(b)
<u>0.5</u>	Crew Leader	54.84	<u>27.42</u>
5.5			181.08
Average labor cost, 2 shift operation			\$190.13 ^(c)

- (a) These values include 110% overhead and 15% DOC profit.
- (b) Part of DOC overhead staff. Labor costs appear in undistributed cost.
- (c) A 10% shift differential is included for second shift

Material costs are a function of the piping/tank size. Principal components are absorbent materials, plastic sheeting and bags, and gases for torches. The quantities and unit costs used in these analyses are listed below.

Material	Piping			Tanks
	0-2 in. dia	2-14 in. dia.	32-47 in. dia.	1/2 in. tank wall
Abs. Matl. @ \$0.32/ft ²	10ft ² \$3.20	15ft ² \$4.80	20ft ² \$6.40	length x dia. x \$0.32
Plastic @ \$0.04/ft ²	25ft ² \$1.00	37.5 ft ² \$1.50	50 ft ² \$2.00	length x dia. x \$0.04
Gases @ \$6.75/hr	0.017 hr \$0.11	0.033 hr \$0.22	0.33 hr \$2.23	Hours of cut x \$6.75
	\$4.32/cut	\$6.52/cut	\$10.63/cut	As calculated per tank
Including 15% DOC profit:	\$4.97/cut	\$7.50/cut	\$12.22/cut	1.15 x As calculated per tank

C.2.3 Removal and Packaging of Contaminated Piping 0.5 in. Dia. to 2 in. Dia.

All contaminated piping is assumed to be stainless steel, Schedule 140 to 160. Cutting is accomplished using a plasma arc torch mounted on a mechanically-driven track system. The piping is cut into nominal 15 ft lengths, for packaging into maritime containers. The basic operations are listed below, together with the estimated clock times required to accomplish each operation.

• Install scaffolding at cut location	15 min.
• Remove insulation at cut location	5 min.
• Attach track-mounted torch system	5 min.
• Install contamination control system	5 min.
• Cut pipe	1 min. (a)
• Remove track-mounted torch system	5 min.
• Bag ends of piping section	5 min.
• Remove contamination control system	5 min.
• Transfer the piping section to a maritime container	5 min. (b)
• Remove scaffolding and move to next location	15 min.
Crew-minutes for making one cut (actual duration)	61 min.

Work Difficulty Adjustments:

Height/Access adjustment for scaffold work	10% of actual duration
Respiratory protection adjustment	20% of actual duration
Adjusted Work Duration	$1.3 \times \text{actual duration} = 79.3 \text{ min.}$
Non-productive time adjustments:	
Radiation/ALARA adjustment	8.2% of adjusted duration
Suit-up/un-suit in anti-contamination clothing	39.4% of adjusted duration
Work breaks (2 per shift)	9.8% of adjusted duration
Total Work Duration per cut	$1.574 \times \text{adjusted duration} = 125 \text{ min.}$
Crew-Hours per cut	$= 2.08 \text{ hrs.}$
Total Labor Cost per cut	$2.08 \times \$190.13/\text{crew-hr} = \395.47
Crew Exposure Hours per cut (adjusted duration)	$= 1.32 \text{ hrs.}$
Exposure person-hours per cut @ 5.5 pers-hours/crew-hour	$= 7.3 \text{ hrs.}$

(a) Nominal time for cutting rate of 30 in./min.

(b) This activity is in parallel with scaffold removal/next installation.

C.2.4 Removal and Packaging of Contaminated Piping 2.5 in. Dia.
to 14 in. Dia.

All contaminated piping is assumed to be stainless steel, Schedule 140 to 160. Cutting is accomplished using a plasma arc torch mounted on a mechanically-driven track system. The piping is cut into nominal 15 ft lengths, for packaging into maritime containers. The basic operations are listed below, together with the estimated clock times required to accomplish each operation.

• Install scaffolding at cut location	15 min.
• Remove insulation at cut location	10 min.
• Install track-mounted torch system	10 min.
• Attach lifting devices to pipe section	10 min.
• Install contamination control system	10 min.
• Cut pipe	2 min. (a)
• Remove track-mounted torch system	5 min.
• Bag ends of piping section	5 min.
• Remove contamination control system	5 min.
• Transfer the piping section to a maritime container	10 min. (b)
• Remove scaffolding and move to next location	15 min.
Crew-minutes for making one cut(actual duration)	87 min.

Work Difficulty Adjustments:

Height/Access adjustment for scaffold work	10% of actual duration
Respiratory protection adjustment	20% of actual duration
Adjusted Work Duration	$1.3 \times \text{actual duration} = 113 \text{ min.}$

Non-productive time adjustments:

Radiation/ALARA adjustment	8.2% of adjusted duration
Suit-up/un-suit in anti-contamination clothing	39.4% of adjusted duration
Work breaks (2 per shift)	9.8% of adjusted duration
Total Work Duration per cut	$1.574 \times \text{adjusted duration} = 178 \text{ min.}$
Crew-Hours per cut	$= 2.96 \text{ hrs.}$
Total Labor Cost per cut	$2.96 \times \$190.13/\text{crew-hr} = \562.78
Crew Exposure Hours per cut (adjusted duration)	$= 1.88 \text{ hrs.}$
Exposure person-hours per cut @ 5.5 pers-hours/crew-hour	$= 10.36 \text{ hrs.}$

(a) Nominal time for cutting rate of 30 in./min.

(b) This activity is in parallel with scaffold removal/next installation.

C.2.5 Removal and Packaging of Contaminated RCS Piping

All contaminated piping is assumed to be stainless steel, Schedule 140 to 160. Cutting is accomplished using a plasma arc torch mounted on a mechanically-driven track system. The piping is cut for packaging into maritime containers, with the relatively straight sections between the RPV and the steam generator and between the RPV and the primary pump removed in one piece, and the curved section between the steam generator and the primary pump cut into two sections. The basic operations are listed below, together with the estimated clock times required to accomplish each operation.

• Install scaffolding at cut location	30 min.
• Remove insulation at cut location	20 min.
• Attach lifting devices to piping section	20 min.
• Install track-mounted torch system	20 min.
• Install contamination control system	15 min.
• Cut pipe	20 min. (a)
• Remove track-mounted torch system	15 min.
• Bag ends of piping section	10 min.
• Remove contamination control system	10 min.
• Transfer the piping section to a maritime container	30 min. (b)
• Remove scaffolding and move to next location	30 min.
Crew-minutes for making one cut (actual duration)	190 min.

Work Difficulty Adjustments:

Height/Access adjustment for scaffold work	10% of actual duration
Respiratory protection adjustment	20% of actual duration
Adjusted Work Duration per cut	$1.3 \times \text{actual duration} = 247 \text{ min.}$

Non-productive time adjustments:

Radiation/ALARA adjustment	8.2% of adjusted duration
Suit-up/un-suit in anti-contamination clothing	39.4% of adjusted duration
Work breaks (2 per shift)	9.8% of adjusted duration
Total Work Duration per cut	$1.574 \times \text{adjusted duration} = 389 \text{ min.}$
Crew-Hours per cut	= 6.48 hrs.
Total labor cost per cut	$6.48 \times \$190.13/\text{crew-hr} = \$1,232.04$
Crew Exposure Hours per cut (adjusted duration)	= 4.12 hrs.
Exposure Pers-hours per cut @ 5.5 pers-hours/crew-hour	= 22.6 hrs.

(a) Based on 30 inch pipe and assuming a nominal cutting rate of 8 in./min.

(b) This activity is in parallel with scaffold removal/next installation.

C.2.6 Removal and Packaging of Contaminated Tanks, Tank Diameters between 3 ft and 15 ft

All contaminated tanks are assumed to be stainless steel, approximately 0.5 inches in wall thickness. Cutting is accomplished using a plasma arc torch mounted on a mechanically driven track system. The cutting rate is 4 ft/min., which includes the torch changeout time of 15 min. for every 30 min. of torch operation. The tank is cut into nominal 3.5 ft x 7.5 ft segments for packaging in maritime containers, which are limited in contents weight to less than 35,000 lb. The basic operations are listed below, together with the estimated clock times required to accomplish each operation.

• Install scaffolding around the tank location	15 min.
• Remove insulation from the tank	30 min.
• Install contamination control system	15 min.
• Install track-mounted torch system	10 min.
• Attach lifting devices to tank section	10 min.
• Make major cut in tank wall	A min.
• Remove track-mounted torch system	10 min.
• Place the tank section in the disposal container	10 min. (b)
• Remove contamination control system	15 min.
• Remove scaffolding and move to next location	15 min.

(a)

The number of major cuts per tank is given by:

$$N = [1 + (h/7.5)\text{next integer}] + [(\pi \times D/3.5)\text{next integer}] + 6 \text{ (>7.5 ft dia.)}$$

$$\text{or} + 2 \text{ (<7.5 ft dia.)},$$

where D is the tank diameter and h is the tank height, in feet. Major cuts are defined as circumferential cuts, longitudinal cuts, and cuts across tank ends.

The cumulative length of cut, L, is given by:

$$L = \pi \times D \times [1 + (h/7.5)\text{next integer}] + h \times [(\pi \times D/3.5)\text{next integer}] + 6 \times D \text{ (>7.5 ft dia.)}$$

$$\text{or} + 2 \times D \text{ (<7.5 ft dia.)}$$

(a) These operations are repeated for each major cut.

(b) This activity is conducted in parallel with torch track removal and reinstallation for next cut.

The average time (minutes) per cut, A, is given by:

$$A = [L/(\text{cutting rate in ft/min.})]/N$$

Work Difficulty Adjustments:

Height/Access adjustment for scaffold work	10% of actual duration
Respiratory protection adjustment	20% of actual duration
Adjusted Work Duration	1.4 x actual duration

Non-productive time adjustments:

Radiation/ALARA adjustment	8.2% of adjusted duration
Suit-up/un-suit in anti-contamination clothing	39.4% of adjusted duration
Work breaks (2 per shift)	9.8% of adjusted duration

Cumulative crew-hours per tank	1.3 x 1.574 x actual duration
or	1.3 x 1.574 x [90 + N x (30 + A)]/60

Other Calculations:

Total Labor Cost per Tank: (Crew-hours/tank)(Dollars/crew-hour)

One crew-hour = 5.5 person-hours. The cost per crew-hour is defined to be \$190.13

Crew Exposure Hours per Tank (adjusted duration) = $1.3 \times [90 + N \times (30 + A)]/60$

Exposure pers-hours per tank @ 5.5 pers-hours/crew-hour = $5.5 \times [1.3 \times [90 + N \times (30 + A)]/60$

EXAMPLE CALCULATION:

Diameter = 10.7 ft, height = 27 ft

N, the number of major cuts is given by:

$$N = [1 + (27/7.5)\{\text{rounded to next integer}\}] + [\pi \times 10.7/3.5]\{\text{rounded to next integer}\} + 6 = 1 + 4 + 10 + 6 = 21$$

L, the total length of cut in sectioning the tank is given by:

$$L = \pi \times 10.7 \times (1 + 4) + 27 \times 10 + 6 \times 10.7 = 503 \text{ ft}$$

A, the average cutting time, is given by:

$$A = L/N/(\text{cutting rate}) = 503 \text{ ft} / 21 \text{ cuts} / 4 \text{ ft/min.} = 6 \text{ min./cut}$$

$$\begin{aligned} \text{Crew-hours} &= 1.3 \times 1.574 \times [90 + N \times (30 + A)]/60 \\ &= 2.046 \times [90 + 21 \times (30 + 6)]/60 = 28.85 \text{ crew-hours} \end{aligned}$$

$$\text{Labor Costs} = 28.85 \text{ crew-hours} \times \$190.13/\text{crew-hour} = \$5485.25$$

$$\text{Person-hours} = 28.85 \times 5.5 \text{ pers-hours/crew-hour} = 158.7 \text{ pers-hours}$$

$$\begin{aligned} \text{Exposure pers-hours} &= 1.3 \times (14.1 \text{ exp. crew-hours}) \times 5.5 \text{ pers-hours/crew} \\ &= 100.8 \text{ exposure person-hours} \end{aligned}$$

C.2.7 Labor and Materials Costs per Hour of Equipment Removal Time

The postulated staffing for crews engaged in removing and packaging pumps and miscellaneous equipment within the reference BWR is given below, together with appropriate labor rates for each type of crew member. Multiplying the hourly rate for each labor type by the number of crew members of that type and summing over all labor types yields the labor rate per crew hour.

<u>Pers-hrs/crew-hr</u>	<u>Category</u>	<u>Labor Rate</u> <u>(\$/pers-hr)</u>	<u>Cost^(a)</u> <u>(\$/crew-hr)</u>
2.0	Laborer	26.37	52.74
1.0	Crafts	49.70	49.70
0.5	H. P. Tech.	36.82	-- ^(b)
0.5	Crew Leader	54.84	27.42
4.0			129.86
Average labor cost, 2-shift operations			\$136.35 ^(c)

(a) These values include 110% overhead and 15% DOC profit.

(b) Part of DOC overhead staff. Labor costs appear in undistributed cost.

(c) A 10% shift differential is included for second shift.

Material costs depend on pump/equipment size. For this analysis, it is assumed that the average pump or item of miscellaneous equipment is a cylinder whose height is twice its diameter. To be conservative, it is further assumed that this cylinder is oriented with its axis horizontal to the floor and that the area of the absorbent material should be twice the projected area of the cylinder on the floor. Under these assumptions, the area of required absorbent material is

$$\text{area} = 3 \times \text{vol}^{2/3},$$

where vol is the volume of the item. The costs of plastic and absorbent material, including 15% DOC profit are then:

$$\text{Abs. Matl. @ } \$0.32/\text{ft}^2 = 3 \times \text{vol}^{2/3} \times \$0.32 \times 1.15$$

$$\text{Plastic @ } \$0.04/\text{ft}^2 = 3 \times \text{vol}^{2/3} \times \$0.04 \times 1.15$$

C.2.8 Removal and Packaging of Pumps and Miscellaneous Equipment Weighing Less than 100 Pounds

For items weighing less than 100 pounds, it is assumed that scaffolding will not be required and that the attached piping has already been severed from the item (accounted for in Sections C.2.4 or C.2.5). The basic removal operations are listed below, together with the estimated clock times required to accomplish each operation.

• Disconnect power/instrument/sensor lines	20 min.
• Unbolt item from its mounting	10 min.
• Rig and move item to packaging area	10 min.
Crew-minutes for removing one item (actual duration)	40 min.

Work Difficulty Adjustments:

Respiratory protection adjustment	20% of actual duration
Adjusted Work Duration per item	1.2 x actual duration = 48 min.

Non-productive-time adjustments:

Radiation/ALARA adjustment	8.2% of adjusted duration
Suit-up/un-suit in anti-contamination clothing	39.4% of adjusted duration
Work breaks (2 per shift)	9.8% of adjusted duration
Total Work Duration per item	1.574 x adjusted duration = 75.6 min.
Crew-Hours per item	= 1.26 hrs.
Total labor cost per item (1.26 x \$136.35/crew-hr)	= \$171.69
Crew Exposure Hours per item (adjusted duration)	= 0.80 hrs.
Exposure Person-hours per item @ 4.0 pers-hours/crew-hour	= 3.20 hrs.

C.2.9 Removal and Packaging of Pumps and Miscellaneous Equipment Weighing More than 100 Pounds

The assumptions here are similar to the ones made in the preceding section, except that it is now assumed that scaffolding may be required and that the removal operation will be more time consuming. The basic removal operations are listed below, together with the estimated clock times required to accomplish each operation.

• Install scaffolding at equipment location	30 min.
• Disconnect power/instrument/sensor lines	30 min.
• Unbolt equipment from its mounting	20 min.
• Rig and move item to packaging area	10 min.
Crew-minutes for removing one item (actual duration)	90 min.

Work Difficulty Adjustments:

Height/Access adjustment for scaffold work	10% of actual duration
Respiratory protection adjustment	20% of actual duration
Adjusted Work Duration per item	$1.3 \times \text{actual duration} = 117 \text{ min.}$

Non-productive time adjustments:

Radiation/ALARA adjustment	8.2% of adjusted duration
Suit-up/un-suit in anti-contamination clothing	39.4% of adjusted duration
Work breaks (2 per shift)	9.8% of adjusted duration
Total Work Duration per item	$1.574 \times \text{adjusted duration} = 184 \text{ min.}$
Crew-Hours per item	$= 3.07 \text{ hrs.}$
Total labor cost per item ($3.07 \times \$136.35/\text{crew-hr}$)	$= \$418.59$
Crew Exposure Hours per item (adjusted duration)	$= 1.95 \text{ hrs.}$
Exposure Pers-hours per item @ 4.0 pers-hours/crew-hour	$= 7.80 \text{ hrs.}$

C.2.10 Removal and Packaging of RCS Pumps

The attached piping is presumed severed from the pump body previously (accounted for under RCS Piping Removal). The pump ports are sealed with steel plates welded in place, lifting attachments are connected to the pump/motor assembly, the supports and stabilizers are removed, and the unit is lifted to the operating deck and placed in a horizontal shipping cradle. The basic operations are listed below, together with the estimated clock times required to accomplish each operation.

• Install scaffolding at cut location	60 min.
• Remove pump cooling system ducts	30 min.
• Remove insulation from pump body	30 min.
• Disconnect lubrication and seal cooling lines	20 min.
• Disconnect instrument/sensor lines	10 min.
• Cap inlet and outlet pump ports	30 min.
• Attach lifting devices to pump assembly	60 min.
• Disconnect pump supports and stabilizer units	90 min.
• Lift the pump assembly to the operating deck	60 min.
• Secure the pump assembly to the shipping cradle	30 min.
• Remove scaffolding and move to next location	60 min.

Crew-minutes for removing one pump	(actual duration)	480 min.
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Work Difficulty Adjustments:

Height/Access adjustment for scaffold work	10% of actual duration
Respiratory protection adjustment	20% of actual duration
Adjusted Work Duration per pump	1.3 x actual duration = 624 min.

Non-productive time adjustments:

Radiation/ALARA adjustment	8.2% of adjusted duration
Suit-up/un-suit in anti-contamination clothing	39.4% of adjusted duration
Work breaks (2 per shift)	9.8% of adjusted duration
Total Work Duration per pump	1.574 x adjusted duration = 982 min.
Crew-Hours per pump	= 16.4 hrs.
Total labor cost per pump (16.37 x \$190.13/crew-hr)	= \$3,112.43
Crew Exposure Hours per pump (adjusted duration)	= 10.4 hrs.
Exposure Person-hours per pump @ 5.5 pers-hours/crew-hour	= 57.2 hrs.

C.2.11 High-Pressure Water Wash/Vacuuming of Surfaces

All contaminated horizontal surfaces are washed using a manually operated cleaning system which washes the surface using high-pressure (250 psig) jets and collects the water and removed material simultaneously using a vacuum collection system. This system permits excellent cleansing while avoiding recontamination due to dispersion of the water. The same system, employing modified cleansing heads, is used to wash vertical or overhead surfaces and stairs. An additional 20% of labor time is postulated to be required for the vertical and overhead surfaces cleaning and an additional 5% of labor time is required for stairs. The costs per square foot of surface cleaned are developed below.

A crew consisting of 2 laborers, 1 crafts, 0.5 crew leader, and 0.5 health physics technician is required for the cleansing operation. Normally, there will be two crews working per shift, with two-shift operations. The crew labor costs and exposure levels are:

<u>Pers-hrs/crew-hr</u>	<u>Category</u>	<u>Labor Rate (\$/pers-hr)</u>	<u>Cost^(a) (\$/crew-hr)</u>	<u>Dose Rate (mrem/crew-hr)</u>
2.0	Laborer	26.37	52.74	2
1.0	Crafts	49.70	49.70	0
0.5	H. P. Tech.	36.82	-- ^(b)	0
0.5	Crew Leader	54.84	27.42	0
4.0			129.86	2
Average labor cost, 2-shift operations			\$136.35 ^(c)	

(a) These values include 110% overhead and 15% DOC profit.

(b) Part of DOC overhead staff. Labor costs appear in undistributed cost.

(c) A 10% shift differential is included for second shift.

During an 8-hour (480 minute) shift, the actual cleansing time is estimated to be 4 hours, based on the following:

480 - 120 (suit-up) - 30 (breaks) - 25 (ALARA) - 15 (warmup) - 50 (cleanup), or 240 minutes net working time using the cleansing system. Assuming a cleansing rate of 8 ft²/minute, about 1,920 ft² can be cleansed in one shift.

Thus, the cost per square foot of surface cleansed is given by:

$$8 (\$136.35) / 1920 \text{ ft}^2 = \$0.568/\text{ft}^2$$

Material costs to support system operation include:

Vacuum hose replacement (4 times/yr)	\$1,180
HEPA filter replacement (once/yr)	300
Misc. parts (steam hose, filters) per yr	<u>2,000</u>
Total material costs/yr	\$3,480

With a system operating time of 1040 hr/yr, the material costs per ft^2 are:

$$[\$3,480/\text{yr}] / [1040 \text{ hr/yr} \times 60 \text{ min/hr} \times 8 \text{ ft}^2/\text{min}] = \$0.007/\text{ft}^2$$

and the total operating costs for the system are $\$0.575/\text{ft}^2$ for horizontal surfaces. For vertical and overhead surfaces, an additional 20% is added to the operations time and the labor costs to account for the time used in maneuvering the bucket crane, fork-lift basket, etc., to reach the elevated surfaces. Then, the unit cost factor for elevated surfaces is:

$$\$0.575/\text{ft}^2 \times 1.2 = \$0.690/\text{ft}^2$$

For stairs, an additional 5% is added to the operations time and the labor costs to account for the time used in maneuvering the equipment on the stairs. Then, the unit cost factor for stairs is:

$$\$0.575/\text{ft}^2 \times 1.05 = \$0.604/\text{ft}^2$$

The water usage, and hence liquid radwaste generation, at the rate of 1 gallon per minute of system operation is:

$$1 \text{ gallon}/8 \text{ ft}^2 = 0.125 \text{ gallons}/\text{ft}^2$$

Summary

Unit cost factor (horizontal surfaces)	= \$0.575/ft ²
Unit cost factor (vertical/overhead)	= \$0.690/ft ²
Unit cost factor (stairs)	= \$0.604/ft ²
Liquid radwaste generation	= 0.125 gallons/ft ²
Radiation Exposure	= 0.004 mrem/ft ²

C.2.12 Cutting Uncontaminated Concrete Walls and Floors

All concrete walls and floors are assumed to be uncontaminated or to have been decontaminated before sawing operations begin. Thus, the costs of cutting uncontaminated concrete to provide access to other components are considered to be cascading costs.

Material and labor costs for cutting uncontaminated concrete walls and floors are based on the cut measured in inch-feet (i.e., a cut 1-inch deep, 1 foot long, equals 1 inch-foot). Based on discussions with an industry source, a cutting rate of 60 inch-feet per hour is used in this study. The unit cost for blade material is estimated at \$0.44 per in-ft of cut.

The postulated staffing for crews engaged in cutting the uncontaminated concrete within the reference BWR is given below, together with appropriate labor rates for each type of crew member. Multiplying the hourly rate for each labor type by the number of crew members of that type and summing over all labor types yields the labor rate per crew hour.

<u>Pers-hrs/crew-hr</u>	<u>Category</u>	<u>Labor Rate (\$/pers-hr)</u>	<u>Cost^(a) (\$/crew-hr)</u>
1.0	Laborer	26.37	26.37
1.0	Crafts	49.70	49.70
0.5	Crew Leader	54.84	27.42
2.5			103.49
Average labor cost, 2-shift operations			\$108.66 ^(b)

(a) These values include 110% overhead and 15% DOC profit.

(b) A 10% shift differential is included for second shift.

Cutting of concrete walls is accomplished using a wall-saw on a mechanically driven track system. Cutting of concrete floors is done with a slab-saw. Scaffolding will be used as needed for installing and removing the track system when sawing openings in walls. The concrete pieces are cut into various shapes and sizes, depending upon the size of the openings desired. No packaging is contemplated, since the removed material is uncontaminated. The removed pieces of concrete are transferred to nearby storage areas. The basic operations for cutting concrete walls and concrete floors follow, together with the estimated clock times required to accomplish each operation are shown below.

Cutting Concrete Walls

• Install scaffolding at cut location	15 min.
• Install track-mounted cutting system	10 min.
• Install vacuum/water-spray dust control system	5 min.
• Cut concrete @ 1 in-ft/min.	[thickness of cut (in) x length of cut (ft)]
• Remove track-mounted cutting system	5 min.
• Remove vacuum/water-spray dust control system	5 min.
• Transfer the concrete section to a storage area	5 min. ^(a)
• Remove scaffolding and move to next location	15 min.

Crew-minutes for making
one cut (actual duration)

$$60 \text{ min.} + \frac{N^{(b)}}{1 \text{ in-ft/min.}} \text{ min.}$$

Work Difficulty Adjustments:

Height/Access adjustment for scaffold work	10% of actual duration
Respiratory protection adjustment	10% of actual duration
Adjusted Work Duration	1.2 x actual duration

Non-productive Time Adjustments:

Radiation/ALARA adjustment	8.2% of adjusted duration
Suit-up/un-suit in protective clothing	39.4% of adjusted duration ^(c)
Work breaks (2 per shift)	9.8% of adjusted duration
Total Work Duration per cut	1.574 x adjusted duration

Crew Exposure Hours per in-ft of cut (adjusted duration)	0
Exposure Person-hours per in-ft of cut	0
Total materials cost per in-ft of cut	\$0.44

(a) This activity is in parallel with scaffold removal/next installation.

(b) $N = [\text{thickness of cut (in)} \times \text{length of cut (ft)}]$.

(c) A conservative estimate since no contamination is postulated to be involved in the cutting operations; however, protective clothing is assumed to be worn during industrial-type cutting operations.

Cutting Concrete Floors

- Install floor slab holding device 30 min. (a)
- Install cutting system 5 min.
- Install vacuum/water-spray dust control system 5 min.
- Cut concrete @ 1 in-ft/min. [thickness of cut (in) x length of cut (ft)]
- Remove cutting system 5 min.
- Remove vacuum/water-spray dust control system 5 min.
- Transfer the concrete section to a storage area and disengage floor slab holding device 10 min.

Crew-minutes for making
one cut (actual duration) 60 min. + $\frac{N^{(b)}}{1 \text{ in-ft/min.}}$ min.

Work Difficulty Adjustments:

Height/Access adjustment for scaffold work	0% of actual duration
Respiratory protection adjustment	10% of actual duration
Adjusted Work Duration	1.1 x actual duration

Non-productive Time adjustments:

Radiation/ALARA adjustment	8.2% of adjusted duration
Suit-up/un-suit in protective clothing	39.4% of adjusted duration (c)
Work breaks (2 per shift)	9.8% of adjusted duration
Total Work Duration per cut	1.574 x adjusted duration

Crew Exposure Hours per in-ft of cut (adjusted duration)	0
Exposure Person-hours per in-ft of cut	0
Total materials cost per in-ft of cut	\$0.44

(a) Building crane is used for this operation.

(b) $N = [\text{thickness of cut (in)} \times \text{length of cut (ft)}]$.

(c) A conservative estimate since no contamination is postulated to be involved in the cutting operations; however, protective clothing is assumed to be worn during industrial-type cutting operations.

C.2.13 Removal of Contaminated Concrete Surfaces

Those contaminated horizontal surfaces which are not sufficiently decontaminated using the high-pressure washing system are removed using a commercially available pneumatically operated surface removal system. Commercial systems which use very high-pressure water jets for surface removal are also available. For this analysis, a specific commercial system manufactured by

Pentex, Inc. is assumed (the Moose™ and associated smaller units) which chips off the surface and collects the dust and chips into a waste drum, and filters the air to prevent recontamination of the cleaned surfaces.

It is postulated that the depth of concrete to be removed will vary from location to location, but that on the average, removal of about one inch will be sufficient to remove the residual radioactive contamination. Because the removal system selected removes about 0.125 inch of material per pass, an average of 8 passes will be required over the contaminated areas. Because the Moose™ cannot get closer to walls than about 6 inches, smaller units of the same type (Squirrel III™, and Corner Cutter™) are used to clean the perimeter areas of rooms. For this analysis, it is postulated that the perimeter areas comprise about 20% of the total surface area to be cleaned. For 1-pass removal operations, the Moose™ is assumed to clean at the rate of about 115 ft² per hour and the Squirrel™ cleans at the rate of about 30 ft² per hour. Combining these rates by weighting with the fractions of surface removed by each unit, the nominal removal rate becomes about 100 ft²/hr. Assuming an average of 8 passes are required, the effective average cleaning rate becomes 12.5 ft²/hr.

Staffing of this crew is postulated to consist of 3 laborers (one on the Moose™, one on the Squirrel™, one watching the compressor and handling the filled waste drums), about 1/4 each of a crew leader and a health physics technician.

<u>Pers-hrs/crew-hr</u>	<u>Category</u>	<u>Labor Rate(\$/hr)</u> <u>(\$/labor-hr)</u>	<u>Cost^(a)</u> <u>(\$/crew-hr)</u>	<u>Dose Rate</u> <u>(mrem/crew-hr)</u>
3.00	Laborer	26.37	79.11	3
0.25	H. P. Tech.	36.82	-- ^(b)	0
<u>0.25</u>	Crew Leader	54.84	<u>13.71</u>	<u>0</u>
3.50			92.82	3
Average for 2-shift operation			\$97.46 ^(c)	

(a) These values include 110% overhead and 15% DOC profit.

(b) Part of DOC overhead staff. Labor costs appear in undistributed cost.

(c) A 10% shift differential is included for second shift.

During an 8-hour (480 minute) shift, the actual cleansing time is estimated to be 5.33 hours (320 minutes), based on the following:

$$480 - 120 \text{ (suit-up)} - 30 \text{ (breaks)} - 10 \text{ (ALARA)}$$

or 320 minutes net working time using the cleansing system. Assuming a cleansing rate of $12.5 \text{ ft}^2/\text{hour}$, about 67 ft^2 can be cleansed in one shift. Thus, the labor cost per square foot of surface cleansed is given by:

$$(\$97.46/\text{crew-hr}) / (320/480 \times 12.5) \text{ ft}^2/\text{hr} = \$11.70/\text{ft}^2$$

The cutting bits for the units are assumed to be replaced every 80 hours of operation, for an equivalent cost of about \$13 per hour of operation. Principal additional costs would be filter replacements at about \$2.50 per hour of operation, and waste drums for the collected debris at about \$0.07 per square foot per pass (or \$0.539 per square foot for eight passes).

The duration of the removal effort would be about 32 weeks, based on $21,600 \text{ ft}^2$ to be removed, the $12.5 \text{ ft}^2/\text{hr}$ removal rate, two shifts per day, and a daily operating time of 5.33 hours per shift. Because of the relatively short time that the equipment is needed, rental would be preferable to purchase. Assuming a 5-yr lifetime, straight-line depreciation, and a 25% utilization factor, the equipment cost of about \$148,000 would be amortized at a rate of about \$2,300/wk, or about \$43.12 per hour of operation.

Rental of a 365-cfm capacity compressor sufficient to supply the main unit and the edger unit simultaneously would be about \$2,025/month, or about \$8.76 per hour of operation.

The total material and rental cost per square foot for the eight passes is then given by:

$$[\$13/\text{hr. (bits)} + \$2.50/\text{hr. (filters)} + \$43.12/\text{hr. (system)} + \$8.76/\text{hr. (compressor)}] / 12.5 \text{ ft}^2/\text{hour} + \$0.539/\text{ft}^2 \text{ (drums)} = \$5.93/\text{ft}^2$$

Thus, the total cost per square foot of horizontal surface removal is estimated as \$11.70 (labor) + \$5.93 (material and rental) = \$17.63/ft². The smaller units (Squirrel III™ and Corner Cutter™) could be utilized on vertical surfaces. The cost per square foot of vertical surface removed would be approximately four times the horizontal cost, due to the lower removal rates of the smaller units:

$$4 \times [\$11.70 \text{ (labor)} + \$5.39 \text{ (material)}] + \$0.539 \text{ (drums)} = \$68.90/\text{ft}^2$$

Summary

Unit cost factor (horizontal surfaces) = \$17.63/ft²

Unit cost factor (vertical/overhead) = \$68.90/ft²

Waste volume generated (1 in. removed) = 0.083 ft³/ft²

Radiation Exposure = 0.24 mrem/ft²

C.2.14 Removal and Packaging of Contaminated Metal Surfaces

All contaminated metal surfaces are assumed to be stainless steel, approximately 0.125 inches in wall thickness. Cutting is accomplished using a plasma arc torch mounted on a mechanically driven track system. The cutting rate is 4 ft/min., which includes the torch changeout time of 15 min. for every 30 min. of torch operation. The surfaces are cut into nominal 7.5 ft x 18 ft segments for packaging in modified maritime containers. Crew size and composition, work difficulty adjustments and non-productive time adjustments are assumed to be the same as for tank cutting operations, Section C.2.6. The basic operations for removing a section of rectangular steel surface H feet high by W feet wide are listed below, together with the estimated clock times required to accomplish each operation.

• Install scaffolding at surface location		15 min.
• Install contamination control system		15 min.
• Install track-mounted torch system		10 min.
• Attach lifting devices to surface section		10 min.
• Make major cut in metal surface	(a)	A min.
• Remove track-mounted torch system		10 min.
• Place the section in the disposal container		10 min. (b)
• Remove contamination control system		15 min.
• Remove scaffolding and move to next location		15 min.

(a) These operations are repeated for each major cut.

(b) This activity is conducted in parallel with torch track removal and reinstallation for next cut.

Total Crew-hours for segmenting a rectangular section (actual duration): $[60 + N(30 + A)]/60$,

where N is the number of major cuts per section, and A is the average time per major cut. A major cut is a vertical or horizontal cut extending across the complete height or width of the rectangular section. Thus a major cut is either H feet long or W feet long. The number of major cuts is given by:

$$N = N_{\text{horiz}} + N_{\text{vert}},$$

where N_{horiz} , the number of horizontal cuts, is given by

$$N_{\text{horiz}} = \text{TRUNC}[H/7.5],$$

and N_{vert} , the number of vertical cuts, is given by

$$N_{\text{vert}} = \text{TRUNC}[W/18]$$

The average time for each major cut is

$$A = (N_{\text{horiz}} \times W + N_{\text{vert}} \times H)/N/\text{Rate},$$

where Rate is the cutting rate, 4 feet/minute.

EXAMPLE CALCULATION: - Sectioning a steel surface 40 feet high by 80 feet wide.

H = 40, W = 80.

The number of horizontal cuts, N_{horiz} , is given by

$$N_{\text{horiz}} = \text{TRUNC}(40/7.5) = 5,$$

and the number of vertical cuts, N_{vert} , is

$$N_{\text{vert}} = \text{TRUNC}(80/18) = 4.$$

Thus, the total number of cuts is given by

$$N = N_{\text{horiz}} + N_{\text{vert}} = 9.$$

Putting this together gives for the average length of time per cut:

$$A = (N_{\text{horiz}} \times W + N_{\text{vert}} \times H) / N / \text{Rate} = (5 \times 80 + 4 \times 40) / 9 / 4 = 15.6 \text{ minutes/major cut.}$$

$$\text{Total crew hours} = 1.3 \times 1.574 \times [60 + N(30 + A)] / 60$$

$$= 1.3 \times 1.574 \times [60 + 9(30 + 15.6)] / 60 = 16.0 \text{ hours.}$$

The factors 1.3 and 1.574 are the work difficulty and non-productive time adjustments, developed in Section C.2.6.

C.2.15 Removal and Packaging of Contaminated Ducts 6 x 8 in. to 42 x 80 in.

All contaminated ducts are assumed to be galvanized steel, 20 to 16 gauge. The ducts are assumed to be separated into about 8-ft sections. The time bases are drawn from R.S. Means 1991⁽¹⁾ for duct removal. The average rate of removal in linear feet per 8-hour day for the inventory of ductwork in the reference BWR is calculated to be about 62 linear feet, by interpolation of the Means data. Thus, the average time per section of duct removed is about 60 minutes, including scaffolding. Subtracting 4 minutes per hour for work breaks leaves 56 minutes of direct labor per 8-ft section. The time duration factors that need to be considered are respiratory protection, protective clothing changes, work breaks and ALARA. The postulated crew size, cost, and associated radiation dose are given below.

<u>Pers-hrs/crew-hr</u>	<u>Category</u>	<u>Labor Rate (\$/pers-hr)</u>	<u>Cost^(a) (\$/crew-hr)</u>	<u>Dose Rate (mrem/crew-hr)</u>
2.0	Laborer	26.37	52.74	2
0.5	H. P. Tech.	36.82	-- ^(b)	0
<u>0.5</u>	Crew Leader	54.84	<u>27.42</u>	<u>0</u>
3.0			80.16	2
Average labor cost, 2-shift operations			\$84.17 ^(c)	

(a) Includes a 10% shift differential for the second shift.

(b) Part of DOC overhead staff. Labor costs appear in undistributed cost.

(c) 10% shift differential for second shift.

The removal operations and associated time durations are listed below.

- Install scaffolding at cut location --
- Remove duct section 56 min.
- Bag ends of duct section 5 min.

- Flatten section 5 min.
- Transfer the flattened section to a maritime container 5 min.
- Remove scaffolding and move to next location --

Crew-minutes for removing one section (actual duration) 71 min.

Work Difficulty Adjustments:

Respiratory protection adjustment 20% of actual duration

Adjusted Work Duration $1.2 \times \text{actual duration} = 85 \text{ min.}$

Non-productive time adjustments:

Radiation/ALARA adjustment 8.2% of adjusted duration

Suit-up/un-suit in anti-contamination clothing 39.4% of adjusted duration

Break time 9.8% of adjusted duration

Total Work Duration per section $1.574 \times \text{adjusted duration} = 134 \text{ min.}$

Crew-Hours per ft = $134 \text{ min}/8 \text{ ft} = 16.75 \text{ min/ft} = 0.279 \text{ hours/ft}$

Total Labor Cost per ft = $0.279 \times \$84.17/\text{crew-hr} = \23.50

Operations: 2 crews per shift, 2 shifts per day

Crew Exposure Hours per ft, assuming exposure to 2 laborers = $2 \times 0.279/1.574$
= 0.355 hrs/ft.

Assumed radiation dose rate = 1.0 mrem/hr

Radiation Dose per ft removed = 0.355 mrem/ft

C.2.16 Removal of Steel Floor Grating

It is assumed that contaminated steel floor grating (on stairs, platforms, and walkways) will be removed during decommissioning in essentially the same manner in which it was installed; therefore, installation labor factors were used, based on "Building Construction Cost Data 1991" by R. S. Means,⁽²⁾ p. 130, and modified for a radiation zone environment. Steel floor grating is assumed to weigh 10.4 lb/ft^2 . In an uncontaminated environment, the performance rate is 550 ft^2 of steel floor grating installed (removed) per 8 hours

(about 68.75 ft²/hr), by interpolation of the Means values. Based on the non-productive work time factor (1.574) given in Section C.2.1, the available time per 8-hr shift used in this re-evaluation analysis is found by:

$$8 \text{ hrs}/1.574 = 5.083 \text{ hrs}$$

The worker efficiency in respiratory equipment (1.2) for a radzone environment reduces the total removal efficiency per shift as follows:

$$5.083 \text{ hrs} \times (68.75 \text{ ft}^2/\text{hr} / 1.2) = 291.2 \text{ ft}^2/\text{shift}$$

or to an hourly rate of $291.2 / 8 \text{ hrs} = 36.4 \text{ ft}^2/\text{hr}$

The postulated crew size, cost, and associated radiation dose are given below.

<u>Pers-hrs/crew-hr</u>	<u>Category</u>	<u>Labor Rate</u> <u>(\$/pers-hr)</u>	<u>Cost^(a)</u> <u>(\$/crew-hr)</u>	<u>Dose Rate</u> <u>(mrem/crew-hr)</u>
3.0	Laborer	26.37	79.11	3
0.5	H. P. Tech.	36.82	--(b)	0
<u>0.5</u>	Crew Leader	54.84	<u>27.42</u>	<u>0</u>
4.0			106.53	3
Average labor cost, 2-shift operations			\$111.86 ^(c)	

(a) Includes 110% overhead, 15% DOC profit.

(b) Part of DOC overhead staff. Labor costs appear in undistributed cost.

(c) 10% shift differential for second shift.

Crew-Hours per ft ²	0.0275
Total Labor Cost per ft ²	0.0275 x \$111.86/crew-hr = \$3.08
Crew Exposure Hours per ft ²	0.0275 hrs.
Exposure Pers-hours per ft ²	@ 4.0 pers-hours/crew-hour = 0.11 hrs.
Radiation Dose-rate (mrem/hr)	1.0

Principal material costs are gases for torches at \$7.76/hr, including 15% DOC profit (see Section C.2.2).

C.2.17 Decontamination of Handrails

All contaminated handrails are assumed to be 2-inch-diameter carbon steel. One lineal foot (LF) of handrail equals about $1/2 \text{ ft}^2$ of surface area. The assumed decontamination rate is $15 \text{ ft}^2/\text{hour}$ or about 30 LF/hr. Decontamination will be done manually using industrial wipes and Radiacwash™ (diluted 5:1). The waste will be bagged for disposal. This work is not anticipated to require either respiratory protection or scaffolding. The postulated crew size, cost, and associated radiation dose are given below.

<u>Pers-hrs/crew-hr</u>	<u>Category</u>	<u>Labor Rate</u> <u>(\$/pers-hr)</u>	<u>Cost^(a)</u> <u>(\$/crew-hr)</u>	<u>Dose Rate</u> <u>(mrem/crew-hr)</u>
2.0	Laborer	26.37	52.74	2
0.5	H. P. Tech.	36.82	-- ^(b)	0
0.5	Crew Leader	54.84	27.42	0
3.0			80.16	2
Average labor cost, 2-shift operations			\$84.17 ^(c)	

(a) Includes 110% overhead, 15% DOC profit.

(b) Part of DOC overhead staff. Labor costs appear in undistributed cost.

(c) 10% shift differential for second shift.

The decontamination operations and associated time durations are listed below.

- Manually decontaminate 1 LF of handrail 2 min.^(a)
- Radiation survey 1 min.
- Move to next location 1 min.^(b)

Crew-minutes for decontamination of 1 LF (actual duration) = 3.0 min.

Work Difficulty Adjustments: None required.

Adjusted Work Duration: 1.0 x actual duration = 3.0 min.

(a) Assumed to be washed twice, rinsed once, and dried.

(b) The move is made in parallel with the survey.

Non-productive time adjustments:

Radiation/ALARA adjustment	3.1% of adjusted duration
Suit-up/un-suit in anti-contamination clothing	37.5% of adjusted duration
Work breaks (2 per shift)	9.4% of adjusted duration

Total Work Duration per LF $1.500 \times$ adjusted duration	= 4.50 min.
Crew-Hours per LF	0.075 hrs.
Total Labor Cost per 1 LF $0.05 \times \$84.17/\text{crew-hr}$	= \$6.31
Crew Exposure Hours per 1 LF (adjusted duration)	= 0.033 hrs.
Exposure Pers-hours per 1 LF @ 2.0 pers-hours/crew-hour	= 0.10 hrs.
Radiation Dose-rate (mrem/hr)	= 1.0

During an 8-hour (480 minute) shift, the actual cleansing time is estimated to be 5.33 hours (320 minutes), based on the following:

$$480 - 120 \text{ (suit-up)} - 30 \text{ (breaks)} - 10 \text{ (ALARA)}$$

Assuming a cleansing rate of 30 LF/hour ($15 \text{ ft}^2/\text{hour}$), about 160 LF (80 ft^2) can be cleansed in one crew-shift. Assuming two crews per shift, two shifts per day, the duration of the cleansing effort in the containment, fuel, and auxiliary buildings would be about 17.6 days, based on an estimated 11,226 LF of handrails to be cleansed.

The costs of materials used in the decontamination operations are

Industrial Wipes w/hand-held dispenser (McMaster-Carr, Edition 98, p. 1060.)

Wipes @ \$14.76/275-ft roll (9-3/4 in. wide)

Dispenser @ \$13.50/each

Radiacwash™ @ \$15/gal (Air Products Corporation, Catalog 68)

Principal material costs are: 1) industrial wipes (at an estimated usage rate of 10 wipes/6-ft section) for an equivalent cost of about \$0.09/LF and 2) cleansing solution, used at a rate of 430 LF/gal, for an equivalent cost of about \$0.03/LF. In addition, it is estimated that eight hand-held

dispensers are needed, for an equivalent cost of about \$0.01/LF. A used wipe is estimated to occupy about 0.00324 ft³. At 1.67 wipes per foot, this works out to 0.0054 ft³ of waste per LF of railing. Similarly, the waste volume from the gallon cans of cleansing solution accumulates at a rate of

$$(1/430) \text{ gallon-containers/ft} \times 0.134 \text{ ft}^3/\text{gallon-container} = 0.0003 \text{ ft}^3/\text{LF}.$$

Thus the rate at which waste is generated is about 0.0057 ft³/LF. A 55-gallon drum holds about 7.35 ft³. So, at \$26.95 per drum, the cost for this waste is about \$0.02/LF. Thus, the total cleansing cost per lineal foot is estimated to be:

$$\begin{aligned} &\$6.31 \text{ (labor)} + \$0.09 \text{ (wipes)} + \$0.03 \text{ (Radiacwash™)} + \$0.02 \text{ (drums)} + \\ &\$0.01 \text{ (dispensers)} = \$6.46/\text{LF} \end{aligned}$$

Summary

Unit cost factor = \$6.46/LF

Waste volume generated = 0.0057 ft³/LF

C.2.18 Removal of Contaminated Floor Drains

Discussions between the authors and senior staff of Pacific Nuclear Services (PNS)^(a) were held concerning PNS's experiences to date with chemical decontamination of drain systems at nuclear power plants. PNS indicates that it is probably not cost-effective, nor practical to chemically decontaminate reactor drain systems prior to disassembly. Therefore, the piping in the drain systems at the reference BWR is not postulated to be chemically decontaminated before disassembly. Removal and packaging of contaminated piping associated with the drains is covered under Sections C.2.3 and C.2.4. This section discusses only the removal of the drains, which is postulated to occur after the drain piping has been removed.

(a) Pacific Nuclear Services specializes in chemical decontamination services and is currently under contract to Consolidated Edison of New York to perform the first full-system decontamination of a commercial PWR in the U.S.

It is estimated that there are 320 drains that could be radioactively contaminated. The volume of a "typical" drain is conservatively estimated to be about 2.80 ft³, using a rough approximation to calculate the space occupied by the "plug" that is postulated to be removed by a core drill. Each plug is estimated to weigh about 550 pounds, based on a 16-in-diameter concrete plug (containing the drain) being cut from a nominal 2-ft-thick reinforced concrete floor.

The following procedure for the removal of contaminated floor drains is based upon discussions between the authors and senior staff of the Columbia Concrete Sawing Company.

It is assumed that 3-inch-wide steel strapping is bolted underneath the plug to prevent it from falling upon completion of the core drilling operation. In addition, the top of each drain is covered with plastic prior to the start of drilling. A water mist is used during core drilling operations for dust control, as required. The water is collected by means of a vacuum at the top end and by a plastic trough that empties into a bucket at the bottom of the plug, resulting in the collection of an estimated total of 5 gallons of potentially contaminated waste water per plug. Very limited, if any, respiratory equipment is anticipated to be needed for core drilling operations associated with removal of the floor drains.

Upon completion of drilling, the plug is rigged for lifting, raised, moved, and placed in a B-25 metal container. The basic operations are listed below, together with the estimated clock times required for each operation.

- Above Drain: drill anchor hole for drill stand, set anchor, and bolt drill stand to floor; cover drain with plastic; water & vacuum clean in place 10 min. (a)
- Below Drain: install scaffolding; drill bolt holes and affix steel strapping; rig plastic trough/bucket 35 min.
- Core drill the drain plug 206 min. (b)
- Collect and dispose of waste water 30 min. (c)
- Rig, lift, move, and place plug in disposal container 30 min.

- Secure prefabricated cover over hole 5 min.
- Remove scaffolding and equipment and move to next location 15 min.

Crew minutes for removing one drain (actual duration) 291 min.

- (a) This operation is conducted in parallel with the Below Drain operations.
 (b) Nominal time for core drilling rate of 7 in./hr., including diamond-core bit replacements.
 (c) This operation is conducted in parallel with the core drilling operations.

Work Difficulty Adjustments:

Height/Access adjustment 7% of actual duration

Adjusted Work Duration 1.07 x actual duration = 311 min.

The total crew-minutes per drain removal activity =

estimated work duration of 291 min. x work difficulty adjustment of 7% x non-productive time

adjustment given previously in Section C.2.1 of 1.574 = ~ 490 minutes (roughly, one drain removed per 8-hr shift)

Radiation Exposure time =

estimated work duration of 291 min. x 1.07 = ~311 min. (or, ~ 5.2 hrs)

A crew consisting of 1 laborer, 1 crafts, 0.5 crew leader, and 0.5 health physics technician is required for the removal operation. Normally, there will be four crews working per shift, with two-shift operations. The crew labor costs and exposure levels are:

<u>Pers-hrs/crew-hr</u>	<u>Category</u>	<u>Labor Rate</u> <u>(\$/pers-hr)</u>	<u>Cost (a)</u> <u>(\$/crew-hr)</u>	<u>Dose Rate</u> <u>(mrem/crew-hr)</u>
1.0	Laborer	26.37	26.37	0.5
1.0	Crafts	49.70	49.70	0.5
0.5	H. P. Tech.	36.82	--(b)	0
<u>0.5</u>	Crew Leader	54.84	<u>27.42</u>	<u>0</u>
3.0			103.49	1

Average labor cost, 2-shift operations \$108.66^(c)

(a) These values include 110% overhead and 15% DOC profit.

(b) Part of DOC overhead staff. Labor costs appear in undistributed cost.

(c) A 10% shift differential is included for second shift.

Crew-Hours per drain = 8.0 hrs

Total Labor Cost per drain (8.0 x \$108.66/crew-hr) = \$869.28

Crew Exposure Hours per drain (adjusted duration) = 5.2 hrs.

Exposure Pers-hours per drain @ 2.0 pers-hours/crew-hour = 10.4 hrs.

Radiation Dose-rate (mrem/hr) = 0.5

Principal material costs (including 15% DOC profit) are:

- diamond-core bit replacements at \$4.60/inch depth
 $\$4.60/\text{inch depth} \times 24\text{-in. thick floor} = \$110.40/\text{drain}$
- absorbent materials and plastic are estimated at \$5.80/drain
- equipment rentals
 $(4 \text{ power units at } \$1,035/\text{wk} + 4 \text{ drain plug pullers at } \$138/\text{wk}) / 5 \text{ days/wk} = \$938.40/\text{day}$
 $(\$938.40/\text{day}) / 8 \text{ drains/day} = \$117.30/\text{drain}$

On a weight-basis, it is estimated that a B-25 container will hold 17 drain plugs, situated in two layers. Thus the container cost per drain is $(\$618.50/\text{container}) / (17 \text{ drains/container}) = \36.38 .

Thus, the total removal cost per drain is \$869.28 (labor) + \$110.40 (core bits) + \$5.80 (materials) + \$117.30 (equipment rentals) + \$36.38 (containers) = \$1,139.16/drain.

Summary^(a)

Unit cost factor = \$1,139.16/drain

Waste volume generated, water = 5 gal/drain

Waste volume generated, solids = 2.80 ft³/drain

Radiation exposure = 5.2 mrem/drain

(a) Specific specialized equipment purchases for this drain removal task are included separately in Appendix B, Table B.6.

C.3 TRANSPORTATION COSTS

The CECP data base contains distances from all commercial reactor sites to the postulated geologic repository at Yucca Mountain and to the low-level disposal sites at Hanford and Barnwell. The distances provided are suggested distances only and may be changed as desired by the user. If the user does not find the desired site in the site listing, the desired site name and distances to disposal facilities can be added to the site listing. In addition to site name and distances, the user specifies the name of the desired low level waste disposal site. This site information, along with the plant inventory and reactor pressure vessel characteristics, enables the CECP to calculate transportation costs.

To calculate transportation costs, the CECP employs a different cost formula for each cask (CNS 8-120B, NuPac 14-210H, NAC-LWT, and TN-8) that will be used in decommissioning. These formulas are provided in Appendix B.

C.4 REFERENCES

1. "Means Estimating Handbook 1991," Robert Snow Means Company, Inc., Kingston, Massachusetts 1991
2. "Building Construction Cost Data 1991," Robert Snow Means Company, Inc., Kingston, Massachusetts 1991

APPENDIX D

EFFECTS OF THE SPENT NUCLEAR FUEL INVENTORY ON
DECOMMISSIONING ALTERNATIVES

APPENDIX D

EFFECTS OF THE SPENT NUCLEAR FUEL INVENTORY ON DECOMMISSIONING ALTERNATIVES

Current U.S. Nuclear Regulatory Commission (NRC) policy requires removal of all spent nuclear fuel (SNF) from a facility licensed under Title 10 CFR Part 50⁽¹⁾ before DECON can be accomplished. A number of removal alternatives exist, including transfer to another storage pool or transfer to either a wet or dry independent spent fuel storage installation (ISFSI), licensed under Title 10 CFR Part 72.⁽²⁾ Transfer to another storage pool is constrained by the availability of space in another pool. Transfer to a dry ISFSI is constrained by limits on allowable fuel cladding temperatures. These temperature limits necessitate storage in water pools for extended periods of time following discharge from the reactor prior to dry storage, with the length of the storage period dependent upon the fission product heat generation in the fuel, which is a function of the initial enrichment and irradiation history of the fuel. The use of a dry ISFSI may also be constrained by the availability of equipment to transfer SNF from dry storage casks to transportation casks prior to shipment to a repository.

The analyses presented in this appendix reflect the expected situation at the reference boiling water reactor (BWR), the WNP-2 plant near Richland, Washington, if the plant operated until expiration of its operating license, and therefore are representative of other large BWRs that do operate until their licenses expire. These analyses do not necessarily reflect the actual situation at the WNP-2 reactor.

Under the contractual agreements between the U.S. Department of Energy (DOE) and the nuclear utilities for disposal of SNF, SNF owned by utilities is placed in an acceptance queue, ranked by date of discharge on an oldest-fuel-first (OFF) basis. Subsequently, the amount of SNF accepted from a given utility in a given year is determined by its place in the queue and the amount of SNF to be accepted by DOE during that year.

Based upon the current regulatory environment and upon the SNF cooling time analyses presented in this appendix, the minimum period for spent fuel pool operation and plant safe storage prior to dismantlement at the reference BWR is estimated to be 4.6 years, provided that the owner constructs and licenses an onsite ISFSI under Part 72. Without an onsite ISFSI, the minimum period for pool operation and plant safe storage prior to decommissioning is estimated to be 9 years. This 9-year estimate presumes the utility maintains its fuel pool under a Part 50 possession-only license after shutdown, together with reliance on the DOE's acceptance of the SNF under the 10 CFR Part 961 contractual agreement to empty the fuel pool.

The regulatory considerations, background information, and the details of the analyses leading to the above conclusions are presented in subsequent sections of this appendix in the following order:

- regulatory considerations governing SNF disposal
- postulated allocation of the waste management system's annual acceptance capacity for the reference BWR
- background information related to post-shutdown storage of SNF
- generic considerations related to post-shutdown storage of SNF, including the range of storage/disposition alternatives and a methodology for evaluating the present value of the total storage system life-cycle costs for two basic options of SNF storage
- required SNF cooling time following discharge before dry storage
- rationale for the spent fuel storage option postulated for the reference BWR.

D.1 REGULATORY CONSIDERATIONS GOVERNING SNF DISPOSAL

The Nuclear Waste Policy Act of 1982 (NWPA)⁽³⁾ assigns to the federal government responsibility to provide for the permanent disposal of SNF^(a)

(a) As delineated in Title 10 CFR Part 961, Appendix E,⁽⁴⁾ SNF is broadly classified into three categories - standard fuel, nonstandard fuel, and failed fuel. Most, if not all, SNF from the reference BWR is assumed to fall into the standard fuel category. One of the General Specifications for standard fuel is a minimum cooling time of five years.

and high-level radioactive waste (HLW).^(b) The Director of the Department of Energy's (DOE) Office of Civilian Radioactive Waste Management (OCRWM) is responsible for carrying out the functions of the Secretary of Energy (Secretary) under the NWPA. Section 302(a) of the NWPA authorizes the Secretary to enter into contracts^(c) with owners or generators^(d) of commercial SNF or HLW. The Standard Contract for Disposal of Spent Nuclear Fuel and/or High-Level Radioactive Waste⁽⁴⁾ represents the sole contractual mechanism for DOE acceptance and disposal of SNF and HLW. It establishes the requirements and operational responsibilities of the parties to the Contract in the areas of administrative matters, fees, terms of payment for disposal services, waste acceptance criteria, and waste acceptance procedures. The Standard Disposal Contract provides for the acquisition of title to the SNF or HLW by DOE, its transportation to DOE facilities, and its subsequent disposal.

Concerning the issue of priority being afforded to permanently shutdown reactors, DOE has responded thusly⁽⁵⁾:

"Article VI.B of the Standard Disposal Contract allows that priority may [emphasis added] be afforded to shutdown reactors. DOE has not determined whether or not priority will be accorded to shutdown reactors or, if priority is granted, under what circumstances. DOE recognizes that granting priority to shutdown reactors invites questions of equity among all owners and generators of SNF."

With regard to DOE's beginning operations in 1998, DOE's intention, consistent with the NWPA and the Contract, is to initiate acceptance of spent fuel from Purchasers as soon as a DOE facility commences operations. DOE has stated that waste acceptance at a monitored retrievable storage (MRS) facility could begin in 1998 if the initiatives detailed in the November 1989 "Report to Congress on Reassessment of the Civilian Radioactive Waste Management Program"⁽⁶⁾ are fully implemented. While SNF acceptance by DOE appears

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- (b) HLW means the highly radioactive material resulting from the reprocessing of spent nuclear fuel, including liquid waste produced directly in reprocessing and any solid material derived from such liquid waste that contains fission products in sufficient concentrations; and other highly radioactive material that the Nuclear Regulatory Commission, consistent with existing law, determines by rule requires permanent isolation.
 - (c) Individual contracts are based upon the Standard Contract for Disposal of Spent Nuclear Fuel and/or High-Level Radioactive Waste (10 CFR Part 961), which will be referred to as the "Standard Disposal Contract" or "Contract" for subsequent discussion in this report.
 - (d) Owners or generators of SNF and HLW who have entered into agreements with DOE or have paid fees for purchase of disposal services are referred to as "Purchasers."

unlikely, for the purpose of this study the acceptance schedule developed by DOE which assumes starting acceptance in 1998 are used. Until waste acceptance begins, the owners and generators of SNF/HLW will continue to be responsible for storing their spent fuel.

D.1.1 Standard Disposal Contract Requirement for an Annual Capacity Report

Under the terms of the Standard Disposal Contract (Article IV), the DOE issues an Annual Capacity Report (ACR)⁽⁷⁾ wherein DOE's annual SNF/HLW receiving capacity is projected and the annual acceptance ranking allocations to the Purchasers are presented for 10 years following the projected commencement of DOE facility operations. As specified in the Contract, the ACR is for planning purposes only and thus is not contractually binding on either DOE or the Purchasers. The Standard Disposal Contract states that beginning April 1991, DOE shall issue the first annual Acceptance Priority Ranking for receipt of SNF/HLW. The Contract further specifies that, beginning in January 1992, and based on the Acceptance Priority Ranking, the Purchasers shall submit Delivery Commitment Schedules (DCSs) to DOE identifying the SNF/HLW that the Purchasers propose to deliver to the Federal Waste Management System (FWMS). The Contract provides that the approved DCSs will become the bases for Final Delivery Schedules, which are to be submitted by the Purchasers not less than 12 months before the designated year of DOE's anticipated acceptance of title to the SNF/HLW and subsequent transport to a DOE facility.

D.1.2 Waste Acceptance Projections

The waste acceptance projections used in the ACR are representative of a FWMS configuration authorized by the Nuclear Waste Policy Amendments Act of 1987 (Amendments Act),⁽⁸⁾ which includes an MRS facility. Article II of the Standard Contract specifies that "The services to be provided by DOE under this contract shall begin, after the commencement of facility operations, not later than January 31, 1998...." DOE recognizes that, under current conditions, waste acceptance at a DOE facility can begin in 1998 only if the federal government is able to consummate a timely agreement, which is enacted into federal law, with a host State or Indian Tribe for the siting of an MRS facility. The Nuclear Waste Negotiator, which is a representative of the

federal government appointed by the President, is actively seeking a State or Indian Tribe willing to host an MRS facility or a geological repository.⁽⁵⁾

DOE's projected acceptance rates for the first 10 years of FWMS operation, extracted from the ACR,⁽⁷⁾ are given in Table D.1. These rates do not reflect the MRS facility schedule linkages with the repository development that were imposed by the Amendments Act, but are consistent with the 10,000-MTU storage capacity limit contained in the Amendments Act for an MRS facility before a repository starts operation. These acceptance rates assume commencement of facility operations in 1998. If the current linkages between MRS facility construction and repository construction authorization are maintained, it is estimated that commencement of MRS facility operations could not start until at least 2007.⁽⁷⁾

TABLE D.1. Projected Waste Acceptance Rates for Spent Nuclear Fuel^(a)

<u>Year</u>	<u>SNF (MTU)</u>
1998	400
1999	600
2000	900
2001	900
2002	900
2003	900
2004	900
2005	900
2006	900
2007	<u>900</u>
Total	8,200

(a) According to information contained in Reference 7, the reference BWR's first fuel acceptance allocation does not appear until CY 2011.

Operation of the FWMS with the waste acceptance rates presented in Table D.1 would result in the receipt of 8,200 MTU of SNF at the MRS facility during the first 10 years of operations. This table provides only the current estimate of the system throughput rates and is subject to change depending upon the system design and configuration and Congressional action regarding the conditions for the siting of an MRS facility. DOE will further define and specify the system operating and waste acceptance parameters as the program progresses and inform the Purchasers accordingly at the earliest feasible time. Until the SNF is accepted by DOE, Section 111(a)(5) of the NWSA assigns

the waste owners and generators the primary responsibility to provide for, and pay the costs of, interim storage.⁽⁷⁾

D.2 POSTULATED ALLOCATION OF THE WASTE MANAGEMENT SYSTEM'S ANNUAL ACCEPTANCE CAPACITY FOR THE REFERENCE BWR

As previously mentioned, DOE is required to accept all commercial SNF/HLW for permanent disposal from owners or generators who executed and have complied with the Contract as prescribed in the NWPA. However, since acceptance capacity will be limited in any given year, a ranking or sequencing process is necessary to allocate the available acceptance capacity. The ranking is based on the date-of-final-discharge data supplied by the Purchasers and the OFF criterion established by the Contract.

No quantities of SNF from the reference BWR are currently eligible for acceptance during the first 10 years of projected FWMS operation. Projections done for this study of the transfers of SNF necessary to deplete the SNF inventory at the reference BWR are presented in Table D.2. The data shown in the table are based upon the projected acceptance rates, shown previously in Table D.1, but continued until approximately 10,000 MTU (the legal limit) are stored at the MRS in 2010, at which time the repository is scheduled to begin operation. Beyond 2010, the FWMS is projected to operate at an annual receipt rate of 3,000 MTU. The final shipments of SNF from the reference BWR are projected to occur in the year 2033.

Based upon a pool capacity of 2,658 spent fuel assemblies, it can also be seen from Table D.2 that the reference BWR will not have adequate pool capacity to accommodate its remaining inventory without the need for additional storage capability for 2 years, assuming DOE receives SNF beginning in 1998 and at the rates given in Table D.1. For the purpose of this study, it is assumed that some form of onsite SNF storage is provided during this 2-year period by the utility. Because this SNF storage requirement occurs during the operating years of the reference plant, it is considered an operations cost.

TABLE D.2. Postulated SNF Disposition Schedule for the Reference BWR^(a)

<u>Calendar Year of Fuel Pick Up</u>	<u>Year/Month of Discharge</u>	<u>SNF Inventory (Assemblies)</u>	<u>SNF Assemblies Accepted Each Year</u>
2011	1986/04	2840	96
2011	1987/04	2835	124
2012	1988/04	2684	151
2012	1989/04	2669	137
2013	1990/04	2584	208
2014	1991/04	2580	120
2015	1992/04	2504	76
2015	1993/04	2364	140
2016	1994/06	2344	132
2017	1995/09	2212	132
2017	1996/09	2234	91
2018	1996/09	2197	37
2018	1997/10	2181	130
2018	1999/01	2165	130
2020	2000/02	2150	130
2021	2001/03	2024	126
2021	2002/04	1899	125
2022	2003/08	1891	123
2023	2004/09	1769	122
2023	2005/10	1760	124
2024 ^(b)	2006/11	2485	124
2025	2008/02	2365	120
2026	2009/03	2246	119
2026	2010/04	2127	119
2027	2011/06	2008	119
2028	2012/09	1886	122
2028	2013/09	1763	123
2029	2014/11	1658	105
2030	2014/11	1647	11
2030	2016/02	1535	112
2031	2017/03	1422	113
2031	2018/05	1308	114
2031	2019/09	1194	114
2032	2020/10	1079	115
2032	2022/01	964	115
2033	2023/03	849	115
2033	2024/02	764	85
2033 ^(c)	2024/04	0	764

- (a) Based on Reference 9 and on the postulated acceptance projections done for this study (see text for details). Does not represent the actual situation at the WNP-2 reactor, but is reasonably representative of large BWRs that operate for their licensed lifetime.
- (b) CY 2024 is the EIA projected year of final shutdown for the reference BWR (see text for details).
- (c) CY 2033 is the year in which the reference BWR's SNF inventory is reduced to zero on the OFF allocation basis.

It should be noted that WNP-2's current operating license expires in CY-2013, based upon a 40-year license period, beginning with the start of construction. The NRC now permits the operating license periods of commercial nuclear reactor power stations to begin at the start of commercial operation of those reactors. The Energy Information Administration's (EIA) projected year of final shutdown for the WNP-2 plant is CY-2024 (the date shown in Table D.2).⁽¹⁰⁾ This license end-date used by the EIA assumes that the 40-year licensing period began at the start of commercial operation of the WNP-2 plant, not at the start of construction. The EIA's shutdown date of CY-2024 is used throughout this study for the purpose of developing decommissioning schedules.

D.3 BACKGROUND INFORMATION RELATED TO POST-SHUTDOWN STORAGE OF SPENT NUCLEAR FUEL

The DOE's Office of Civilian Radioactive Waste Management (OCRWM) submitted the "Final Version Dry Cask Storage Study" to NRC in January 1989 for final review. Information copies of the document were also provided to Congress. After receiving final NRC comments on the study, OCRWM formally submitted the "Final Version Dry Cask Storage Study,"⁽¹¹⁾ to Congress in March 1989 accompanied by NRC's comments. The study presents two major conclusions: 1) existing technologies are technically feasible, safe and environmentally acceptable options for storing spent fuel at civilian reactor sites until such time as a federal facility is available to accept the spent fuel, and 2) OCRWM is not authorized to provide direct financial support for at-reactor storage. The latter conclusion is based on the NWPA, which established the Nuclear Waste Fund. As stated in Section 111(a)(5), "the generators and owners of high-level radioactive waste and spent nuclear fuel have the primary responsibility to provide for, and the responsibility to pay the costs of, the interim storage of such waste and spent fuel until such waste and spent fuel is accepted by the Secretary of Energy in accordance with the provisions of this Act." Thus, it is the DOE's position that the utilities are responsible for storing spent fuel at reactor sites until an operating federal facility is available to accept the fuel.⁽¹²⁾

In a generic environmental impact statement on spent fuel storage,⁽¹³⁾ the NRC expressed confidence that the regulations now in place will ensure adequate protection of the public health and safety and the environment during the period when the SNF is in storage. The reactor operating license may be amended at the end of the plant operating life. Thus, spent fuel may be stored in the reactor pool under an amended reactor operating license pursuant to 10 CFR Part 50.⁽¹⁾ The reactor license, however, cannot be terminated until the reactor is decommissioned. To fully decommission the reactor, all spent fuel must be removed from the fuel pool.

Currently, there are nine shutdown nuclear power plants in the U.S. with fuel onsite. They are: Rancho Seco Nuclear Generating Station of Sacramento Municipal Utility District; Humboldt Bay Unit 3 of Pacific Gas & Electric; the Dresden 1 plant of Commonwealth Edison Company; the LaCrosse unit of Dairyland Electric Co-op, Inc.; the Shoreham station of The Long Island Power Authority; the Fort St. Vrain plant of Public Service Co. of Colorado; the Yankee Rowe plant of Yankee Atomic Electric Co. of Massachusetts; the San Onofre Unit 1 of Southern California Edison Co. and San Diego Gas and Electric Co.; and the Trojan plant of Portland General Electric Co. All shutdown plants have utilized light-water-cooled reactors with the exception of the Fort St. Vrain plant, which employs a high-temperature gas-cooled reactor. Fort St. Vrain fuel is highly enriched and for that reason, may require special treatment before disposal at the presently contemplated federal geologic repository.

Several storage system designs are presently licensed or about to be licensed for storage of SNF in the U.S. These include water pools for wet storage, and metal casks, concrete casks, horizontal concrete modules, and air-cooled vaults for dry storage. A natural-circulation-cooled vault ISFSI is in service at Ft. St. Vrain. Transportable metal storage casks, for at-reactor dry storage, are not currently certified in the U.S. To use metal casks designed for dual-purpose service, a utility would have to obtain an NRC license for storage under 10 CFR Part 72⁽²⁾ and specify a cask certified for storage by the NRC and for transportation in accordance with regulations in 10 CFR Part 71.⁽¹⁴⁾ In addition, the licensing and certification of these casks would have to address concerns about using the casks for transportation

after extended use for storage. Concrete casks and horizontal storage modules cannot be transported intact. However, the metal canisters containing the fuel may be able to fit inside a transportable cask. Nonetheless, some form of storage unit-to-transport cask transfer capability would be required on the reference site, to provide for recovery from a cask seal failure or some abnormal condition occurring with the storage units.

On the other hand, the safety of storage in spent fuel pools has been widely demonstrated. In the review of its Waste Confidence Decision,⁽¹⁵⁾ the NRC concluded that spent fuel can be stored safely and without significant environmental impacts for at least 30 years beyond the licensed life for operation (which may include the term of a revised or renewed license) of that reactor at its spent fuel storage basin or at either an onsite or an offsite ISFSI. This finding was supported by the NRC's experience in conducting more than 80 individual safety evaluations of spent fuel storage. In particular, the NRC noted that the cladding of the spent fuel is highly resistant to failure under the conditions of pool storage, and the NRC cited up to 18 years of continuous-storage experience for Zircaloy-clad fuel.

Thus, SNF can be stored either in a pool or in dry storage facilities. Though both types of storage may be used at the same reactor site, they are subject to different NRC regulations. This is because the spent fuel pool is normally considered to be an integral part of the nuclear power plant and subject to regulation under 10 CFR Part 50. Dry storage facilities are considered independent of the plant, and are subject to regulation under 10 CFR Part 72. A general license under Subpart K, Part 72 can be granted to Part 50 licensees, if approved storage devices are used.

D.4 GENERIC CONSIDERATIONS RELATED TO POST-SHUTDOWN STORAGE OF SNF

An important consideration when selecting the decommissioning mode to employ on a retired power reactor facility is what to do with the SNF stored onsite. The range of storage/disposition alternatives of SNF is discussed in Section D.4.1. A methodology for evaluating the present value of the total storage system life-cycle costs is presented in Section D.4.2, together with an evaluation for two basic alternatives for SNF storage.

D.4.1 Storage/Disposition Alternatives for SNF

The following discussion on the disposition alternatives for SNF is based upon information extracted from a study on such alternatives for Rancho Seco Nuclear Generating Station⁽¹⁶⁾ and other sources. Based upon those sources, an overview of post-shutdown spent fuel storage alternatives is presented in Figure D.1. The disposition alternatives for SNF shown in the figure appear to illustrate the range of alternatives currently available upon final shutdown. It can be seen from the figure that two major groups of alternatives are available, onsite and offsite storage.

The onsite storage alternatives can be subdivided into wet and dry storage. Wet storage could be accomplished by utilizing the existing spent fuel pool (SFP) or by transferring the SNF to a wet ISFSI. Both alternatives are included as possibilities in Figure D.1. It should be noted that a bypass is provided around the improvements associated with modifying the existing pool (i.e., a reduction in support systems necessary to maintain SNF in wet storage) in the event the time of storage in the SFP can be limited, thereby reducing the incentive for incurring the costs of the changes.

Five alternatives for dry storage are shown in Figure D.1: metal storage casks, concrete casks, vault storage, horizontal storage modules, and transportable or dual-purpose casks. These methods of dry storage have been previously studied and evaluated by DOE.⁽¹¹⁾ Depending upon the type of dry storage selected, a transfer to a shipping cask may be necessary before transport to the DOE repository. That mode of transfer can be wet or dry, as illustrated in Figure D.1. However, it should be recognized that the NRC may require the licensee to maintain fuel transfer capability in case of emergencies as long as fuel is onsite.^(e) Off-site storage alternatives include

(e) For an at-reactor-site ISFSI that is to become its own separate site, it is necessary, as part of decommissioning design requirements, that the ISFSI be capable of direct spent fuel shipments to the MRS or geologic repository. Currently, the issue of compatibility of dry storage designs with offsite transportation system designs for shipment to an MRS or geologic repository remains unresolved. Achievement of compatibility in design means that spent fuel in dry storage would not need to be returned to the reactor pool for unloading and the loading into a shipping cask. Vendors are exploring various means to meet NRC policy on this matter. Presently, they include dual-purpose cask design and shipment of sealed canistered spent fuel.⁽¹⁷⁾ In addition, dry transfer facilities are also under consideration.

(a) Based on information contained in References 11 and 16.

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FIGURE D.1. Storage/Disposition Alternatives for Spent Nuclear Fuel^(a)

both wet and dry storage possibilities for storing SNF at another plant, a commercial storage facility, and off-shore. The possibilities of foreign reprocessing and disposal are included in Figure D.1, even though no serious opportunity for foreign disposal currently exists. In the case of reprocessing, all wastes arising from that process that are returned to the U. S. should be in a form acceptable to the DOE for final disposal, as shown in Figure D.1.

In the Rancho Seco study⁽¹⁶⁾ the possibility of carrying out a demonstration program with transportable dry storage casks, and shipping 56 low-burnup Rancho Seco fuel assemblies for reinsertion in another nuclear plant was considered. The demonstration program was selected by Rancho Seco because a dual-purpose cask demonstration program with long-term storage prior to shipment has not yet been carried out.

It was concluded in the Rancho Seco study that none of the alternatives with economic viability evaluated for their spent fuel storage and disposition were precluded specifically because of lack of an applicable structure of federal safety regulations. However, differences did emerge among the attractiveness of alternatives due to cost of compliance with applicable regulations. The study also concluded that many of the alternative paths for Rancho Seco spent fuel disposition are not viable because of a combination of technical, economic and recipient acceptance barriers. Included in this category are:

- early shipment to storage at another plant, commercial, or government site
- disposal offshore
- offshore storage or reprocessing

The Rancho Seco study showed that offshore storage/reprocessing had the highest cost relative to other options evaluated for Rancho Seco as well as the greatest number of regulatory and non-regulatory impediments.

Other conclusions drawn from the Rancho Seco study⁽¹⁶⁾ are:

- storage in concrete storage-only casks or storage in the modified SFP are the lowest cost options, if Congressional or DOE policies and programs delay initiation of delivery services of the spent fuel well beyond 1998
- the lower the fuel pool security, monitoring and maintenance cost actually achieved, the more attractive is the fuel pool option
- the longer the predicted storage time (after the initial years that the fuel must remain in the pool to remove decay heat), the more economically attractive is dry storage in concrete casks relative to storage in the modified pool

- the crucial problem with all the storage-only options is the uncertainty in predicting delivery time plus the necessity of managing a one- to two-year backend loading-to-shipping-cask campaign, cask disposal, and a cask facility dismantling program in the indefinite future.

Overall, the study concluded that for several reasons the Rancho Seco situation with regard to spent fuel storage and final disposition was unique and that the higher capital cost transportable cask alternative should be pursued. However, it should be recognized that a similar conclusion may be unlikely at other light water reactor power stations, because of differences in their fuel storage and disposition situations.

D.4.2 Consideration of Two Basic Alternatives for SNF Storage

Because of delays in the implementation of the FWMS, many reactors will have large inventories of SNF, and in some situations may have already been forced to install external dry storage facilities on their sites to contain SNF that exceeded their pool capacities. An additional complication arises because the FWMS will only be able to accept SNF at a finite rate, and, under the terms of the contract between DOE and the U.S. nuclear utilities, allocation of acceptance rights to the utilities is to be based on an OFF basis, and the SNF must be cooled at the reactor site for at least five years before acceptance. Because of the large backlog of SNF in the utilities' pools, periods ranging from 5 to 26 years after reactor shutdown will pass before an individual reactor's pool could be emptied and the pool decommissioned (see Table D.3).

Faced with the need to store the SNF for an extended period of time, a utility has to evaluate its storage options to determine which decommissioning mode best suits its particular situation. If, for example, the utility had strong reasons for pursuing DECON, it would be necessary to transfer the SNF from the pool to an onsite dry ISFSI as soon after shutdown as possible, to make it possible to proceed with decontamination and disassembly of the reactor facility in a timely manner. If, on the other hand, the utility preferred to place the reactor facility in SAFSTOR for an extended period (< 60 years), the utility could choose to maintain the pool under a Part 50 possession-only license (POL) until the FWMS had accepted all of the site

TABLE D.3. Distribution of Sites Storing SNF for Given Number of Years Following Shutdown^(a)

<u>Years After Shutdown Until Spent Nuclear Fuel Inventory Reaches Zero</u>	<u>Number of Sites</u>
5	7
6	3
7	10
8	5
9 ^(b)	12
10	7
11	5
12	4
13	2
14	11
15	28
16	12
17	7
18	1
19	1
20	1
24	2
25	2
26	3

(a) Derived from information contained in Reference 9.

(b) The reference BWR's (WNP-2's) inventory is reduced to zero in the year 2033, or 9 years after final shutdown, assuming the plant operates until 2024.

SNF inventory, or to place all of the SNF in an ISFSI (wet or dry) initially, even though the facility was placed in SAFSTOR, depending upon the amount of SNF in the inventory and the length of the storage period until the inventory was removed. Two basic alternatives are evaluated further in subsequent subsections:

- continue operation of the spent fuel pool at the reactor (under a Part 50 POL)
- transfer all SNF to an onsite ISFSI (wet or dry), and maintain fuel transfer capability.

In some circumstances, a given reactor site may have already installed a dry ISFSI onsite to handle the overflow from its reactor pool. In that case, the options involve continuing to operate both storage facilities or to transfer the pool SNF inventory to the onsite ISFSI. In all of these situations, a major factor in the decision-making process is the total life-cycle cost of the planned operations. To assist in making these decisions, a methodology has been developed which evaluates the present value of the life-cycle cost of

each of the utility's options. A number of factors influence these evaluations, including such things as:

- What is the total onsite SNF inventory at reactor shutdown?
- When does the reactor terminate power operations?
- When does the FWMS begin accepting SNF from the site?
- At what rate does the FWMS accept SNF from the site?
- What would be the minimum time required for DOE to accept all of the utility's SNF?

Note: In accordance with 10 CFR Part 961 (the Contract), the minimum time to deliver the last discharge of SNF would be 5 years following shutdown.

- If no ISFSI exists at shutdown, what are the costs of building and licensing, under 10 CFR Part 72, an onsite ISFSI (wet or dry)?
- What are the costs of continuing wet storage in the existing reactor pool(s)?
- What are the costs per unit quantity of SNF for dry storage devices?
- What are the annual operating costs associated with the existing wet storage mode and/or an ISFSI (wet or dry)? What are the decommissioning costs for the existing wet storage mode and/or an ISFSI (wet or dry)?

Note: Regarding the potential impacts on the selection of decommissioning alternatives, the following statement is made in 10 CFR Part 50.54(bb) concerning how reasonable assurance will be provided that funds will be available to manage and provide funding for the spent fuel upon expiration of the reactor operating license. "For nuclear power reactors licensed by the NRC, the licensee shall, within 2 years following permanent cessation of operation of their reactor or 5 years before expiration of the reactor operating license, whichever comes first, submit written notification to the Commission for its review and preliminary approval of the program by which the licensee intends to manage and provide funding for the management of all irradiated fuel at the reactor following permanent cessation of operation of their reactor until title to the irradiated fuel and possession of the fuel is transferred to the Secretary of Energy for its ultimate disposal in a repository. Licensees of nuclear power reactors that permanently ceased operation by April 4, 1994, are requested to submit such written notification by April 4, 1996. Final Commission review will be undertaken as part of any proceeding for continued licensing under Part 50 or Part 72 of this chapter. The licensee must demonstrate to NRC that the elected actions will be consistent with NRC requirements for licensed possession of irradiated nuclear fuel and that the actions will be implemented on a timely basis. Where implementation of such actions requires NRC authorizations, the licensee shall verify in the notification that submittals for such actions have been or will be made to NRC and shall identify them. A copy of the notification shall be retained by the licensee as a record until expiration of the reactor operating license. The licensee shall notify the NRC of any significant changes in the proposed waste management program as described in the initial notification."

D.4.3 Present Value Life-Cycle Costs of Two Alternatives for SNF Storage

The present value (PV) of the total storage system life-cycle cost can be estimated for each system, for purposes of comparison. The following expression yields the PV of the life-cycle cost for the case of utilizing the spent fuel pool until the total inventory of SNF has been transferred to DOE.

$$PV = D_{p0} + \sum_{i=1}^N D_{pi}/(1+k)^i + DD_p/(1+k)^N$$

where D_{p0} is the cost of isolating the spent fuel pool from the retired plant systems; D_{pi} is the annual operating costs of the wet storage facility in constant dollars of Year 0 (year of reactor shutdown); k is the net discount rate (interest minus inflation) which is assumed constant over the storage period; i is the number of years since reactor shutdown for which the operations costs are being calculated; and N is the number of years after reactor shutdown required for the onsite inventory to reach zero. Once the inventory is zero, the existing storage facility is decommissioned, at a cost of DD_p , in constant Year 0 dollars.

A similar expression can be used to calculate the present value of the life-cycle cost of utilizing the spent fuel pool until the hottest fuel assemblies can be safely placed into dry storage, then using dry storage until the total inventory of SNF has been transferred to DOE.

$$PV = D_{p0} + \sum_{i=1}^n D_{pi}/(1+k)^i + D_{d0}/(1+k)^n + DD_p/(1+k)^{n+1} + \sum_{i=n}^N D_{di}/(1+k)^i + DD_d/(1+k)^N$$

where n is the number of years after reactor shutdown that the hottest SNF must cool before being placed into dry storage; D_{d0} is the cost of creating and loading the dry ISFSI in Year n ; D_{di} is the annual cost of operating and maintaining the dry ISFSI; and DD_d is the cost of decommissioning the dry ISFSI, all values in Year 0 dollars. Other terms are as defined above. Because the costs of deactivating and decommissioning the pool are included in

the normal plant decommissioning costs, they are not costed in these life-cycle cost analyses.

The estimated annual costs of operating the SNF storage pool or the ISFSI storage facility are given in Table D.4. The cost of separating the spent fuel pool systems from the balance of plant systems is estimated to be about \$0.5 million, and operating and maintaining the spent fuel storage pool during safe storage of the rest of the plant is estimated to be \$5.5 million per year, as given in Table D.4.

TABLE D.4. Estimated SNF Storage Operational Costs at the Reference BWR^(a,b)

Cost Category	Estimated Annual Cost (1993\$) ^(c)		
	Pool	Safe Storage	ISFSI ^(d)
Non-Personnel Costs			
Instr. & Elect. Maint. (matl. & supplies)	113,958	--	10,000
Mech. Maint. (materials & supplies)	146,960	--	5,000
Chemistry (materials & supplies)	283,800	--	--
Radwaste Onsite Processing (supplies)	59,980	--	10,000
Radwaste Contract Removal & Disposal	84,800	--	15,000
Environmental Monitoring (matl. & supplies)	43,743	4,860	43,743
Protective Clothing Laundry	83,539	9,282	27,300
Electric Power (@ \$0.027/kWh) ^(e)	48,600	5,400	23,824
State Regulatory Costs ^(f)	220,000	24,000	220,000
Licensing & Inspection ^(g)	13,666	1,518	13,666
Nuclear Liability & Property Ins. ^(h)	<u>507,600</u>	<u>600,000</u>	<u>507,600</u>
Subtotal, Non-Personnel Costs	1,606,646	645,060	876,133
Personnel Costs			
Utility Staff Labor ⁽ⁱ⁾	<u>3,902,809</u>	<u>433,646</u>	<u>1,241,530</u>
Total Annual Operating Cost	5,509,455	1,078,706	2,117,663

(a) Based on information found in Reference 18, and adjusted for use in this reevaluation study.

(b) The values given in the table do not contain a contingency allowance.

(c) The costs of operating the pool and providing safe storage for the plant are allocated 90% to pool operations and 10% to safe storage operations.

(d) ISFSI costs, with concurrent safe storage operations.

(e) Based on estimated plant load of 0.23 MW during Period 3.

(f) Derived from Table B.16.

(g) Study estimate: based on NRC billings to two utilities with SNF stored in pools at retired reactors.

(h) Based on \$1,107,600/yr for both pool and safe storage operations, and subsequent \$600,000/yr for safe storage only (see Table B.8).

(i) Derived from Table 3.2.

The net discount rate is assumed to be 3% per year, and the duration of pool operations is assumed to be 9 years, based upon information in Table D.2.

With these assumptions, the present value of the SNF pool operations until the inventory has reached zero is evaluated to be about \$43.3 million.

Similarly, the initial cost of establishing a dry ISFSI (D_{d0}) includes the capital costs of casks, transporters, and other handling equipment, plus the labor costs of loading the SNF into the casks and transporting the casks to the ISFSI location for storage. Assuming a pool inventory of 1886 assemblies, storage capacity for about 359 metric tonnes of uranium (MTU) is required. Based upon data from Reference 11, the estimated cost of storage capacity is about \$65,000/MTU (about 37 concrete casks), for a total cost of about \$23.4 million, expended during Year 4. Because the plant must install an ISFSI for operational reasons about 2 years prior to shutdown, equipment and storage pads/ fences/etc., which would otherwise cost about an additional \$5 million during Year 4, are already in place and not charged to decommissioning. The labor costs for removing the SNF from the pool and placing it in the ISFSI during Year 4 are estimated to be about \$0.25 million. Thus, the total cost for additional casks and for loading the ISFSI (D_{d0}) would be about \$23.7 million. Labor and non-personnel costs associated with ISFSI operation (D_{di}) are estimated to be about \$2.1 million per year. Decommissioning costs for the ISFSI (DD_d) are estimated to be about 10% of the capital cost, or about \$2.9 million during Year 10.

The first 4.6 years of pool storage results in an initial cumulative expenditure of \$23.5 million (present value). Added to those pool operating costs are the capital cost of sufficient casks to store the remaining fuel in the ISFSI (\$20.77 million, present value), and the cumulative costs of 5 years of ISFSI operation (\$8.64 million, present value) and of the ISFSI decommissioning costs (\$2.19 million, present value). The resulting cost of SNF storage operations utilizing 4.6 years of pool storage and 5 years of dry cask storage is about \$55.11 million, in present value.

Simply continuing to operate the spent fuel pool for the additional 5 years would result in a total cost for storing the SNF remaining in the pool of about \$47.4 million, present value. Thus, for the relatively short storage time considered in this analysis, it would be more cost-effective to store the SNF in the fuel storage pool than to add sufficient casks to store all of the

fuel in the dry ISFSI. However, if the storage period were to be extended to 13 years or greater, the present value cost of ISFSI storage would become less than that of spent fuel pool storage, as shown in Figure D.2, where the present value of the cumulative costs for pool operation and for pool plus dry ISFSI operation and decommissioning are shown for 15 years following reactor shutdown.

FIGURE D.2. Present Value Costs for SNF Storage Operations

D.5 REQUIRED SNF COOLING TIME FOLLOWING DISCHARGE BEFORE DRY STORAGE

To determine the cooling time required before fuel from WNP-2 could be placed in dry storage at the site, the assumption was made that the fuel would be stored in metal storage casks (which may or may not be transportable). The required time delay following discharge before spent fuel can be placed into the dry cask storage is primarily a function of the fuel burnup and reactor operating history (with a small sensitivity to initial enrichment). The first step in the approach taken to estimate the required delay time was to develop a curve of maximum cladding temperature for fuel stored in metal casks as a function of the decay heat output rate (watts/MTU). Data from an experimental program at GE-Morris were examined, wherein maximum fuel rod cladding tempera-

tures were inferred from measurements made on the REA cask containing 52 BWR assemblies from the Cooper Nuclear Station.⁽²⁰⁾ The measurement made with an ambient temperature of 22 degrees centigrade and nitrogen coolant was selected for this analysis, to permit comparison with the later measurements made on PWR fuel in three cask test programs^(21,22,23) at the Idaho National Engineering Laboratory, as discussed in NUREG/CR-5884, the reevaluation of decommissioning the reference PWR.⁽²⁴⁾ For the BWR fuel, the data included:

- An average value of 0.1904 MTU/assembly, derived from data contained in PNL-5777, BWR SPENT FUEL STORAGE CASK PERFORMANCE TEST: Volume 1, Cask Handling Experience and Decay Heat, Heat Transfer, and Shielding Data⁽²⁰⁾ for the fuel used in the cask test. The decay heat load on the REA cask was 14,400 watts at the time of the measurement, with 52 assemblies, 9.9012 MTU/cask load, for a heat loading of 1454 watts/MTU, and a maximum cladding temperature of 209°C with a nitrogen atmosphere in the cask, and an ambient temperature of 22°C. The average fuel burnup was 26,544 MWD/MTU, the cooling time was 2.81 years at the time of the measurement, and the initial enrichment was 2.5 wt% ²³⁵U.

For the PWR fuel, the data included:

- An average value of 0.4582 MTU/assembly, derived from data contained in DOE/RL-90-44, Spent Fuel Storage Requirements 1990-2040⁽¹⁹⁾ for the fuel used in the PWR cask tests. The average fuel burnup ranged from 24,200 to 35,400 MWD/MTU, and the initial enrichments ranged from 1.86 to 3.20 wt% ²³⁵U.
- Castor-V/21 cask: 28 kW heat load, 21 assemblies, 9.622 MTU/cask load, for a heat loading of 2910 watts/MTU and a maximum cladding temperature of 368°C in a cask atmosphere of nitrogen, and an ambient temperature of 24°C, extracted from EPRI NP-4887, THE CASTOR-V/21 PWR SPENT-FUEL STORAGE CASK: Testing and Analyses.⁽²¹⁾
- MC-10 12.6 kW heat load, 24 assemblies, 10.9972 MTU/cask load, for a heat loading of 1146 watts/MTU and a maximum cladding temperature of 181°C in a cask atmosphere of nitrogen, and an ambient temperature of 24°C, extracted from EPRI NP-5268, THE MC-10 PWR SPENT-FUEL STORAGE CASK: Testing and Analysis.⁽²²⁾
- TN-24P 20.5 kW heat load, 24 assemblies, 10.9972 MTU/cask load, for a heat loading of 1862 watts/MTU and a maximum cladding temperature of 241°C in a cask atmosphere of nitrogen, and an ambient temperature of 20°C, extracted from EPRI NP-5128, The TN-24P PWR SPENT-FUEL STORAGE CASK: Testing and Analyses.⁽²³⁾

These average heat loadings were plotted versus the maximum cladding temperature inferred from the measurements on each loaded cask, to obtain a curve of maximum cladding temperature versus fuel decay heat emission rate, as shown in Figure D.3.

FIGURE D.3. Decay Heat Emission Rate as a Function of Maximum Cladding Temperature for BWR and PWR Fuel Stored in Metal Casks

The second step was to calculate the allowable maximum temperatures for two levels of internal fuel rod pressurization, for cooling times of 1 to 5 years. Assuming the use of standard 8x8 BWR fuel assemblies, cladding hoop stresses during storage in the range from about 6 to 9 MPa were calculated. The maximum allowable cladding temperature during dry storage was calculated using the methodology given in PNL-6639, DATING - A Computer Code for Determining Allowable Temperatures for Dry Storage of Spent Fuel in Inert and Nitrogen Gases.⁽²⁵⁾ Postulating a storage period of 300 years to avoid any sensitivity to storage duration, the allowable cladding temperatures were calculated for fuel with cooling times ranging from 1 to 5 years, for assumed

cladding hoop stresses ranging from 6 to 9 MPa. The results of these calculations are shown in Table D.5.

TABLE D.5. Calculated Allowable BWR Cladding Temperatures in Dry Storage

<u>Cooling Time (years)</u>	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>5</u>
Max. Temp. ($^{\circ}\text{C}$ @ 6 MPa)	576	547	529	512	485
Max. Temp. ($^{\circ}\text{C}$ @ 7 MPa)	571	542	524	507	480
Max. Temp. ($^{\circ}\text{C}$ @ 8 MPa)	567	538	520	503	476
Max. Temp. ($^{\circ}\text{C}$ @ 9 MPa)	563	534	516	500	472

Because the difference between the measured and calculated cladding temperatures in the cask tests discussed earlier tended to be in the vicinity of 30°C , a safety factor of 30°C was subtracted from the above values, resulting in allowable values ranging from 546 to 442°C .

Nominal values of 540 and 445°C were selected as a reasonable range of cladding temperatures to consider for limits, taking into account the safety factor. Maximum allowable decay heat rates for cladding temperatures of 540 and 445°C were read from the curve of Decay Heat versus Cladding Temperature (Figure D.3) to be about 4000 and 3280 watts/MTU, respectively.

To determine the required cooling times for spent fuel having differing levels of burnup and initial enrichment, calculated data on decay heat emission were read from tables contained in Regulatory Guide 3.54, Spent Fuel Heat Generation in an Independent Spent Fuel Storage Installation,⁽²⁶⁾ for cooling times of 1, 2, and 5 years, at burnups of 27, 40, and 46 GWD/MTU, and for initial enrichments of 2.5, and 4.0 wt% ^{235}U in the fuel. Those data were adjusted according to the procedures given in the Guide, including an adjusted set for the fuel projected for the end-of-life discharge from WNP-2⁽²⁷⁾ ($42,486$ MWD/MTU @ 3.072 wt% ^{235}U). The data were plotted on a log scale and smooth curves were drawn through the points, as shown in Figure D.4. The cooling times required for decay heat emission rates of 4000 and 3280 watts/MTU, as read from the curve for the projected end-of-life level of burnup and initial enrichment at WNP-2, are 3.82 and 4.59 years, respectively. Based on this analysis, the fuel pool could not be finally emptied until nearly 5 years following reactor shutdown, if the SNF is destined for dry storage onsite. However, examination of Figure D.4 illustrates the very large conservatism

that is inherent in the data and procedures delineated in Regulatory Guide 3.54. Comparison of the decay heat rate measured in the REA cask tests (1454 w/MTU after 2.8 years cooling) with the calculated value (3890 w/MTU) at the

FIGURE D.4. Spent Fuel Decay Heat as a Function of Cooling Time for BWR Fuel same cooling time for approximately the same burnup (26,554 MWD/MTU for the experiment vs. 27,000 MWD/MTU for the calculation) shows that the calculation appears to overestimate the decay heat rate by a factor of about 2.67. If the calculated curve for the end-of-life fuel were adjusted downward to compensate for the apparent bias in the calculated values, the cooling times required for that fuel would be more like 1.25 and 1.60 years, respectively. For conservatism, and for consistency with the analysis in the previous PWR reevaluation study,⁽²⁴⁾ a minimum cooling time of 4.6 years has been selected for this reevaluation of the reference BWR study.

D.6 RATIONALE FOR THE SPENT FUEL STORAGE OPTION POSTULATED FOR THE REFERENCE BWR

When the reference BWR is operating and space is available in its fuel pool, the incremental cost of storing spent fuel is relatively low because security services, fuel handlers, pool maintenance and monitoring personnel

are already available at the site. When the plant is shut down, the facility operating license issued by the NRC needs to be modified to one permitting possession of the fuel and radioactive materials but not operation of the facility. This modification enables a significant reduction in the costs of maintaining the facility. A substantial portion of the costs required to maintain the shutdown facility becomes those associated with safe storage of the spent fuel. Even when the aforementioned license modifications are accomplished, it is anticipated that the reference BWR will sustain significant costs, unrelated to decommissioning, for spent fuel security, cooling, and monitoring. Such expenses will stop only when the fuel is removed from fuel pool storage. If the ultimate disposal of the fuel is in the contemplated federal repository, the costs may extend over a long period of time, especially if construction of the federal repository is delayed.

The following general information concerning spent fuel storage is extracted from Klepfer and Bowser,⁽¹⁶⁾ and adapted, where appropriate, to this study in support of the rationale for the spent fuel storage option postulated for the reference BWR.

The costs of spent fuel storage at a shutdown nuclear plant vary depending upon the characteristics of the storage site, the owner's future plans for it, and whether the utility has other nuclear plants. Typical considerations are as follows:

- If the shutdown plant is at a multi-unit nuclear site, such as in the case of Dresden-1, the costs of storing spent fuel will be relatively low and roughly equivalent to those for an operating plant. [The reference BWR, WNP-2, is not a multi-unit nuclear site.]
- If the utility owns other nuclear plants, it can consider transshipment of the spent fuel from the shutdown plant to its remaining operating nuclear plants. Such a transfer could reduce costs, especially if the federal repository gets further and further delayed. [For the purpose of this study, it is assumed that the reference BWR's owners cannot consider transshipment of the reactor's fuel to another of its nuclear plants because the reactor is the only nuclear plant owned by the utility.]
- If the shutdown plant is at a site where other power generation units are located, such as in the case of Humboldt Bay and LaCrosse, the costs of storing spent nuclear fuel are reduced

because security and maintenance services are available already. [At present, the reference BWR is exclusively a nuclear generating site.]

- When the shutdown plant is large in size, as is the case of the reference BWR, there could be incentives to repower the plant with other types of fuel. Such repowering is even more attractive if the nuclear plant can be decontaminated and decommissioned. The NRC regulations provide for two principal alternatives after a reactor has been shut down and defueled:
 - DECON - This option requires that the fuel be shipped offsite.^(f) The equipment, structures, and portions of the facility and site containing radioactive contaminants are removed or decontaminated to a level that permits the property to be released for unrestricted use shortly after cessation of operations.⁽²⁸⁾ [This means that the reference plant (WNP-2) cannot be decontaminated and released from regulatory controls until its fuel is shipped. In the OFF option, this cannot occur until at least 2033,⁽¹⁰⁾ some 9 years after final reactor shutdown, unless another option for offsite spent fuel storage besides the permanent DOE repository can be developed. In this study, the OFF option is assumed to be the most realistic case. On the other hand, due to the exchange process contained in the Contract, the most optimistic case would allow SNF delivery to DOE at shutdown plus 5 years (presumed in this study to be a highly unlikely event).
 - SAFSTOR - This option permits placing the facility in a safe storage condition for up to 60 years. Fuel may be stored in the fuel pool. According to information contained in Reference 29, WNP-2's licensed/maximum fuel pool capacity of 2,658 assemblies (including full core reserve) will occur in 1999, with a total additional capacity needed for 2,211 assemblies through 2021. The end of plant life is projected by EIA to be 2024.⁽¹⁰⁾ However, as previously shown in Table D.2, the reference BWR will not have adequate pool capacity to accommodate its remaining inventory without the need for additional storage capability for 2 years, assuming DOE receives SNF beginning in 1998 and at the rates given in Table D.1. For the purpose of this study, it is assumed that some form of onsite SNF storage is provided during this 2-year period by the utility. Because this SNF storage occurs during the operating years of the reference plant, it is considered an operations cost.

To determine the minimum SAFSTOR period for the reference BWR, it is assumed that the SNF remains stored in the reference BWR's fuel pool, under the 10 CFR Part 50 possession-only license, after final reactor shutdown in

(f) "Offsite" could be a wet or dry "independent spent fuel storage facility (ISFSI)," but it may be that this separate facility could be adjacent to the plant facility. Two "redefined" sites, a DECON reactor site and an ISFSI site, would result. Use permits and licenses for the resulting sites could conceivably be complicated by the interaction of the two sites.⁽¹⁶⁾

CY 2024.^(g) Then, the minimum SAFSTOR period for the reference BWR, without use of the DCS exchange process, can be defined as the time between the year of reactor shutdown, in CY 2024, and the year in which the last shipments occur in CY 2033, or 9 years.

It is further concluded that immediate dismantlement (DECON) in the exact same manner as defined in the original BWR study⁽³⁰⁾ does not appear to be viable because decommissioning cannot start immediately after final reactor shutdown without removal of the stored SNF. Based upon the estimated SNF cooling-time analysis presented in Section D.5, the fuel pool could not be finally emptied until at least 4.6 years following reactor shutdown because of cladding temperature limitations for dry storage. The transfer of the fuel from the pool into dry storage could proceed beginning at shutdown; and continue throughout the intervening years until the final assemblies were removed; or, the transfer of the fuel could be done in a single campaign, beginning about 4 years after shutdown.

For this study, it is assumed that the spent fuel pool is maintained under the POL and is not converted into an NRC-licensed ISFSI under 10 CFR Part 72, which might allow immediate dismantlement of the remainder of the facility. The reasons provided by the NRC for not assuming conversion of the existing fuel pool into a licensed wet-storage ISFSI in this study are:

- Interpretation of the NRC definition of decommissioning does not allow conversion to a Part 72 license. The license must remain a Part 50 license until the reactor is decontaminated and the site restored for unrestricted use.
- Conversion to a Part 72 license is a costly and difficult undertaking and separating the reactor components from those needed to support a wet ISFSI usually cannot be done in a satisfactory way to ensure the health and safety during the reactor dismantlement process because areas and equipment that support spent fuel pools have commonality with the existing reactor; dismantlement of the reactor could compromise the integrity of the wet ISFSI.
- Costs for maintaining a Part 50 possession only license (POL) can be reduced by amendments or exemptions as requested by licensees with shutdown reactors. Amendments or exemptions have been made

(g) CY 2024 is the Energy Information Administration's projected year of final shutdown for the WNP-2 plant, as defined in References 10 and 19.

for reduction of onsite property damage insurance and the staff is also considering similar requests for liability insurance.

The modified DECON alternative developed for this study entails transferring the SNF, after an adequate cooling period, to an at-reactor-site ISFSI (dry-cask storage), which is licensed under Part 72, followed by decommissioning of the reference reactor facility. It is further assumed that the at-reactor-site ISFSI has fuel transfer capability in case of emergencies as long as fuel is onsite; however, it should be recognized that no licensed dry-storage technology currently provides such capability.

It is important to note here that there is a definite interaction between decommissioning decisions and any final selection for post-shutdown storage of a specific reactor's spent fuel, if required. Such decisions must include consideration of the final disposition schedule of the fuel within the context of the overall federal waste management system.

The results of the analyses presented in this appendix realistically reflect the available decommissioning alternatives for the reference BWR. It should be recognized, however, that the situation described in this appendix, with regard to spent fuel storage and its eventual delivery to DOE, is predicated on the current regulatory environment and on site-specific information associated with the reference BWR. Therefore, the conclusions reached herein concerning decommissioning alternatives for the reference BWR may not be the same for other BWR power stations.

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APPENDIX E

DISMANTLEMENT AND DISPOSAL ACTIVITIES, MANPOWER, AND COSTS FOR THE REACTOR PRESSURE VESSEL AND INTERNALS, AND SACRIFICIAL SHIELD

APPENDIX E

DISMANTLEMENT AND DISPOSAL ACTIVITIES, MANPOWER, AND COSTS FOR THE REACTOR PRESSURE VESSEL, INTERNALS, AND SACRIFICIAL SHIELD

The levels of neutron-activation in the metallic reactor pressure vessel (RPV) and its internals vary greatly with proximity to the fueled region of the vessel. Those components located close to the fueled region are very highly activated, with some segments being classified as Greater-Than-Class C (GTCC) radioactive waste (10 CFR 61.55).⁽¹⁾ The GTCC material must be packaged for transport to and disposal in a geologic repository or other such disposal facility as the Nuclear Regulatory Commission (NRC) may approve. The canisters postulated for this study are 9 in. square outside dimension, and can contain material as long as 175 in. Transport of the GTCC material to the repository is postulated to be accomplished using spent fuel casks (NAC-LWT and TN-8, containing 1 and 2 canisters per shipment, respectively, because of weight limitations on the cask payload). Other components, located some distance from the fueled region, are still strongly activated but are classified as Class B or C waste and require packaging for shielded transport to and disposal in a licensed low-level waste (LLW) burial site. Still other portions of these components are only slightly activated and are classified as Class A waste, acceptable for unshielded transport to an LLW burial site. In this analysis, the activation analyses for the reference BWR, originally presented in NUREG/CR-0672,⁽²⁾ are used to define the classification of the various components and segments of those components, as described in Addendum 2 to NUREG/CR-0672,⁽³⁾ and the various segments are segregated for packaging according to their activity levels.

E.1 BASIC DISASSEMBLY PLAN

To facilitate the disassembly and packaging operations for the RPV internals, two plasma-arc cutting systems are postulated to be installed inside the reactor building. One is mounted on the refueling bridge, principally for major disassembly of the core barrel and other internals. The

second cutting system is mounted on a separate bridge/manipulator assembly at the far end of the dryer/separator storage pool, together with a cutting table and appropriate jigs for holding the various pieces during cutting operations, to facilitate packaging in appropriate containers. All cutting of the stainless steel internals with the plasma-arc systems is performed under water, with the exception of the reactor coolant system (RCS) piping connections to the RPV.

The RPV head and the steam separator and dryer assemblies are removed and placed in their normal storage locations prior to defueling. Following defueling, the steam separator and dryer assemblies are segmented and packaged for disposal. The core spray and feed water ring headers are removed and segmented for packaging and disposal. The lower core support assembly and core shroud are removed from the RPV and placed into the dryer/separator storage pool for disassembly. The control rod guide tubes are removed and packaged. The jet pumps are removed and segmented for packaging and disposal. Disassembly, sectioning, and packaging of the RPV internal structures are carried out in the dryer/separator storage pool. That pool is maintained filled with deionized water until removal, sectioning, and packaging of the stainless steel RPV internals have been completed, after which it is drained and decontaminated. Following the sectioning and packaging of the RPV internals, the RPV head is reinstalled and the RCS is drained for the safe storage period.

Sectioning and packaging of the RPV is delayed until the deferred dismantlement period. The RPV is refilled with deionized water to provide shielding during the subsequent sectioning of the RPV. The seals between the RPV and the reactor containment enclosure and the reactor building structure are removed to provide access for removing the insulation surrounding the vessel prior to beginning sectioning of the RPV. Following insulation removal, the oxyacetylene cutting of the RPV gets under way, with the water level being maintained just below the level of the cutting operations. Cutting of the RCS piping/RPV connections is performed as the connections are uncovered during the lowering of the water level in the RPV. Cutting of the RPV is performed in air within the concrete/steel sacrificial shield, using an oxyacetylene cutting system. The oxyacetylene torch is applied to the outside

of the RPV, thereby avoiding any problems in penetrating the stainless steel lining of the vessel. The viability of this approach was demonstrated by Lundgren⁽⁴⁾ for cutting thick (9 in.) sections of carbon steel clad with thin stainless steel on one side.

The postulated procedures for these activities are presented in this appendix, together with estimates of the time and cost of these activities. The dimensions of the RPV and its internal structures used in these analyses are derived from information given in the reference BWR report⁽²⁾ and from backup information supporting that report. The density postulated for stainless steel in these analyses is 0.29 lb/in.³, or 8044 kg/m³.

E.2 CORE SHROUD ASSEMBLY COMPONENTS

The core shroud in the reference BWR consists of three cylindrical shells, attached together to form a tall cylinder, as illustrated in Figure E.1. The upper cylinder is about 43 in. tall and about 220 in. outside diameter. The central cylinder, which surrounds the fueled region of the core, is about 168 in. tall and approximately 207 in. outside diameter. The lower cylinder is about 56 in. tall and about 201 in. outside diameter. The cylinders have wall thicknesses of 2 in., and are joined using 2 coupling rings at the intersection of the cylinders. The upper and lower coupling rings are 2 in. and 3.7 in. thick, respectively, and have outer and inner diameters of 220 in. and 203 in., and 207 in. and 186 in., respectively. The shroud is supported on the shroud support cylinder which is about 205 in. O.D., 195 in. I.D., and about 69 in. high. The jet pump support ring is attached to the RPV wall and the shroud support cylinder which is attached to the RPV lower head, and the jet pump assemblies are attached to the support ring and to the recirculation inlet nozzles in the RPV wall.

E.2.1 Shroud Components Expected to Exceed Class C Activation Levels

The upper and central core shroud cylinders and their coupling ring, which surrounds the fueled region of the core, are expected to have a significant fraction of their material activated to greater-than-class C (GTCC) levels. Thus, the upper and central core shroud cylinders and coupling ring are segmented and packaged as GTCC material. The full-density volumes of

FIGURE E.1. Reference BWR Core Shroud Assembly

these shroud assembly components are calculated below.

Upper Cylinder: $(\pi/4)[(220)^2 - (216)^2] \text{ in.}^2 \times 43 \text{ in.} = 58,899 \text{ in.}^3$, or 0.965 m^3 .

Upper Ring: $(\pi/4)[(220)^2 - (203)^2] \text{ in.}^2 \times 2 \text{ in.} = 11,296 \text{ in.}^3$, or 0.185 m^3 .

Central Cyl.: $(\pi/4)[(207)^2 - (203)^2] \text{ in.}^2 \times 168 \text{ in.} = 216,393 \text{ in.}^3$, or 3.546 m^3 .

The weight of the GTCC material is calculated to be:

$286,588 \text{ in.}^3 \times 0.29 \text{ lb/in.}^3 = 83,111 \text{ lb}$, or $37,778 \text{ kg}$.

The upper and central shroud cylinders are separated from the upper and lower coupling rings (circumferential cuts of 691, 650, and 650 lineal inches @ 2 in. thick). The cylinders are cut into vertical strips, 8.5 in. wide, and 43 in. long for the upper cylinder, and 168 in. long for the middle cylinder:

$\pi(220/8.5) = 81.3$ strips (82 cuts for 3,526 lineal inches @ 2 in. thick)
and $\pi(207/8.5) = 76.5$ strips (77 cuts for 12,936 lineal inches @ 2 in. thick).

The equivalent length of these strips is:

$82 \times 43 \text{ in.} + 77 \times 168 \text{ in.} = 16,462 \text{ in.}$,

which when arranged into pieces that are 175 in. long for canister loading, and 4 strips per canister, results in 23.5 canisters. The residual half-strips are inserted into the partially filled canister, yielding 24 canisters total. The upper coupling ring is cut into 16 pieces, 43 in. long, (136 lineal inches of cut @ 2 in. thick), an equivalent of 4 strips 2-in. thick, for one additional canister.

The packaged volume, weight per canister, and effective packaged density of the GTCC material within the canisters are:

$25 \text{ canisters} \times 0.24 \text{ m}^3/\text{can} = 6.000 \text{ m}^3$

$37,778 \text{ kg}/25 \text{ canisters} = 1,511 \text{ kg}/\text{can}$, with an effective density of 6.296 kg/m^3 , about 79% of theoretical density.

E.2.2 Core Shroud Components Activated to Less than GTCC Levels

The full-density volumes of the core shroud assembly components expected to be activated to Class C levels or less are calculated below.

Lower Ring: $(\pi/4)[(207)^2 - (186)^2] \text{ in.}^2 \times 3.7 \text{ in.} = 23,983 \text{ in.}^3$, or 0.393 m^3 .

Lower Cylinder: $(\pi/4)[(201)^2 - (197)^2] \text{ in.}^2 \times 56 \text{ in.} = 70,020 \text{ in.}^3$, or 1.147 m^3 .

Lower Support: $(\pi/4)[(205)^2 - (195)^2] \text{ in.}^2 \times 69 \text{ in.} = 216,770 \text{ in.}^3$, or 3.552 m^3 .

Jet Pump Ring: $(\pi/4)\{[(251)^2 - (197)^2] - [10 \times (20)^2] - [2 \times (25)^2]\}$ in.²
x 2 in. = 29,754 in.³, or 0.488 m³.

Jet Pump Assm: $10 \pi(10.75)(0.365)138 + 20 \pi(8.625)(0.322)125 + 10 \pi(6.625)$
 $\times (0.280)75 + 20 \pi(11.5)(0.365)85 = 65,612$ in.³, or 1.075 m³.

The lower coupling ring is separated from the shroud support cylinder (1 cut, 631 lineal inches @ 2 in. thick), and is cut into 18 segments about 38 in. x 10.5 in. x 3.7 in. (18 cuts, 189 lineal inches @ 3.7 in. thick) for packaging in an 8-120B cask liner.

The shroud support cylinder is separated from the jet pump ring (1 cut, 675 lineal inches @ 2 in. thick) and from the RPV lower head (1 cut, 675 lineal inches @ 4.75 in. thick), and is cut into 18 segments, about 46 in. x 69 in. x 4.75 in. (18 cuts, 1,242 lineal inches @ 4.75 in. thick), for packaging in 9 maritime containers. The cylinder weight is about 62,860 lb.

The jet pump assemblies are separated from the recirculation inlet nozzles, and are cut into segments to facilitate packaging the highly activated portions in 12 cask liners for the NAC-1 cask. The total weight of the components is about 12,500 lb. The less highly activated jet pump diffusers (weight about 6,500 lb) are cut and packaged into 1 liner for the 8-120B cask. The disassembly operations require 220 cuts, for a total of 16,100 lineal inches @ 0.36 in. thick.

The jet pump support ring is separated from the RPV wall (1 cut, 789 lineal inches @ 2 in. thick), and is cut into three 120-degree segments for packaging in a maritime container (3 cuts, 54 lineal inches @ 2 in. thick). The weight of the ring is about 8,630 lb.

E.2.3 Top Fuel Guide

Some portions of the top fuel guide are expected to be activated to GTCC levels. Thus, this assembly is also segmented and packaged for disposal as GTCC material.

The top fuel guide is an egg-crate type of structure, with a 12-in. pitch. The structural material is about 12 in. wide and about 0.4 in. thick. The egg-crate is attached to a circumferential ring, about 207 in. outer diameter, 2 in. thick, and 12 in. high. The full-density volume of this material is:

$$5,395 \text{ in.} \times 0.4 \text{ in.} \times 12 \text{ in.} = 25,896 \text{ in.}^3, \text{ or } 0.425 \text{ m}^3,$$

for the eggcrate, plus the volume of the circumferential ring:

$$(\pi/4)[(207)^2 - (203)^2] \text{ in.}^2 \times 12 \text{ in.} = 15,457 \text{ in.}^3, \text{ or } 0.253 \text{ m}^3,$$

for a total of 0.678 m^3 .

The weight of this material is:

$$[25,896 \text{ in.}^3 + 15,457 \text{ in.}^3] \times 0.29 \text{ lb/in.}^3 = 11,992 \text{ lb, or } 5,440 \text{ kg.}$$

The plates making up the egg-crate are cut into approximately 12 in. x 8 in. segments (588 cuts, for 7,056 lineal inches @ 0.4 in. thick). The flat segments make up an equivalent strip length of 8,092 linear inches, which, when arranged in 175 in. lengths, yields 46 strips. The strips are loaded 20 per canister, or 2.30 canisters.

The surrounding support ring is segmented into vertical sections 8.5 in. wide by 12 in. high by 2 in. thick (77 cuts, for 924 lineal inches @ 2 in. thick), or the equivalent of 5.3 strips 175 in. long. The strips are loaded 4 per canister, yielding 1.3 canisters. Thus, the combined packaged volume for the top fuel guide is about 4 canisters of GTCC material.

The packaged volume, weight per canister, and effective packaged density of the material within the canisters are:

$$4 \text{ canisters} \times 0.24 \text{ m}^3/\text{can} = 0.96 \text{ m}^3.$$

$$5,440 \text{ kg} / 4 \text{ canisters} = 1,360 \text{ kg/can, with an average density of } 5,667 \text{ kg/m}^3, \text{ about } 70\% \text{ of theoretical density.}$$

E.3 CORE SUPPORT PLATE AND ASSOCIATED SUBSTRUCTURES

The lower portion of the RPV internals is comprised of the core support plate, 185 4-lobe orificed fuel supports and 24 single-lobe orificed fuel supports, 185 control rod guide tubes, 185 control rod drive housings, and 55 instrumentation guide tubes. These components are assumed to be activated to Class C levels or less.

E.3.1 Core Support Plate

The core support plate assembly is comprised of the top plate, 7 stiffener beams, 14 stiffener rods, and a peripheral ring. The weight of the assembly is about 20,500 lb. The assembly is unbolted from the core shroud assembly, and removed from the RPV. The stiffener rods are cut free from the peripheral ring (14 cuts, 13 lineal inches @ 0.88 in. thick) and the bolts attaching the stiffener beams to the plate are removed, separating the plate from the remainder of the assembly. The rods are cut on both sides of the beams (184 cuts, 162 lineal inches @ 0.88 in. thick). The beams are cut twice for packaging (14 cuts, 357 lineal inches @ 0.88 in. thick). The peripheral ring is cut free from the plate (1 cut, 625 lineal inches @ 1.75 in. thick), and is cut into 18 sectors (18 cuts, 257 lineal inches @ 1.75 in. thick). The plate is cut into 8 strips approximately 24 in. wide, which are cut into 3 segments for packaging (98 cuts, 334 lineal inches @ 2 in. thick). The assembly pieces are packaged in liners for the 8-120B cask.

E.3.2 Orificed Fuel Supports

There are 185 4-lobe and 24 1-lobe orificed fuel supports. The units are about 11 in. in height, and weigh about 62 lb and 15 lb, respectively, for a total weight of about 11,830 lb. All of the units are packaged, without cutting, in an 8-120B cask liner for disposal.

E.3.3 Control Rod Guide Tubes and Drive Housings

There are 185 control rod guide tubes which are about 160 in. in length, are 10.75 in. O.D., and weigh about 18.70 lb/ft. The upper 70 in. of each guide is activated to varying levels and is separated from the rest of the tube for packaging in an 8-120B cask liner and weigh about 20,180 lb. The lower portions of the CR guide tubes (about 26,000 lb) and the CRD housings (about 41,860 lb) are separated from the RPV at the vessel penetrations, and cut as necessary to facilitate packaging in a modified maritime container. Total cutting is about 185 cuts, 6,248 lineal inches @ 0.165 in. thick, plus 185 cuts, 3,867 lineal inches @ 0.5 in. thick. There are also 185 CR velocity limiters, 9.9 in. dia. x 20 in. long, which weigh a total of about 14,222 lb. The limiters are nested within the lower portions of the CR guide tubes, and packaged in modified maritime containers.

E.3.4 Instrumentation Guide Tubes

There are 55 instrumentation guide tubes which penetrate the bottom of the RPV and extend up to the core support plate. These tubes are about 335 in. in length, 1.9 in. O.D., and weigh 2.718 lb/ft, for a total weight of about 4,173 lb. The upper 70 inches of the tubes are separated from the rest of the tubes (55 cuts, 328 lineal inches @ 0.15 in. thick) for packaging into 8-120B cask liners, together with the upper CR guides. The lower portions of the tubes are cut free from the RPV lower head at the feed-through sleeves (55 cuts, 435 lineal inches @ 0.5 in. thick), and as appropriate to facilitate packaging in maritime containers (about 55 cuts, 328 lineal inches @ 0.15 in. thick). The 872 lb of activated guide tube is packaged in an 8-120B cask liner, together with the activated CR guide tube segments, and the remaining 3,301 lb of tube is packaged in a modified maritime container.

E.4 STEAM SEPARATOR AND DRYER ASSEMBLIES

The steam separator consists of 226 tubes attached to the domed steam shroud plate positioned above the top fuel guide. The steam dryers are positioned above the steam separator tubes, with a skirt that surrounds and extends about half-way down the length of the separator tubes. The separator tubes are comprised of two tubes of different diameters, stacked one above the other, end to end. The domed steam shroud plate and the lower sections of the separator tubes are expected to be activated to some significant level of radioactivity, while the upper sections of the separator tubes and the dryer assemblies are expected to be contaminated on the surfaces, with little activation.

E.4.1 Steam Separator

The activated lower sections of the 226 separator tubes are separated from the domed steam shroud plate and cut to about 48 in. in length. The tube segments are 6.625 in. O.D., 6.357 in. I.D., and weigh about 9.29 lb/ft, for a total weight of about 8,398 lb. The remaining upper segments of the separator tubes range from about 115 in. to 150 in. in length, and consist of the remainder of the 6.625 in O.D. pipe, plus the 12.75 in. O.D., 12.39 in. I.D. pipe with its internal structure, which weighs about 50,000 lb. The domed

steam shroud plate is attached at its periphery to an outer edge ring which is 3 in. thick, 10 in. high, 220 in. O.D., and weighs about 5,930 lb. The domed plate is about 2 in. thick, has a radius of curvature of about 210 in., and weighs about 19,700 lb.

The ring is cut from the domed plate (1 cut, 672 lineal inches @ 2 in. thick) and is cut into 15 segments (15 cuts, 150 lineal inches @ 3 in. thick. The lower tube segments are cut free of the domed plate and from the upper tubes (452 cuts, 9,408 lineal inches @ 0.134 in. thick), for packaging into 8-120B cask liners, together with the CR guide tubes and instrumentation guide tubes.

The domed plate is segmented into strips about 24 in. wide (116 cuts, 800 lineal inches @ 2 in. thickness), and the strips are packaged in 8-120B cask liners, with maximum payloads of about 12,500 lb per liner, resulting in about 2 cask liners.

The upper portions of the 6.625 in O.D. steam separator tubes are left attached to the 12.75 in. O.D upper separator tubes and are packaged into 4 modified maritime containers.

E.4.2 Steam Dryer Assembly

The steam dryer assembly is comprised of six steam dryer units mounted on a support plate, with a skirt attached to the support plate, located above the steam separator assembly. Each dryer consists of an enclosure containing a set of perforated plates, about 24 in. wide and 90 in. high. The length of the units vary from about 164 in. to 236 in. The dryer units are cut free from the support plate (6 cuts, 2,536 lineal inches @ 1 in. thick) and packaged as units into 3 modified maritime containers. The support plate is cut free from the dryer skirt (1 cut, 2,680 lineal in. @ 0.5 in. thick) and cut into a few segments and packaged into the same maritime containers (4 cuts, 100 lineal inches @ 1 in. thickness).

The dryer skirt is about 268 in. O.D., 72 in. high, and about 0.5 in. in thickness, and weighs about 8,774 lb. The skirt is cut into 18 segments about 47 in. x 72 in. (18 cuts, 2,138 lineal inches @ 0.5 in. thick), and packaged into maritime containers together with the steam dryers.

E.5 REACTOR PRESSURE VESSEL

The RPV, illustrated in Figure E.2, is a right circular cylinder with a diameter of 265 in., a 7 in. wall thickness, and hemispheric ends.

FIGURE E.2. Reactor Pressure Vessel

The seal between the RPV and the surrounding reactor containment vessel is removed to improve access to the RPV and facilitate separating the RPV from the RCS piping, and to facilitate removal and packaging of the insulation surrounding the RPV. With the insulation and the RCS piping removed, access to the outside of the RPV is available for sectioning the RPV using oxyacetylene torches. Disassembly and packaging of the RPV is described in the following subsections.

E.5.1 Insulation

The vessel insulation is comprised of packages of multiple layers of thin aluminum sheet contained within a stainless steel outer jacket. The insulation is built in segments which are latched together and which are contoured to surround the entire vessel, top and bottom heads and the cylindrical side wall. These packages are approximately 4 in. thick and are of various sizes to facilitate installation and removal. The packages are removed, flattened to reduce their volume, and packaged in 2 standard maritime containers.

E.5.2 RPV Upper Head and Flanges

The penetrations through the RPV upper head are cut off flush with the hemispheric surface, and are packaged together with the head and flange segments in special steel boxes for unshielded shipment.

A circumferential cut is made just above the head upper flange (1 cut, 830 lineal inches @ 4.5 in. thick). The flange is cut into 20 segments (20 cuts, 600 lineal inches @ 17 in. thick) and packaged 2 segments/per box, for 10 boxes (48 in. x 48 in. x 36 in.) with a weight/box of about 12,174 lb. The remainder of the upper head is cut into 39 segments (12 cuts, 3,588 lineal inches @ 4.5 in. thick) approximating 46 in. x 46 in. in area and packaged 6 segments/box, for 7 boxes (48 in. x 48 in. x 30 in.) with a total weight of about 65,260 lb.

A circumferential cut is made just below the head lower flange (1 cut, 832 lineal inches @ 7 in. thick). The flange is cut into 20 segments (20 cuts, 720 lineal inches @ 14 in. thick) and packaged 2 segments/box, for 10 boxes with a weight/box about 12,168 lb.

The 3 nozzles on the upper head are cut out of the head (3 cuts, 124 lineal inches of cut @ 4.5 in. thick), and packaged with the head segments.

There are 108 studs and nuts for fastening the RPV upper head to the rest of the vessel. The studs are about 7 ft long and about 6 in. O.D., and the nuts are about 10 in. long and about 10 in. O.D., for a total weight of about 67,000 lb. The studs and nuts are packaged into special steel boxes

which contain 18 ea. studs and nuts, for 6 boxes with a weight per box of about 11,167 lb.

E.5.3 RPV Side Wall

The RPV side wall consists of 3 sections, the upper 261 in. section of slightly activated material, the central 240 in. section of strongly activated material, and the lower 83 in. section of slightly activated material. These sections contain 40 nozzles of varying size, which are removed by cutting around the nozzle at the RPV side wall. The 40 nozzle cuts comprise about 3,080 lineal inches of cut @ 7 in. thick.

Circumferential cuts are made in the upper section at three 87 in. intervals (3 cuts, 2,498 lineal inches @ 7 in. thick). Each of the three rings is cut into 18 segments (54 cuts, 4,698 lineal inches @ 7 in. thick), yielding pieces about 46 in. x 87 in. x 7 in., and packaged 2 segments/box, for 26 boxes (48 in. x 96 in. x 18 in.) with a weight of about 15,900 lb/box.

The strongly activated portion of the RPV wall is cut into 8 rings, each about 30 in. high (8 cuts, 6,600 lineal inches @ 7 in. thick). Each ring is cut into 20 segments (160 cuts, 4,800 lineal inches @ 7 in. thick) ranging in width from 50 in. to 20 in., to facilitate packaging in 27 cask liners for the 8-120B cask, which are 62 in. dia. and 32 in. high, with weights of about 14,626 lb/liner.

The lower slightly activated section of the RPV wall is cut free from the lower head (1 cut, 832 lineal inches @ 7 in. thick) and segmented into 18 sections (18 cuts, 1,494 lineal inches @ 7 in. thick) about 46 in. x 83 in. x 7 in. and packaged in 9 steel boxes (48 in. x 96 in. x 18 in.), 2 segments/box, which weigh about 15,000 lb/box.

E.5.4 RPV Lower Head

The RPV lower head is cut free of the RPV support skirt (1 cut, 795 lineal inches @ 2 in. thick). The head is cut into 53 segments (15 cuts, 4,876 lineal inches @ 8 in. thick) about 46 in. x 46 in. x 8 in., and packaged into 14 steel boxes (48 in. x 48 in. x 36 in.), 2 segments/box, with a weight of about 17,467 lb/box. Separation of the various lower head penetrations from the lower head was described previously in Sections E.3.3, and E.3.4.

The RPV support skirt is cut free from the skirt base ring (1 cut, 795 lineal inches @ 2 in. thick), forming a cylinder about 253 in. O.D., 90 in. high, and 2 in. thick. The skirt is cut into 18 segments (18 cuts, 1,620 lineal inches @ 2 in. thick) about 49 in. x 90 in. x 2 in., and packaged in maritime containers. The total weight of the skirt is about 41,160 lb.

The skirt base ring is about 268 in. O.D., 234 in. I.D., and 5 in. thick. The ring is cut into three 120 degree segments (3 cuts, 51 lineal inches @ 5 in. thick) and packaged in a maritime container. The total weight is about 19,438 lb.

The inner collar beneath the lower RPV head is about 247 in. O.D., 72 in. high, and about 3 in. thick. The collar is cut into 18 segments (18 cuts, 1,620 lineal inches @ 3 in. thick) about 46 in. x 72 in. x 3 in., and packaged in maritime containers. The total weight is about 48,000 lb.

The bottom CRD housing and instrumentation guide plate is about 232 in. dia. and about 3 in. thick. It is penetrated by 185 CRD housings and 55 instrument guides. The plate is cut into three strips (2 cuts, 373 lineal inches @ 3 in. thick), each about 78 in. wide, for packaging in a maritime container. The total weight is about 7,670 lb.

E.6 SACRIFICIAL SHIELD

The approach, duration, and cost of dismantling the sacrificial shield are discussed in this section. The sacrificial shield assembly consists of a bottom steel ring seated upon the reactor support pedestal, and 5 structural rings of varying heights, assembled to form a right cylindrical shell whose nominal dimensions are 360 in. O.D., 310 in. I.D., and 575 in. high. The structural rings are comprised of steel structural members and inner and outer skins, with the voids filled with concrete. Numerous openings pierce the shield to accommodate the RCS piping connections to the RPV.

The postulated disassembly process utilizes a specialty contractor employing diamond rope saws to segment the shield into 60 pieces, each approximately 93 in. x 114 in. x 25 in thick. To facilitate sawing, the outer skin and the top plate of the shield are cut along the planned saw lines to provide the diamond rope access to the contained concrete. Both axial cuts

and circumferential cuts are made, to separate the shield into segments that can be transported by truck to the disposal site.

Seventeen major cuts with oxyacetylene torches are made to provide access to the concrete, with a total length of cut of about 1,100 ft. The holes for the diamond rope are bored through the shield at the corners of the planned segments, 60 holes, for total length of bore of about 125 ft. The total area to be sawn in segmenting the shield is estimated to be about 2,314 ft². Scaffolding is installed within the shield enclosure to support the diamond rope saw equipment, and is repositioned to permit repositioning the equipment to lower elevations as the sawing progresses. The total time required for segmenting the shield is estimated to be about 8 weeks for 2 crews of 5 persons each, assuming the use of two saw units simultaneously, on a 2-shift operation. The estimated specialty contractor cost for the effort is about \$750,000.^(a)

The segments, which weigh about 36,000 lb each, are packaged in form-fitting steel containers, which weigh about 1000 lb each, and are shipped unshielded, in 60 legal-weight truck shipments of about 37,000 lb each. The total disposal volume of the sacrificial shield is about 9,760 ft³.

E.7 SUMMARY OF CUTTING AND PACKAGING ANALYSES

The results of the analyses for cutting and packaging the RPV internals and the RPV itself are presented in this section.

E.7.1 Cutting Team Compositions

Removal of the RPV internals and the RPV requires a sequence of operations, repeated many times, to cut and package these contaminated/activated materials. The equipment is set up to make the cut, the piece to be cut is grappled to support it during and after the cutting, the cut piece is removed from the cutting location to the packaging location, and the piece is placed into the appropriate container preparatory to shipment for disposal. All of the GTCC material is packaged in canisters (9 in. x 9 in. x 178 in.) which can

(a) Based on discussions with concrete sawing specialty contractors.

be stored in the spent fuel pool and which are compatible with spent fuel shipping cask baskets.

Removal and packaging of the RPV internals is postulated to require two manipulator systems with attached plasma arc cutting devices, one mounted on the refueling bridge crane for in-vessel cutting, and a second unit mounted over the location of the disassembly stand for the core shroud and other internals, in the dryer/separator storage pool. Taking into consideration the two cutting systems operated in parallel by a single crew, and the handling times associated with moving large sections from the RPV to the refueling cavity for further sectioning, the cumulative crew-hours for cutting are postulated to be about one-third less than the cumulative operating time, for both the plasma arc torch and the oxyacetylene cutting operations. During RPV sectioning, oxyacetylene cutting torches are attached to the manipulator systems.

One crew per shift operates the cutting systems. Each crew is postulated to consist of the staff listed in Table E.1.

TABLE E.1. Staffing and Labor Rates Postulated for Cutting Crews

<u>Person-hrs per crew/hr</u>	<u>Category</u>	<u>Labor Rate (\$/hr)^(a)</u>	<u>Labor Cost (\$/crew-hr)</u>	<u>Dose-rate (mrem/crew-hr)</u>
3	Craftsman	49.70	149.10	30
4	Laborer	26.37	105.48	40
1	H.P. Tech.	36.82	-- (b)	5
$\frac{1}{9}$	Foreman	54.84	<u>54.84</u>	<u>5</u>
			309.42	80
Average cost per crew-hour (cutting)			324.89 ^(c)	

(a) Labor rates are in 1993 dollars, and include 110% overhead, and 15% DOC profit.

(b) Part of utility/DOC overhead staff, included in undistributed costs.

(c) Includes a 10% shift differential for second shift work.

In addition to the dedicated cutting crews, a non-dedicated crew for handling the packaged materials operates on the third shift, to deliver and remove the casks/containers to and from the work areas and to prepare the casks and containers for transport. This crew is comprised of a foreman, 2 equipment operators, 2 craftsmen, and 2 health physics technicians. During the cutting and packaging of the RPV internals, this crew is provided by the utility, at a daily cost of \$1,546.40, and received an average radiation dose of about 35 mrem/crew-hr. During the cutting and packaging of the RPV, this

crew is provided by the DOC¹, at a daily cost of \$2,500.48, and received an average radiation dose of 35 mrem/crew-hr. These costs are included in the non-dedicated labor costs.

E.7.2 Cutting Operation Time Estimates

It is estimated that about 2 weeks will be required for initial installation and checkout of the cutting and manipulator systems. Subsequent cutting operations are estimated to require about 20 minutes to set up for each cut, including attaching grapples to the piece to be cut. The cutting time will depend upon the type of cutting, the material thickness, and the length of cutting required. Following a cut, about 20 minutes is estimated to be required to remove the cut piece from the cutting location and place it in the appropriate package. These efforts can continue in parallel with the next setup/grappling operation, which begins about half-way through the moving/packaging operation.

Underwater plasma arc cutting rates are postulated to range from about 14 in./min. for 0.5-in. thick stainless steel to about 5 in./min. for 5-in.-thick stainless steel, based on information developed at TMI-2⁽⁵⁾ and European experience described in ECFOCUS.⁽⁶⁾ Rates for oxyacetylene cutting of carbon steel are postulated to range from about 13 in./min. for 1.5-in. thick carbon steel to about 3 in./min. for 14-in.-thick carbon steel, based on information presented in the Decommissioning Handbook.⁽⁷⁾ For many of the cutting operations, the actual cutting time is a very small fraction of the total operating time for a cut.

The total operating time (in minutes) for cutting the j^{th} component can be expressed by:

$$T_j = 30 N_j + \sum (L_{ij}/R_{ij})$$

where N_j is the number of cuts, L_{ij} is the length of the i^{th} cut, and R_{ij} is the cutting rate for the i^{th} cut in the j^{th} component.

The effective time required to segment a component is greater than the total operating time described above. The effective time also includes the amount of time the crew spends in radiation protection/ALARA activities, in

dressing and undressing with anti-contamination clothing, and on work breaks. The cutting equipment is basically automated and controlled remotely underwater. The gases evolved during cutting are filtered through the pool water and are captured and removed using ventilation hoods placed just above the pool surface over the cutting areas. As a result, respiratory protection should not be required for the crew during underwater cutting.

An additional factor associated with the plasma arc cutting is the time required to change the torch when it fails to function. Experience at TMI-2⁽⁵⁾ suggests that a torch fails about every 7.5 cuts. Assuming the change-out time is 2 hours each occurrence, the torch change-out factor is about 46%. Thus, the work difficulty factors appropriate for the underwater cutting are:

Non-productive-Time Adjustments

- Protective Clothing (8 x 15 min./shift) 39.4%
- Break Time (2 x 15 min./shift) 9.8%
- ALARA Activities (25 min./shift) 8.2%

Work Difficulty Adjustments

- Torch Change-out (1 every 7.5 cuts) 46%

Thus, the effective time for underwater cutting is given by:

$$TE_j = T_j (1 + 0.394 + 0.098 + 0.082)(1.46) = 2.30 T_j$$

For the in-air oxyacetylene cutting of the RPV, and the in-air plasma arc cutting of the insulation and RPV piping, respiratory protection is assumed to be required for the crew, with a work difficulty factor of 20%. The torch change-out problems anticipated with the underwater plasma arc torch should not occur with the in-air plasma arc torch or the oxyacetylene torch. For in-air cutting, the effective cutting time per component is given by:

$$TE_j = T_j (1.574)(1.20) = 1.88 T_j$$

Because the single cutting crew is operating two cutting systems in parallel, and some of the cutting is accomplished simultaneously, it is assumed that the actual crew-time will be reduced from the operating time by

about a factor of %. Thus, the actual time for the purposes of calculating cost and schedule is given by $TB_j = \% TE_j$. The exposure hours for the cutting crews are given by $TB_j/1.574$, since only actual contact hours in the radiation fields apply.

The cost of the cutting operation for the j^{th} component is calculated as the product of the actual crew-time for that component, TB_j , and the cost per crew-hour, as displayed in the next-to-last column of Table E.2.

E.7.3 RPV and Internals Cutting Analyses Details

The details of the analyses for cutting the RPV internals and the RPV into pieces suitable for packaging for disposal are presented in Table E.2, where each component is identified, and the number of cuts needed to section that component, the cutting thickness of the component, the total length of cut, the cutting rate for that material thickness, the cutting time and total elapsed time, and the labor costs for that component are listed.

E.7.4 GTCC Cutting and Packaging

The details of the cutting and packaging of material postulated to be activated to levels greater than Class C are presented in Table E.3. These materials are postulated to be packaged in 9-in. x 9-in. x 178-in.-square canisters whose envelopes approximate that of a PWR fuel assembly and are compatible with PWR spent fuel cask baskets. The components are listed in column 1, and the component weights calculated from the reference BWR report⁽²⁾ (and from Reactor Safety Analysis Reports and other supporting information) are given in column 2. Dividing those values by the theoretical density of the metal yields the full-density volumes given in column 3. The volumes of the component material, when packaged using the high-density approach developed in this appendix, are given in column 4. The numbers of 9-in.-square canisters that would arise from the high-density packaging approach are given in column 5.

TABLE E.2. Reactor Pressure Vessel and Internals Cutting Details

Component	Thickness (in.)	No. of Cuts	Total Length (in.)	Cutting Rate (in./min)	Cutting Time (min)	Operating Time (min)	Effective Time (min)	Labor Costs (a) (1993 \$)	Dose (b) (person-rem)
<u>Internals</u>									
Equipment Setup/Testing and Post-Use Removal							6 crew-wks	77,973	2.16
Core Shroud (GTCC)	2.0	178	18,589	8	2,325	7,665	11,753	63,577	
Top Fuel Guide (GTCC)	0.4, 2	665	7,980	15, 8	586	20,536	31,488	170,504	
Shroud Support	2, 4.75	39	3,412	8, 5	705	2,445	3,749	20,280	
Jet Pumps & Support	0.3, 2	224	16,943	16, 8	1,112	7,832	12,009	64,962	
Core Support Plate	0.9, 2	329	1,747	11, 8	194	10,064	15,431	83,476	
CR Guides	0.165,	185	6,248	23	272	5,822	8,925	48,282	
CR Drive Housings	0.5	185	3,867	14	276	5,826	8,934	48,374	
Inst. Guides	0.2, 0.5	165	1,091	23, 14	60	5,010	7,682	41,553	
Steam Separator	0.14, 2, 3	584	11,030	24, 8, 6	601	18,121	27,786	150,454	
Steam Dryer	0.5, 1	29	7,454	14, 11	584	1,454	2,229	12,060	
		2,583			6,715	84,775	129,986 (2,166 hr)	703,522	219.60
<u>Reactor Pressure Vessel</u>									
Equipment Setup/Testing and Post-Use Removal							4 crew-wks	51,982	1.44 (b)
Upper Head	4.5	16	4,542	7.5	606	1,086	1,361	7,404	
Upper Flange	17	20	600	2	300	900	1,128	6,136	
Lower Flange	14	20	720	3	240	840	1,053	5,454	
Activated Wall Sections	7	168	11,400	5.5	2,073	7,113	8,915	48,492	
Non-Act. Wall Sections	7	77	10,354	5.5	1,883	4,193	5,255	28,585	
Nozzles	7	40	3,080	5.5	560	1,760	2,206	11,945	
Lower Head	8	16	5,671	8, 4.5	1,183	1,663	2,084	11,286	
Skirt	2	19	2,415	12	201	771	966	5,206	
Skirt Ring	5	3	51	7	8	98	123	663	
Collar	3	18	1,620	9.5	171	711	891	4,802	
Base Ring	3	2	373	9.5	40	100	125	679	
Subtotal		399			7,265	19,234	24,107 402 hr	130,761	30.75 (b) 250.35

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(a) Does NOT include a 25% contingency.

(b) Includes radioactive decay from reactor shutdown to time of cutting.

TABLE E.3. Calculated Weights, Full-Density Volumes, Packaged Volumes, and Numbers of Canisters of GTCC LLW Generated During the Decommissioning of the Reference BWR

<u>Reactor Core Components</u>	Component Weight (lbs)	Full-Density Volume (ft ³)	Packaged Volumes (ft ³)(a)	No. of Canisters
Core Shroud	83,111	165.8	208.6	25
Top Fuel Guide	11,992	23.9	33.4	4
Totals	95,103	189.7	242.0	29

(a) 9-in.-sq. by 178-in.-high canisters, disposal volume of 8.344 ft³ (0.24 m³) each.

E.7.5 Packages for Disposal

The number, type, and weight of packages, volume per package, number of shipments, weight per shipment, and disposal volume per shipment resulting from the cutting and packaging of the RPV, its internals, and the sacrificial shield are summarized in Table E.4.

E.7.6 Estimated Costs

The costs of removing, cutting, packaging, transport, and disposal are summarized in Table E.5. The removal/cutting labor costs are derived from Table E.2. The cost of disposal containers, transport cost (including cask rental), and disposal costs are derived from Table E.4 and Appendix B.

The initial 2 weeks (20 shifts) of the RPV internals cutting operations are devoted to installing and testing the plasma arc torches and the manipulator systems in the RPV and dryer/separator pool areas.

The estimated schedule for cutting and packaging of the RPV internals is shown in Figure E.3. Upon completion of the cutting and packaging operations for the internals, a final week is devoted to removal of the plasma-arc cutting systems and to final packaging and shipping from the dryer/separator pool. The elapsed calendar time for the cutting and packaging of the RPV internals is estimated to be about 37 weeks.

FIGURE E.3. Postulated Schedule for Cutting/Packaging the RPV Internals

The initial week (10 shifts) of the RPV sectioning is devoted to installing and testing the oxyacetylene torches and the manipulator system in the reactor vessel. The estimated schedule for cutting and packaging of the RPV and the sacrificial shield is shown in Figure E.4. Upon completion of the cutting and packaging operations, a final week is devoted to removal of the cutting systems and to final packaging, shipping, and cleanup. Thus, the elapsed calendar time for the cutting and packaging of the RPV and the sacrificial shield is estimated to be about 15 weeks.

FIGURE E.4. Postulated Schedule for Cutting/Packaging the RPV and Sacrificial Shield

E.7.8 Impacts on Transport and Disposal Costs of Disposal at Barnwell

The transport and disposal costs for low-level radioactive wastes are sensitive to the distance between the reactor site and the disposal facility, and to the charge schedule at the disposal site. The costs of transport and disposal of LLW from the WNP-2 site to and disposal at the Chem-Nuclear facility at Barnwell, South Carolina and the U.S. Ecology facility at Richland, Washington, are presented in Table E.6. The estimated transport cost to Barnwell is nearly a factor of 6 larger than the transport cost to Richland, reflecting the much greater distance traveled. Similarly, the disposal cost at Barnwell is about a factor of 4 larger than the disposal cost at Hanford, reflecting the much higher disposal rate structure at Barnwell.

TABLE E.6. Sensitivity of Transport and Disposal Costs for LLW to Disposal Facility Location and Rates^(a)

Location	Transport Costs (1993 \$)	Disposal Costs (1993 \$)
Richland LLW	1,096,332	34,583,597
Barnwell LLW	6,436,540	147,030,218

(a) Costs do NOT include a 25% contingency.

E.7 REFERENCES

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APPENDIX F

ACTIVITIES, MANPOWER, AND COSTS FOR DISMANTLEMENT AND DISPOSAL OF THE TURBINE,
TURBINE CONDENSER, MOISTURE SEPARATOR REHEATERS, FEEDWATER HEATERS, FEED PUMP
AND TURBINE ASSEMBLY, AND DRYWELL STRUCTURAL MEMBERS

APPENDIX F

ACTIVITIES, MANPOWER, AND COSTS FOR DISMANTLEMENT AND DISPOSAL OF THE TURBINE, TURBINE CONDENSER, MOISTURE SEPARATOR REHEATERS, FEEDWATER HEATERS, FEED PUMP AND TURBINE ASSEMBLY, AND DRYWELL STRUCTURAL MEMBERS

Because the reference boiling water reactor (BWR) utilizes a direct-cycle steam turbine system, with the steam generated within the reactor vessel using reactor coolant water, the turbine and turbine condenser are contaminated internally. As a result, it is postulated for this study that all of the turbine and turbine condenser must be removed and packaged for disposal as low-level radioactive waste (LLW). In practice, it may be possible to decontaminate a significant fraction of the material in these units to unrestricted release levels. However, for conservatism, no release of turbine or condenser materials is assumed.

F.1 DISASSEMBLY AND PACKAGING

The approach assumed in this analysis is to section the various elements of the turbine, condenser, moisture separator reheater, feedwater pump and turbine drive, feedwater heaters, and the drywell structural members, into segments sized to fit within standard or modified maritime containers, or to be capped and sealed for shipment as its own container. In many cases, the packaged segments weigh more than is allowed for a legal-weight truck shipment, and must be transported as over-weight truck shipments. The segmentation, packaging, and transport parameters utilized in these analyses were selected on the basis of simplicity and achievability, without any significant effort to trade off segmentation costs against packaging and transport costs.

While the thickness of the material being cut varies from one location to another, a conservative cutting rate of 0.4 ft per min. has been postulated for all materials. The results are not very sensitive to the cutting rate because the actual cutting time is a small fraction of the crew-time devoted to a cut. The cutting crews and the unit cost factor defined in Appendix C

for cutting large, thick-walled pipe, greater than 30 in. dia. are used, unless otherwise specified. It is assumed that there are 2 crews per shift, 2 shifts per day, for a total of 32 crew-hours per day. For tube bundle cutting, specialty contractor crews are brought in to operate the diamond rope saws, with an assumed cutting rate of 5 ft²/hr, at a cost of \$325/ft² of cross-sectional area cut. The radiation dose rate to workers is postulated to be in the range of about 1 mrem/hr for direct-contact work.

F.2. SEGMENTATION AND PACKAGING OF THE TURBINE

A moveable ventilation enclosure, about 30 ft long x 20 ft high and 30 ft wide, is placed over the section of the turbine being segmented, to collect and filter the smoke and fumes arising from the cutting operations. Each repositioning is postulated to require about 2 hr. The enclosure will have to be repositioned frequently to facilitate handling and packaging of the large segments, perhaps 20 times during the turbine segmentation. The results of the cutting and packaging analyses for the turbine are presented in Table F.1.

TABLE F.1. Segmentation and Packaging of Turbine Components

<u>Component</u>	<u>Number of Containers(a)</u>	<u>Container Shipping Weight (lb)(b)</u>	<u>Disposal Volume (ft³)</u>	<u>Length of Cut (ft)</u>	<u>Number of Cuts</u>
H.P. Turbine Cover	3	46,242	1,920	33	2
Base	3	50,567	1,920	46	2
Rotor	1	79,506	640	12	2
Blades & Bolts	1	49,746	640	--	--
L.P. Turbine Cover & Ends	15	44,027	9,600	651	45
Outer Base Cover	21	47,906	13,440	630	36
Outer Base Ends	15	44,912	9,600	156	18
# 1 Inner Cover & Base	6	58,590	3,840	112	12
# 2 Inner Cover & Base	12	48,495	7,680	230	18
Outer Blades, Rings	3	42,433	1,920	10	9
Rotor Shaft	3	58,739	1,920	38	6
Rotor Blades	9	41,200	5,760	10	18
Steam Chest (2 ea.)	<u>4</u>	64,122	<u>2,560</u>	<u>44</u>	<u>2</u>
Totals	96		61,440	1,972	170

(a) Containers: 4 ft x 8 ft x 20 ft; empty weight: 3,000 lb; cost: \$4,965; disposal volume: 640 ft³.

(b) Each container comprises 1 shipment, LWT (<40,000 lb payload) or OWT (>40,000 lb payload).

For the 170 cuts identified in Table F.1, the duration of the turbine segmentation would be about 1,105 crew-hrs, plus the 40 crew-hrs devoted to moving the ventilation enclosure, plus about 135 crew-hrs devoted to constructing the ventilation enclosure and installing the associated fans and filters, for a total of about 1,280 crew-hrs, with a labor cost of about \$243,372. At 32 crew-hrs per day, the turbine segmentation and packaging would require about 40 days, or about 8 weeks. The radiation dose to workers is estimated to be about 2.37 person-rem.

F.3. SEGMENTATION AND PACKAGING OF THE TURBINE CONDENSER

The turbine condenser is a massive steel shell structure, about 105 ft long x 33 ft wide x 49 ft high, with a nominal wall thickness of 1 in., located directly beneath the turbine. The condenser contains 6 tube bundles, each about 50 ft long x 9 ft wide x 24 ft high. The segmentation and packaging of the condenser is summarized in Table F.2.

TABLE F.2. Segmentation and Packaging of Turbine Condenser Components

<u>Component</u>	<u>Number of Containers(a)</u>	<u>Container Shipping Weight (lb)(b)</u>	<u>Disposal Volume (ft³)</u>	<u>Length of Cut (ft)</u>	<u>Number of Cuts</u>
Steam inlet shell	4	37,706	640	360	48
Shell upper housing	4	42,247	640	440	32
Shell side walls	8	41,284	1,280	1,740	64
Shell end and interior vertical plates	3	40,124	480	1,422	48
Tube bundle sections	30 ^(c)	67,782	75,000	375 ^(d)	36
Shell interior floor	2	41,688	320	546	23
Shell bottom floor	4	38,176	640	600	27
Water boxes and miscellaneous piping	5 ^(e)	40,000	6,800	200	30
Totals	60		85,800	5,308 ft ² 375 ft ²	272 36

(a) Unless otherwise noted, all containers are modified maritime containers, 1 ft x 8 ft x 20 ft; empty weight, 2,000 lb; cost, \$4,000; disposal volume, 160 ft³.

(b) Each container comprises 1 shipment, LWT (<40,000 lb payload) or OWT (>40,000 lb payload).

(c) Special containers: 10 ft₃ x 10 ft x 25 ft; empty weight, 6,500 lb; cost, \$6,000; disposal volume, 2,500 ft³.

(d) Total cross-sectional area of tubes cut using diamond rope saw.

(e) Container: 8 ft x 8½ ft x 20 ft; empty weight, 4180 lb; cost, \$3,650; disposal volume 1,360 ft³.

The approach postulated for disassembly and packaging of the condenser is as follows: The interior of the shell and the exterior of the tube bundles

(about 42,000 ft² of surface) are washed using very high pressure water jets, to remove the readily removable surface contamination. One lower side wall is removed, sectioned and packaged, to provide ready access to the tube bundles and the intermediate water boxes for cutting into sections using a diamond rope saw. The tube bundles are cut free from the tube sheets at the water boxes and at every third tube support plate, resulting in 30 tube bundle segments that are approximately 9½ ft x 9½ ft x 24 ft high, and are packaged in special oversized boxes, nominally 10 ft x 10 ft x 25 ft. The assorted piping in the steam inlet areas is cut and removed, providing vertical access into the condenser shell. The intermediate water boxes and tube bundle segments are lifted vertically to the turbine building floor for packaging. The remaining sections of the condenser shell are sectioned and packaged. Because much of the condenser is comprised of large sheets of 1-in.-thick steel, a special modified maritime container, 1 ft high x 8 ft wide x 20 ft long, is used for most of the segments.

The internal washing operations are estimated to require about 210 crew-hrs to wash the internal surfaces of the condenser shell and the outside surfaces of the tube bundles. Because the condenser is divided into three compartments, three washing crews can operate simultaneously. Thus, the duration of the washing operation would be about 4½ days. The total washing cost would be about \$28,927. The radiation dose to the workers is estimated to be about 0.292 person-rem.

For the 272 plate cuts identified in Table F.2, the duration of the turbine condenser segmentation would be about 1,768 crew-hrs, plus about 40 crew-hrs devoted to moving the ventilation enclosure, for a total of about 1,808 crew-hrs, at a cost of about \$343,762, and an estimated radiation dose of 3.451 person-rem. At 32 crew-hrs per day, the turbine condenser segmentation and packaging would require about 56 days, or about 11 weeks. The cutting of the tube bundles by the specialty contractor staff would require about 75 hours of cutting time, plus about 2 hours for each new setup of the equipment, for about 145 actual hours. Including the work difficulty factor of 1.3 and the non-productive time factor of 1.574, the duration of the effort is about 297 crew-hrs. An on-site crew of 6 persons per shift is assumed for the diamond sawing team. Using two cutting systems, this effort

could be accomplished in about 10 days on a two-shift basis, in parallel with the on-going shell separation operations. Assuming an average cost of \$325/ft² of material sawed, the tube cutting operations would cost about \$121,875, with an estimated radiation dose of 0.618 person-rem.

In summary, the duration of the condenser segmentation and packaging operations is estimated to be about 12 weeks, at a total labor cost of \$435,637, and a cumulative radiation dose of about 4.36 person-rem.

F.4. SEGMENTATION AND PACKAGING OF MOISTURE SEPARATOR REHEATERS

The two moisture separator reheaters associated with the main steam system are nearly 13 ft dia. and 93 ft long, and weigh about 460,000 lb each. Each reheater contains four U-tube bundles of 1617 tubes each, which are about 36 ft long and 4½ ft dia., fastened to a tube sheet with a hemispheric channel head at the outboard end, two steam distribution manifolds, and 12 sets of mist extractor chevrons. The segmentation and packaging of the moisture separator reheaters is summarized in Table F.3.

TABLE F.3. Segmentation and Packaging of Moisture Separator Reheaters

<u>Component</u>	<u>Number of Containers</u>	<u>Container Shipping Weight (lb)^(a)</u>	<u>Disposal Volume (ft³)</u>	<u>Length of Cut (ft)</u>	<u>Number of Cuts</u>
Tube bundles	4 ^(b)	34,000	3,800	126	8
Shell	5 ^(c)	39,865	1,600	691	30
Shell ends, baffles, supports, etc.	4 ^(d)	41,608	2,560	140	50
Totals	13		7,960	957	88

(a) Each container comprises 1 shipment, LWT (<40,000 lb payload) or OWT (>40,000 lb payload).

(b) Special containers: 5 ft x 5 ft x 38 ft; empty weight, 4,300 lb; cost, \$4,500; disposal volume, 950 ft³.

(c) Modified maritime container: 2 ft x 8 ft x 20 ft; empty weight, 2,500 lb; cost, \$4,600; disposal volume, 320 ft³.

(d) Modified maritime container: 4 ft x 8 ft x 20 ft; empty weight, 3,000 lb; cost, \$4,965; disposal volume 640 ft³.

The approach postulated for disassembly and packaging of these units is the following: The tube bundles are cut free from the shell by cutting around the channel heads, and the bundles are withdrawn from the shell and placed into special containers, 5 ft x 5 ft x 38 ft. With the tube bundles removed, the interior of the shell together with the steam manifolds and mist extractor chevrons (about 4,500 ft² of surface) are washed using high-pressure water

jets to reduce the level of contamination. The remaining internal components of the shell are removed and cut as necessary to facilitate packaging with the tube bundles. The shell can now be treated as a large tank, and be cut into segments for reduced-volume packaging.

The washing of the interior of the shell and associated components is estimated to require about 22½ hrs. Because the shell interior consists of essentially a single compartment, only one crew at a time can work therein. Thus, the duration of the washing operation would be less than 2 days. The cost of the washing operation is estimated to be \$3,099, and the radiation dose received by the workers is estimated to be about 0.033 person-rem.

For the 88 plate cuts identified in Table F.4.1, the duration of the moisture separator reheater segmentation would be about 572 crew-hrs, plus about 40 crew-hrs devoted to moving the ventilation enclosure, for a total of about 612 crew-hrs, at a cost of about \$116,362. At 32 crew-hrs per day, the moisture separator reheaters segmentation and packaging would require about 19 days, or about 4 weeks. The radiation dose to workers is estimated to be about 1.167 person-rem.

In summary, the duration of the segmentation and packaging of the moisture separator reheaters is estimated to be about 21 days, at a labor cost of about \$119,461, and a radiation dose to workers of about 1.200 person-rem.

F.5 SEGMENTATION OF THE FEEDWATER PUMP AND FEEDWATER PUMP TURBINE ASSEMBLIES

There are two feedwater pump and turbine drive assemblies associated with the feed and condensate system. Each unit is skid-mounted, occupies a space of about 5045 ft³, and weighs about 132,700 lb. For disposal, the assemblies are postulated to be disassembled and packaged as described below. The segmentation and packaging of the feedwater pump/turbine drive units is summarized in Table F.4.

Disassembly of the feedwater pump/turbine drive units for packaging is accomplished as follows: The pump is mechanically decoupled from the turbine, the inlet and outlet pump nozzles are capped, the pump, pump cradle, and the portion of the skid supporting the pump are separated from the rest of the skid, and the exterior of this smaller unit is washed with high-pressure water

TABLE F.4. Segmentation and Packaging of the Feedwater Pumps and Turbine Drives

<u>Component</u>	<u>Number of Containers</u>	<u>Container Shipping Weight (lb)</u>	<u>Disposal Volume (ft³)</u>	<u>Length of Cut (ft)</u>	<u>Number of Cuts</u>
Feed pump	2(a)	14,360	960	8	6
Drive turbine	2(a)	96,788	2,098	8	6
Lubrication system	2(a)	16,800	1,376	0	0
Valves, servo motors,	1(b)	12,900	640	0	0
Totals	7		5,074	16	12

(a) Shipped as own container. Volume based on imaginary enclosure containing entire unit.

(b) Modified maritime container: 4 ft x 8 ft x 20 ft; empty weight, 3,000 lb; cost, \$4,965; disposal volume, 640 ft³.

jets. Assuming the exterior is successfully cleaned, the pump/cradle unit is shipped as its own container. The envelope enclosing the pump unit has a volume of about 480 ft³, and the unit weighs about 14,360 lb.

The turbine drive unit and its supporting frame is separated from the lubrication system section of the frame, and all interconnecting piping is removed and openings capped or plugged. The appendages attached to the turbine unit, such as the control valves, servo motor, and connecting piping, are removed and packaged in steel boxes. The sealed turbine exterior is washed with high-pressure water jets. Assuming the exterior is successfully cleaned, the turbine drive unit is shipped as its own container. The envelope enclosing the turbine unit has a volume of about 1049 ft³, and the unit weighs about 96,788 lb.

The lubrication system portion of the frame is drained of oil, and all interconnecting lines are removed and capped or plugged. The envelope enclosing the lubrication system has a volume of about 688 ft³, and the unit weighs about 16,800 lb. The residual components removed previously are packaged in a single modified maritime container (4 ft x 8 ft x 20 ft) whose contents weigh about 9,900 lb.

It is estimated that preparing the feed pumps and their drive turbines for disposal would require about two crew-shifts for each assembly to remove the external piping and appendages, two crew-shifts for each assembly to wash and survey the external surfaces, and one crew-shift to section each of the

support frames into three segments. The estimated labor cost per assembly is about \$6,745, plus about \$500 for closure materials and welding supplies, for a total labor and material cost of \$13,989, and the duration of the effort would be about 8 days. The estimated radiation dose to workers is about 0.140 person-rem.

F.6. FEEDWATER HEATERS

There are 16 large feedwater heaters associated with the feed and condensate system. These units are of a size (40 to 50 ft long x 6 to 8 ft dia., with weights between 78,000 and 162,000 lb) that would permit intact removal and shipment by capping all of the shell openings and decontaminating the exterior surfaces. All of the shipments would be by over-weight truck. It is estimated that capping operations would require about two cutting crew-shifts per unit to weld the closure caps, about one surface washing crew-shift to decontaminate the exterior surface using high pressure water jets, at a materials cost of about \$500 per unit and a labor cost of about \$4,132 per unit, and an elapsed time of about 2 days per unit. The total labor and materials cost for all 16 units is estimated to be about \$74,127. Assuming two units can be worked on simultaneously without interference, the removal duration is estimated to be about 16-18 days, or about 3½ weeks. The radiation dose to workers is estimated to be about 0.670 person-rem.

F.7. SEGMENTATION OF BEAMS, PLATES, GRATINGS, AND CABLE TRAYS FROM THE CONTAINMENT DRYWELL

The interior of the reactor containment vessel (the drywell) contains a large assortment of steel beams, plates, and gratings, which are assumed to be surface-contaminated, and are removed and packaged for disposal as LLW. Some 118 individual items have been identified. In addition, the drywell contains a large number of cable trays filled with cables, which must also be removed and packaged for disposal. Estimates of the costs, waste volumes and radiation doses associated with these removal and disposal operations are developed in this section.

With the RPV and the sacrificial shield removed, the interior of the drywell is accessible from the refueling floor using the reactor building

bridge crane. Thus, the removal of the structural members and major equipment is carried out simultaneously, starting at the upper level of the drywell. Gratings are lifted out and placed into modified maritime containers for transport and disposal. Beams are cut free from attachments and lifted out and packaged. Plates are segmented as necessary and lifted out and packaged. The many structural steel beams are assumed to be cut into lengths compatible with the maritime containers (<20 ft), and loaded into the 2-ft-high containers up to a payload of about 36,000 lb.

The total number of cuts required is estimated to be 611, with a total cutting length of 2,200 linear ft. These amounts are increased by 10% to account for additional items not identified uniquely, resulting in 672 cuts. The cutting time for these operations is postulated to be similar to cutting of medium-sized pipe, or about 3 hrs/cut, for a total operations time of 2,016 crew-hrs. At 32 crew-hr/day, the duration of these removal operations will be nearly 63 days, or about 12½ weeks. The removal labor cost will be about \$383,302. The radiation dose to workers is estimated to be about 3.848 person-rem. The volume of waste for disposal is based on the payload weight limit of the maritime containers, about 37,500 lb. The total estimated weight of these materials is 1,189,312 lb, which, when divided by 37,500 lb/container, results in about 31.7 of the 2 ft x 8 ft x 20 ft modified containers, with a burial volume of 10,240 ft³.

The weight and volume of the cables and cable trays are estimated based upon the maximum hanging weights for which the various elevations in the drywell are rated. The sum of these rated loads is 51,885 lb. To estimate the volume of this material, a specific gravity of 2 is assumed, with a resulting volume of 416 ft³. Based on the 37,500 lb payload weight limit for the maritime containers, about 1.4 of the 2-ft-high containers would be required. The number of linear feet of tray w/cables is not known. An allowance of 100 cuts is made for cutting the cable trays into segments for packaging, for a duration of 300 crew-hours, at a cost of about \$57,039, and an estimated radiation dose of about 0.572 person-rem.

In summary, the operations to remove beams, supports, gratings, and cable trays from the drywell will require about 2,316 crew-hrs, at a labor

cost of about \$440,350, and a radiation dose to workers of about 4.420 person-rem. and will fill about 33 modified maritime containers (10,560 ft³ disposal volume).

APPENDIX G

DECOMMISSIONING METHODS

APPENDIX G

DECOMMISSIONING METHODS

The information presented in this appendix is essentially identical with the information presented in NUREG/CR-5884,⁽¹⁾ Appendix G, and is included here for completeness.

Methods, equipment, and disassembly procedures postulated to be used to accomplish various decommissioning activities at nuclear facilities, such as the reference boiling water reactor (BWR), were discussed in considerable detail in NUREG/CR-0672.⁽²⁾ Some of those methods are no longer state-of-the-art, other methods/techniques have seen improvements, some have never matured for subsequent decommissioning applications as anticipated (e.g., the arc saw),^(a) and some new decommissioning-related techniques, methods, and equipment have come on the scene. Information associated with this latter group is presented in Appendix K of Reference 2 and is not repeated here. The information given in this appendix is presented in the following order:

- system decontamination
- surface decontamination
- removal techniques and equipment
- water treatment and disposal.

G.1 SYSTEM DECONTAMINATION

The current state of knowledge regarding full-system chemical decontamination of PWRs and BWRs is not sufficient to make any significant distinctions between the two reactor types at this time. Thus, the information in this section is essentially identical with the information presented previously in Section G.1 of NUREG/CR-5884.⁽¹⁾

(a) To date there is insufficient operating data to accurately compare arc saw cutting to other more conventional means.

For this reevaluation study, a full-system chemical decontamination approach is postulated (recirculatory method) wherein dilute chemical decontamination solutions are recirculated through the reactor coolant and attached associated systems until the desired degree of decontamination is obtained. The dissolved radioactivity and chemicals are removed on ion exchange resin and the water is either reused for an additional decontamination step or treated further for discharge. This technique was identified to reduce the dose rates (and therefore exposures) incurred during the subsequent removal and disposition of the primary coolant system piping and associated equipment.

The information presented herein is based to a large extent on discussions between the authors and senior staff of Pacific Nuclear Services (PNS), located in Richland, Washington, who specialize in chemical decontamination services.

The major contributors to the estimated total cost and occupational radiation exposure for full-system chemical decontamination at the reference BWR are summarized in Table G.1. The total cost for these activities is estimated at about \$14 million, not including contingency. The total occupational radiation dose is estimated to be about 46 person-rem.

The assumptions used in this study are described below, followed by a general discussion of the estimated cost, dose, volumes of radwastes, and schedule associated with the full-system chemical decontamination of the reference BWR.

G.1.1 Assumptions

In developing the chemical decontamination scenario and the subsequent analysis, the following assumptions were used:

- The BWR primary system components description and radioactive inventory were taken from NUREG/CR-0672.⁽²⁾
- Full-system chemical decontamination of BWRs by a specialty contractor (vendor) is postulated to be routine work by the time this operation commences at the reference BWR (i.e., it is assumed that at least three such campaigns have been successfully completed prior to the reference BWR campaign).

- The full-system chemical decontamination will be completed during the first year following final shutdown, after defueling of the reactor.

TABLE G.1. Summary of Estimated Costs and Radiation Dose for Full-System Chemical Decontamination of the Reference BWR

<u>Cost Item</u>	<u>Estimated Cost (1993\$) ^(a)</u>	<u>Estimated Dose (person-rem) ^(b)</u>
Chemical Decontamination:		
Fixed-cost Contract (Specialty Contractor) ^(c)	12,500,000	12
Utility Support	usc ^(d)	28
Disposal of Radioactive Wastes from Chem. Decon 18 High-Integrity Containers (HIC)	404,498 ^(e)	-
Electricity ^(f)	238,000 ^(g)	
Water treatment/release		
Fixed-cost Contract Specialty Contractor) ^(c)	750,000	~ 2
Utility support	usc	-
Radioactive Waste Disposal from Water Treatment: ^(c)		
5 High-Integrity Containers	61,803 ^(h)	<0.1
Protective clothing & equipment services (vendor only)	22,176 ⁽ⁱ⁾	-
Totals (w/o contingency)	14,041,377	~45.7

- (a) The number of significant figures is for computational accuracy and does not imply precision to that many significant figures.
- (b) A dash means not applicable, unless indicated otherwise.
- (c) See text for details.
- (d) "usc" indicates that costs are included in the utility staff costs during this period.
- (e) Based upon disposal cost information provided by Chem-Nuclear Systems, Inc. for the Barnwell site (see Appendix B). The total estimated burial cost for the 18 HICs is \$1,731,780.
- (f) Assumes the use of various pumps, including the recirculation pumps, for about 2 weeks consumes approximately 2,100 MWh of electricity as described in NUREG/CR-0672. ⁽²⁾
- (g) Undistributed cost.
- (h) Based upon disposal cost information provided by Chem-Nuclear Systems, Inc. for the Barnwell site (see Appendix B). The total estimated burial cost for the 5 HICs is \$373,800.
- (i) Based upon discussions with industry personnel, these services are estimated to be approximately \$21/day/person for rad-zone workers only.

- No water rinses are needed following chemical decontamination; the solutions will be drained, treated, and released according to applicable release standards; the systems will be left dry.
- Decontamination does not permit release of the components for unrestricted use because of tightly adherent residual contamination; controlled removal and final disposition (either burial or shipment to a commercial decontamination/volume reduction facility) will be required.

- Removal of components after decontamination requires the same labor as without decontamination because the components are still contaminated. The same precautions and preparations, contamination controls and packaging would be required. However, significantly less occupational radiation dose would be incurred and fewer personnel would be needed to accomplish the work.
- The postulated decontamination factor (DF) for the full-system chemical decontamination of the reference BWR is a DF of 10.
- Decontamination dose reductions are accounted for in subsequent removal of components after chemical decontamination for each of the three decommissioning alternatives, as applicable.
- The waste disposal costs presented in this appendix were specifically developed for the reference BWR, which is located within the Northwest Compact, assuming disposal at the U.S. Ecology site in Richland, Washington. To provide additional information, the costs also were estimated for disposal of the reference BWR wastes at the Barnwell site in Barnwell, South Carolina.

G.1.2 Discussion

Just as in NUREG/CR-0672,⁽²⁾ the principal systems considered for chemical decontamination in this reevaluation study are the reactor coolant system (RCS) and inter-tied systems, i.e., those systems that contain deposited contamination representing a radiation dose rate hazard for further decommissioning effort once they are drained and dried. In the opinion of the authors, chemical decontamination of these systems is a necessary step even if the current decommissioning plan calls for placing the facility in safe storage for an extended period of time, since completing the decontamination step removes most of the internal radioactive contamination and leaves all options open for changing the decommissioning plan at a later date. It is unlikely that a chemical decontamination could be carried out without major equipment renovation after the facility has been in safe storage for a few years, due to equipment deterioration. If a decision were made to dismantle after 5 to 10 years of safe storage, the radiation exposures encountered would be about a factor of 10 greater if the plant had not been previously decontaminated. It should be noted that even without chemical decontamination, the amount given for water cleanup prior to release (shown in Table G.1 would still be incurred.

The chemical decontamination project is postulated to be done by an experienced specialty contractor (vendor) well established in systems decontamination and associated integrated outage activities, under contract to the utility. During the planning and preparation stage, procedures and results from previous decontamination efforts will be reviewed to obtain maximum benefit from previous experience. Then, with the reactor completely defueled and the pressure vessel head reinstalled, the RCS and associated systems will be isolated from the spent fuel pool system. All possible branches of the systems will be operated during the decontamination period, with heated solution circulating through pumps, heat exchangers, piping, and tanks, and returning to the RCS loop for reheat and cleanup.

Current information on chemical decontamination of light-water reactors was obtained from a comprehensive review of the literature and from discussions with senior staff of PNS. The PNS staff emphasized that it should be recognized that: 1) full-system chemical decontaminations of light-water reactors are very plant-specific; 2) the amount of radwastes depends on the solvent used for the job; and 3) a first-of-a-kind full-system chemical decontamination of a BWR could cost in the range of \$20 to \$25 million. However, when such decontaminations of BWRs become "routine" (defined here as after at least three such campaigns have been successfully completed), a cost in the range of \$10 to \$15 million could be anticipated for a full-system chemical decontamination. This latter cost includes mobilization/demobilization costs, all contractor staff costs, the costs of chemicals, mobile equipment, hoses, etc., onsite radwaste processing, high-integrity containers (HICs) for the resultant waste, and transportation costs, but not final burial costs of the HICs.

Based upon the information obtained from PNS staff, the following schedule, dose and cost values, and volumes of radwastes associated with a specialty contractor's effort are postulated to be reasonable estimates for use in this reevaluation study:

- About 4 months is estimated for the completion of the full-system chemical decontamination project at the reference BWR. About 2 months is estimated for mobilization, including reactor-specific indoctrination training, equipment installation, tie-ins, etc.; 1 week around-the-clock for decontamination process application; 1

month to process the waste onsite (outside the reactor building such that these latter activities do not interfere with other decommissioning tasks) and for concurrent treatment and release of the water from the reactor systems; and 3 weeks for demobilization and shipment of the resultant wastes.

- A 3- to 5-step process will be required to obtain the desired results from the decontamination process.
- An occupational radiation exposure in the range of 30 to 50 person-rem could be expected for the decontamination effort. For purposes of this study, a mid-range value of 46 person-rem has been assigned to this work.^(b)
- In consideration of the uncertainties associated with a full-system chemical decontamination to be done in the future, including the proprietary constraints and the highly competitive business climate for this type of work, and based upon an anticipated cost in the range of \$10 to \$15 million, a mid-range cost of about \$12.5 million has been assigned to the work.
- Somewhere between about 2,400 and 3,500 ft³ of dewatered resin, Class A waste, containing about 5,000 curies of activity, could be expected to result from the full-system chemical decontamination job. A mid-range volume of about 3,000 ft³ is used in this study.

The polyethylene HICs postulated to be used for the radioactive resins resulting from the chemical decontamination operations must be dewatered before burial. The HICs also are assumed to contain a nominal 15% void. For the HICs postulated for use in this study (burial volume of 5.72 m³ or about 200 ft³/HIC), about 170 ft³ of waste resin/HIC (assuming a 15% void) results in about 18 HICs requiring disposal at the low-level waste burial ground at Hanford. Nine of 18 HICs are postulated to require engineered concrete barriers for disposal, since they are assumed to contain 2% to 6% chelates. The remaining 9 HICs are assumed to contain <0.1% chelates. It is further assumed that the contact readings on the HICs are about 80 R/hr. Based upon these assumptions, it is calculated that each HIC contains approximately 278 curies.

Under the postulated conditions just described, the estimated burial cost for the 18 HICs given in Table G.1 is \$404,498, for disposal at the U.S.

(b) It is postulated that the vendor's staff receive about 30% of the dose and the utility staff about 70%, based upon information contained in Reference 3.

Ecology facility at Hanford, and is \$1,731,780 for disposal at the Chem-Nuclear facility at Barnwell (see Appendix B).

Upon completion of the chemical decontamination process, the solution remaining in the systems cannot be released without some form of additional treatment since the water is expected to still contain measurable radioactivity. Therefore, the water will be treated by batch process by a specialty contractor (sampled, analyzed and treated again, as necessary until release criteria are met) and released according to applicable release standards. The decontaminated systems will be left dry. As shown in Table G.1, the cost for final water treatment is estimated to be \$750,000. It is further estimated to take 30 days, working 21 shifts per week. Since the waste activity concentration is not well known at this point, it is difficult to predict with confidence either the occupational radiation dose or the volume of waste that will result from these activities. However, for the purpose of this study, 1) an occupational radiation exposure of approximately 2 person-rem is anticipated for these activities; and 2) it is roughly estimated that an additional five 5.72-m³ HICs of spent ion exchange resin could be required. Assuming disposal at the U.S. Ecology facility at Hanford (see Appendix B), the cost of subsequent disposal of the HICs (Table G.1), estimated to be \$61,803,^(c) is assumed to be the responsibility of the utility. For disposal at the Chem-Nuclear site at Barnwell (see Appendix B), the total estimated burial cost for the 5 HICs given in Table G.1 is \$373,800.

The utility is responsible for the costs of indoctrination training for all non-utility staff coming onsite; energy; protective clothing and equipment services; routine radwaste collection, processing, and disposition; and final disposal of the decontamination wastes. Also, security measures required during the chemical decontamination project are assumed to be the responsibility of the utility.

In addition to the specialty contractor's (vendor's) staff, which is assumed to be 18 people, the utility must provide technical support. A description of the optimum project staff is provided in Reference 4, based upon

(c) Based upon disposal cost information for HICs provided by U.S. Ecology (see Appendix B); assumes < 0.1 % chelates, < 50 curies, and < 5 R/hr contact readings.

recent chemical decontaminations at boiling water reactors. This study's approach is similar. Typical support staff for the reference BWR are listed in Table G.2.

TABLE G.2. Station Staff Support for Chemical Decontamination

<u>Position</u>	<u>Estimated Number Required</u>
Station Project Manager (days) or Responsible Engineers (one/shift)	3
Plant technical support (one per shift)	3
Head liaison engineer (one per shift)	3
Consultant (one per shift)	3
Dedicated health physics support (2 per shift)	6
One chemist plus one chemical technician per shift	6
Pipe fitters (two per shift on standby)	6
Instrument tech. and electrician (1 each/shift on standby)	6
Laborers (two per shift on standby)	6

The above-listed persons are part of the existing Period 2 utility staff.

In addition, PNS staff related that their experiences to date with chemical decontamination of drain systems indicates that it is probably not cost-effective, nor practical, to chemically decontaminate reactor drain systems prior to disassembly. Therefore, the piping in the drain systems at the reference BWR is not postulated to be chemically decontaminated before disassembly.

G.1.3 Estimated Task Schedule and Sequence

The overall task schedule and sequence of events for performing the chemical decontamination is given in Figure G.1. It can be seen from the figure that the contractor's total time onsite, including mobilization and demobilization, is estimated at 4 months. It is further estimated to require a 12-month lead time to scope and schedule the work, develop the plans, procedures, training requirements, and calculations associated with the chemical decontamination project.

- (a) Steps 1, 2, and 4 are done by the utility.
 (b) Eighteen people are used for this work.
 (c) Utility staff support of the specialty contractor (SC) minimizes costs. (3) See text for utility staffing details.

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FIGURE G.1. Estimated Task Schedule and Sequence for Chemical Decontamination

G.2 SURFACE DECONTAMINATION

In this study, all contaminated horizontal surfaces are assumed to be washed using a manually operated cleaning system which washes the surface using high-pressure (250 psig) jets and collects the water and removed material simultaneously using a vacuum collection system. This system permits excellent cleaning while avoiding recontamination due to dispersion of the water. The same system, employing modified cleaning heads, is used to wash vertical or overhead surfaces. An additional 20% of labor time is postulated to be required for the vertical and overhead surfaces cleaning.

In general, the water-jet/vacuum decontamination activity can proceed independently of the recirculatory method. The specifics of the water-jet/vacuum decontamination activity are described in detail in Appendix C, together with the costs per square foot of surface cleaned.

G.3 REMOVAL TECHNIQUES AND EQUIPMENT

The various removal techniques and equipment assumed for the removal of contaminated and uncontaminated structural materials are discussed in subsequent sections.

G.3.1 Removal of Contaminated Concrete Surfaces

Those contaminated horizontal surfaces which are not sufficiently decontaminated using the high-pressure washing system (see Section G.2) are removed using a commercially available pneumatically operated surface chipper removal system. Commercial systems which use very-high-pressure water jets for surface removal are also available. For this analysis, a specific commercial system manufactured by Pentex, Inc. is assumed (the Moose™ and associated smaller units), which chips off the surface and collects the dust and chips into a waste drum, and filters the air to prevent recontamination of the cleaned surfaces.

It is postulated that the depth of concrete to be removed will vary from location to location, but that on the average, removal of about 1.0 in. will be sufficient to remove the residual radioactive contamination. Because the removal system selected removes about 0.125 in. of material per pass, an average of 8 passes will be required over the contaminated areas. Because the Moose™ cannot get closer to walls than about 6 inches, smaller units of the same type are used to clean the perimeter areas of rooms. For this analysis, it is postulated that the perimeter areas comprise about 20% of the total surface area to be cleaned. For 1-pass removal operations, the Moose™ is assumed to clean at the rate of about 115 ft² per hour. Smaller units clean at the rate of about 30 ft² per hour. Combining these rates by weighting with the fractions of surface removed by each unit, the nominal removal rate becomes about 100 ft²/hr. Assuming an average of 8 passes are required, the effective average cleaning rate becomes about 12.5 ft²/hr.

The smaller units (Squirrel III™ and Corner Cutter™) could also be utilized on vertical surfaces. The cost per square foot for vertical surfaces would be approximately four times the cost for horizontal surfaces, due to the lower removal rates of the smaller units. Staffing of the crews and unit cost factors are developed in Appendix C and are not repeated here.

G.3.2 Cutting Uncontaminated Concrete Walls and Floors

All concrete walls and floors are assumed to be uncontaminated or to have been decontaminated before sawing operations begin. Thus, the costs of cutting uncontaminated concrete to provide access to other components are considered to be cascading costs.

Material and labor costs for cutting uncontaminated concrete walls and floors are based on the length of cut, measured in inch-feet (e.g., a cut 1-inch-deep, 1-foot-long, equals 1 inch-foot). Based up discussions with an industry source, 60 inch-feet per hour is used in this study as a reasonable cutting rate.

Cutting of concrete walls is accomplished using a wall-saw on a mechanically driven track system. Cutting of concrete floors is done with a slab-saw. Scaffolding will be used as needed for installing and removing the track system when sawing openings in walls. The concrete pieces are cut into various shapes and sizes, depending upon the size of the openings desired. No packaging is contemplated, since the removed material is postulated to be uncontaminated. The removed pieces of concrete are transferred to nearby storage areas. The basic operations for cutting concrete walls and concrete floors, together with the estimated clock times required to accomplish each operation, the staffing, and the unit costs, are developed in Appendix C.

G.4 WATER TREATMENT AND DISPOSAL

Selected water treatment and solidification operations associated with decommissioning the reference BWR are described in this section.

G.4.1 Spent Fuel Pool Water Treatment and Disposal

Once the spent nuclear fuel inventory has reached zero, approximately 5 years after final shutdown, the spent fuel pool (SFP) water cannot be released without some form of additional treatment since the water will contain measurable radioactivity. Therefore, the water will be treated by a specialty contractor using a batch process (sampled, analyzed and treated again, as necessary until release criteria are met) and released according to applicable release standards. The SFP and associated systems will be left dry.

Discussions with a qualified vendor have suggested that the estimated vendor's cost for this task would be about \$450,000. Subsequent transportation costs for the resultant radioactive wastes are included in this cost estimate, but radwaste burial costs are the responsibility of the utility. The effort is estimated to take 18 consecutive days, working 21 shifts per week (6 people per shift). Protective clothing and equipment for vendor's staff are expected to cost the utility about \$ 6,804.

Since the SFP water quality and extent of deposit accumulation from the fuel assemblies are not well known at this point, it is difficult to predict with confidence either the occupational radiation exposure or the volume of waste that will result from these activities. However, for the purpose of this study, it is assumed that 1) an accumulated occupational radiation dose of approximately 2 person-rem will result from these activities; and 2) that about three 5.72 m³ HICs would be required.

Based upon information contained in Appendix B, the cost of three HICs is estimated at \$23,475. The transportation cost for the HICs from the manufacturer's facility to the plant site is estimated at \$4,210, based upon a direct quote from the Tri-State Motor Transport Company. Twelve days of cask rental charges comes to an estimated \$15,000. Burial costs at U.S. Ecology are estimated at \$40,544. Burial costs at Barnwell are estimated to be \$224,280, based upon the assumptions that individual HICs contain less than 50 curies of activity each and have surface contact readings of less than 20 R/hr.

A summary of the total estimated costs and occupational radiation dose for this activity is presented in Table G.3.

G.4.2 Temporary Waste Solidification System

The specifics associated with the decontamination of surfaces using high-pressure water wash/vacuuming are described in detail in Appendix C and are not repeated here. However, the water usage and associated liquid radwaste generation, treatment, transport and disposal are addressed here. At the calculated generation rate of 1 gallon per minute of system operation (see Appendix C for details), it is estimated that approximately 12,156 gallons of

TABLE G.3. Summary of Estimated Costs and Radiation Dose for Spent Fuel Pool Water Treatment and Subsequent Waste Disposal

<u>Cost Item</u>	<u>Estimated Cost (1993\$) ^(a)</u>	<u>Estimated Dose (person-rem)</u>
Fixed-cost Contract ^(b)	450,000	~1.2
Transport of HICs to Plant Site from Mfgr. ^(c)	4,211	-- ^(d)
High-Integrity Containers ^(e)	23,475	--
Cask Rental ^(f)	15,000	--
Transportation	-- ^(g)	--
Burial ^(h)	<u>40,554</u>	--
Totals	533,018	~1.2
Protective Clothing & Equip- ment Services (vendor only)	6,804 ⁽ⁱ⁾	--

(a) The number of significant figures is for computational accuracy and does not imply precision to that many significant figures.

(b) See text for details.

(c) Based on quote from Tri-State Motor Transport Company.

(d) Dashes mean no dose associated with this item.

(e) Based on Table B.3.

(f) Based on Table B.2.

(g) Included in \$450,000 Fixed-Cost Contract.

(h) For disposal at the U.S. Ecology facility at Hanford. For disposal at the Barnwell site (see Appendix B), the total estimated burial cost for the three HICs is \$224,280.

(i) Included in Period undistributed costs.

high solids, low activity waste solutions will result from the surface cleaning tasks at the reference BWR. It is postulated that a transportable evaporator-solidification system, together with specialty contractor operating personnel, will be used to provide this additional liquid radioactive waste handling capability and final cleanup capability at the reference BWR.

Based upon discussions with senior staff at PNS, the waste solutions are estimated to be processed for disposal (i.e., evaporated/solidified in four 5.72 m³ HICs) at a unit cost of about \$10/gallon. Mobilization/demobilization costs add another \$20,000, resulting in a total cost of \$141,560 for this fixed-price contract. Overall, about 26 days are required to complete the task, including mobilization/demobilization. Occupational radiation exposure is anticipated to be about 0.3 person-rem.

The cost of the HICs, cask rental, transportation and final disposal of the HICs are the responsibility of the licensee. Based on information contained in Appendix B, the HICs are estimated to cost \$31,300; 14 days of cask rental come to \$17,500; total transportation costs are estimated at about

\$28,589; and disposal costs at U.S. Ecology are estimated at \$49,442. Burial costs at Barnwell are estimated at \$293,300. The burial cost estimates are based upon the assumptions that individual HICs contain less than 5 curies of activity each and have surface contact readings of less than 5 R/hr. A summary of the total estimated costs and occupational radiation exposure for this activity is presented in Table G.4.

TABLE G.4. Summary of Estimated Costs and Radiation Dose for Temporary Waste Solidification System Operation and Subsequent Waste Disposal

<u>Cost Item</u>	<u>Estimated Cost (1993\$)</u> ^(a)	<u>Estimated Dose (person-rem)</u>
Fixed-cost Contract (Specialty Contractor) ^(b)	141,560	<0.3
<u>Radwaste Disposal</u>		
High-Integrity Container ^(c)	31,300	
Cask Rental ^(d)	17,500	
Transportation ^(e)	28,589	
Burial ^(f)	<u>49,442</u>	
Subtotal	<u>126,831</u>	<u><0.02</u>
Totals	268,391	0.32

(a) The number of significant figures is for computational accuracy and does not imply precision to that many significant figures.

(b) See text for details.

(c) Based on Table B.3.

(d) Based on Table B.2.

(e) Based on direct quote from Tri-State Motor Transport Company. Includes transportation charges for the empty cask from Barnwell, SC to WNP-2, the loaded casks from WNP-2 to the U.S. Ecology site at Hanford, and the empty cask back to Barnwell, SC.

(f) For disposal at the U.S. Ecology site at Hanford. For disposal at the Barnwell site (see Appendix B), the total estimated burial cost for the four HICs is \$293,300.

G.5 REFERENCES

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APPENDIX H

ESTIMATED NON-RADIOACTIVE DEMOLITION
AND SITE RESTORATION COSTS FOR WNP-2

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APPENDIX H

ESTIMATED NON-RADIOACTIVE DEMOLITION AND SITE RESTORATION COSTS FOR WNP-2

The purpose of this study is to provide current bases in 1993 dollars for demolition cost estimates for non-radioactive demolition and site restoration for the reference Boiling Water Reactor (BWR), WNP-2 and to upgrade NUREG/CR-0672. This study addresses changes in demolition costs, technology, and regulations to date and subsequent to the original decommissioning cost studies of the reference BWR in 1978.

Once all radioactive materials in a boiling water reactor (BWR) are removed or decontaminated, the Nuclear Regulatory Commission (NRC) is requested to terminate the possession-only license and release the site for unrestricted use. Following license termination, the utility decides whether the remaining on site structures are to be demolished or left standing. Although NRC does not exercise jurisdiction over removal of non-contaminated structures and restoration of the site, development of demolition and site restoration costs is presented in this appendix for completeness. The costs were calculated as if the demolition contractor were bidding on the job.

H.1 SUMMARY

Technological improvements in demolition equipment and techniques over the past 15 years have improved safety and general efficiency; but have not overcome the persistent difficulties of demolishing the strongest nuclear structures.

Recycling of economically valuable resources was practiced in the demolition industry prior to its present emphasis, and remains a strong consideration. The recycling of concrete by on-site crushing is a relatively recent general practice.

In addition to general inflation, there has been a continuing extension of regulatory authority over general demolition and disposal. Costs of special handling of asbestos material and lead containing material have been greatly increased. Costs of disposal of demolition debris have far exceeded general inflation.

The total estimated cost of demolition for the reference BWR of \$48,238,100 is summarized in Table H.1. below.

TABLE H.1. Summary of Estimated Demolition and Site Restoration Costs For WNP-2

<u>Building Name, Description</u>	<u>Building #</u>	<u>Estimated Demolition Costs (1993 Dollars)</u>
Reactor Containment and Building	2	\$14,313,600
Turbine Generator Building	4	10,110,100
Radwaste and Control Building	3	4,964,700
Cooling Towers	n/a	2,911,100
Diesel Generator Building	7	670,600
Plant Support Structures	34	3,143,200
Service Building	27	388,000
Circulating Water Pumphouse	30	289,800
Rifle Range	n/a	61,500
Miscellaneous Light Structures	n/a	511,900
Site Restoration	n/a	1,426,000
Copper Salvage Allowance	n/a	<u>- 200,000</u>
Sub-total		38,590,500
25% Contingency		<u>9,647,600</u>
Total		\$48,238,100

H.2 GENERAL METHODOLOGY FOR DEMOLITION COST ESTIMATES

Basic structural characteristics which are relevant to demolition techniques were examined for the major plant structures, such as

- Physical Arrangement of the Plant
- Structure Seismic Classifications
- General Degree of Steel Reinforcing

- Height Above Grade of Various Structures
- Areas of Buildings and Footprint Areas
- Quantities of Reinforced Concrete, Steel, and Debris
- Disposal Sites for Concrete and Debris

Demolition quantity estimates in cubic meters (m^3), square meters (m^2), and megagrams (Mg) were taken from the demolition "quantities" described in NUREG/CR-0672, and generated from information furnished by WPPSS. Appropriate unit costs were then applied to these quantities to develop cost estimates in 1993 dollars.

For certain "light" structures (such as warehouses, sheds and other miscellaneous "Butler Buildings") no material quantities, per se, were developed as an intermediate step in determining the demolition cost estimate. For these items, the contractor examined photographs and construction drawings, when available, together with a site visit to determine a unit cost per square meter for the individual buildings. These unit cost estimates are based on personal experience from demolishing similar structures. The building footprint (surface area of foundation) and number of stories were furnished by WPPSS or determined from plant drawings. The unit costs were then applied. Finally a 25% contingency factor was applied to the site's total cost to account for unforeseeable changes of conditions and/or costs.

H.2.1 Assumptions For The Development Of Cost Estimates

The analyses of the effort and costs involved in demolishing the reference BWR structures and restoring the site are based on the following assumptions:

- All above-ground structures on the plant site are demolished and removed.
- Building structures are to be demolished down to 1 m below grade; holes are broken in the sub-basement floors for drainage; the empty below-grade volumes are to be filled to within 1 m of the

grade level with concrete rubble; and the last meter is backfilled with 0.85m earth and 0.15m topsoil.

- The demolition contractor has salvage rights, with these values reflected in the estimated costs of the respective structures. These values assume completely depreciated equipment after the useful life of the plant has expired.
- Excess rubble may be disposed below 1 meter below grade level onsite.
- Other debris is to be disposed of at the regional landfill at Roosevelt, Washington, some 100 km from the site.
- Costs associated with cement asbestos board (CAB) cooling fins and other CAB in the cooling towers are included in this estimate. Possible asbestos containing roofing materials on various buildings are included in these costs. Friable asbestos, such as found in pipe insulation and gaskets, is not included in this study.
- Costs associated with "normal" spillage of petroleum products and cleanup of the resultant contaminated earth are considered in this study as a contingency cost.
- Costs associated with compliance with the Lead Hazard regulations are considered in this study as a contingency cost.

H.2.2 Factors Affecting Estimation Of Demolition Costs

Change in cost estimates for demolition of the reference BWR plant are influenced by regulatory requirements, available demolition technology, labor rates, equipment requirements, disposal costs for debris, salvage, the addition and upgrading of buildings and structures on the site, and problem areas in estimating demolition costs.

H.2.2.1 Regulatory Requirements

EPA and OSHA-initiated regulations and interpretations affect this study principally in the areas of asbestos, lead, and debris disposal

requirements. There is a continuing addition of materials to the special handling categories. Non-friable Cement Asbestos Board (CAB) and roofing material are being regulated, where they were not 15 years ago. Fluorescent light bulbs and ballasts have been added. Lead paint has also been added. Fill sites that were considered safe 15 years ago are not acceptable today under current interpretations. Current regulatory costs are incorporated into this study; but the prediction of future regulatory requirements falls under the contingency allowance.

H.2.2.2 Demolition Technology

A new generation of hydraulic excavators with attachments such as hammers, grapples, shears, and crushers has developed. The diamond rope saw is a recent development that has potential application in heavy demolition, and it is cost effective in certain circumstances. Crane and explosives technologies have steadily improved.

The advance in demolition techniques and equipment most directly related to Seismic Class 1 structures has been the development of the hydraulic hammer. The hammer is taking over work previously only done by the crane and ball-and-chain and drilling and explosives. However, the crane continues to have greater reach than the hammer, while explosives continue to have far more breaking power than the largest hammers. Progress has been evolutionary, and the same ultimate limitations in dealing with reactor containment vessels that we faced in 1978, we still face in 1993.

H.2.2.3 Miscellaneous Factors

Changes in labor rates, equipment costs, and salvage have evolved along lines of general inflation. Disposal costs for demolition debris have increased nearly ten-fold in the past ten years. The addition and upgrading of buildings and structures is site-specific; while they add to decommissioning costs, they do not affect other costs.

H.2.3 Problem Areas In Estimation Of Demolition Costs

No reliable precedent exists for estimating the costs of demolishing the heavily reinforced, massive Seismic Class 1 reinforced concrete structures of the reference BWR. The Shippingport reactor is the closest example, but its walls were only half the thickness and reinforcement of the BWR. Since difficulty increases geometrically with both strength and thickness, one to one comparisons would not be reliable. Shippingport demonstrated that the larger hydraulic hammers can break up substantial walls and floors that could previously only be broken by explosives. Limited experience at WNP-5 at Satsop, Washington, indicated that such hammers were ineffective. The estimates presented in the appendix result from comparisons of the reference BWR structures with industrial-type structures that have been demolished. In addition, judgment factors are applied, based on experience, for the massiveness, grade of concrete, extra-heavy reinforcing steel, and the height of the structures.

An area of concern in estimating demolition costs has been the cost assigned to hammering and separating the concrete from the rebar, both with and without weakening by explosives. Concrete in the reference BWR structures is high quality, extra thick, well aged, and well bonded to extra-heavy reinforcing steel. Most of the structures have confining and self-reinforcing cross walls that restrict access and make use of equipment difficult. Singly, these factors tend to increase demolition costs markedly, and their combination compounds the effect. In spite of the great improvements made in hydraulic attachments, a large "if" remains. In the case of the reactor containment vessel, the reinforcement is so massive that drilling for explosives is extremely difficult to the point of practical impossibility. The drills continually encounter steel and drills aren't designed to drill through massive steel. Diamond rope saw cutting has potential. Assigning dollar values to these factors relies heavily on subjective judgment.

H.3 DEMOLITION CONSIDERATIONS

All above-ground structures on the plant site will be demolished and removed down to 1 meter below grade, and all site features restored, by grading and planting, to "Native" condition.

Major structures include the Reactor building, Turbine building, Radwaste Complex, Diesel Generator building, Plant Support Facility, Plant Engineering Building, Service building, Circulating Water Pumphouse, Makeup Water Pumphouse, Spray Pond Complex, Rifle Range, Records Management building, Document Storage building, and five warehouse buildings. The plant layout and major structures are illustrated in Figures B.1 through B.6 of Appendix B. Portable trailers are not included in these tables since they will either be removed prior to demolition or their resale value would offset the costs of removal.

H.3.1 Demolition Methods For Seismic Class 1 Structures

In the cases of the Reactor building and the Turbine Generator building, building demolition proceeds from the top down after machinery and equipment are removed. Where a bridge crane is in place, it is used for moving out the existing machinery and moving in the demolition equipment and supplies, using the existing lifting shaft. During floor-by-floor demolition, the lifting shaft is used to drop the rubble. Where floor openings are needed for rubble dumps, but do not already exist, they can be cut down to ground or basement level.

Typical demolition equipment required on the top working floor (for removing the roof, preparing the work floor for breaking by hydraulic hammer, drilling for placement of explosives, and removing rubble) consists of manlifts, a crane, hydraulic excavators with hydraulic hammers, shears and grapple attachments and drilling machines. (Hydraulic drilling machines are now being manufactured as attachments to hydraulic excavators.)

The top structure of a steel-capped building is conventionally removed by reversing the construction procedure. A hydraulic crane and man-lifts positioned on the floor below the roof, or on the ground, are used to remove the roofing, steel siding, and structural framework. Alternatively, the steel superstructure above the concrete work-deck may be removed by pullover.

Pullover can be accomplished by cutting loose and pulling out the end walls, then weakening and pulling the structure sideways. The walls are to be braced and rigged for pulling before weakening them.

This procedure is in common use, but it should be overseen by an experienced superintendent. An appropriate engineering and safety plan is to be drawn up and reviewed and enforced for this and every other wrecking operation.

When the upper steel building has been removed down to the concrete work-deck, lift up drilling and hammering, grappling, and concrete crushing equipment to the work deck to proceed with the concrete removal. The drilling and explosive procedures are necessary for the reactor containment structure. In case of difficulty in locating the rebar patterns to find starting positions for down-drilling, the hydraulic hammers can be used to expose the rebar.

The general sequence for removal of the concrete would be to down-drill the shield and any other massive walls and floors for explosives. Blast half the floor, walls, and shield, then use hammers and shears and grapples to break through the broken floors to clear a working space, and, if possible, build a ramp down to the next lower level. Move equipment to a protected place on the lower floor or to the ground by crane, then blast the second half of the upper floor and walls and shield. From the lower floor working space, demolish the second half of the upper floor. Repeat the sequence floor by floor to the ground. Continually review the engineering and safety plan as the work progresses.

H.3.2 Transport Of Demolition Debris

Loading and hauling demolition debris generally costs more than loading and hauling dirt or gravel. Demolition trucks are not loaded or dumped as fast as dirt and gravel trucks because of their longer, higher-sided trailers and the uneven sizes of the materials they haul. Hauling costs in the wrecking industry reflect these conditions.

Concrete rubble from the reference BWR may be buried on site. Demolition debris and asbestos are to be trucked to the Rabanco Regional Landfill at Roosevelt, Washington, some 100 kilometers distance.

H.3.3 Salvage and Recycling Considerations

In this study, structural steel has been given a nominal net value of \$50 per ton (\$55/ Mg) stockpiled on the ground. The costs of loading, hauling, and disposal (sale) are borne by the contractor from the point of stockpile. This appraisal is reflected in a lowered per unit price for steel buildings from what they otherwise would be. The recycle rate for structural steel approaches 100%.

Reinforcing bar is generally accounted for by moderating the unit demolition price rather than a separate itemization. The cost of removing unanticipated reinforcing bar greatly exceeds any salvage value of the rebar. Once in a stockpile, the costs of sorting, cutting, loading, shipping, and disposal costs are borne by the contractor, not as a job cost. When concrete is recycled, 100% of the related rebar is recycled.

Scrap tin (light sheet metal) generally does not pay for its preparation and hauling costs. It is not considered to be of any net scrap value or allowance; however, to avoid disposal costs, close to 100% of tin is recycled as scrap metal.

Equipment will be thoroughly depreciated and presumably obsolescent by the time the plants are to be dismantled. It is highly specialized and subject to technological change. Even when relatively new and unused, its sales value has been a disappointing 7% of cost (Satsop Plant WNP-5). Its principal value after use will be as scrap for its copper content. This copper content is included in the consideration for copper salvage. Close to 100% of equipment is recycled for its metal content.

Copper is a significant consideration in demolition of an electrical generation plant such as this. Estimation is made difficult by the fact that a portion of the copper will be radioactively contaminated and must be disposed of as such. A rough estimate is that there is a net value of copper of \$200,000 which could be recovered by the contractor. All accessible copper is recycled.

It is recommended that the demolition bid invitation specify an allowance to the owner of \$200,000 for copper salvage, which is to be deducted from the total bid price. This clear definition has several

values to both parties. The owner(ratepayers) is assured of consideration for the copper salvage value. It clearly gives the contractor authority and responsibility for the security of the copper. (Copper is frequently "lost, strayed, or stolen".) It brings the contractor "on board" with the owner to prevent non-radioactive copper from going to the radioactive landfill along with externally contaminated conduit that it might be inside. It gives the contractor access to early cash flow when large expenditures are being made, but before payments have been received.

Concrete recycling generally costs some \$5.00 per truck yard/ton beyond the costs of nearby free disposal. However when the waste material must be transported any distance or disposal fee paid, it is generally cheaper to crush and stockpile the reusable material on site. Where there is a reuse for the material on site or a sale nearby, it costs less to recycle the concrete than to landfill it. On balance, the net cost of specifying the recycling of concrete and stockpiling it on site is negligible. It is recommended that recycling of concrete, not used to fill voids under structures, be specified. The cost estimates are unchanged because the economic opportunities equal the added costs.

H.4 UNIT COSTS

Where quantities of material were available for separate structures, cost estimates were based on volumes and tonnages. Where quantities were not readily available, square footages were used. Cross checks were calculated to relate known quantities and footages vs. footages only, to verify the correlation between the two. Primary structures were mainly estimated based on quantities. Most secondary structures were estimated on a square footage basis related to commercial experience.

It is to be noted that when concrete is broken, there is an expansion factor of approximately 2 to 1. In this study, the in-place solid measure has been used for consistency to describe the quantities in primary breaking, secondary breaking, and disposal. In commercial practice, the secondary breaking and disposal is commonly calculated in "truck measure". To convert the in-place measurements used here

into truck measure, the quantities are to be doubled and the unit cost halved. The total cost remains unchanged.

Unit cost figures for removal of steel; drilling/blasting, secondary treatment and loading/hauling of reinforced concrete; and removing "light" structures were developed to cover labor, equipment, supplies, overhead, profit and taxes. Items included are base pay, FICA, unemployment insurance, bodily injury and property damage insurance, equipment rental and operating costs, fuel and supplies, and contractor overhead and profit. The unit costs do not include contractors' performance bonds. Washington State Sales Tax, which is applicable to the overall demolition contract price, is not included in the unit prices, but is itemized separately according to Washington State law.

H.5 EQUIPMENT REQUIREMENTS FOR DEMOLITION

A listing of the major equipment requirements is included as Table H.2. It is not intended to list every piece of equipment that could be used, but to give a basic capability to perform the essential tasks. Each contractor would vary these equipment requirements to suit their experience and personal preferences.

H.6 DEMOLITION AND SITE RESTORATION COSTS, WNP-2

The estimated costs for the non-radiological demolition and site restoration of the reference BWR after decommissioning by immediate dismantlement are developed in this section. Tables H.3 through H.7 show demolition cost estimates for specific major structures. Tables H.8 through H.12 summarize cost estimates for demolition of miscellaneous lighter structures & buildings, and Table H.13 details site restoration cost estimates. These costs include labor, supplies, insurance, overhead, and contractor profit, but exclude State Sales Tax and contractors' bonding costs. They show allowance for copper salvage as a separate line item. A 25% contingency is added to account for unknowns. Discussions of specific demolition methods and the derivation of cost estimates for the various plant structures are given in the following subsections.

TABLE H.2. Equipment Requirements for Demolition, WNP-2

<u>Equipment Item</u>	<u>Application</u>	<u>Number Required</u>
300 ton Crane	High lifts of heavy loads	1
100 ton Crane	Lifts and ball-and-chain	2
80 ton Hydraulic Crane	Dismantle roof structures	2
1m3 Hydraulic Excavator	Clean up and loading debris	6
3m3 Hydraulic Excavator	Operates Hammer and Shear	6
5m3 Hydraulic Excavator	Hammer, Shear, Grapple & Pulverizer	6
Komatsu 1000 Excavator	Heavy duty hammer and Shear	1
983 Track Loader	Cleanup and rough grading	2
Air Track Drills	Drilling holes for explosives	4
Air Compressors	Air supply for pneumatic tools	6
Hydraulic Hammers	Breaking concrete	12
Hydraulic Shears	Cutting rebar, structural steel and pipe	12
Hydraulic Grapples	Handling of concrete and steel	6
Hydraulic Pulverizers	Crushing of concrete	6
Brokk Hydraulic Units	Remote control breaking of concrete & steel	4
Diamond Rope Saw	Cutting of massive concrete	1
700 & 900 Series Bobcats	Rehandling and moving of Debris	14
Hydraulic Drill	Drilling holes for explosives	2
Oxy/acetylene Torch Outfit	Cutting steel	20
Plasma Arc Cutting Outfit	Cutting steel and non-ferrous metals	20
Demolition Truck/Tractor	Hauling debris	6
Rigging	Moving equipment and material	As req.
Breaking Balls	Breaking concrete	4
Battering Ram	Breaking concrete	1
Misc Equipment & Supplies	Safety equipment, hand tools, job trailers, etc	As req.

H.6.1 Reactor Building And Primary Containment Vessel

The biological shield wall is 1.54 meters thick and heavily reinforced with four courses of #18 rebar (5.7cm) on 24 cm centers, horizontally and vertically. With overlaps, it is virtually a series of steel walls. This reinforcing would seriously interfere with drilling for explosives from the sides. It would also seriously interfere with diamond drilling, coring, or sawing, since the steel "eats up" the diamonds. Limited testing at Satsop, Washington (WNP-5) has indicated that the largest hydraulic hammers cannot penetrate from the side.

The vertical "walls" of rebar in 4 courses spread across 1.54 meters of wall thickness indicate that there must be spaces between

these courses of approximately 20 cm, which would be relatively free of rebar. This is where drilling could reasonably take place. Down-drilling from the top of the wall is the procedure recommended.

For primary breaking, explosives would be used. Hydraulic hammers would be used for secondary breaking of the reactor building.

(Secondary breaking here would be as difficult as most primary breaking on other heavy structures.) Hydraulic excavators with hammers, shears and grapples are the tool of choice for breaking and rehandling of heavily reinforced concrete. Their speed, precision, power, and safety make them the favored method for cutting steel reinforcing bar, pipes, and steel beams. They are faster, safer, and less expensive than oxy-acetylene torches or plasma arc torches. In the case of the Reactor (and Turbine) buildings, they are to be used in conjunction with explosives.

An offset drilling pattern would be used to optimally fragment the concrete. After each blast, the rubble is cleaned up, the rebar is cut to manageable lengths and segregated, and the material put down chutes or enclosed drops. Walls and floors are to be taken down as the removal of the reactor containment vessel proceeds downward. Outer walls are cut loose at the corners, pulled onto the work floors, broken, and disposed of. Secondary breakage is accomplished with hydraulic hammers and rehandling is done with grapples.

The cost estimate for the demolition of the Reactor Building and Primary Containment Vessel is given in Table H.3.

H.6.2 Turbine Generator Building

Although the Turbine Generator Building is not as tall as the Reactor Building, it is equally massive. The demolition methods used for this building are similar to those for the Reactor Building, described previously. Cost estimates are based on using explosives for the primary breaking, with heavy duty hydraulic hammers doing more primary and the secondary breaking once the structure has been weakened. Further breaking and separation of rebar from concrete will be done with concrete pulverizing attachments and shears.

TABLE H.3. Estimated Reactor Building and Primary Containment Demolition Costs

<u>Estimated Costs (1993 Dollars)</u>				
<u>Material/Activity</u>	<u>Amount</u>	<u>Unit</u>	<u>Unit Cost</u>	<u>Activity Cost</u>
<u>Reinforced Concrete:</u>				
Drilling & Blasting	31,368	m3	\$261.60 ^(a)	\$8,205,900
Secondary Breaking and Rubble Cleanup	31,368	m3	78.48 ^(b)	2,461,800
Loading, Hauling & Disposal	31,368	m3	52.32 ^(c)	1,641,200
<u>Structural Steel</u>	1,699	Mg	385.89 ^(d)	655,600
<u>Removal</u>				
Primary Containment Vessel, Cutting and Removal	1,854	Mg	727.68 ^(e)	1,349,100
<u>Total</u>				<u>\$14,313,600</u>

- (a) Equivalent to \$200/yd³
- (b) Equivalent to \$60/yd³
- (c) Equivalent to \$40/yd³
- (d) Equivalent to \$350/ton
- (e) Equivalent to \$660/ton

The structural steel roof structure will be removed by conventional methods utilizing shears as the primary pieces of equipment. Alternatively the pullover method could be used. The cost of removing the steel roof is priced by the square meter. (This was cross-checked with the weight-of-steel basis used for the Reactor Building, and the bases correlate with each other. Square measure is used where weights are not readily available for separate portions of buildings.)

The cost estimate for the Turbine Generator Building is given in Table H.4.

TABLE H.4. Estimated Turbine Generator Building Demolition Costs

<u>Material/Activity</u>	<u>Amount</u>	<u>Unit</u>	<u>Estimated Costs (1993 Dollars)</u>	
			<u>Unit Cost</u>	<u>Activity Cost</u>
<u>Reinforced Concrete:</u>				
Drilling & Blasting and Hammering	31,132	m ³	\$163.50 ^(a)	\$5,090,100
Secondary Breaking and Rubble Cleanup	31,132	m ³	78.48 ^(b)	2,443,200
Loading, Hauling & Disposal	31,132	m ³	\$52.32 ^(c)	1,628,800
<u>Structural Steel</u>				
Removal & Recycling	12,580	m ²	75.36 ^(d)	<u>948,000</u>
Total				\$10,110,100

(a) Equivalent to \$125/yc³

(b) Equivalent to \$60/yc³

(c) Equivalent to \$40/yc³

(d) Equivalent to \$7.00/ ft²

H.6.3 Radwaste And Control Building

The procedures for demolishing the Radwaste and Control building are similar to those used for the Reactor building and the Turbine building. The Radwaste/Control building is Seismic Category 1, with many closely spaced, self-reinforcing cross walls. Explosives combined with hydraulic hammers and pulverizers are the options to be used here.

The cost estimate for demolition of the Radwaste and Control Building is given in Table H.5.

TABLE H.5. Estimated Radwaste And Control Building Demolition Costs

			<u>Estimated Costs (1993 Dollars)</u>	
<u>Material/Activity</u>	<u>Amount</u>	<u>Unit</u>	<u>Unit Cost</u>	<u>Activity Cost</u>
<u>Reinforced Concrete</u>				
Primary Breaking/ Hammering	19,340	m ³	\$117.72 ^(a)	\$2,276,700
Secondary Breaking and Rubble Cleanup	19,340	m ³	52.32 ^(b)	1,011,900
Loading, Hauling & Disposal	19,340	m ³	52.32	1,011,900
<u>Structural Steel</u>				
Removal & Recycling	6,170	m ²	107.65 ^(c)	<u>664,200</u>
Total				\$4,964,700

(a) Equivalent to \$90/yd³

(b) Equivalent to \$40/yd³

(c) Equivalent to \$10/ft²

H.6.4 Cooling Towers

Six circular cooling towers are constructed of pre-cast concrete modules on a cast-in-place concrete basin. Drift eliminators and splash bars are made of Cement Asbestos Board (CAB). The CAB is currently required to be handled as asbestos waste. The material must be removed, handled, transported, and disposed of as a hazardous waste. Those costs were incorporated into this study. After removing the CAB, the structures can be dismantled and broken with hydraulic shears, grapples, pulverizers, and hammers.

The cost estimate for demolition of the Cooling Towers is given in Table H.6.

TABLE H.6. Estimated Demolition Costs For The Cooling Towers

<u>Material/Activity</u>	<u>Amount</u>	<u>Unit</u>	<u>Estimated Costs (1993 Dollars)</u>	
			<u>Unit Cost</u>	<u>Activity Cost</u>
<u>Reinforced Concrete</u>				
Primary Breaking	10,436	m ³	\$78.48 ^(a)	\$819,000
Loading, Hauling & Disposal	10,436	m ³	39.24 ^(b)	409,500
<u>Cement Asbestos Board</u>				
Removal and Packaging	5,985 ^(c)	Mg	115.74 ^(d)	692,700
Hauling and Disposal	5,985	Mg	165.40 ^(e)	<u>989,900</u>
Total				\$2,911,100

(a) Equivalent to \$60/yd³

(b) Equivalent to \$30/yd³

(c) Equivalent to 6,599 tons

(d) Equivalent to \$127.60/ ton

(e) Equivalent to \$150/ ton

H.6.5 Diesel Generator Building

The Diesel Generator Building is a Seismic Category 1 structure of reinforced concrete. Three diesel oil storage tanks are located below the ground floor slab. The demolition procedures are similar to other Seismic Category 1 structures.

The cost estimate for demolition of the Diesel Generator building is given in Table H.7. The contingent costs of having to clean up contaminated earth related to the storage tanks is not included in the breakdown; but is recognized as a contingency cost. Special costs associated with tank removal are also recognized as a contingency, and are covered by the contingency allowance.

TABLE H.7. Estimated Diesel Generator Building Demolition Costs

			<u>Estimated Costs (1993 Dollars)</u>	
<u>Material/Activity</u>	<u>Amount</u>	<u>Unit</u>	<u>Unit Cost</u>	<u>Activity Cost</u>
<u>Reinforced Concrete</u>				
Primary Breaking/ Hammering	3,016	m³	\$117.72 ^(a)	\$355,000
Secondary Breaking and Rubble Cleanup	3,016	m³	52.32 ^(b)	157,800
Loading, Hauling & Disposal	3,016	m³	52.32	157,800
Total				<hr/> \$670,600

(a) Equivalent to \$90/yd³

(b) Equivalent to \$40/yd³

H.6.6 PLANT SUPPORT STRUCTURES

The plant structures directly supporting operations are discussed and estimated in this subsection, with the estimated costs given in Table H.8.

H.6.6.1 Plant Support Facility

This is a heavily reinforced building designed to provide backup to the Operations Facility located in the main reactor complex. Its demolition will utilize the procedures applicable to the main complex, except that it is not a fully Seismic 1 structure. Hydraulic hammers together with pulverizers and grapples are adequate to remove it.

The cost estimate for demolition of this structure is given in Table H.8

H.6.6.2 Plant Engineering Building

The Plant Engineering Building is of moderately heavy construction, with tilt-up walls and concrete roof panels. It can be demolished by hydraulic excavators equipped with hammers, shears, pulverizers, and grapples.

The cost estimate for demolition of this structure is given in Table H.8

H.6.6.3 Makeup Water Pumphouse

The Makeup Water Pumphouse is located on the bank of the river. It is constructed of reinforced concrete and contains a sump pit substructure and a superstructure. The concrete can be broken and left in the below grade void. A hydraulic hammer and shear could dispose of the structure.

The cost estimate for demolition of this structure is given in Table H.8

H.6.6.4 Spray Pond Complex

Two spray ponds and two standby service water pumphouses form a complex of Seismic Category 1 structures. Each pond is constructed integrally with a pumphouse. Each pair of structures, consisting of pond and pumphouses, is adjacently located, but structurally separated. The spray pond structures are rectangular reinforced concrete, consisting of a structural slab and four perimeter walls. The pump houses are cast in place reinforced concrete. Demolition would be done by hydraulic excavator equipped with hammer, shears, pulverizer, and grapple.

The cost estimate for demolition of this structure is given in Table H.8

H.6.6.5 Records Management Building

A one story structure on a concrete slab, on grade, with insulated steel walls and roof. Demolish with hydraulic excavator, sort debris, steel, and concrete.

TABLE H.8. Estimated Demolition and Removal Costs for Plant Support Structures

<u>Material/Activity</u>	<u>Amount</u>	<u>Unit</u>	<u>Estimated Costs (1993 Dollars)</u>	
			<u>Unit Cost</u>	<u>Activity Cost</u>
Plant Support Facility	9,755	m ²	\$91.50 ^(a)	\$892,600
Plant Engineering Building	9,383	m ²	80.73 ^(b)	757,500
Makeup Water Pumphouse	718	m ³	104.64 ^(c)	75,100
Spray Pond Complex	4,700	m ³	104.64	491,800
Records Management Building	1,914	m ²	69.97 ^(d)	133,900
Document Storage Building	3,003	m ²	69.97	210,100
Warehouses	10,400	m ²	55.98 ^(e)	<u>582,200</u>
Total				\$3,143,200

- (a) Equivalent to \$8.50/ft²
 (b) Equivalent to \$7.50/ft²
 (c) Equivalent to \$80.00/yd³
 (d) Equivalent to \$6.50/ft²
 (e) Equivalent to \$5.20/ft²

The cost estimate for demolition of this structure is given in Table H.8

H.6.6.6 Document Storage/Office Records Mgmt

A one story structure on a concrete slab, on grade, with insulated steel walls and roof. Demolish with hydraulic excavator, sort debris, steel, and concrete.

The cost estimate for demolition of this structure is given in Table H.8

H.6.6.7 Warehouses

These structures are open high bay buildings with concrete slabs on grade and insulated steel sides and roof structure. They can be readily removed by conventional methods.

The cost estimate for demolition of this structure is given in Table H.8 .

H.6.7 Service Building

Exterior above grade walls of the Service Building are made of pre-cast concrete panels. Interior walls are steel stud composition type. All floors are reinforced concrete. The roof is of insulated metal decking supported by steel trusses. Demolition would be by hydraulic excavators equipped with shears, grapples, hammers, and pulverizers.

The cost estimate for demolition of the Service Building is given in Table H.9

H.6.8 Circulating Water Pump house

The Circulating Water Pump house has a structural steel and insulated metal sided superstructure and a reinforced concrete substructure, rectangular in plan, associated with the Cooling Towers. It can be demolished by a hydraulic excavator equipped with hammer, shear, grapple, and pulverizer.

The cost estimate for demolition of this structure is given in Table H.10

H.6.9 Rifle Range

The rifle range is 175 feet long with side walls of creosoted railroad ties 15 feet high. The ties are criss-crossed at 90 degree angles, starting at 45 degrees, to form side walls along the length of the range to a height of 15 feet. They are backfilled with sand. It is estimated that half of the ties will be contaminated with lead bullets, which currently classifies them as hazardous waste. The other

TABLE H.9. Estimated Service Building Demolition Costs

			<u>Estimated Costs (1993 Dollars)</u>	
<u>Material/Activity</u>	<u>Amount</u>	<u>Unit</u>	<u>Unit Cost</u>	<u>Activity Cost</u>
<u>Reinforced Concrete</u>				
Primary Breaking/ Hammering	1,838	m ³	\$100.72 ^(a)	\$185,100
Loading, Hauling & Disposal	1,838	m ³	52.32 ^(b)	96,200
Debris Removal and Disposal	612	m ³	65.40 ^(c)	40,000
<u>Structural Steel</u>				
Removal	395	Mg	168.81 ^(d)	<u>66,700</u>
Total				\$388,000

(a) Equivalent to \$77/yd³

(b) Equivalent to \$40/yd³

(c) Equivalent to \$50/yd³.

(d) Equivalent to \$150/ton

TABLE H.10. Estimated Circulating Water Pump House Demolition Costs

<u>Material/Activity</u>	<u>Amount</u>	<u>Unit</u>	<u>Estimated Costs (1993 Dollars)</u>	
			<u>Unit Cost</u>	<u>Activity Cost</u>
<u>Reinforced Concrete:</u>				
Breaking/Disposal in Place	2,593	m ³	\$104.64 ^(a)	\$271,300
<u>Structural Steel</u>				
Removal	112	Mg	165.34 ^(b)	<u>18,500</u>
Total				\$289,800

(a) Equivalent to \$80/yd³

(b) Equivalent to \$150/ton net

half are contaminated with creosote, which classifies them as contaminated waste. Each must be disposed of at certified landfills. In addition, some 100 tons of sand are considered to be lead contaminated.

The cost estimate for demolition and disposal of the Rifle Range is given in Table H.11.

TABLE H.11. Estimated Rifle Range Demolition Costs

<u>Material/Activity</u>	<u>Amount</u>	<u>Unit</u>	<u>Estimated Costs (1993 Dollars)</u>	
			<u>Unit Cost</u>	<u>Activity Cost</u>
Demolition and Disposal of Creosote Contaminated Ties	54	Mg ^(a)	\$165.38 ^(b)	\$9,000
Demolition & Disposal of Lead Contaminated Creosoted Ties	54	Mg	330.76 ^(c)	18,000
Loading and Disposal of Lead Contaminated Earth	91	Mg ^(d)	330.76	30,000
Demolition and Disposal Wood Structures	139	m ²	32.30 ^(e)	4,500
Total				<u>\$61,500</u>

- (a) Equivalent to 60 tons
- (b) Equivalent to \$150/ ton
- (c) Equivalent to \$300/ ton
- (d) Equivalent to 100 tons
- (e) Equivalent to \$3.00/ ft²

H.6.10 Miscellaneous Structures

There are numerous structures on the site for which demolition costs are based on square footage or for which a lump sum estimate was made. These structures are listed in Table H.12. Unit costs were based on the type of structure and construction and the general difficulty of demolition. Estimates for most simple

TABLE H.12. Estimated Demolition Costs For Miscellaneous Structures

Description / Name	Bldg #	Total area (m2)	Estimated Costs (1993 Dollars)	
			Unit Cost	Activity Cost
Technical Support Building	5	523	\$115.72 ^(a)	\$60,500
Health Physics Access Point	6	229	69.97 ^(b)	16,000
R.R.C. Pump ASD Building	8	201	55.98 ^(c)	11,200
Maintenance Services	11	934	69.97	65,300
Security	13	578	55.98	32,400
Laborers Storage	15	130	55.98	7,200
Lube Storage/ Paint Shop	19	78	55.98	4,400
Backflow Preventer Building	21	19	55.98	1,000
Gas Bottle Storage	22	58	83.97 ^(d)	4,900
Diesel Polishing Building	23	57	55.98	3,200
Sewage Treatment Plant	24	166	91.65 ^(e)	15,300
Alternate access point (A.A.P.)	25	465	69.97	32,500
Outage Contract Shop	32	697	55.98	39,000
Water Filtration Building	33	176	55.98	9,800
Decontamination Laundry	35	260	55.98	14,600
Electrical Building #1	38	204	55.98	11,400
Electrical Building #2	39	204	55.98	11,400
Pumphouse #2	40	37	55.98	2,100
Pumphouse #1	41	37	55.98	2,100
Document Storage Facility	47	254	77.02 ^(f)	19,500
Meteorological Tower Building	49	186	55.98	10,400
Meteorological Warehouse	50	186	55.98	10,400
Fire Brigade Training	59	116	55.98	6,500
Fire Brigade/ Storage	60	84	55.98	4,700
Primary Access Point (P.A.P.)	62	372	69.97	26,000
Secondary GuardHouse	63	72	59.20	4,300
Battery Shop/ Maintenance	72	214	55.98	12,000
Oil and Solvent Storage	74	372	55.98	20,800
Operations/ Carpenters	75	595	55.98	33,300
Vacant	85	63	55.98	3,500
Inlet Structure(In river)	IS	58	139.95 ^(g)	8,100
Blowdown Box	BB	58	139.95	8,100
Total				\$511,900

(a) Equivalent to \$10.75/ ft²

(b) Equivalent to \$6.50/ ft²

(c) Equivalent to \$5.20/ ft²

(d) Equivalent to \$7.80/ ft²

(e) Equivalent to \$8.50/ ft².

(f) Equivalent to \$7.15/ ft²

(g) Equivalent to \$13.00/sq.ft.

structures of concrete block or steel siding are based on the building's "footprint" area. Multi-story structures are usually based on a unit cost for floor area. All estimates assume disposal of concrete rubble on site.

The cost estimates for demolition of these structures are given in Table H.12.

H.6.11 Site Restoration

In addition to the buildings and structures described in the previous sections, there are many other man-made structures that must be removed.. These include parking lots, roads, and railroads. All man-made structures will be removed to a depth of 1 meter below grade, back-filled with earth and reseeded with native ground cover. The backfilling is to be 0.85 m with fill dirt and the top 0.15 m with topsoil.

The cost estimate for restoration of the WNP-2 site is given in Table H.13.

TABLE H.13. Estimated Site Restoration Costs

<u>Material/Activity</u>	<u>Amount</u>	<u>Unit</u>	<u>Estimated Costs (1993 Dollars)</u>	
			<u>Unit Cost</u>	<u>Activity Cost</u>
Loading, Hauling, Placing, grading Earth Fill	37,519 ^(a)	m ³	\$26.16 ^(b)	\$981,500
Loading, Hauling, Placing & Grading Topsoil, & Seeding	11,329	m ³	39.24 ^(c)	444,500
Total				<hr/> \$1,426,000

(a) Equivalent to 466,300 ft²

(b) Equivalent to \$25/yd³

(c) Equivalent to \$40/yd³

H.7 AREAS FOR POTENTIAL COST REDUCTION

Research into the nature of concrete and steel and their responses to various applications of heat is believed to hold the potential for multi-million dollar savings in non-radioactive demolition of the primary structures^(1,2). This research could assure a backup method if present technology should fail; or it could supplant present technology.

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10. SUPPLEMENTARY NOTES

11. ABSTRACT (200 words or less)

With the issuance of the Decommissioning Rule (June 27, 1988), nuclear power plant licensees are required to submit to the U.S. Nuclear Regulatory Commission (NRC) for review, decommissioning plans and cost estimates. This reevaluation study provides some of the needed bases documentation to the NRC staff that will assist them in assessing the adequacy of the licensee submittals. This report presents the results of a review and reevaluation of the PNL 1980 decommissioning study of the WNP-2 nuclear power plant for the DECON, SAFSTOR, and ENTOMB decommissioning alternatives. These alternatives now include an initial 5-7 year period during which the spent fuel is stored in the spent fuel pool, prior to beginning major disassembly or extended safe storage of the plant. This report also includes consideration of the NRC requirement that decommissioning activities leading to termination of the nuclear license be completed within 60 years of final reactor shutdown, consideration of packaging and disposal requirements for Greater-Than-Class C low-level waste, and reflects all costs in 1993 dollars. Sensitivity of the total license termination cost to the disposal costs at different low-level radioactive waste disposal sites, and to different depths of contaminated concrete surface removal with the facilities are also examined.

12. KEY WORDS/DESCRIPTORS (List words or phrases that will assist researchers in locating the report.)

boiling water reactor (BWR)
decommissioning
cost/dose/sensitivity analyses

13. AVAILABILITY STATEMENT

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14. SECURITY CLASSIFICATION

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