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# Decision Document for the Low-Activity Waste Retrieval Strategy for Tanks 241-AN-103, 241-AN-104, 241-AN-105, and 241-AW-101

O. R. Rasmussen

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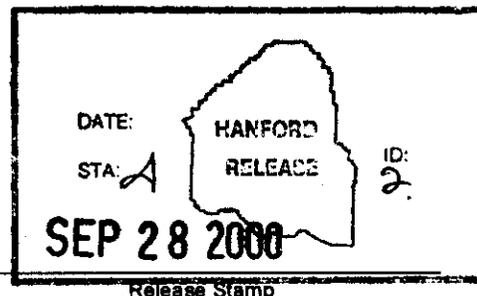
**Abstract:**

This report documents the preferred approach (retrieval strategy) to prepare and transfer waste from low-activity waste source tanks containing soluble solids (Tanks 241-AN-103, 241-AN-104, 241-AN-105 and 241-AW-101) to the vitrification plant. Several opportunities to further refine the selected retrieval strategy were identified; these were recommended for follow-on studies.

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# **Decision Document for the Low-Activity Waste Retrieval Strategy for Tanks 241-AN-103, 241-AN-104, 241-AN-105, and 241-AW-101**

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

**CH2MHILL**

*Hanford Group, Inc.*

Richland, Washington

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

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# **Decision Document for the Low-Activity Waste Retrieval Strategy for Tanks 241-AN-103, 241-AN-104, 241-AN-105, and 241-AW-101**

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

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**DECISION DOCUMENT FOR THE LOW-ACTIVITY WASTE  
RETRIEVAL STRATEGY FOR TANKS 241-AN-103,  
241-AN-104, 241-AN-105, AND 241-AW-101**

**DECISION APPROVALS**

Decision Maker



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R. A. Dodd  
Double-Shell Tank and Waste Feed Delivery  
Operations Director

09/05/00  
Date

**DECISION SUPPORT BOARD CONCURRENCE**

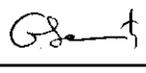
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G. P. Duncan, Project Definition Operations

8/31/00  
Date

for   

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A. F. Choho, Retrieval Engineering

8/31/00  
Date



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R. S. Popielarczyk, Chief Engineer

9/17/00  
Date



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C. E. Leach, Nuclear Safety and Licensing

9/12/00  
Date

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**DECISION DOCUMENT FOR THE LOW-ACTIVITY WASTE  
RETRIEVAL STRATEGY FOR TANKS 241-AN-103,  
241-AN-104, 241-AN-105, AND 241-AW-101**

**1.0 STATEMENT OF THE PROBLEM TO BE DECIDED**

What is the preferred approach to prepare and transfer waste from low-activity waste (LAW) source tanks containing soluble solids (Tanks 241-AN-103, 241-AN-104, 241-AN-105, and 241-AW-101) to the Vitrification Plant?

**2.0 DATE OF SELECTION**

The date of selection will be on the date the decision-maker signs this document.

**3.0 DECISION-MAKER**

The decision-maker is Ryan A. Dodd, Double-Shell Tank and Waste Feed Delivery Operations Director.

**4.0 DECISION ACTION OFFICER**

The decision action officer is A. F. Choho, Manager, Retrieval Engineering.

**5.0 LOW-ACTIVITY WASTE RETRIEVAL STRATEGY DECISION**

The strategy selected to prepare and transfer waste from LAW source Tanks 241-AN-103, 241-AN-104, 241-AN-105, and 241-AW-101 is as follows.

1. Accelerate the schedule for the retrieval of supernatant and dissolution of solids from Tank 241-AN-104 or 241-AN-105 to confirm equipment and retrieval strategy designs early enough that adjustments can be made if necessary.
2. Install mixer and transfer pumps in the source tanks on a just-in-time basis. This minimizes the time this equipment is passively stored in saturated salt solutions and reduces or eliminates the potential encrustation of the equipment.

3. Install a transfer pump in the source tanks and decant the existing clarified supernatant to a staging tank using in-line water dilution. Monitor flammable gas concentrations in the vapor space of the source tanks. When gas release events occur, slow or halt decanting until the ventilation system has returned the flammable gas concentrations to nominal conditions. Increase dilution water flow if gas evolution from the solids layer is rapid enough to suspend significant amounts of solids in the supernatant phase.
4. Settle, characterize, and decant the clarified LAW from the staging tank to the Vitrification Plant.
5. Add water to the source tank, install a mixer pump, and mix the contents to dissolve the soluble salts.
6. Settle, characterize, and decant the clarified LAW supernatant from the source tank directly to the Vitrification Plant.

## **6.0 KEY CONSIDERATIONS**

The LAW Feed Delivery Strategy decisions were based primarily on the considerations discussed below. A more extensive range of options, presented in HNF-4347, *Alternatives Generation and Analysis for Low-Activity Waste Retrieval Strategy*, was considered and evaluated by the authors of the Alternatives Generation and Analysis, the Technical Advisory Group, and the Decision Support Board. The options are summarized in Table 1.

### **6.1 ACCELERATED SCHEDULE FOR THE INITIAL RETRIEVAL OF SUPERNATANT**

Accelerating the schedule for initial retrieval of the supernatant provides an early opportunity to observe the waste behavior during the removal of the supernatant and allows for the early installation and operation of mixer pumps to dissolve soluble solids. This early test of the process and equipment will allow time for changes, if they are needed, before continuous production starts.

### **6.2 JUST-IN-TIME INSTALLATION OF PUMPS**

The consensus of the Decision Support Board was that just-in-time installation of pumps in saturated salt solutions presents the best opportunity for on-time feed delivery. While a just-in-time installation requires more time-critical planning and scheduling than early installation, it avoids the risk of crystal growth on impellers, ports, seals, and shafts that could lead to pump failure.

Table 1. Summary Assessment of Alternative Options for Low-Activity Waste Feed Delivery Strategy. (2 sheets)

| Step | Options  | Advantages  | Disadvantages/Risks  | Original Strategy* | AGA, Decision Board Strategy* | Recommended for Future Evaluation |
|------|--|---|--|--------------------|-------------------------------|-----------------------------------|
| 1    | <p>Remove obsolete equipment and provide access for new equipment in risers and pump pits</p> <p>A. Remove multifunctional instrument tree, slurry distributor, pump pit jumpers, transfer pump, and ~24 cm (10-in.) salt well screen (Tanks 241-AN-103, 241-AN-104, and 241-AN-105 only).<br/>Save ~38 cm (15-in.) video system for reuse.</p> <p>B. Remove multifunctional instrument tree, slurry distributor, and jumpers.<br/>Dispose of old ~38 cm (15-in.) video system (scrap).<br/>Leave existing transfer pump and salt well screen in tank.</p> | <p>Cleares risers and pits for new equipment.</p> <p>Reduced cost and exposure by deleting pump and screen removal.<br/>Reduced cost by deleting video camera reuse. Reduced future cost and maintenance by using small portable video systems in ~10 cm (4-in.) risers.<br/>Leaves ~107 cm (42-in.) riser available for other uses.<br/>Existing pump available as potential spare pump for decanting.<br/>Design is complete.</p> | <p>High radiation and exposure risk associated with removing encrusted screen and pump before salt dissolution.<br/>High cost, maintenance problems associated with removal and reuse of ~38 cm (15-in.) video camera.<br/>Requires analysis of salt well screen for resistance to mixer pump forces.<br/>Requires drawing revisions, jumper design modifications.</p> | X                  | Not evaluated                 | X                                 |
| 2    | <p>Install above-ground retrieval infrastructure</p> <p>A. Install full Project W-211 infrastructure.</p> <p>B. Install temporary utilities for low-cost retrieval equipment such as propeller mixers and submersible pumps.</p>   | <p>Reduced cost. A low-cost LAW study has been initiated.</p>   | <p>High cost. Funding may not be available in time for LAW schedule.<br/>Engineering study and design required.</p>  | X                  | Not evaluated                 | X                                 |
| 3    | <p>Install mixer and transfer pumps in waste</p> <p>A. Install two mixer pumps and one transfer pump in each tank 2 yr or more before planned use and before startup approval.</p> <p>B. Install pumps after startup approval, immediately before actual use. Start flush and exercise program immediately.</p>  | <p>Completes project work on schedule.<br/>Equipment is in place well before needed.<br/>Pumps ensured of full operability when needed.</p>   | <p>Crystal growth on pump components is expected. Pumps may not be operable when needed.<br/>Requires thorough planning and preparation to ensure on-time installation and startup.</p>  | X                  | Not evaluated                 | Not evaluated                     |
| 4    | <p>Select initial mixer pump intake elevation</p> <p>A. Place intake ~15 cm (6 in.) above tank bottom in ~4.6 m (~15 ft) of semisolid salt slurry after water lancing.</p> <p>B. Elevate pump intake into liquid phase with jackscrew lift table that allows lowering pump as solids are dissolved.</p>  | <p>Pump operability is assured.<br/>Lift table has been designed by Project W-211.<br/>Ensures 25% of LFL will not be exceeded.</p>   | <p>Higher cost and complexity for lift table.<br/>Long cycle time for LAW batch.<br/>Risk that solids will not resettle sufficiently to meet &lt;2% insoluble solids specification in schedule time allowed, resulting in solids carryover to staging tank.</p>  | X                  | Not evaluated                 | Not evaluated                     |
| 5    | <p>Decant ~1.89 to 2.27 ML (500 to 600 kgal) of clarified supernatant to staging tank</p> <p>A. Mix convective and nonconvective phases to remove flammable gases from nonconvective phase in a slow, controlled manner.<br/>Settle solids for 50 to 120 days.<br/>Decant reclarified supernatant with in-line water dilution.</p> <p>B. Mix waste to degas, then pump slurry with approximately 1:1 water dilution for in-line dissolution of soluble salt fraction.</p>  | <p>Short LAW batch cycle time. Ensures 25% LFL will not be exceeded.</p>  | <p>Increased risk of plugging pipeline.<br/>Carryover of all insoluble solids to two staging tanks, requiring staging tank cleanouts.</p>  |                    |                               |                                   |

Table 1. Summary Assessment of Alternative Options for Low-Activity Waste Feed Delivery Strategy. (2 sheets)

| Step          | Options  | Advantages  | Disadvantages/Risks   | Original Strategy*  | AGA, Decision Board Strategy* | Recommended for Future Evaluation |
|---------------|--|---|---|---|-------------------------------|-----------------------------------|
| 5 (Continued) | C. Mix waste to degas, then pump one-half of slurry to staging tank with 1:1 water dilution. Blend remaining slurry with water in source tank, settle, and decant.   | Short LAW batch cycle time. Ensures 25% LFL will not be exceeded.   | Increased risk of plugging pipeline. Insoluble solids carryover to one staging tank, requiring staging tank cleanout.   |   |                               |                                   |
|               | D. Decant existing clear supernatant with in-line water dilution, allowing nonconvective phase gases to degas naturally. Slow or halt decant when GREs occur until flammable gas concentration returns to nominal levels. Increase in-line dilution to dissolve solids injected into the liquid phase. | Short LAW batch cycle time.   | Slightly elevated risk of approaching or exceeding 25% of the LFL, but flammable gas study rates risk increase as insignificant.  | Risk of entrained solids carryover to staging tanks because of GREs muddying up supernatant, but risk is not distinguishable from old baseline. |                               | X                                 |
| 6             | A. Add water after initial decanting is complete.  | Evaluated in flammable gas study. No risk.  | For case 5.D only. May allow several GREs to occur, with solids injection into supernatant during decant.   | X   | X                             |                                   |
|               | B. Add water during initial decanting.   | Starts crust dissolution and softening early. Likely to reduce number of GREs and solids injection into supernatant for case 5.D. | Shifting tank crust with damage to in-tank equipment. Not specifically evaluated in flammable gas study but not expected to be significant.   |   |                               | X                                 |
| 7             | A. Mix with two mixer pumps.   | Effective dissolution guaranteed.   | Two pumps may be overkill with unnecessary installation and removal costs.  | X   | Not evaluated                 |                                   |
|               | B. Mix with one mixer pump. Install second mixer pump only if needed.  | Effective dissolution virtually certain with one mixer pump.  | Reduces pump installation and removal costs.  |   | Not evaluated                 | X                                 |
|               | C. Mix waste and water by sluicing from staging tank to sluicer in source tank.  | A low-cost sluicing system could be developed as part of a low-cost LAW alternative.  | Recirculation loop piping is not available. Engineering study would be required to assess options for switching ~5 cm (2-in.) piping from flush/dilution to sluicing.                                     |   |                               | X                                 |
| 8             | A. Mix, settle, sample, and ship from two staging tanks.   | Provides second solids separation stage. Guarantees LAW will be within solids specifications.                                     | Requires significant tank space to be available.  | X   |                               |                                   |
|               | B. Mix, settle, sample, and ship one batch from staging tank. Settle, sample, and ship second batch from source tank.  | Saves tank space. Solids separation is nearly as effective as for two staging tanks.  | Slightly increased risk of out-of-specification LAW because of high solids.   |   | X                             |                                   |
|               | C. Sample and ship both batches directly from source tank.   | Saves most tank space.  | Significant risk of out-of-specification LAW for first batch. Difficult scheduling for initial transfer to Vitrification Plant as settling time for initial undiluted LAW cannot be predicted accurately. |   |                               |                                   |
|               | D. Mix, sample, and ship from two staging tanks with settling solids and decanting LAW.  | Prevents solids buildup in staging tank; feasible if samples show less than 2% solids   | Risks shipping LAW that exceeds 2% solids specification.  |   |                               |                                   |

\*Shaded cells indicate the low-activity waste retrieval options selected.

AGA = Draft Alternatives Generation and Analysis (HNF-4347, 2000, Alternatives Generation and Analysis for Low-Activity Waste Retrieval Strategy, Rev. 0, Fluor Hanford, Incorporated, Richland, Washington).

GRE = gas release events.

LAW = low-activity waste.

LFL = lower flammability limit.

### 6.3 DELIVERY OF LOW-ACTIVITY WASTE BATCHES

The Decision Support Board chose direct decanting of the available clarified ~1.89 to 2.27 ML (500 to 600 kgal) of supernatant from each tank for obtaining the initial LAW batches. Direct decanting was selected for the following reasons:

1. Flammable gas studies (HNF-3447, Appendix F) have shown that direct decanting can remove the gases from the solids layer with the same high level of safety as mechanical mixing. During decanting, gases are released by a reduction in hydrostatic pressure. In mechanized mixing, gases are released gradually by suspending the gas-trapping solids in the liquid phase. Decanting is expected to produce several rapid gas releases from waste pockets ("gobs") that become buoyant. While the risk of approaching 25% of the lower flammability level is slightly higher for direct decanting, the overall difference in risk is insignificant. A mixing and resettling period of 2 to 6 mo, as required in the original base case, is therefore not necessary for flammable gas control. Eliminating the mechanical de-gassing step shortens the batch cycle time and significantly improves the chances for on-time feed delivery.
2. Direct decanting is expected to carry a minimal quantity of insoluble solids to the staging tank. Direct decanting will most likely result in the injection of some solids into the liquid phase by a series of small gas release events, but in the judgment of the Decision Support Board, the volume of solids is expected to be smaller than the volume that would be carried over as a result of incomplete settling after mechanical de-gassing.
3. The first LAW batch from each tank must be transferred with in-line water dilution to a staging tank, where entrained solids are settled before LAW is decanted to the Vitrification Plant. The Decision Support Board agreed that direct decanting of the initial batch from the source tank to the Vitrification Plant would pose too great a risk of exceeding the 2% solids limit.
4. The Decision Support Board agreed that the second feed batch can reasonably be shipped to the Vitrification Plant without intermediate staging and decanting because laboratory tests show that settling rates will be greatly improved after water dissolution of the solids phase. With adequate solids separation feasible in the source tank, it will be possible to minimize tank space problems early in the program, as well as to minimize the need for cleaning intermediate storage tanks between uses.

### 6.4 ADDITIONAL AREAS FOR STUDY AND DECISION MAKING

The Decision Support Board, as intended, resolved the main strategy issues. With these key decisions confirmed, a number of additional follow-on studies and decisions are essential to arrive at a fully effective LAW feed delivery system.

1. It is recommended that an evaluation be performed for the option of leaving the existing transfer pump and salt well screens in place. Removal of the existing salt well screens and transfer pumps in Tanks 241-AN-103, 241-AN-104, and 241-AN-105 may produce

high radiation exposures to personnel because of the massive salt encrustations anticipated both on the inside and outside of the screens. These encrustations are likely to be extremely difficult to wash off in the present tank environment. With the existing pump and screen temporarily left in the central ~30 cm (12-in.) riser, the new transfer pump would be installed in the central ~107 cm (42-in.) riser in lieu of the permanent video camera, and in-tank observations would be made whenever necessary with portable video cameras inserted through outside ~10 cm (4-in.) risers.

2. It is recommended that early utilization of the pump lift table designed by Project W-211 be evaluated. Full insertion of the initial mixer pump in the ~305 to 457 cm (10- to 15-ft-) deep nonconvective phase is expected to pose a significant risk of pump damage from operation in an excessively viscous environment. Rather than keeping the Project W-211 jackscrew pump lift table on a build-if-needed status, an evaluation should be performed to assess the benefits of building and testing the lift table well ahead of time and of using the table to elevate the pump intake into the liquid phase BEFORE initial pump operation begins.
3. It is recommended that an evaluation be performed to assess installation of the second ~224 kW (300-hp) mixer pump on an if-needed basis. Experience with the single ~112 kW (150-hp) mixer pump in Tank 241-SY-101 suggests that a second pump is probably not necessary for dissolving salt, and significant cost savings in pump installation and removal may be attainable.
4. It is recommended that the benefits and risks of adding water to the source tanks during the initial decanting be assessed. While the flammable gas release aspects of this option have not been fully studied, potential advantages include a reduced volume of solids carryover to the staging tank by reducing the number of expected gas release events, as well as a reduced risk of equipment damage from the shifting of floating crust blocks. Early water addition may partially dissolve and soften crust sections, rendering draw down induced movement harmless to equipment.
5. A Low-Cost LAW Retrieval Scenario study that was started in fiscal year 2000 should be accelerated in fiscal year 2001 to prepare for the possibility that full funding for a permanent retrieval system will not be available in time to meet LAW delivery commitments. The Low-Cost LAW study should explore such potential cost reduction actions as the use of temporary power and utilities, and the temporary installation of low-cost transfer and mixing equipment, such as submersible pumps and propeller mixers (RPP-6421, *Evaluation of Flygt™ Propeller Mixers for Double-Shell Tank High-Level Waste Auxiliary Solids Mobilization*<sup>1</sup>). The study of temporary installations is justified by the very short duration of the individual LAW retrieval operations.

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<sup>1</sup> Flygt is a trademark of the ITT Flygt Corporation, Svetsarvagen 12 Solna, Sweden Corporation, Sweden.

## 7.0 HISTORICAL PERSPECTIVE ON THE LOW-ACTIVITY WASTE STRATEGY DECISION

On May 6 and 7, 1999, Brian Peters and Olaf Rasmussen, lead authors, presented the first draft of the Alternatives Generation and Analysis for the LAW Strategy (HNF-4347) to the Decision Support Board. The members of the Decision Support Board participating in this review were as follows:

|   |                                       |
|---|---------------------------------------|
| Planning and Integration                          | Jeffrey A. Voogd (for R. D. Wojtasek) |
| Project Development and Implementation            | Warren T. Thompson                    |
| Systems Engineering                               | Steven M. O'Toole                     |
| Retrieval Operations                              | Ryan A. Dodd                          |
| Maintenance                                       | Thomas J. Kelley                      |
| Waste Feed Delivery Program System Implementation | Ralph W. (Bill) Root                  |
| Retrieval Engineering                             | Anne-Marie F. Choho                   |
| Chief Engineer                                    | Robert S. Popielarczyk                |
| Nuclear Safety and Licensing                      | Thomas C. Geer                        |
| Life-Cycle Projects                               | Gilles P. Chevrier                    |
| Radiological Controls                             | Ralph H. Lipfert                      |
| Industrial Safety                                 | Peter L. Smith (for William T. Dixon) |
| Quality Assurance                                 | John F. Bores                         |

The Draft Alternatives Generation and Analysis (HNF-4347) evaluated various combinations of the options presented in Table 1 and proposed a preferred strategy. The Decision Support Board considered the alternatives and voted unanimously to recommend the strategy described in Section 5.0 of this decision document, pending the results of a flammable gas modeling study. The new strategy was implemented as interim guidance on June 22, 1999 (Treat, 1999, *Interim Guidance on LAW Retrieval Strategy*). At the time of the Decision Support Board meeting, Russ L. Treat, Manager, Waste Feed System Definition, was the appointed decision-maker.

On November 1, 1999, Brian Peters and Olaf Rasmussen presented the results of the flammable gas modeling study (HNF-4347, Appendix F) and Retrieval Engineering's recommendation to the Technical Advisory Group. The members of the technical advisory group for this review were as follows:

|   |                        |
|---|------------------------|
| Systems Engineering                               | Steven M. O'Toole      |
| Retrieval Operations                              | Ryan A. Dodd           |
| Maintenance                                       | Thomas J. Kelley       |
| Waste Feed Delivery Program System Implementation | Ralph W. (Bill) Root   |
| Retrieval Engineering                             | Anne-Marie F. Choho    |
| Chief Engineer                                    | Robert S. Popielarczyk |

Nuclear Safety and Licensing  
Quality Assurance  
Waste Feed System Definition

Carole E. Leach  
John F. Bores  
Russ L. Treat

At the time of the Technical Advisory Group meeting, the decision-maker was Warren T. Thompson, Program Principal Engineer, Tank Waste Retrieval and Disposal. After consideration, the Technical Advisory Group voted unanimously to recommend acceptance of the Decision Support Board's recommendation providing that compared cost estimates for project work under both the baseline and recommended alternatives did not exhibit major differences. Confirmation of comparable costs was provided and documented in HNF-4347.

At the time of final approval, the decision-maker was Ryan A. Dodd, Manager of Waste Retrieval Support Operations.

## **8.0 ALTERNATIVE SELECTED**

The alternative selected by the decision-maker is that described above in Section 5.0, as recommended by Retrieval Engineering, the Decision Support Board, and the Technical Advisory Group.

## **9.0 DECISION CRITERIA**

The decision criteria used in the selection of the chosen alternative were based directly on the following fundamental objectives:

1. Maximize public, worker, and environmental safety by minimizing the following:
  - Accidental radiation exposure to the public
  - Chronic radiation exposure to the worker
  - Accidental radiation exposure to the worker
  - Accidental chemical exposure to the worker
  - Worker industrial hazards
2. Maximize regulatory compliance:
  - U.S. Department of Energy
  - U.S. Environmental Protection Agency
  - Washington State Department of Ecology
  - Washington State Department of Health
3. Minimize life-cycle costs:
  - Design and construction cost
  - Operations cost
  - Decontamination and decommissioning cost

4. Maximize the chances of success of the waste feed delivery mission:
- Initial delivery of feed on time
  - Routine delivery of feed on time
  - Initial quantity of feed adequate
  - Routine quantity of feed adequate
  - Feed within specifications
  - Tri-Party Agreement milestones met (Ecology, EPA, and DOE, 1996, *Hanford Federal Facility Agreement and Consent Order*).

In addition to decision criteria, an assessment of programmatic risks was used in the selection of the recommended alternative. While the Decision Support Board ranking of priorities and relative weighting in some cases did not match the rankings developed by the Technical Advisory Group, the overall conclusion was the same. The Draft Alternatives Generation and Analysis (HNF-4347), which developed the groundwork for assessing alternatives, has been issued as a historical document.

## **10.0 ASSUMPTIONS**

The most important assumptions used in reaching this decision were as follows.

1. As directed by the U.S. Department of Energy, LAW prepared by decanting of supernatants and dissolution of solids was assumed to comply with the Vitrification Plant permits, the Final Safety Analysis Report, and the Technical Safety Requirements. Therefore little or no feed blending will be required.
2. It was assumed that current waste characterization data (chemical and physical) are accurate.
3. It was assumed that the potential for moderate gas release events (rollovers) exists during initial decanting. Therefore installed equipment must be designed to withstand such events.

## **11.0 ALTERNATIVES REJECTED**

Options for processing LAW are shown in Table 1. The original 1998 strategy is indicated in Table 1 along with the new Decision Support Board-approved strategy, which is shown in a parallel column. In many options, both strategies are the same. Rejected alternatives are those not shown in either column.

The final list of nine alternatives assessed in detail in the historical Draft Alternatives Generation and Analysis document (HNF-4347) is shown in Table 2 below. Each of the eight strategy steps listed corresponds to a strategy step in Table 1. The letters in each row, "A," "B," "C," or "D," correspond to one of the options listed for that step in Table 1. The nine alternatives, examined in the Draft Alternatives Generation and Analysis (HNF-4347) and by the Decision

Support Board, can be mapped to each of the columns in Table 2 with the options detailed in Table 1. Alternative 1 is the original base case strategy and Alternative 4c is the strategy recommended by the Draft Alternatives Generation and Analysis (HNF-4347) and by the Decision Support Board. The nine final alternatives are illustrated in Figures 1 through 9.

**Table 2. Alternatives Cross Reference to Table 1.**

| Strategy Step |                                    | Alternatives and Options Selected from Table 1<br>in the Final Alternatives Generation and Analysis |           |          |          |           |           |           |           |          |
|---------------|------------------------------------|---|-----------|----------|----------|-----------|-----------|-----------|-----------|----------|
|               |                                    | Alt<br>1  | Alt<br>1b | Alt<br>2 | Alt<br>3 | Alt<br>3b | Alt<br>4a | Alt<br>4b | Alt<br>4c | Alt<br>5 |
| 1             | Remove obsolete equipment          | A   | A         | A        | A        | A         | A         | A         | A         | A        |
| 2             | Install infrastructure             | A   | A         | A        | A        | A         | A         | A         | A         | A        |
| 3             | Install pumps in waste             | A   | A         | A        | A        | A         | A         | A         | B         | B        |
| 4             | Select mixer pump intake elevation | A   | A         | A        | A        | A         | A         | A         | A         | –        |
| 5             | Decant supernatant                 | A   | A         | B        | C        | C         | D         | D         | D         | D        |
| 6             | Add water to source mix            | A   | A         | –        | A        | A         | B         | B         | A         | –        |
| 7             | Mix, dissolve, settle, decant      | A   | A         | –        | A        | A         | A         | A         | A         | C        |
| 8             | Sample and deliver LAW             | A   | D         | A        | A        | B         | A         | A         | B         | A        |

## 12.0 REFERENCES

Ecology, EPA, and DOE, 1996, *Hanford Federal Facility Agreement and Consent Order*, 2 vols., Washington State Department of Ecology, Olympia, Washington; U.S. Environmental Protection Agency, Washington, D.C.; and U.S. Department of Energy, Washington, D.C.

HNF-4347, 2000, *Alternatives Generation and Analysis for Low-Activity Waste Retrieval Strategy*, Rev. 0, CH2M HILL Hanford Group, Inc., Richland, Washington.

RPP-6421, 2000, *Evaluation of Flygt™ Propeller Mixers for Double-Shell Tank High-Level Waste Auxiliary Solids Mobilization*, Rev. 0, CH2M HILL Hanford Group, Inc., Richland, Washington.

Treat, R. L., 1999, *Interim Guidance on LAW Retrieval Strategy* (Interoffice Memo 73600-99-006 to A. F. Choho, June 22), Lockheed Martin Hanford, Inc., Richland, Washington.

Figure 1. Alternative 1 – Original (1998) Baseline.

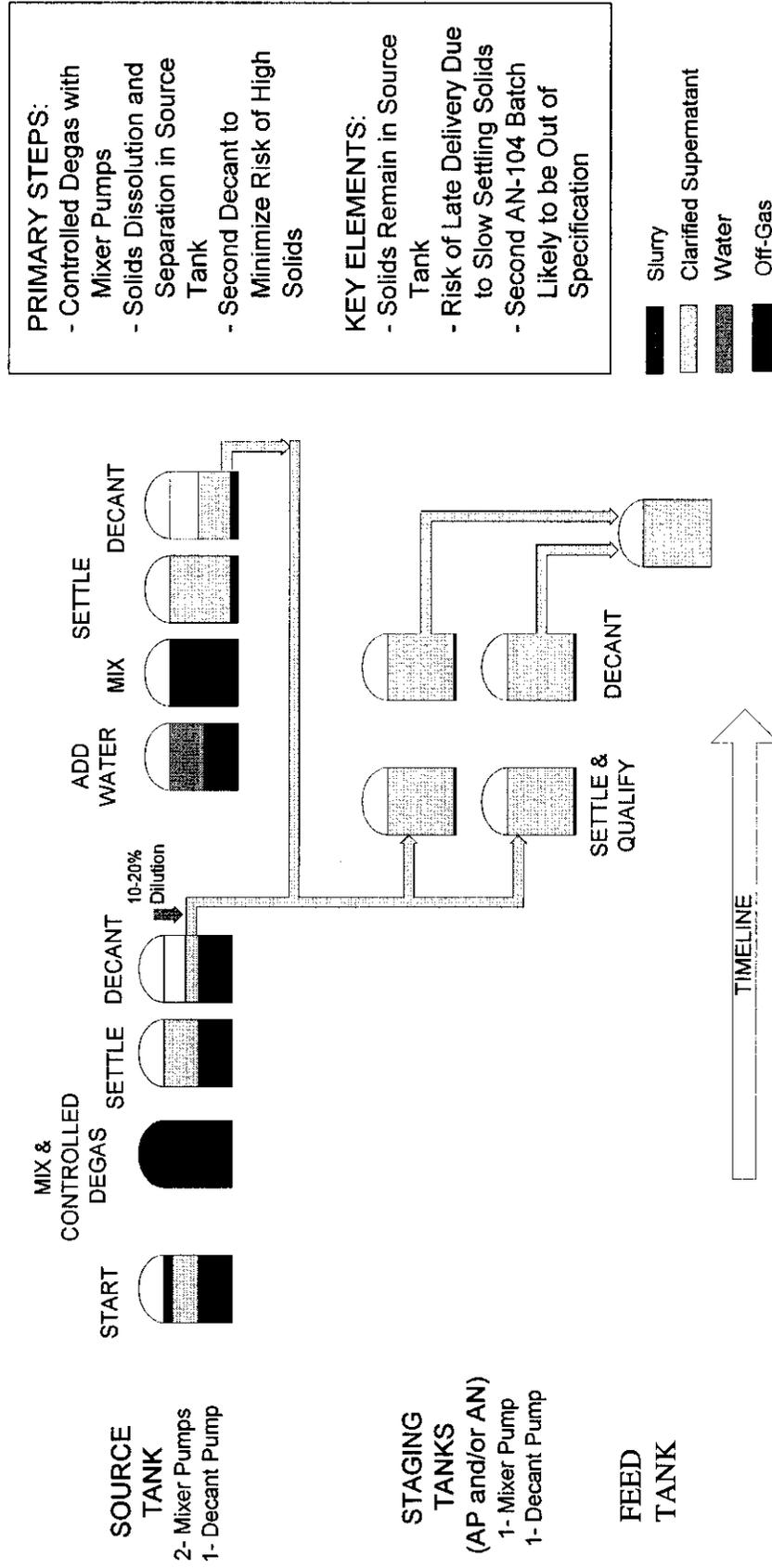


Figure 2. Alternative 1b – Baseline Minus Backup Decant.

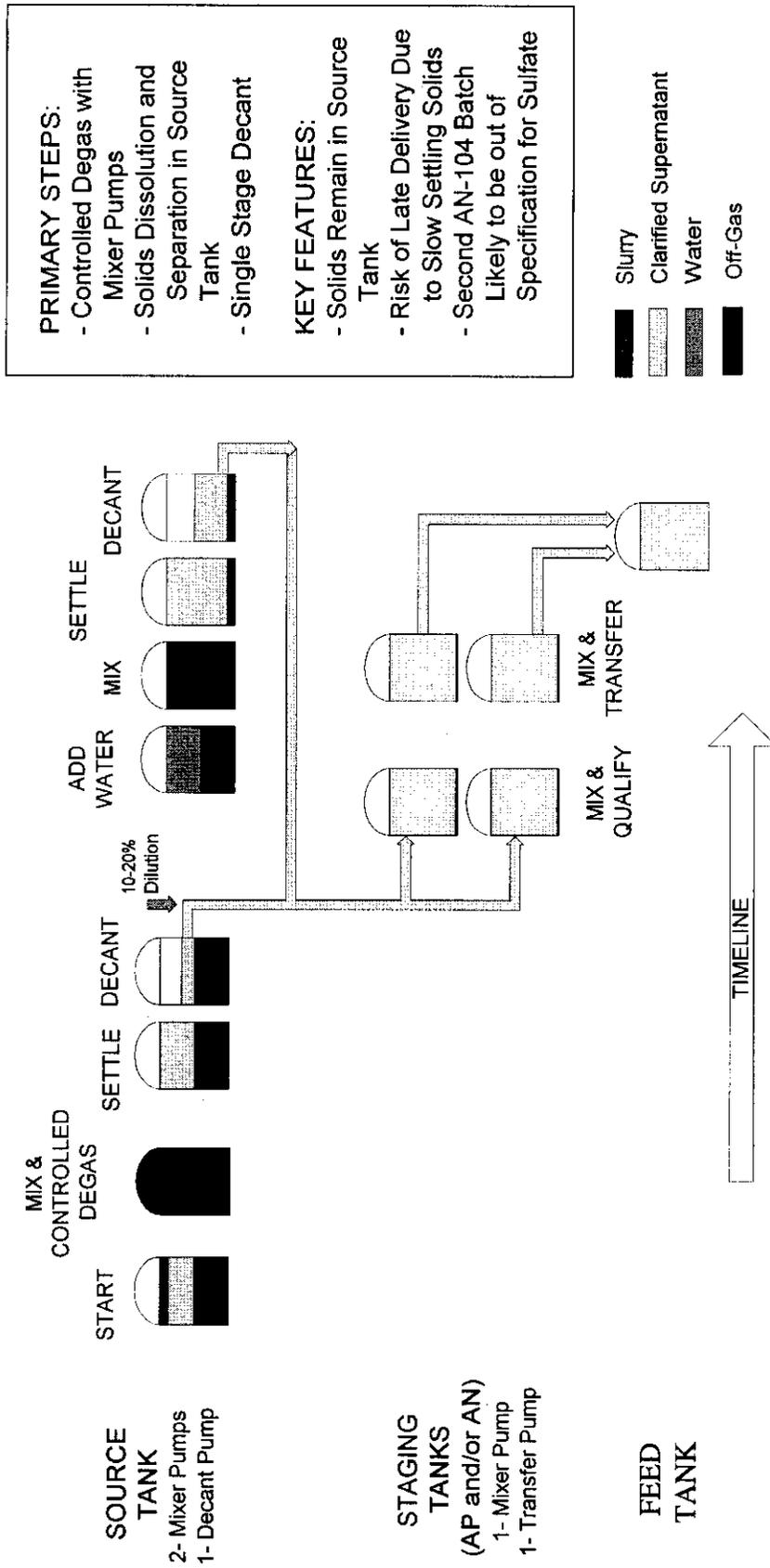


Figure 3. Alternative 2 – Slurry with In-Line Dilution.

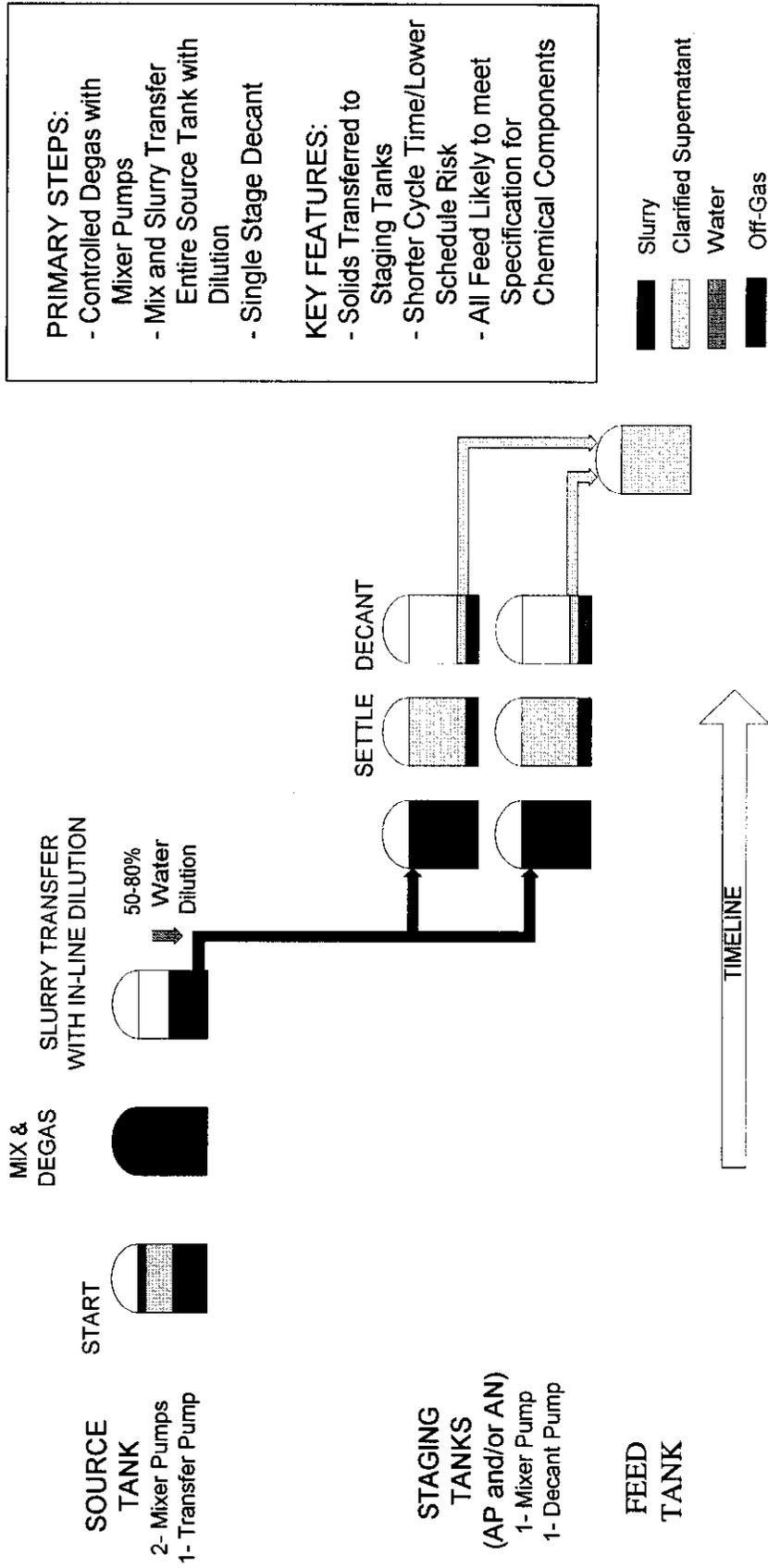


Figure 4. Alternative 3 – Combination.

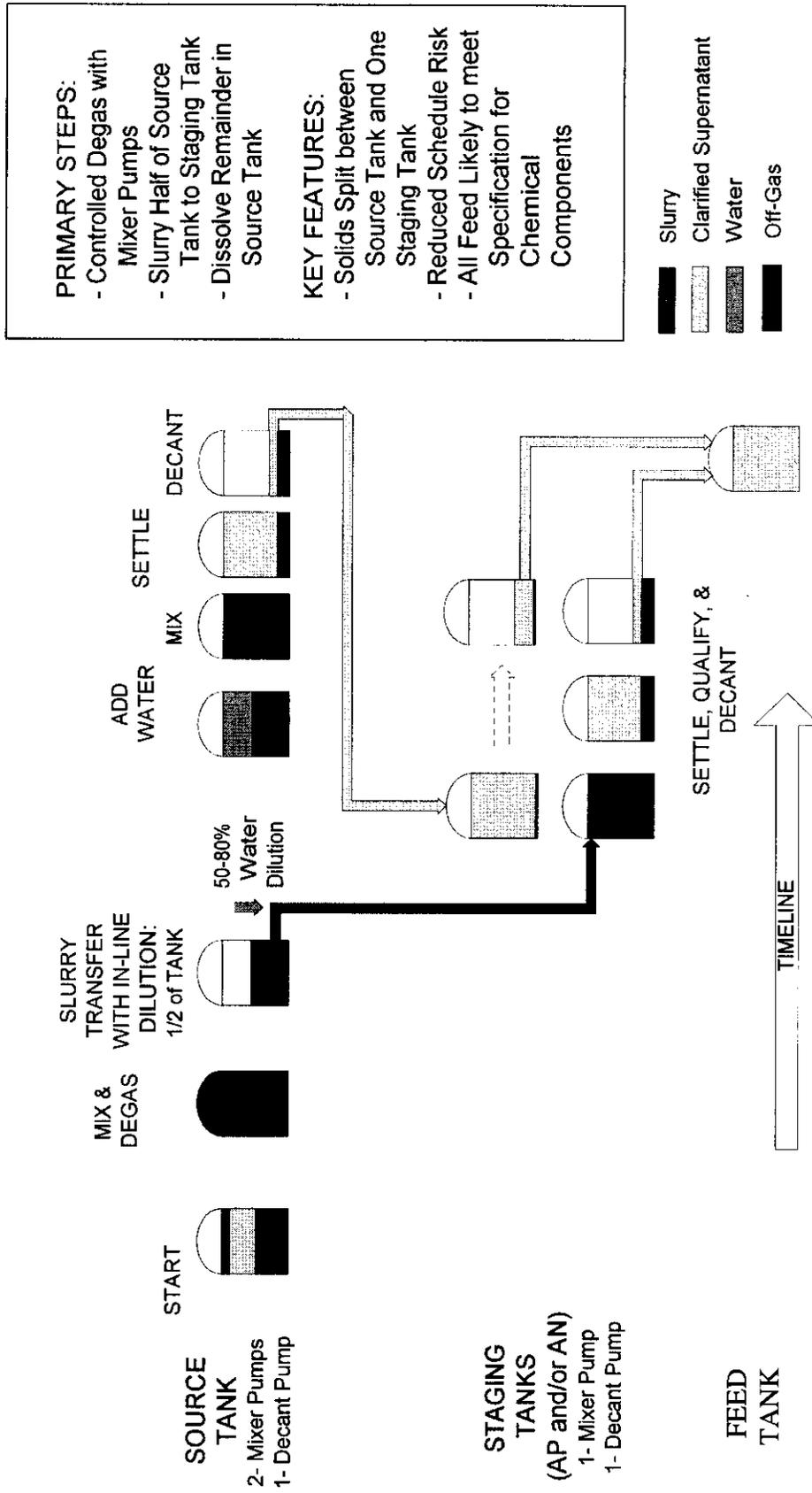


Figure 5. Alternative 3b – Combination with Single Staging Tank.

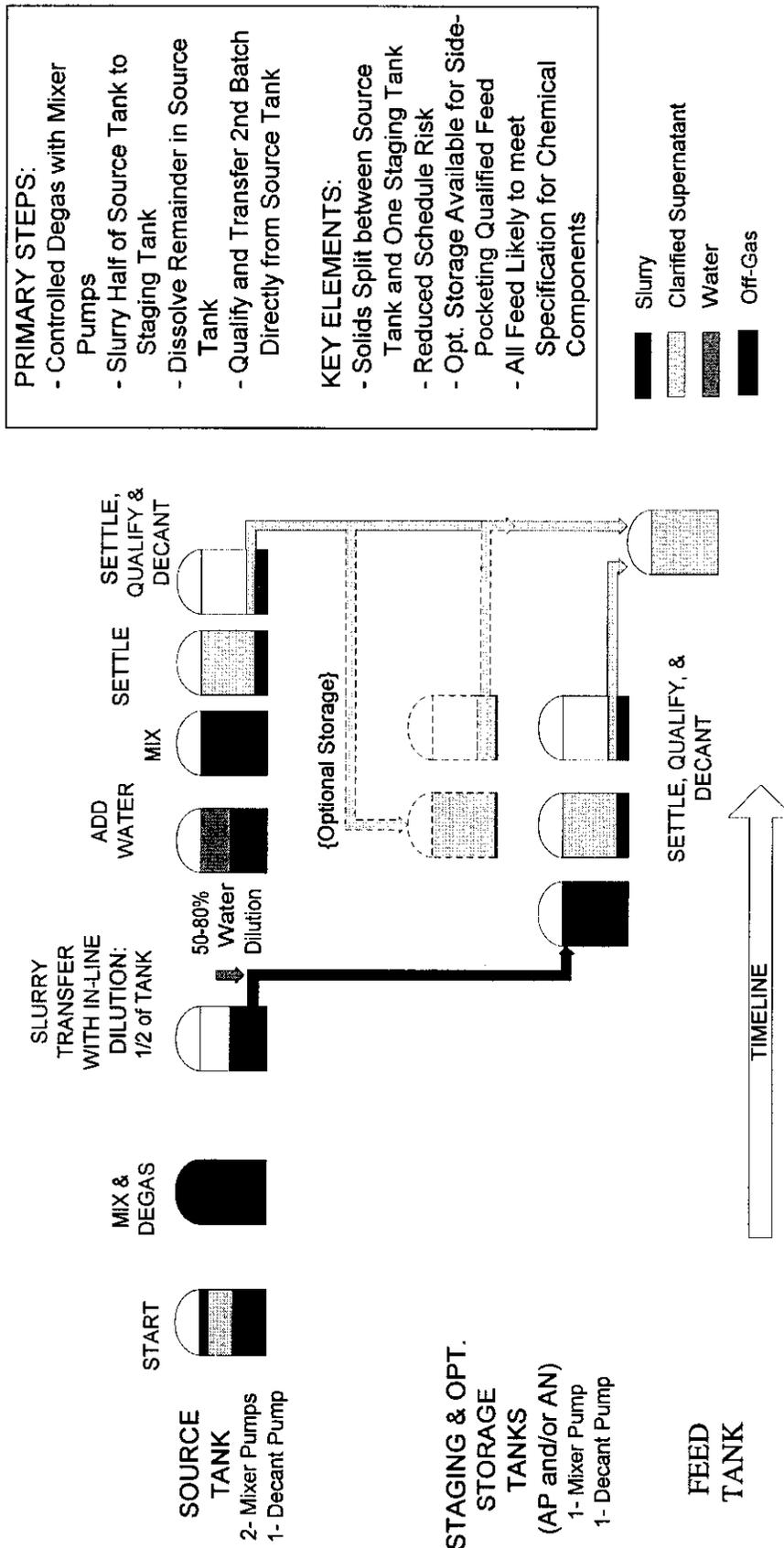


Figure 6. Alternative 4a – Decant.

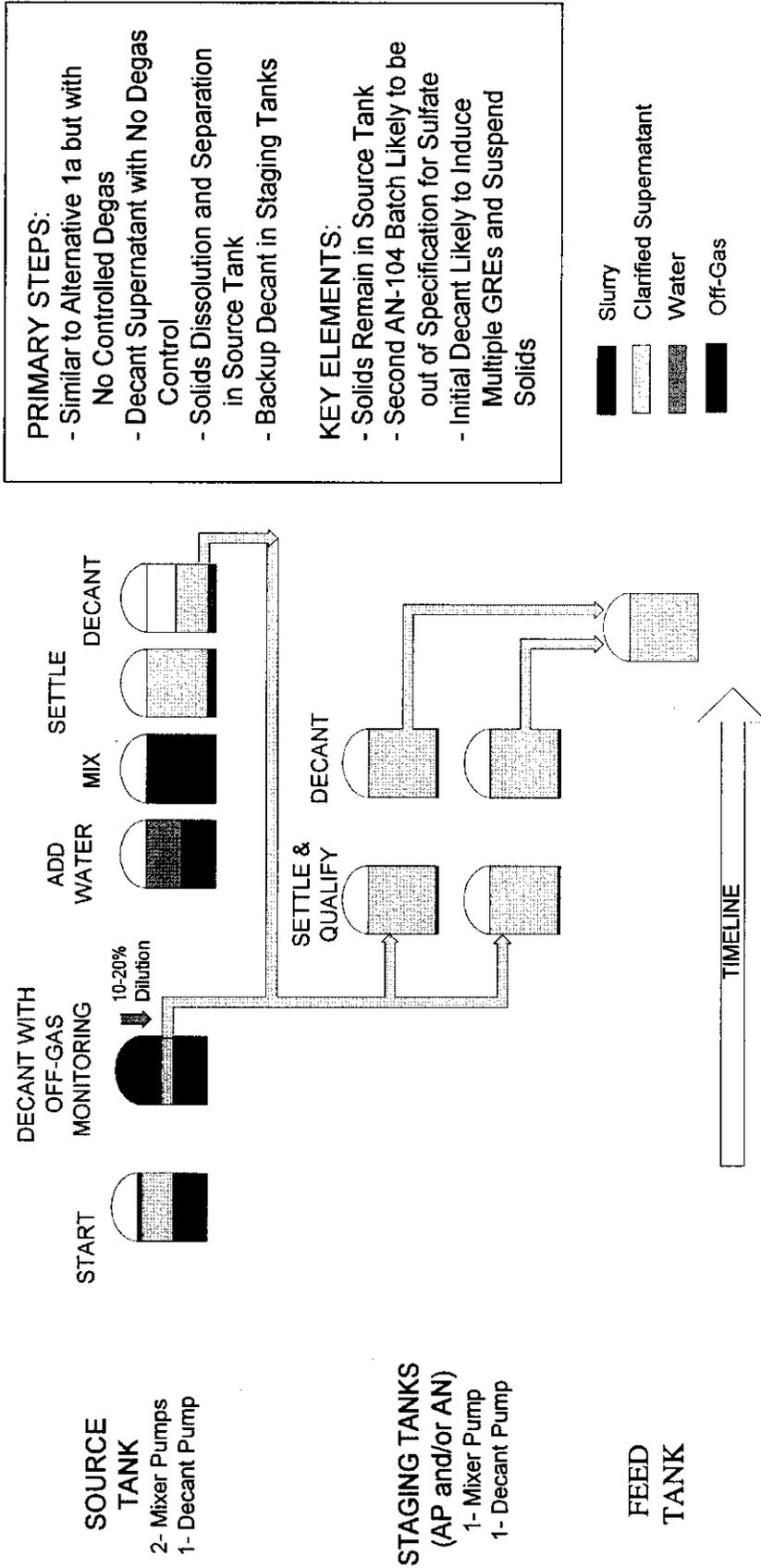


Figure 7. Alternative 4b – Decant with Simultaneous Water Addition (Feed and Bleed).

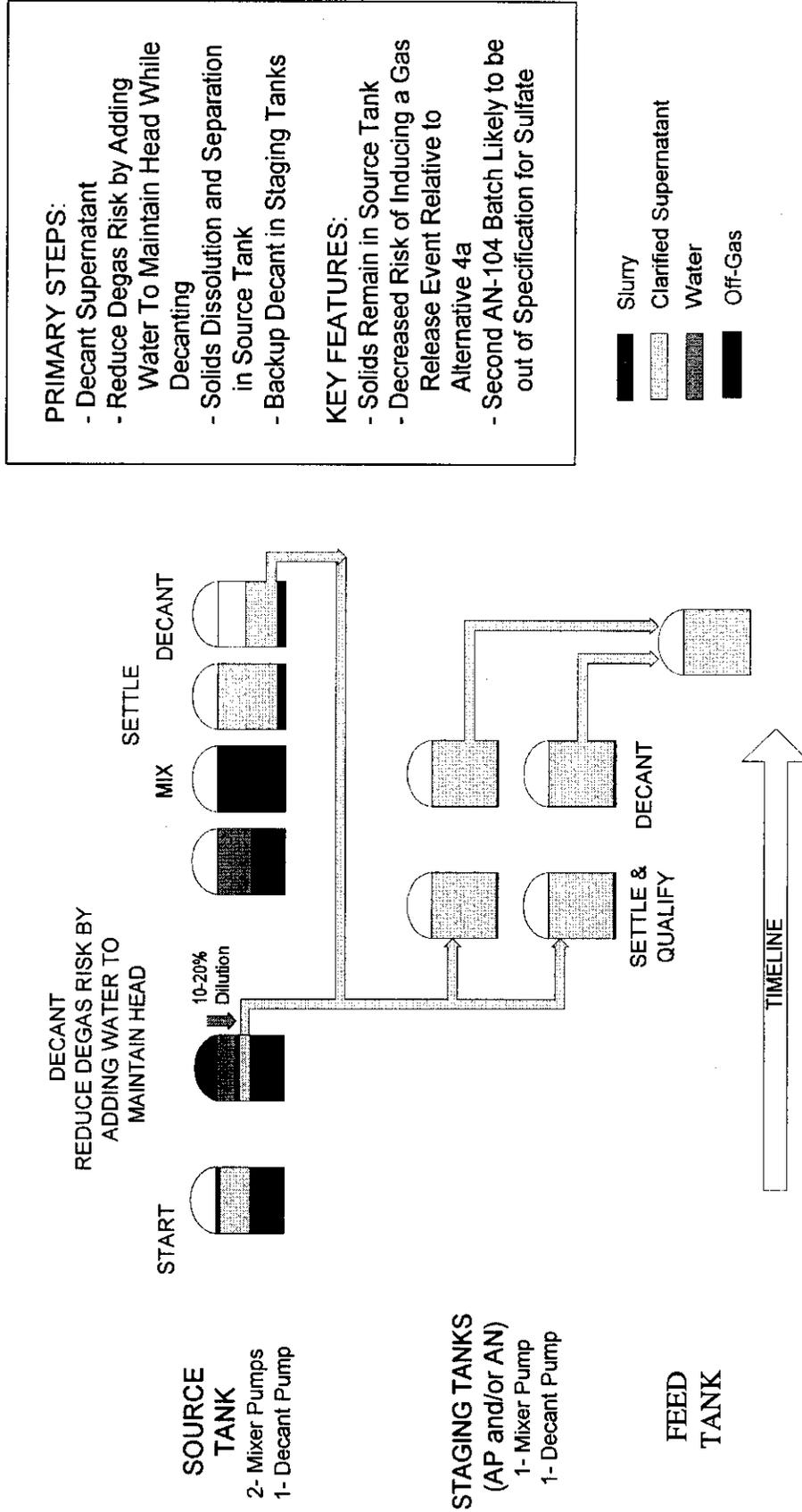




Figure 9. Alternative 5 – Sluicing.

