



UNITED STATES
NUCLEAR REGULATORY COMMISSION

REGION II
SAM NUNN ATLANTA FEDERAL CENTER
61 FORSYTH STREET, SW, SUITE 23T85
ATLANTA, GEORGIA 30303-8931

June 22, 2005

Framatome ANP
ATTN: Mr. Ronald J. Land
Plant Manager
2101 Horn Rapids Road
Richland, Washington 99352-5102

SUBJECT: NRC INSPECTION REPORT NO. 70-1257/2005-003

Dear Mr. Land:

This report refers to the inspection conducted from June 6-9, 2005, at the Richland Facility. The purpose of the inspection was to perform a review of plant operations to determine whether activities authorized by the license were conducted in accordance with NRC requirements. At the conclusion of the inspection, the findings were discussed with those members of your staff identified in the report.

The inspection consisted of selective examinations of procedures and representative records, interviews with personnel, and observation of activities in progress. No violations were identified.

In accordance with 10 CFR 2.390 of the NRC's "Rules of Practice," a copy of this letter and Enclosure 1 will be available electronically for public inspection in the NRC Public Document Room or from the Publicly Available Records (PARS) component of NRC's document system (ADAMS). ADAMS is accessible from the NRC Web site at <http://www.nrc.gov/reading-rm/adams.html> (the Public Electronic Reading Room).

Should you have any questions concerning this letter, please contact us.

Sincerely,

/RA/

David A. Ayres, Chief
Fuel Facility Inspection Branch 1
Division of Fuel Facility Inspection

Docket No. 70-1257
License No. SNM-1227

Enclosure: NRC Inspection Report

cc w/encl: (See page 2)

cc w/encl:

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 PUBLIC

X SISP REVIEW COMPLETE: Initials: A. G. SISP REVIEW PENDING*: Initials: _____ *Non-Public until the review is complete
 X PUBLICLY AVAILABLE NON-PUBLICLY AVAILABLE SENSITIVE NON-SENSITIVE
 ADAMS: Yes ACCESSION NUMBER: _____

OFFICE	RII:DFFI	RII:DFFI					
SIGNATURE	/RA/	/RA/					
NAME	OLopez	AGooden					
DATE	06/17/05	06/17/05	June 23, 2005				
E-MAIL COPY?	NO	YES	YES NO				

U. S. NUCLEAR REGULATORY COMMISSION

REGION II

Docket No.: 70-1257

License No.: SNM-1227

Report No.: 70-1257/2005-003

Licensee: Framatome ANP, Inc.

Facility: Richland Facility

Location: Richland, Washington

Date: June 6-9, 2005

Inspector: O. López, Fuel Facility Inspector

Approved by: David A. Ayres, Chief
Fuel Facility Inspection Branch 1
Division of Fuel Facilities Inspection

Enclosure

EXECUTIVE SUMMARY

Framatome ANP, Inc.
NRC Inspection Report 70-1257/2005-003

This routine, announced inspection involved observation and evaluation of the licensee's operations. The inspection identified the following aspects of the licensee's program:

- The degradations of items relied on for safety and management measures were being identified, effectively communicated to managers, and resolved in a prompt manner (Paragraph 2.a).
- The reviewed items relied on for safety were adequately implemented and maintained (Paragraph 2.b).
- Plant activities observed were performed safely and in accordance with license requirements. Housekeeping was adequate and no adverse affect on radiological safety or facility emergency egress was noted (Paragraph 2.c).
- The licensee's configuration control system for facility modifications ensured that safety significant modifications were properly reviewed, approved, and documented (Paragraph 2.d).
- Fuel manufacturing operations were conducted in accordance with approved operating procedures. The nuclear criticality safety training emphasized safety principles and practices (Paragraph 2.e).
- Functional test and calibration of the criticality alarm system were performed at the specified frequencies in accordance with approved procedures (Paragraph 2.f).

Attachment:

List of Persons Contacted

Inspection Procedures Used

List of Items Opened, Closed, Discussed

List of Acronyms

REPORT DETAILS

1. Summary of Plant Status

During the inspection period there were no plant upsets. Powder production, pellet production, and fuel assembly proceeded at normal rates.

2. Plant Operations (Inspection Procedure (IP) 88020) (O3)

a. Management and Administrative Practices (O3.01)

(1) Scope and Observations

The inspector interviewed plant personnel and reviewed selected Web Caps reports to verify that safety problems were identified, effectively communicated to management, and reported in a timely manner. The inspector noted that failures of Items Relied on for Safety (IROFS) and/or management measures were captured in Web Caps. The inspector reviewed recent Web Caps items related to failures/degradation of IROFS and management measures. The inspector verified that corrective actions were implemented adequately and in a timely manner, and that management was informed.

(2) Conclusions

The degradations of IROFS and management measures were being identified, effectively communicated to managers, and resolved in a prompt manner.

b. Safety Function (O3.02) Maintenance of Nuclear Criticality Safety Systems (O3.07)

(1) Scope and Observations

The inspector reviewed selected portions of the integrated safety analysis (ISA) and inspected a selection of IROFS in several areas of plant operations in order to verify proper implementation. Some of the reviewed IROFS included the inline monitor systems, overflows and criticality drains, high level transmitters, high temperature and pressure interlocks, nitrogen purge systems, moisture analyzers, and combustible gas detection and cut off systems. No safety issues were identified.

The inspector reviewed functional test instructions, completed tests and inspection records for the reviewed IROFS. The inspector noted that functional tests were performed at the required frequency and the instructions contained the appropriate amount of detail to perform the test. The inspector also observed a functional test of a level transmitter in the uranyl nitrate (UNH) dissolver. No safety problems were identified.

(2) Conclusions

The reviewed IROFS were adequately implemented and maintained.

c. Plant Activities (O3.03)(1) Scope and Observations

The inspector observed activities in several process areas to assess whether operations were performed safely and in accordance with license requirements.

The inspector noted that nuclear criticality safety (NCS) postings, radiological signs, and procedures were properly posted or available to the operators. The inspector did not observe any issues where the housekeeping could affect the radiological safety or emergency egress of the facility. The inspector observed that plant personnel working in radiological control areas wore dosimetry and the proper personal protective equipment. The inspector also observed proper spacing practices and moderation controls in storage locations. No safety problems were identified.

(2) Conclusions

Plant activities observed were performed safely and in accordance with license requirements. Housekeeping was adequate and no adverse affect on radiological safety or facility emergency egress was noted.

d. Configuration Control (O3.04)
Nuclear Criticality Safety Change Control (O3.05)(1) Scope and Observations

The inspector reviewed recent facility modifications to verify that safety significant modifications were reviewed, approved, and documented in accordance with procedures. The inspector discussed and reviewed with the cognizant engineers the engineering change notice packages related to recent modifications performed in select areas. The inspector verified that the operating procedures were revised to reflect the modifications and that operators had been trained in the procedure changes. In addition, the inspector verified that new or modified safety controls were tested before they were put in use.

The affected criticality safety analysis and systems drawings were reviewed to verify that they were accurately revised. The inspector confirmed that modifications to safety systems were adequately controlled and sufficient reviews were performed before and after installation. The engineering change notice packages adequately detailed the extent of the modifications.

(2) Conclusions

The licensee's configuration control system for facility modifications ensured that safety significant modifications were properly reviewed, approved, and documented.

e. Operating Procedures (O3.06)
NCS Training (O3.08)

(1) Scope and Observations

The inspector observed operators and reviewed operating procedures for select processing areas to verify that appropriate procedures were being used. The inspector noted that operators were knowledgeable and complied with the operating procedures and nuclear criticality safety requirements in their process areas.

The operating procedures adequately identified safety significant controls and addressed process parameters, startup, routine operations, and shutdown (emergency and normal). The inspector walked down selected sections of the operating procedures. No problems were identified.

The inspector reviewed lessons plans for the annual and initial criticality safety training. The training explained the safety controls that are used to prevent a criticality accident and emphasized the communication of safety violations to supervisors and managers and compliance with criticality safety requirements. No problems were identified.

(2) Conclusions

Fuel manufacturing operations were conducted in accordance with approved operating procedures. The nuclear criticality safety training emphasized safety principles and practices.

f. Criticality Alarm System (03.10)

(1) Scope and Observations

The inspector reviewed the criticality alarm system functional test and calibration records for the period January 2004 to May 2005 to verify that test and calibration were performed in accordance with approved procedures and at the specified frequency. No problems were identified.

(2) Conclusions

Functional test and calibration of the criticality alarm system were performed at the specified frequencies in accordance with approved procedures.

3. Exit Meeting

The inspection results were summarized on June 9, 2005, with those persons indicated in the attachment. Although proprietary documents and processes were occasionally reviewed during this inspection, the proprietary nature of these documents or processes has been deleted from this report. No dissenting comments were received from the licensee.

ATTACHMENT

1. **PARTIAL LIST OF PERSONS CONTACTED**

Licensee

V. Gallacher, Manager, Chemical and Waste Operations
*R. Land, Site Manager
*R. Link, Manager, Environmental, Health, Safety and Licensing
*C. Manning, Manager, Nuclear Criticality Safety
*L. Maas, Manager, Licensing and Compliance
J. Payne, Manager, Technical Support and Maintenance
*C. Perkins, Manager, Operations

Other licensee employees contacted included engineers, technicians, production staff, security, and office personnel.

*Attended exit meeting on June 9, 2005

2. **INSPECTION PROCEDURE USED**

IP 88020 Regional Criticality Safety Inspection Program

3. **LIST OF ITEMS OPENED, CLOSED, AND DISCUSSED**

<u>Item Number</u>	<u>Status</u>	<u>Type</u>	<u>Description</u>
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None

4. **LIST OF ACRONYMS USED**

ADAMS	Agency-Wide Document Access Management System
ADU	Ammonium Diuranate
IP	Inspection Procedure
IROFS	Items Relied on for Safety
ISA	Integrated Safety Analysis
NCS	Nuclear Criticality Safety
NRC	Nuclear Regulatory Commission
PARS	Publicly Available Records System
UNH	Uranyl Nitrate
UO ₂	Uranium Dioxide