



LOW LEVEL WASTE REPOSITORY STUD REPAIR GUIDANCE DOCUMENT

Summary

Subject to the foregoing this Guidance Note should be read in conjunction with the LLW Repository Ltd IP-2 ISO Container Operational Documentation. Notwithstanding any other term of this Guidance Note, this Guidance Note is intended only to support the Container Design Operational Documentation by explaining the basis of the condition requirements and providing additional information. Nothing in this Guidance Note shall be legally binding upon the Operator of the LLW Repository Ltd and all Terms and Conditions between such Operator and the Customer for the repair of Studs. In the event of any conflict between the provisions of the Guidance Note and any Stud Repair Conditions, the Container Design Approval Conditions shall prevail in all respects.

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Introduction

This document has been prepared to provide guidance on LLW Repository Ltd Sheared Stud Repair and Replacement requirements.

PART A – General Requirements

- A1 Any repairs including stud replacement to LLWR IP-2 ISO containers must be pre authorised by LLWR on submission of a repair concession.
- A2 Request for repair concession shall be made to the Transport & Logistics Team. The LLWR operational inspection authority will raise the concession on the customers behalf and will require details of:
- A2.1 Weld procedure
 - A2.2 Welder Qualification
 - A2.3 NDT Technique Sheet (only required for Level 1 Operator)
 - A2.4 NDT Operators Qualification
- A3 The LLWR IP-2 ISO container Design Authority will review the concession application and subject to approval will authorise the repair

PART B – Procedure for Sheared Stud Replacement

- B1 Replacement studs to be obtained from LLWR.
- B2 This procedure should be followed when replacing a sheared stud.
- B3. Determine area to fit the new stud (Recommended position to be approximately 50mm from the edge of the weld of the failed stud).
- Note:- The old stud is not to be refitted but to be returned to LLWR for examination (if deemed necessary) or discarded.**
- B4 Remove paint approximately 80mm diameter around the area where the new stud is to be fitted. (To allow subsequent testing of the weld and Heat Affected Zone - HAZ).
- B5 Weld the new stud in accordance with the approved weld procedure.
- B6 Carry out Dye Penetrant Inspection of the weld and HAZ. . (Acceptance Criteria – Zero indications).
- Note:- Ensure surface is thoroughly cleaned on completion.**
- B7 Carry out soapy bubble under vacuum test to the old stud position, the new stud position and HAZ in accordance with an approved procedure (Acceptance criteria – Zero bubbles).



- B8 Carry out pressure test to the adjacent orifice seal interspace in accordance with PAA G001 Issue2
- B9 Make good the paint at the repair.
- B10 On satisfactory completion of the repair and testing, a report/reports shall be raised covering repair, NDT and pressure testing. Copies must be submitted to T & L Team.

Note:- This report shall be deemed to confirm that the container is returned to service under the provision of the PA Certificate.

For any queries please contact the LLW Repository Ltd Transport and Logistics Team www.transportandlogistics@llwrsite.com.