



**2017 Winter Meeting
Key West, FL
January 24-26, 2017**



2017 Board of Directors

Chairman

2015-2017 Term

Dana Page (803-701-3596) dana.page@duke-energy.com – Catawba Nuclear Station

Vice-Chairman

2015-2017 Term

2017-2019 Term as Chairman

Steve Lisi (704-875-5124) stephen.lisi@duke-energy.com – McGuire Nuclear Station

Secretary

2017-2019 Term

To be filled at Winter 2017 meeting

Treasurer

2015-2017 Term

Kinsey Boehl (603-773-7638) kinsey.boehl@fpl.com – Seabrook

Steering Committee "At Large" Members

2015-2017 Term

Jeff Fontaine (724-462-3423) fontainej@firstenergycorp.com – Beaver Valley

John Cuffe (620-364-8831 x8080) jocuffe@wcnoc.com – Wolf Creek

Rick Rogers (805-545-3246) rwr2@pge.com – Diablo Canyon

Steering Committee "At Large" Members

2017-2019 Term

One Position open

Past-Chairman / Advisor

2015-2017 Term

Steve Edelman (717-948-8516) steven.edelman@exeloncorp.com – Three Mile Island

**** Terms begin/end after the Summer Meeting of the year indicated ****



**Key West
June 24-26, 2017**

MEETING BOOK INDEX

<u>TAB</u>	<u>TOPIC</u>
1	Meeting Agenda & Note Pages
2	Meeting Critique form
3	List of PWR Attendees by Plant Name List of Vendors Attendees by Company Name
4	Meeting Presentations
5	High Interest Topic

PWR RP/ALARA Association Meeting Agenda Key West, FL - January 2017



Monday, January 23

4:00 – 6:00 pm Steering Board Members - Pre-Meeting & Appetizers



Note To all the PWR RP ALARA Association Representatives:

This is to inform you that PWR RP/ALARA Association Meeting has been granted 1 Continuing Education Credit (CEC) per contact hour to a maximum of 20 CEC and assigned ID 2015-00-038. This credit applies to calendar years 2015-2018.

Please be advised that contact hours do not include meals or business meetings without technical content.

As credit was requested for all participants, this assignment will be posted to the AAHP website.

Tuesday, January 24



- 2:00 – 3:00 pm Meeting Registration – Salon Foyer
- 3:00 – 4:00 pm Opening Ceremonies & Introduction in Salon C:
- Welcome – Opening Remarks (Dana Page)
 - Safety Review – Building Escape Routes (Steve Lisi)
 - Safety Message – (Steve Lisi)
 - Introduction of NSA Representative – (Rick McCormick)
 - Introduction of “Host” Nuclear Plant Representative – (John Cuffe - Wolf Creek)
 - Introductions of Board Members (Dana Page)
 - Introduction of Association Members (All)
 - Association Secretary Report (Jeff Fontaine)
 - Association Treasury Report (Kinsey Boehl)
 - Establish Meeting Expectations/Review Agenda & Meeting Book Contents (Dana Page)
 - Bench Mark Question Solicitation & High Interest Topic Sheets (Rick Rogers)
 - Nominations for Secretary & “At Large” Board Member (2 Positions) (Steve Lisi)
 - Adjourn Day 1 (Dana Page)
- 4:15 – 4:45 pm Steering Committee Meeting
- 5:00 – 6:30 pm Opening Reception & Vendor Displays in Salon A & B

Wednesday, January 25



- 07:00 – 08:00 Breakfast with Vendors in Salon A & B
- 08:00 – 08:05 Meeting Overview (Dana Page)
- 08:05 – 08:10 Safety Message (Rick Rogers)
- 08:10 – 08:20 ALARA Association Group Picture
- 08:20 – 09:40 Breakout Sessions by Plant Type (Document Successes & Challenges and a Golden Nugget)
- 2 Loop & 3 Loop Westinghouse (Jeff Fontaine)
 - 4 Loop Westinghouse - will break out into 2 groups (Kinsey Boehl & Rick Rogers)
 - 4 Loop ICE (Steve Lisi & Dana Page)
 - B & W, CE and Decommissioning Units (Steve Edelman)
- 09:40 – 10:00 **Break / Vendor Interface (Report to Break out Rooms after break)**
- 10:00 – 11:30 Breakout Session by Plant Type (Document Successes & Challenges and a Golden Nugget)
- 2 Loop & 3 Loop Westinghouse (Jeff Fontaine)
 - 4 Loop Westinghouse - will break out into 2 groups (Kinsey Boehl & Rick Rogers)
 - 4 Loop ICE (Steve Lisi & Dana Page)
 - B & W, CE and Decommissioning Units (Steve Edelman)
- 11:30 - 11:40 **10 Minute Break (Report to Salon C after break)**
- 11:40 – 12:30 Vendor Presentations

12:30 – 1:30	Lunch
1:30 – 2:30	Presentation - Water jet Peening (John Cuffe - Wolf Creek)
2:30 – 2:40	10 Minute Break
2:40 – 3:30	Vendor Presentations (Remaining vendors)
3:30 – 3:40	Vote for New Board Members
3:40 – 3:50	End of Day Comments / Adjourn Day 2
4:00 – 4:30	Steering Committee Meeting
5:00 – 6:30	Vendor Reception on the Beach

Thursday, January 26



08:00 – 09:00	Breakfast with Vendors in Salon A & B
09:00 – 09:03	Safety Message (Kinsey Bohel)
09:03 – 09:05	Voting Results for New Board Members (Kinsey Bohel)
09:05 – 10:35	Breakout Session Review (Successes, Challenges and Golden Nuggets) <ul style="list-style-type: none"> • 4 Loop Westinghouse (Kinsey Boehl & Rick Rogers)
10:35 – 11:00	Break / Vendor Interface
11:00 – 12:00	Breakout Session Review (Successes, Challenges and Golden Nuggets) <ul style="list-style-type: none"> • 2 Loop & 3 Loop Westinghouse (Jeff Fontaine)

12:00 – 1:10

Lunch / Passport Drawing

1:10 – 2:10

Breakout Session Review (Successes, Challenges and Golden Nuggets)

- 4 Loop ICE (Steve Lisi & Dana Page)
- B & W, CE and Decommissioning Units (Steve Edelman)

2:10 – 2:20

Break

2:20 – 3:00

Round Table Discussions

3:00 – 3:15

Closing Remarks and Update on 2017 Summer Meeting (Charleston, SC)



June 21-23, 2017

3:30 – 4:30

Steering Committee Post-Meeting

- Opening Remarks
- Welcome New Members
- Review Meeting Critique Sheets
- New Business



Winter 2017 Key West, FL January 24-26, 2017

MEETING CRITIQUE

Optional
Name: _____
Utility: _____

The goal is to meet your expectations regarding this meeting. Please help us by providing your comments and suggestions regarding the following:

Plant Status Report: Only collected at the Summer meetings

Technical Content: _____

Vendor Participation: _____

Meeting Format (Breakout Session vs. Presentation, etc.): _____

Facilities (Meeting Room, Hotel Facilities, Location, etc.): _____

Please list any topics you would like to see the Board address in the future. Also include specific recommendations relative to the suggested presentation format, where possible (e.g. breakout session, technology presentation, survey, etc.): _____

Please provide suggestions for Board activities or actions which would help justify your company's continued participation in the PWR/ALARA Association: _____

Other Comments: _____

Do you anticipate your plant being represented by you or another representative at the Summer 2017 Meeting in Charleston, SC? _____ If not, why?

Return completed form to the Committee Secretary prior to the end of the meeting.

**PWR RP/ALARA Committee Meeting
January 24-26, 2017
Key West, FL
Attendee List by Plant**

ANO

**Melody Gibson
Entergy
1448 State Route 333
Russellville, AR 72802
479-858-7679
mgibson@entergy.com**

Callaway

**Mark VonderHaar
Ameren
PO Box 6250
Fulton, MO 65251
314-974-8661
mvonderhaar@ameren.com**

Beaver Valley Power Station

**Jeffrey Fontaine
First Energy
PO Box 4
Shippingport, PA 15077
724-462-3423
fontainej@firstenergycorp.com**

Catawba

**Dana Page
Duke Energy
4800 Concord Road
York, SC 29745
803-701-3596
dana.page@duke-energy.com**

Braidwood

**Joe Coughlin
Exelon
35100 South Route 53, Suite 84
Braceville, IL 60416
815-417-2722
joseph.coughlin@exeloncorp.com**

Corporate – Exelon

**Patrick Daly
4300 Winfield Road
Warrenville, IL 60555
815-207-0908
patrick.daly@exeloncorp.com**

Byron

**Scott Leach
Exelon
4450 N German Church Rd
Byron, IL 61010
815-406-2736
scott.leach@exeloncorp.com**

Corporate – Southern Nuclear

**James Carswell
40 Inverness Center Parkway, BIN010
Birmingham, AL 35242
205-992-5665
jacarswe@southernco.com**

Byron

**Frank Paslaski
Exelon
4450 N. German Church Rd
Byron, IL 61010
815-406-2732
frank.paslaski@exeloncorp.com**

Davis Besse

**Jim Lochotzki
First Energy
5501 North State Rt 2, DB-1029
Oak Harbor, OH 43449
419-321-7329
jalochotzki@firstenergycorp.com**

DC Cook

David Miller
AEP
One Cook Place
Bridgman, MI 49016
217-855-3238
dwmiller2@aep.com

Point Beach

Cathleen Dole
NextEra
6610 Nuclear Road
Two Rivers, WI 54241
920-755-6462
cathleen.dole@nee.com

Diablo Canyon

Rick Rogers
PG&E
P.O. Box 56, 104/2/217
Avila Beach, CA 93424
805-545-3246
rwr2@pge.com

Seabrook

Kinsey Boehl
NextEra
626 Lafayette
Seabrook, NH 01913
603-773-7638
kinsey.boehl@fpl.com

Farley

Ron Wheeler
Southern Company
7388 North State Hwy 95
Columbia, AL 36319
334-814-4864
rwheeler@southernco.com

Three Mile Island

Steve Edelman
Exelon
PO Box 480
Middletown, PA 17112
717-948-8516
steven.edelman@exeloncorp.com

McGuire

Stephen Lisi
Duke Energy
7800 Hagers Ferry Road
Huntersville, NC 28078
980-878-5124
stephen.lisi@duke-energy.com

VC Summer

Doug Rizzo
SCE&G
PO Box 88
Jenkinsville, SC 29065
803-206-9576
drizzo@scana.com

North Anna

Kevin Licklider
Dominion
1022 Haley Drive
Mineral, VA 23117
540-894-2873
kevin.licklider@dom.com

Vogle

Michelle Williams
Southern Nuclear
7821 River Road
Waynesboro, GA 30830
706-828-4236
miwillia@southernco.com

Oconee

Meghan Demm
Duke Energy
7800 Rochester Highway
Seneca, SC 29672
864-873-5899
meghan.demm@duke-energy.com

Wolf Creek

John Cuffe
WCNOC
1550 Oxen Lane NE, P.O. Box 411
Burlington, KS 66839
620-364-8831 x8080
jocuffe@wcnoc.com

Wolf Creek

James Ervin

WCNOC

698 Glasgow

Lebo, KS 66856

620-343-0242

jaervin@wcnoc.com

Wolf Creek

Bob French

WCNOC

1550 Oxen Lane NE, P.O. Box 411

Burlington, KS 66839

620-364-8831 x8745

bofrenc@wcnoc.com

PWR RP/ALARA Committee Meeting

January 24-26, 2017

Key West, FL

Vendor List by Company

ACT / Silflex Shielding

Dan Schultz
1317 Simpson Way
Escondido, CA 92029
619-913-6205
adrian@silflexshielding.com

EnergySolutions

David Wry
151 LaFayette Drive, Ste 201
Oak Ridge, TN 37830
865-481-6309
klmcreynolds@energysolutions.com

AREVA

Ron Jaworowski
Lew McKeague
John Thomas
3315A Old Forest Road
Lynchburg, VA 24501
704-877-8450
ronald.jaworowski@areva.com

Frham Safety Products

Bobby Harper
Robbie Millen
171 Grayson Road
Rock Hill, SC 29732
803-366-5131
trip@frhamsafety.com

BHI Energy

Rick Peck
Bill Peoples
97 Libbey Industrial Pkwy
Weymouth, MA 02189
508-591-1149
stephanie.fox@
bhienenergy.com

H3D

Y. Andy Boucher
3250 Plymouth Road, Ste 303
Ann Arbor, MI 48105
734-661-6416
andy@h3dhamma.com

Day & Zimmermann

Luther Jones
5426 Robin Hood Road
Norfolk, VA 23513
540-205-5802
luther.jones@dayzim.com

Innovative Industrial Solutions

Stan Robinson
2830 Skyline Drive
Russellville, AR 72802
479-857-6204
stan.robinson@i-i-s.net

Eastern Technologies/OREX

Doug Kay
215 2nd Avenue
Ashford, AL 36312
334-798-1687
bmcwaters@orex.com

ISEC Industrial Security AB

Anthony Spadaro
Sporthallsvagen 2B
Hoganas Sweden
ansp@isec.se

Lancs Industries

Ray Suarez
12704 NE 124th Street
Kirkland, WA 98034
623-363-7687
rsuarez@lancsindustries.com

Ludlum Measurements

Jeff Anspaugh
Allan Hartfield
Mike Shepherd
501 Oak Street
Sweetwater, TX 79556
325-235-5494
ctruitt@ludlums.com

Master-Lee Decon Services

Bob Burns
Rick McCormick
430 Miller Road
Medford, NJ 08055
609-953-3200
mccormick-ml@comcast.net

Mirion Technologies

Taylor Haby
John Lejeune
Jason Stevenson
Perry White
5000 Highlands Pkwy, Ste 150
Smyrna, GA 30082
203-639-2148
tpattison@mirion.com

Newport News Industrial

Tiffany Boyle
Kristin Smith
11850 Jefferson Ave
Newport News, VA 23606
757-619-2578
Tiffany.m.boyle@hii-nns.com

NPO / Eichrom Technologies

Mike Davis
Rebecca Pazos
1955 University Lane
Lisle, IL 60532
630-963-0320
rpazos@eichrom.com

NU-Energy Technologies

David Cruise
Mark Milewski
PO Box 809
Quinton, VA 23141
804-337-9331
David.cruise@
nu-energytechnologies.com

Pajarito Scientific (formerly RPS)

Tony Papso
60 Leonard Drive
Groton, CT 06340
860-445-0334
tpapso@pscnda.com

Radium Inc

Cam Abernethy
463 Dinwiddle Avenue
Waynesboro, VA 22980
540-942-5734
cabernethy@radiuminc.com

Reef Industries

Britney Marburger
Joe Oppenheimer
9209 Almeda Genoa Road
Houston, TX 77075
713-507-4270
pwest@reefindustries.com

Rolls Royce

Tom Kennedy
6546 Pond Road
Williamson, NY 14519
800-836-0285
Thomas.kennedy@
rolls-roycenuclear.com

S&W Technologies

Ralph Servati
Jim Wierowski
23 Scarborough Park
Rochester, NY 14625
585-787-9799
rservati@swtechnologies.com

Scientech/Curtiss-Wright

Jim Hedtke
44 Shelter Rock Road
Danbury, CT 06810
203-448-3329
jhedtke@curtisswright.com

UniTech Services Group

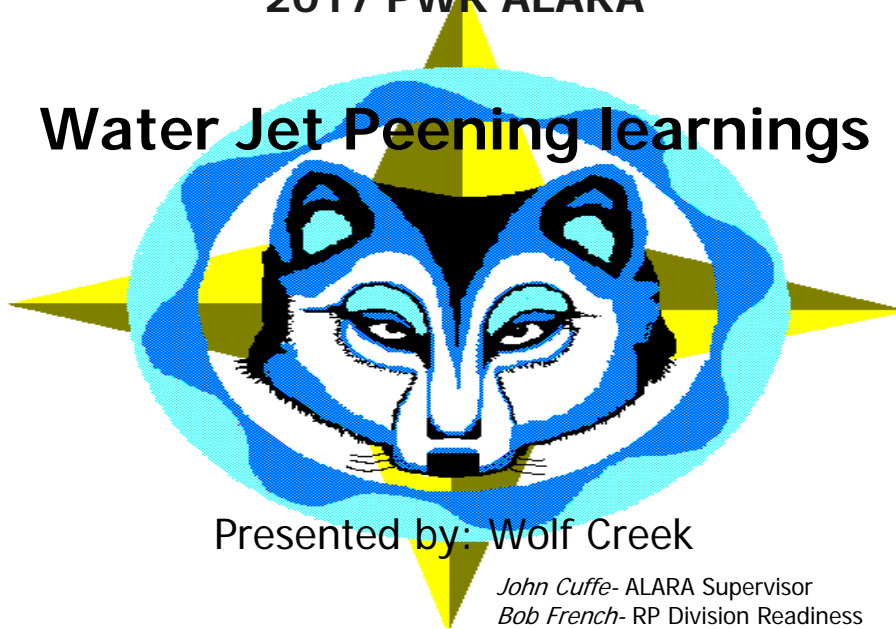
Denise Arlen
Shannon Fitzgerald
295 Parker Street
Springfield, MA 01151
413-543-6911
lperez@unitechus.com

Victoreen - Fluke Biomedical

Mark Marlowe
Mike Thompson
6045 Cochran Road
Solon, OH 44139
440-248-9300
Deanne.wodecki@
flukebiomedical.com

2017 PWR ALARA

Water Jet Peening learnings



Presented by: Wolf Creek

John Cuffe- ALARA Supervisor
Bob French- RP Division Readiness

Agenda



Safety

Why WJP	WC Learning
WJP- Terminology	WJP in Action
Project Description	Results
Tools/ Interactions-videos	Condition Reports

Feedback



Safety

Radiation Protection had 3 contract first aids with
NO
Recordable or loss time injuries!!!
&
No posting or regulatory infractions!!



Why WJP instead of MSIP?

Water Jet Peening vs. MSIP (Mechanical Stress Improvement Process)
Dose, Duration, Dollars

- ~ 10 Rem vs. ~80 Rem
- ~17 days vs. ~40 days
- ~ \$\$ vs. \$\$\$\$ (Wolf creek would have to remove/replace the permanent cavity seal ring)
- Doing Nothing was not an option. Currently Wolf Creek operates with a high hot leg temperature (3rd highest T-hot in the US) compounding the risk of primary water stress corrosion cracking.

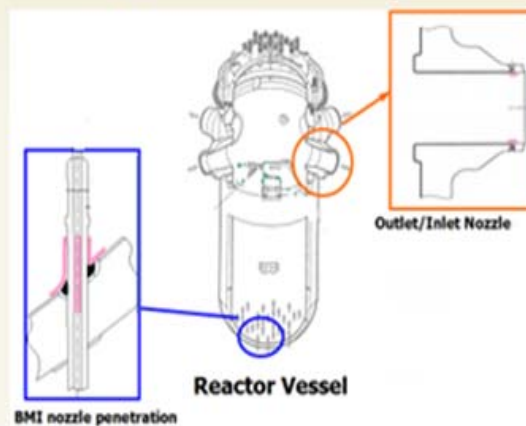
**WJP was controlled as a "Special Process" under 10CFR50 Appendix B criteria

WJP- (what and why) Terminology

- RVN-WJP tool is known as RVN tool
- BMN-NDE tool is known as NDE tool
- BMN-WJP tool is known as BMN tool
- The NDE tool is taller than the BMN tool.
- The RVN tool also does eddy current to find the boundaries of the dissimilar metal portion of the piping.
- The BMN tool has a couple of modes. Standard does the WJP and J weld. A bracket change is required to do the extended J-weld for the EJ mode.
- The BMN tool will also do eddy current of inside of BMN tubes. This is looking for any defects, but is not the typical EC with all its certs, just see something/say something.
- NDE will be performed on tubes 43-58.
- BMN is done on tubes 29-58.
- HPPS skid has three relief valves, 16,000, 18,000, 20,000. The 16,000 relieves back into the system.
- The Tri-Nuc discharges into tank 101, the large tank.
- There is a separate cooling system on the skid, down below, has own pump, closed loop, cools the PDP.
- The circles on the back of the RVN tool are counterweights
- Have to change nozzles after two loops on the RVN tool due to potential erosion of nozzle. The tool rotates upside down to make the change; they do not have to work underneath the tool.
- Have to change nozzles every 10 BMNs. Each time there is a change on both tools, they have to do a pre and post measurement of the nozzle. The tools are small feeler go/no-go probes. Have to insert them into the hole.

Project Description

Waterjet peening on 8 Reactor Vessel Nozzles (Hot and Cold legs) as well as 58 Bottom Mounted Nozzles.





Project Description_{, cont.}

Tasks requiring RP support during the outage include the following.

- Rigging equipment into and out of the cavity
- Nozzle change out and functional checks (Wet tool)
- Filter change out (Master Lee assistance)
- Personnel handling multiple cables (Wet cabling)
- Cleaning equipment when activities are complete
- Packaging equipment for shipping (In Containment)
- Removing containers from Containment to RCA Yard
- Removing containers from RCA Yard and shipping back to Alaron

Keep in mind there are two bridge working platforms so multiple tasks will be taking place at the same time.



Tools / Interactions - video

*RVN-WJP –Tool Mechanism

*RVN-WJP –Tool Installation

*RVN-WJP –Tool Implementation

Tools / Interactions – video Cont.

*BMI-NDI – Mechanism

*BMI-NDI – Implementation

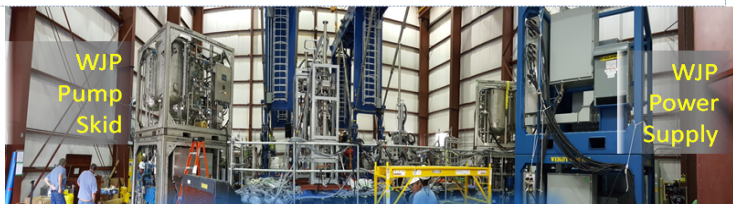
*BMI-WJP – Mechanism

*BMI-WJP – Implementation

WC Learning, Pre outage

Pre-outage mock-up training – Wampum, PA

ALARON Facility



Mockup Facility in Wampum, PA

- Mobilization and setup including bridge erection
 - BMN NDE – to establish weld boundaries
 - BMN WJP – 58 bottom mounted nozzles
 - BMN WJP extended j-welds – 11 BMNs on outer perimeter of bottom head
 - RVN UT – to determine if pre-existing cracks were present
 - RVN WJP – welds on 4 hot leg and 4 cold leg nozzles
 - Demobilization
- All were attended by WolfCreek teams



WC Learning, Training

■ ALARON Radiation Protection facility visit

This visit in support of Water Jet Peening consisted of Two teams on two separate visits. Week one 2 RP supervisors visited and provided template feedback to both our WJP and Wolf creek teams. This template was utilized as a follow up tool for our second team.

Week two team Two consisted of Two RP technicians and two different supervisors. WJP project at Alaron was receptive to feedback/coaching as the team learned more about the interactive portions of the project and provided hands on participation in the project evolutions. This was both shifts with dress out practices occurring on Wed and Thurs.

An alignment conference call was made to site on Tuesday and carried forward into performances the following days. All project members were very receptive and helpful in assisting in data gathering and knowledge sharing. The Wolf creek RP team was provided opportunities to speak during each crew brief.

The overall conclusion of the team is that the main goal was to ensure/establish open lines of communication and a teaming atmosphere. This was accomplished. Wolf Creeks Radiation Protection Expectations were conveyed in every dialog utilizing the above format.

Operations, Quality Control, Security also had similar training visits to Alaron facility in support of Water jet Peening project.



WC Learning, RWP

RWP Number:	163055	Post-job ALARA Review																																																																																																					
RWP Description:	Water Jet Peening (WJP) work activities on Reactor Vessel Nozzles (4 Cold Leg, 4 Hot Leg, and 58 Bottom Mounted Nozzle Penetrations). This is a dissimilar metal Primary Water Stress Corrosion Cracking (PWSCC) Mitigation Method used at nozzle welding locations.																																																																																																						
HP ALARA Section																																																																																																							
HP Tech:	Keith Gilliam	ACAD#	1502																																																																																																				
Review Date :	11/17/2016																																																																																																						
Percent of Estimated Exposure used:	43%	Percent of Estimated Hours used:	44.7%																																																																																																				
<table border="1"> <thead> <tr> <th rowspan="3">Task</th> <th rowspan="3">Description</th> <th colspan="6">EDR- Effective Dose Rate</th> </tr> <tr> <th colspan="2">Original-Estimate Revision # 0</th> <th colspan="2">Current Dose Estimate Revision #</th> <th colspan="2">Actual Exposure</th> </tr> <tr> <th>Hours</th> <th>mREM/ik</th> <th>mREM</th> <th>Hours</th> <th>mREM/ik</th> <th>mREM</th> <th>Hours</th> <th>EDR</th> <th>mREM</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>Mobilize/De-mobilize Equipment tools and material</td> <td>5436</td> <td>0.21</td> <td>1189</td> <td></td> <td></td> <td></td> <td>1809</td> <td></td> <td>537.2</td> </tr> <tr> <td>2</td> <td>WYS/AZZ to Perform Water Jet Peening and Support Activities</td> <td>4544</td> <td>0.21</td> <td>1024</td> <td></td> <td></td> <td></td> <td>1418</td> <td></td> <td>214.7</td> </tr> <tr> <td>3</td> <td>Sonic to Perform Water Jet Peening Activities.</td> <td>3870</td> <td>0.22</td> <td>823</td> <td></td> <td></td> <td></td> <td>1733</td> <td></td> <td>515.3</td> </tr> <tr> <td>4</td> <td>MNESMHI/WCNOG Oversight and Supervision in Support of Water Jet Peening</td> <td>2112</td> <td>0.16</td> <td>330</td> <td></td> <td></td> <td></td> <td>1773</td> <td></td> <td>314.6</td> </tr> <tr> <td>5</td> <td>Personnel In Support of Water Jet Peening Activities</td> <td>1110</td> <td>0.34</td> <td>380</td> <td></td> <td></td> <td></td> <td>215</td> <td></td> <td>59.2</td> </tr> <tr> <td>6</td> <td>RP Coverage and Decon Support for WJP NDE activities</td> <td>1536</td> <td>0.3</td> <td>570</td> <td></td> <td></td> <td></td> <td>1011</td> <td></td> <td>244.9</td> </tr> <tr> <td colspan="2">Totals</td> <td>18708</td> <td>0.24</td> <td>4416</td> <td></td> <td></td> <td></td> <td>8368</td> <td></td> <td>1885.9</td> </tr> </tbody> </table>				Task	Description	EDR- Effective Dose Rate						Original-Estimate Revision # 0		Current Dose Estimate Revision #		Actual Exposure		Hours	mREM/ik	mREM	Hours	mREM/ik	mREM	Hours	EDR	mREM	1	Mobilize/De-mobilize Equipment tools and material	5436	0.21	1189				1809		537.2	2	WYS/AZZ to Perform Water Jet Peening and Support Activities	4544	0.21	1024				1418		214.7	3	Sonic to Perform Water Jet Peening Activities.	3870	0.22	823				1733		515.3	4	MNESMHI/WCNOG Oversight and Supervision in Support of Water Jet Peening	2112	0.16	330				1773		314.6	5	Personnel In Support of Water Jet Peening Activities	1110	0.34	380				215		59.2	6	RP Coverage and Decon Support for WJP NDE activities	1536	0.3	570				1011		244.9	Totals		18708	0.24	4416				8368		1885.9
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Totals		18708	0.24	4416				8368		1885.9																																																																																													
Original Outage Duration:	62	Days	Actual Outage Duration:	66	Days																																																																																																		
RWP was revised:	0	Times	Number of RWP Dose Rate Alarms:	0	Number of RWP Dose Alarms:	0																																																																																																	
Number of RWP Contaminations:	0																																																																																																						
Comments / CRs on contaminations:	No PCIs or PCEs were experienced on this RWP.																																																																																																						

WC Learning, ALARA Package

Work Group Supervisor/HIT Leader Section

Comments on Exposure Estimate:

(Explain why exposure is <80% or >120% of original estimate. Explain revisions made to estimate. Information shall be detailed)

Actual dose on this RWP was significantly below the estimate. This was a first time task in a US Commercial Nuclear Plant. The main reason dose was lower than expected was that fewer hours were expended than expected. Because this was a first time evolution, the hours were based on performance in the Alaron mockup and on a review of the procedures. The mockup and procedures indicated a higher amount of hours, but the workers were able to work more efficiently as they gained actual field experience.

In addition, the dose rates used for the dose estimates assumed similar dose rates to those seen during refueling operations. However, dose rates were lower due to several factors:

- Time since shutdown. Due to a canopy seal weld leak on the Reactor Vessel Head, the plant shut down three weeks earlier than planned. This provided decay time and extra Reactor Coolant System cleanup time.
- Activity created by the process. For reasons documented in the ALARA Plan, no dose or dose rate information was available from the projects performed in Japan. Assumptions were made that the activity created by the process would increase dose rates on the surface of the Refuel Pool, increasing the dose rates on the walkways. However, dose rates on the surface of the water in the Pool were 1.1 to 1.3 mrem/hour throughout the project.
- Dose rates and contamination levels on the Water Jet Peening Tools. Dose rates on the tools were less than 100 mrem/hour contact. Contamination levels were less than 50,000 dpm/100 cm². No high dose rate particles or hot particles have been found. The umbilical cords are also not highly contaminated. The highest dose rate was on the RVN Tool after peening all the RVNs. Pre-Decon dose rates were 230 mrem/hour contact 30 mrem/hour at 12" coming from inside the structure of the tool. Post Decon dose rates were 130/11 mrem/hour. Contamination levels on this tool were up to 250,000 dpm/100 cm² Pre-Decon, 25 to 40,000 dpm/100 cm² Post-Decon.

Lessons Learned:

CR(s) on RWP exposure:

None

Problems Encountered and dose issues:

Procedure issues and equipment problems occurred, but this did not impact dose. The problems impacted schedule performance, but when delays occurred, the workers followed their brief and moved off the walkways.

Strengths:

The workers had good work practices, changing gloves and wiping the area down. RP coverage was excellent, providing prompt survey information.

Additional information (Suggested Enhancements for future work./ RWP Issues):

None

Post Job Comments by Work Group Supervisor / HIT Leader:

The WSI/SONIC personnel handling the WJP tooling were very experienced at moving equipment in and out of the refueling canal water. This also provided dividends to keeping contamination and PCEs very low.

WC Learning, laydown

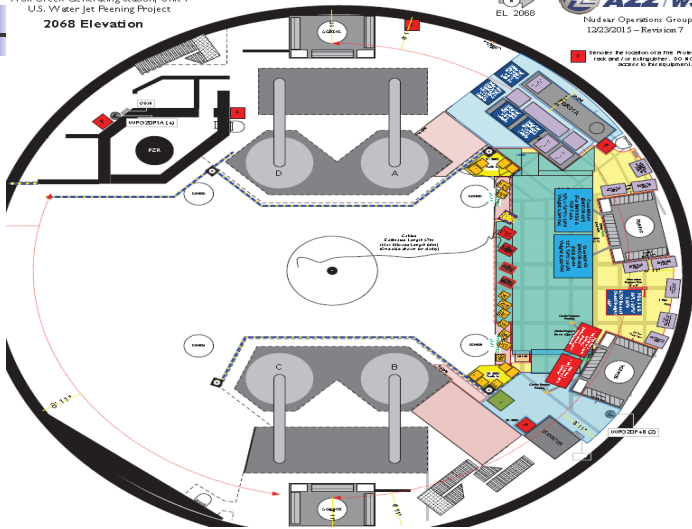
Document: 209536-LD-2068
Wolf Creek Generating Station, Unit 1
U.S. Water Jet Peening Project
2068 Elevation

CONTAINMENT

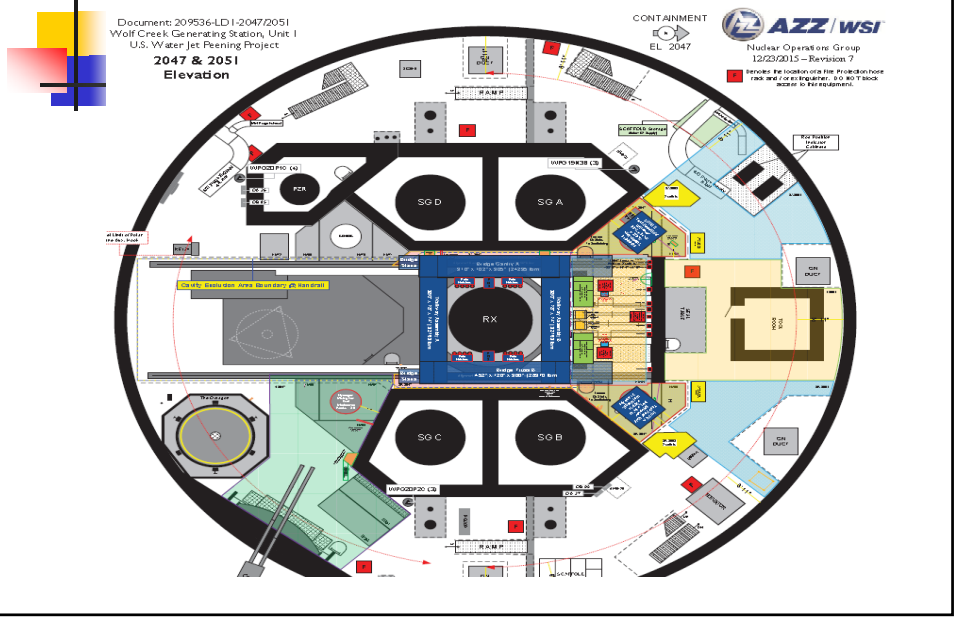
EL. 2068

AZZ / WSI
Nuclear Operations Group
12/23/2015 - Revision 7

REWORK FOR LAYDOWN OF THE PROBABLY FOR THE WJP TOOLING. DO NOT WORK WITHOUT THE REWORK.

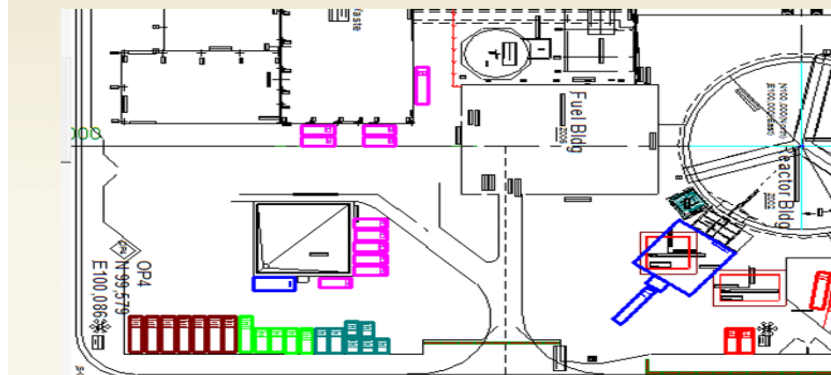


WC Learning, laydown



WC Learning, laydown

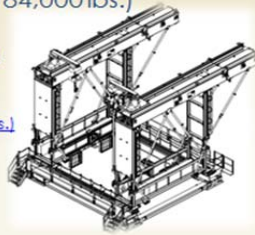
WJP laydown plan for the RCA yard



WC Learning, Equipment

Bridge System (est. weight 184,000 lbs.)

- 8 Major components
- ✓ [2 X Alignment Beams \(5,979 lbs.\)](#)
- ✓ [2 X Walkways \(32,763 lbs.\)](#)
- ✓ [2 X Truss assembly \(28,970 lbs.\)](#)
- ✓ [2 X Gantry assemblies \(24,235 lbs.\)](#)



"Big Blue" Lift System



2 High Pressure Pump Skids (HPPS)

- ✓ 31,000 lbs. each
- ✓ Staged over the Delta and Bravo Hydrogen Mixing Fans

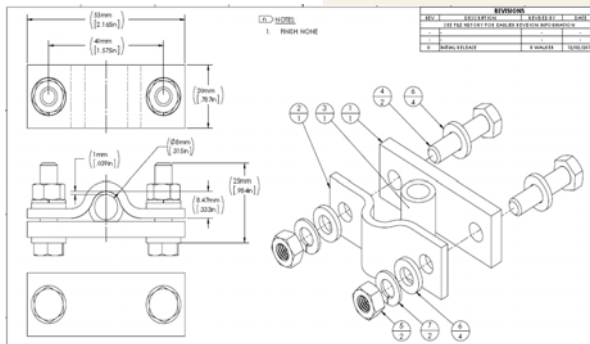
2 Power Distribution Skids (PDS)

- ✓ 6,700 lbs. each
- ✓ Staged between the Charlie and Delta Coolers

WC Learning, Seal table

Thimble Tube Clamp Installation after Low Pressure Seals are installed

- Requested video monitoring
- Need to discuss how we will handle potential leaks
- ✓ As you can see from the pictures continuing to tighten the fixture is not going to eliminate the leak as the seal starts to separate from the tubing.



WC Learning, High Pressure pump skid

- HPPS has two 50 micron filters shown below.



WC Learning, Tooling

BMN WJP tool



RVN WJP tool

2 RVN WJP tools

✓ 2,600 lbs. each

2 BMN NDE tools

✓ 1,984 lbs. each

2 BMN WJP tools

✓ 2,130 lbs. each

2 BMN VT-3 tools

✓ 3,500 lbs. each

WC Learning, Containers

- Boxes can be rigged with the tops on or off

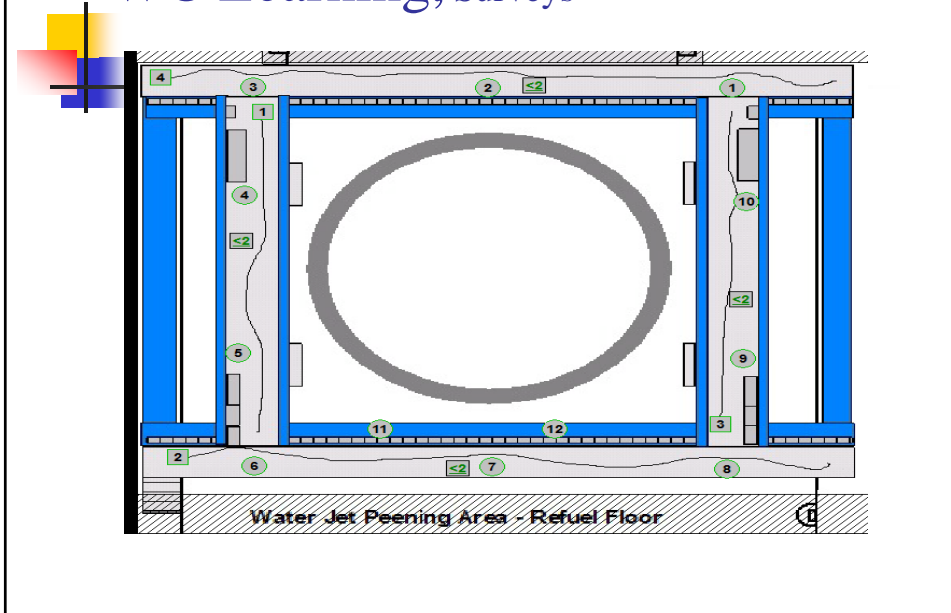


WC Learning, Filters

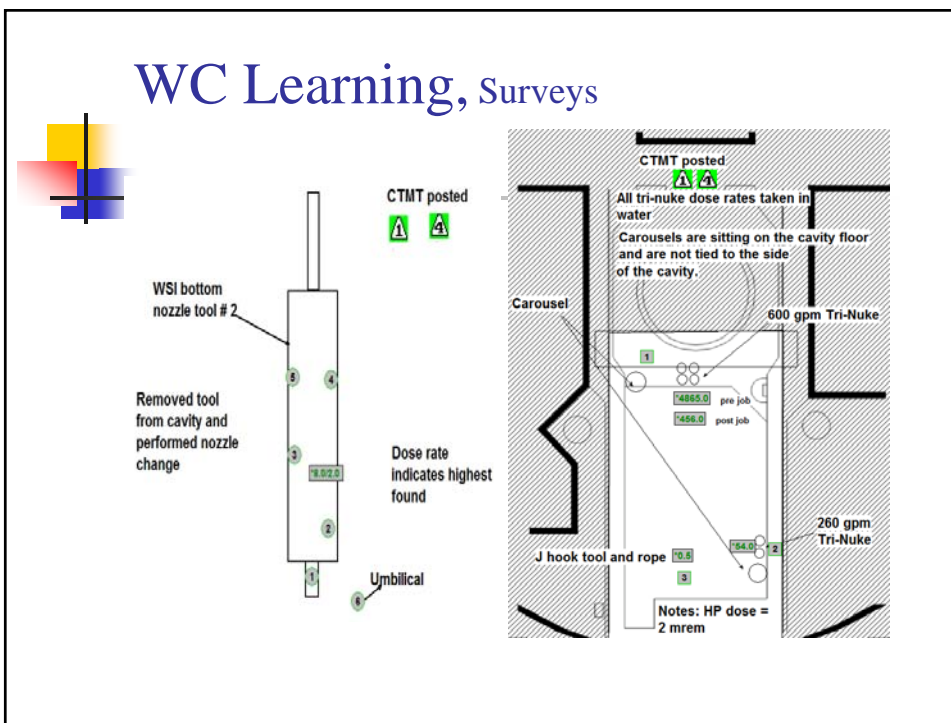
FILTER	MICRON	REASON FOR CHANGE	HOUSING DOSE RATE (Sitem/Hour)	FILTER DOSE RATE (Sitem/Hour)	FILTERS Used	COMMENTS
500 GPM Tri-Nuc (1 st)	2	DP	5.5	25.0	4	Unit was on the floor of the upper cavity just South of vessel. Ran fine until flow dropped.
600 GPM Tri-Nuc (2 nd)	2	Project Complete	1.3	2.0 to 5.0	4	The filters were pulled from housing and placed in carousel, but not surveyed.
260 GPM Tri-Nuc (1 st)	10	DP	0.550	5.0	2	Used at beginning of project to vacuum bottom of vessel after Lower Internals were removed (vessel had never been vacuumed before this).
260 GPM Tri-Nuc (2 nd)	10	DP	0.057	2.0	2	Loss of flow during RVN peening (10/17).
260 GPM Tri-Nuc (3 rd)	10	DP	0.110	0.300	1	Only one filter was removed and replaced. Interference from hoses/wires prevented opening the other filter hatch. Late in project.
260 GPM Tri-Nuc (4 th)	10	Job Complete	Not Surveyed	Not Surveyed	2	The remaining filter from set 3 was removed along with the one that was changed (see above). A replacement set of filters was inserted (the filters used were the ones removed from the WS1 units, still stored in carousels on cavity floor) and the cavity was vacuumed before draining it. No chance for a survey.
WS1 East Modified 260 GPM Tri-Nuc	5	Job complete	0.048	Not Surveyed	2	Filters ran all through the project. Did not have to be changed.
WS1 West Modified 260 GPM Tri-Nuc	5	Job complete	0.057	Not Surveyed	2	Filters ran all through the project. Did not have to be changed.
HPPS Skid Filters	48	Job Complete	0.009	0.050*, 0.002 at 12"	4	The dose rates listed were on one filter, the other three filters were less than 0.002 ccm/hour.
First FBG06 After Project Complete		DP	18	57.8	1	After project was complete, mid-loop period complete, flooded up and moving fuel. 11/5/16
Second FBG06 After Project Complete		DP	7.1	25.2	1	Fuel Movement complete. 11/9/16
First FEO1A After Project Complete		DP	1.8	8.5	1	11/7/16
First FEO1B After Project Complete		DP	1.2	11.5	1	11/7/16

* 19 total Tri-Nuc filters used including vacuuming vessel and vacuuming floor prior to drain down.
 * No issues with pool clarity during the project.

WC Learning, Surveys



WC Learning, Surveys



WC Learning, Surveys

CTMT Posted
Seal Table

RVN tool was removed from the water 2-3mRem General area while suspended above the water. Suction cups were 6-10mRem/hr, 300K Smear was taken on suction cup. Alpha Level II with wet smear, saved 50% of the smears to be counted for alpha, will be counted again when dry, 200K on Nozzle, RVN was moved from the vessel to the play pen, 1st 8 smears taken on RVN Tool smears 9-19 taken on the bridge and work area outside of the HCA

Water Jet Peening Area - Refuel Floor

Smear Data Entry			
Smears 100 sqcm:			
ID	Beta/Gamma	Engr Units	B/G Inst
1	300000.0	DPM	LUD-177 #
2	40000.0	DPM	LUD-177 #
3	40000.0	DPM	LUD-177 #
4	100000.0	DPM	LUD-177 #
5	60000.0	DPM	LUD-177 #
6	30000.0	DPM	LUD-177 #
7	250000.0	DPM	LUD-177 #
8	10000.0	DPM	LUD-177 #
9	1000.0	DPM	LUD-177 #
10	2000.0	DPM	LUD-177 #
11	<1K	DPM	LUD-177 #
12	<1K	DPM	LUD-177 #
13	<1K	DPM	LUD-177 #
14	<1K	DPM	LUD-177 #

Water Jet in Action

BMN WJP tool

RVN WJP tool

Peened BMN

Unpeened BMN

10/21/2016 07:26

Water Jet Results



Condition Reports(21)

AR/CR/PIR #	SUBJECT	DESCRIPTION	INITIATED
00106802	Damaged RVN Water Jet Peening Tool	Water Jet Peening 12655 – During mock up training off site one of the RVN Water Jet Peening tools was damaged. The ECT probe on the RVN tool was caught on a screw which was holding one of the dissimilar metal coupons in place; this caused the probe and bracket to become damaged/bent. This will not be an issue on site as we do not have these screws or coupons in our Reactor Vessel Nozzle. The Water Jet Peening contractor has spare probes at the training facility which can be replaced but does not have a spare bracket. They have contacted their home office in Japan and currently plan to have an individual bring it to the training facility by Sunday. This CR is to track the vendor repair of the damaged tooling and does not affect any plant equipment. This CR should be assigned to Engineering Projects.	08/31/2016
00107126	WJP project concern: Evaluation of protective corrosion layer	During water jet peening, surface corrosion/coating/cure removal occurs. It should be evaluated if the plant has any requirements to maintain this layer or documentation that the layer is not required should be included in the package closeout.	09/14/2016
00107127	WJP project concern: Use of borated water	Water jet peening project will be using borated water during some of the peening operations. The inspection/peening equipment is of Japanese design and has been successfully used with borated water (at what concentration?) and pure water per their report. The support equipment that has been fabricated to provide high pressure water to the equipment, however, has not been operated with borated water (pure tap water was used in mockups). Appropriate evaluation of this equipment and/or testing with borated water should be performed. Specific concerns include escalated nozzle wear during peening operations, plating of boron inside equipment changing operational parameters, cold weather exposure of potentially stagnant borated water in the support equipment (heat trace), and changes in surface effects (potential primary piping cladding penetration, embedded boron, lack of intended peening effect) on peened primary targets with highly borated water.	09/14/2016

Condition Reports cont.

00107742	Potential for Foreign Material in the RCS	This CR is being generated to document the potential of foreign material in the reactor coolant system as a result of the failure of the normal charging pump (PBG04). It has been discussed that since the normal charging pump (NCP) internals seized from full rotational speed in an expeditious manner, there is a possibility that material was removed from the internals of the NCP and has been deposited in the discharge piping. This discharge piping is also common with the safety related centrifugal charging pumps which have been operated since the damage occurred to the NCP which could have deposited debris throughout the RCS. At the time of the damage, flow was established to the RCP seals; however any debris in this line would have been captured in the seal injection filters and is not a concern. The inspection of the lower core plate was completed after core offload with no foreign material found. There are currently plans to remove the lower internals to support waterjet peening at which time further inspections for foreign material will occur. When the normal charging pump internals are replaced under WO series 16-417884, the pump internals should be inspected to determine if any material is missing to decide if further piping inspections for foreign material are warranted.	09/30/2016
00107792	RVN Water Jet Peening Delay by Contractor WSI	RVN Peening delay by Contractor. WC was notified by WSI (Puzan) on 9-28 that all the WSI Sonic personnel will need 4 hours of Traveler training as required by the WSI QA program. This training is required due to all of the Traveler changes that were made at Alaron during crew training. This training is being performed on Critical Path time.	10/01/2016
00107806	Containment 2068 Elev Temporary Work Platforms	The two (2) 2068' elevation work platforms erected for the Water Jet Peening (WJP) Project during RF21 were inadvertently erected and subsequently accepted by Project Engineering without having the deck support beams secured from below by clamping runners of scaffold poles to the bottom flanges as required by Note 8 of Attachment 2 of the TCC BED for SWOs 15-402898-035, -036, and -039. These scaffold runners serve to maintain the alignment of the beams necessary to secure the deck plates as well as to stabilize the assembly for deck installation. The scaffold poles were also to serve as connection points for an edge handrail fabricated from scaffold poles. Each deck beam is currently secured by wire to the 2068' elevation floor grating and the platform deck plate and beams are banded together as required; consequently, the platform is stable and secure, is not an immediate safety concern, and can be used as erected. Nevertheless, Project Engineering recommends that the scaffold runners be installed to add structural stability and as a complement to the wire tie-offs, as intended. This condition report should be assigned to the Water Jet Peening Project Manager for resolution.	10/02/2016

Condition Reports cont.

00108251	Water Jet Peening BMN Tool Failure MNES	On 10-10 a Servo error was received when WJP BMN-NDE tool #1 was lowered into the Reactor vessel. The tool was lifted from the vessel and examined. Troubleshooting determined that the video camera servo position sensor (VT-1) integrated circuit failed upon entry into the water. During repair of the video position sensor two integrated circuits (for TV-2, RV-2 and RV-1) were accidentally short circuited and failed. Ref. MNES NCR SP-16-006	10/11/2016
00108277	Linear Indication on Weld of BMN Number 21	A linear indication was identified by AZZ/WSI on the weld of Reactor Vessel Bottom Mounted Nozzle (BMN) number 21 during the Non-Destructive Examination (NDE) for the Water Jet Peening (WJP) Project during RF21 (reference drawings M-706-00008 and M-706B-00012). The linear indication was documented by AZZ/WSI in MNES/WSI NCR 16-334 and the associated "Remote Visual Inspection Report" (see Attachment). The linear indication should be evaluated by the responsible plant group(s). This condition report should be assigned to the ISI Program for initial evaluation and resolution.	10/12/2016
00108282	Debris attached to WJP tooling	While setting BMN NDE Tool #2 over RV BMN #1 the technicians in the control trailer noticed a small amount of white debris adhered to the tool's nozzle head. The foreign material and quantity is unknown at this time. At the end of the Water Jet Peening project there will be a visual inspection of the vessel to make sure there is no visible debris left in the cavity. Project team will attach pictures to this CR once available.	10/12/2016
00108362	Aggreko technician turned off wrong fuel valve on Temp Gen.	Aggreko technicians on site to perform Maintenance on the two generators supplying temporary power for the RVN Water Jet Peening tools. An Aggreko technician turned off the fuel valve to the operating generator causing a loss of power to the NDE tooling. Although the power was only off a few seconds this caused significant delay to the WJP Operators. The computers had to be rebooted and functional checks completed on the tooling. Also this may have caused a spike in air pressure to the tooling causing cable jacket damage.	10/15/2016
00108384	Indication on Weld of BMN Number 29	An indication was identified by AZZ/WSI on the weld of Reactor Vessel Bottom Mounted Nozzle (BMN) number 29 during the Non-Destructive Examination (NDE) for the Water Jet Peening (WJP) Project during RF21 (reference drawings M-706-00008 and M-706B-00012). The indication was documented by AZZ/WSI in MNES/WSI NCR 16-340 and the associated "Remote Visual Inspection Report" (see Attachment). The indication should be evaluated by the responsible plant group(s). A work order request should also be generated for Wolf Creek QC to evaluate the results of the WSI examination.	10/15/2016


Condition Reports cont.

00108415	Water Jet Peening - WSI missed signing Master Work Traveler	WSI Operators were working thru the Traveler steps for placing RVN tool #1 into the water when it was identified that Master traveler did not have QC hold point signature for the peening spray nozzle torque. QC did verify torquing but failed to complete administrative sign off in work document	10/16/2016
00108455	Clarify WJP Contractor Procedure QAP 9.3R Exam Criteria	During the Water Jet Peening (WJP) Contractor's implementation of Contractor's procedure QAP 9.3R, Rev. 0, Remote Visual Examination of Bottom Mounted Nozzles (BMNs), there have been several visual examination reported indications documented by Contractor's visual examiners. This CR is written to document the need for improved guidance/clarification on implementing the current Revision 0 and for a procedure revision to QAP 9.3R to incorporate such guidance/clarification on the examination and reporting criteria for these visual examinations. Most of the reported indications have been construction-type indications, which are not in accordance with the stated procedure purpose. That purpose as stated in QAP 9.3R (step 1.3.1), is to "assure there is no evidence of pre-WJP primary water stress corrosion cracking". Stated differently, the purpose is to identify service-induced indications in the prescribed examination areas that are pertinent to pre-WJP exams. The indications being reported are not service-induced indications or are outside the prescribed examination areas and do not need to be identified or reported to WCNOC. This is because the construction of the Reactor Vessel and the BMNs (including most of the indications being identified) were previously examined and accepted by appropriate Code required construction and preservice examinations prior to Wolf Creek initial operation and no internal work to the Reactor BMNs has been performed since construction. It is recommended that this CR be assigned to WCNOC RVNM WJP Project and that the Project engineering personnel meet with its WJP Contractor Team (MNES and WSI) to assure the Contractor's visual examiners understand the WCNOC requested and approved visual examination and report criteria as stated in Contractor's procedure QAP 9.3R, Rev. 0. It is also recommended that the Contractor incorporate WCNOC recommended changes to the procedure criteria in the upcoming revision planned for QAP 9.3R.	10/17/2016
00108456	WJP Project Work Instruction Change and	During Water Jet Peening (WJP) Project activities, WSI issued a change to work instruction (WI) WJP-WI-10, Pre-RVN-WJP-Functional Checks, Revision 2 via NCR 16-342 before the WI revision had been transmitted to and accepted by WCNOC. The change to the WI via NRC 16-342 was accepted by	10/17/2016

Condition Reports cont.

00108495	WJP Project Inconclusive ECT Data on RVN C Cold Leg Weld	During the Water Jet Peening (WJP) process for the RVN "C" Cold Leg, Eddy Current Testing (ECT) data for sizing of the weld boundary on the stainless steel cladding side of the weld was unexpectedly inconclusive as documented in MNES NCR SP-16-010 (see Attachment). As a result, a change to the WSI traveler 209536-TR-002-CL (M-706B-00022) will be required to potentially add a partial 4th pass for WJP of the subject nozzle weld. WCNOC will prepare an IFCN for CCP 012655 to accept the change to the WSI traveler. This CR should be assigned to the WJP Project Manager for evaluation and resolution.	10/18/2016
00108550	Indication on Weld of BMN Number 24	A linear indication was identified by AZZ WSI on the weld of Reactor Vessel Bottom Mounted Nozzle (BMN) number 24 during the Non-Destructive Examination (NDE) for the Water Jet Peening (WJP) Project during RF21 (reference drawings M-706-00008 and M-706B-00012). The linear indication was documented by AZZ WSI in MNES WSI NCR 16-348 and the associated "Remote Visual Inspection Report" (see Attachment). The linear indication should be evaluated by the responsible plant group(s) (e.g., Quality Control and ISI Program). A work order request should also be generated for Wolf Creek QC to evaluate the results of the WSI examination.	10/19/2016
00108626	WJP Project Inconclusive ECT Data A Cold Leg RVN Weld	During the Water Jet Peening (WJP) process for the A Cold Leg RVN, Eddy Current Testing (ECT) data for sizing of the weld boundary on the stainless steel cladding side of the weld was unexpectedly inconclusive as documented in MNES NCR SP-16-012 (see Attachment). As a result, a change to the WSI traveler 209536-TR-002-CL (M-706B-00022) will be required to potentially add a partial 4th pass for WJP of the subject nozzle weld. WCNOC will prepare an IFCN for CCP 012655 to accept the change to the WSI traveler. This CR should be assigned to the WJP Project Manager for evaluation and resolution.	10/21/2016
00108630	WSI Peening with wrong revision of Work Traveler MNES	During performance of waterjet peening on the RVN "A" cold leg it was identified by the Peening Operator they were using a traveler that had been superseded. The second peening pass was in progress when this was identified. This peening pass was completed and work was stopped. WSI Supervision was notified. WSI Quality Assurance Management issued a Stop Work for WSI Peening activities.	10/21/2016
00108792	RVN WJP tool nozzle failed post use verification check.	RVN Peening - MNES Supplier Nonconformance Report 16-352 was submitted to WC on 10-25 documenting a "burn" found on the RVN water jet peening tool nozzle during Post use verification. During the post use verification check a Go-No-Go (1.95mm) pin gauge could not be inserted into the nozzle ID bore. This tool nozzle was used to perform peening on RVN "C" and "D" cold leg (inlet) nozzles.	10/25/2016

Condition Reports cont.



00108977	Lift Contacting Jib Crane in Containment KAN SEAL	HARD COPY CR: While performing work inside containment an individual witness a lift that was being performed on WSI walkway for water jet peening come into contact with the jib crane. Contacted project oversight and containment coordinator. No apparent damage was noted from either the walkway or jib crane.	11/01/2016
00109063	Reactor Vessel Nozzle BMN #40 Peening flowrate	This CR has been generated for tracking purposes. WSI has generated NCR 16-383 to identify that during review of CSV files of BMN #40, it was noted that the Water Jet Peening flow rate momentarily decreased below the minimum range specified in PMP-TSP-13, WJP Controlled Parameter Listing. MNES and MHI evaluated this condition and determined that occurrence of low flowrate had no adverse effect on WJP in PWSCC susceptible areas of BMN #40 and that BMN #40 was effectively peened in all required mitigation areas. The MHI evaluation was documented in MNES NCR SP-16-017 and attached WSINCR 16-383 (Attached to this CR).	11/03/2016



Feedback-

HIGH INTEREST TOPIC AND QUESTIONNAIRE
PWR ALARA Association Key West, FL January 24-26, 2017

Topic:

Contact (Name)	Plant	NSSS	Comments
	GINNA	2LW	
	Kewaunee	2LW	
	Point Beach 1,2	2LW	
	Prairie Island 1,2	2LW	
	Ringhals 2,3,4	2LW 3LW	
	Beaver Valley 1,2	3LW	
	Farley 1,2	3LW	
	Harris	3LW	
	North Anna 1,2	3LW	
	Robinson	3LW	
	Surry 1,2	3LW	
	Turkey Point 1,2	3LW	
	VC Summer	3LW	
	Braidwood 1,2	4LW	
	Byron 1,2	4LW	
	Callaway	4LW	
	Catawba 1,2	4LW	
	Comanche Peak 1,2	4LW	
	Cook 1,2	4LW	
	Diablo Canyon 1,2	4LW	
	Indian Point 2,3	4LW	
	McGuire 1,2	4LW	
	Salem 1,2	4LW	

Return completed form to the Committee Secretary prior to the end of the meeting so that it may be included in the meeting report.

HIGH INTEREST TOPIC AND QUESTIONNAIRE

PWR ALARA Association

Key West, FL

January 24-26, 2017

Topic:			
Contact (Name)	Plant	NSSS	Comments
	Seabrook	4LW	
	Sequoyah 1,2	4LW	
	Sizewell B	4LW	
	South Texas 1,2	4LW	
	Vogtle 1,2	4LW	
	Watts Bar	4LW	
	Wolf Creek	4LW	
	Millstone 3,2	4LW, CE	
	Calvert Cliffs	CE	
	Ft. Calhoun	CE	
	Palisades	CE	
	Palo Verde 1,2,3	CE	
	San Onofre 2,3	CE	
	St.Lucie 1,2	CE	
	Waterford	CE	
	ANO 2,1	CE, B&W	
	Crystal River	B&W	
	Davis Besse	B&W	
	Oconee 1,2,3	B&W	
	TMI	B&W	
	Areva		
	EDF		
	Westing- house		

Return completed form to the Committee Secretary prior to the end of the meeting so that it may be included in the meeting report.