



Cleanup Progress Report

October – December 2000

Fluor Hanford

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Project Hanford Management Contractor:
Fluor Hanford, Inc., A Fluor Global Services Company

- Principal Subcontractors:
- DynCorp Tri-Cities Services, Inc.
 - Numatec Hanford Corporation
 - Protection Technology Hanford
 - Duratek Federal Services of Hanford, Inc.

- Technology Management:
- Pacific Northwest National Laboratory

- Environmental Restoration Contractor:
- Bechtel Hanford, Inc.

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1ST QUARTER FISCAL YEAR 2001 HIGHLIGHTS

K Basin Fuel Removal Begins

Our cover photos illustrate a major step forward in Hanford cleanup that took place this past quarter: the initiation of spent fuel removal from the K Basins. Although spent fuel is routinely dried and stored at nuclear power plants around the world, the task at Hanford has never been attempted anywhere before. One factor is that the Hanford fuel is solid uranium metal, unlike the oxide powder or pellet form used in most commercial nuclear reactors – making the job one of the riskiest and toughest in the cleanup universe.

When the transport trailer bearing the first canister loaded with spent fuel pulled out of the loadout bay at the

K West Basin on December 7, it was a sight cheered by the dozens of Spent Nuclear Fuel Project employees and observers on hand. The achievement is a source of great pride for the nearly 800 dedicated Project workers who made it happen, and I was proud to join them on that historic day in signing a commemorative poster. Joining me were Keith Klein, manager of the Department of Energy's Richland Operations Office, Dave Van Leuven, Fluor Hanford executive vice president who has capably led the Project team for the past six months, and Phil Loscoe, director of Spent Nuclear Fuels for DOE-Richland.

Safety Performance Sets Records

Equally impressive was the superb safety record of the Spent Nuclear Fuel Project team – well over two million

Continued

1ST QUARTER FISCAL YEAR 2001 HIGHLIGHTS (CONTINUED)

safe work hours without a lost workday injury. Their contribution enabled the full Fluor Project Hanford team to achieve a DOE complex “best” record of 11 million safe work hours.

Fluor Hanford also earned an Association of Washington Business “Better Workplace” merit award for firms with more than 250 employees because of “strong support for workplace safety and employee involvement in workplace improvements.” Indeed, the nearly one full year without an injury causing a workday to be lost was the result of the diligent efforts of all 5,500 employees to improve the safety and quality of work performed.

Focus Is On Outcomes

In this report, you’ll learn more about our spent fuel work and our safety achievements, along with other cleanup progress. In addition to a redesign for Fiscal Year 2001, we’ve grouped accomplishments by outcome:

restoring the river corridor, transforming the central plateau for long-term waste management, and preparing for the future. We’re including the contributions of our technology management partner, the Battelle-run Pacific Northwest National Laboratory, and noting key environmental restoration work led by our colleague, Bechtel Hanford.

I am pleased that DOE extended our role in Hanford’s cleanup through fiscal 2006, and look forward to keeping you apprised of our ongoing progress.



*President and Chief Executive Officer
Fluor Hanford*

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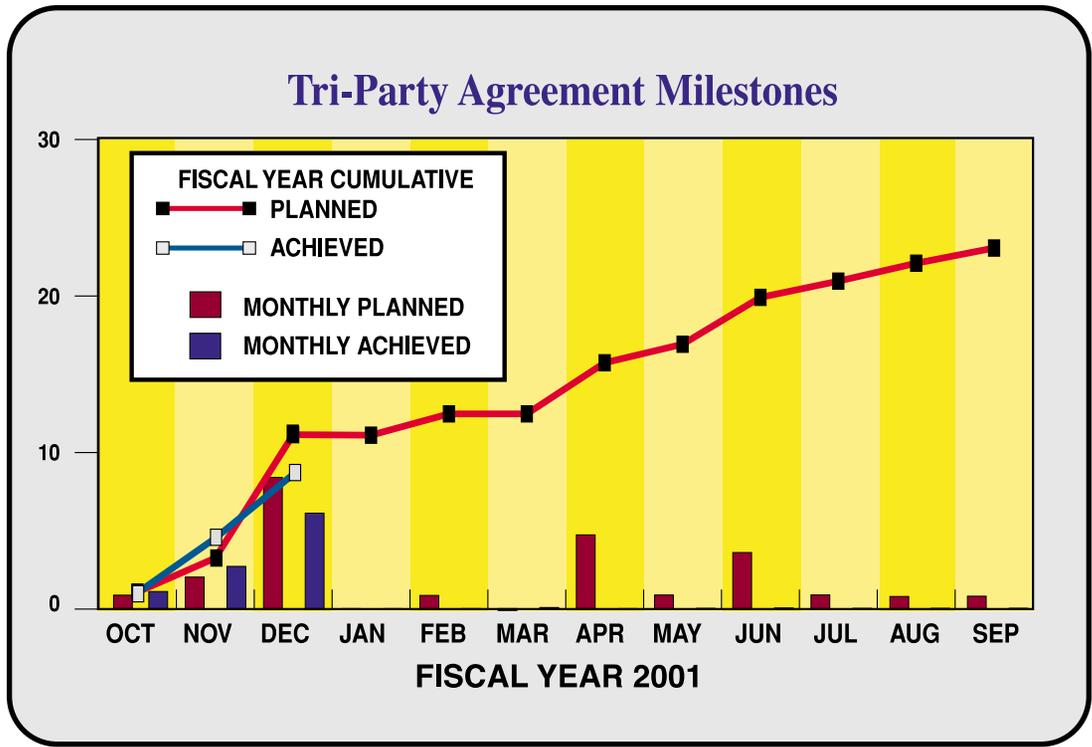
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This fiscal year, Fluor Hanford and its subcontractors, along with DOE's Environmental Restoration Contractor, Bechtel Hanford, are expected to achieve 23 key milestones spelled out in the Tri-Party Agreement that governs Hanford cleanup. Fluor Hanford is directly responsible for eight of those milestones. The chart shows two are overdue. Unexpected technical and mechanical issues precluded full cleanout of the mixed waste and equipment in the radiochemical engineering room known as B Cell in the 300 Area's 324 Building by the November 30 Tri-Party Agreement due date. However, the River Corridor

Project has made a commitment to complete the task by the end of March. Also, thermal treatment of low-level waste by a local vendor did not gear up to full operations as planned this past quarter, but is expected to get under way in the current quarter.

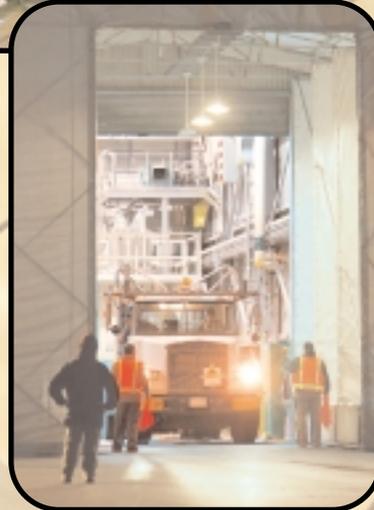
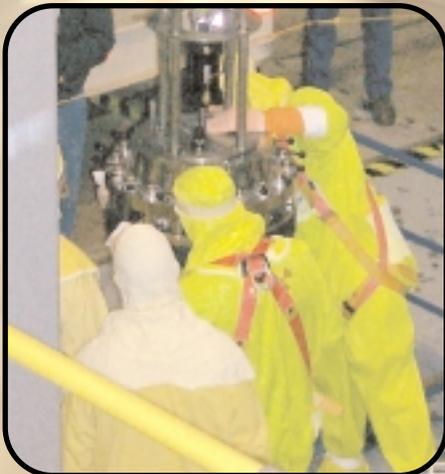
Tri-Party Agreement Milestones



RESTORING THE RIVER CORRIDOR

Spent Nuclear Fuel Project

December 7, 2000, was an historic day for Hanford, when the first batch of spent nuclear fuel was successfully removed from the K West Basin, 400 yards from the Columbia River, and transported to the nearby Cold Vacuum Drying Facility. Following a successful drying cycle, the multi-canister overpack, or MCO, with its six baskets holding 288 fuel elements, was transported to the Canister Storage Building eight miles away in central Hanford. There, the MCO was placed in safe, long-term storage in a steel tube in a below-ground vault.



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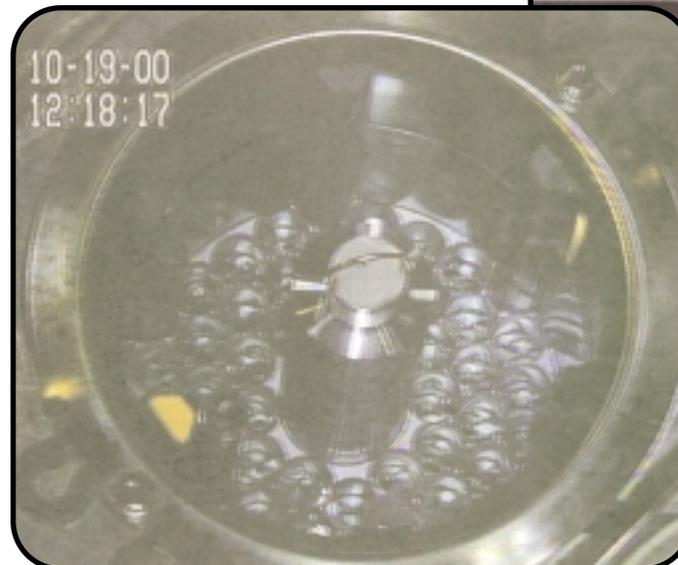
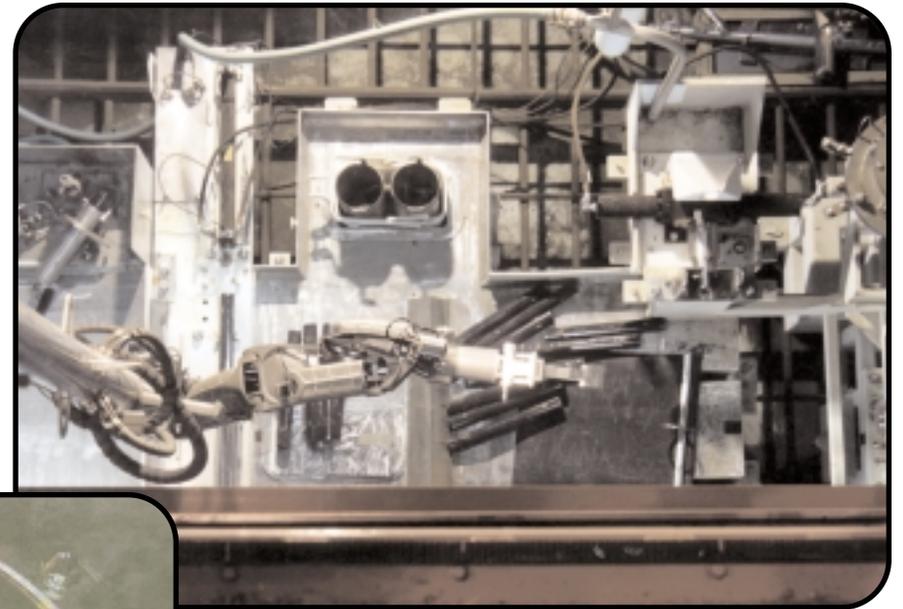
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Spent Nuclear Fuel Project

The start of fuel removal from the K West Basin was the culmination of intense readiness reviews of the Basin, the cask transportation system, the drying facility and the storage building, plus careful, repeated testing of equipment and training of operators over the past several months.



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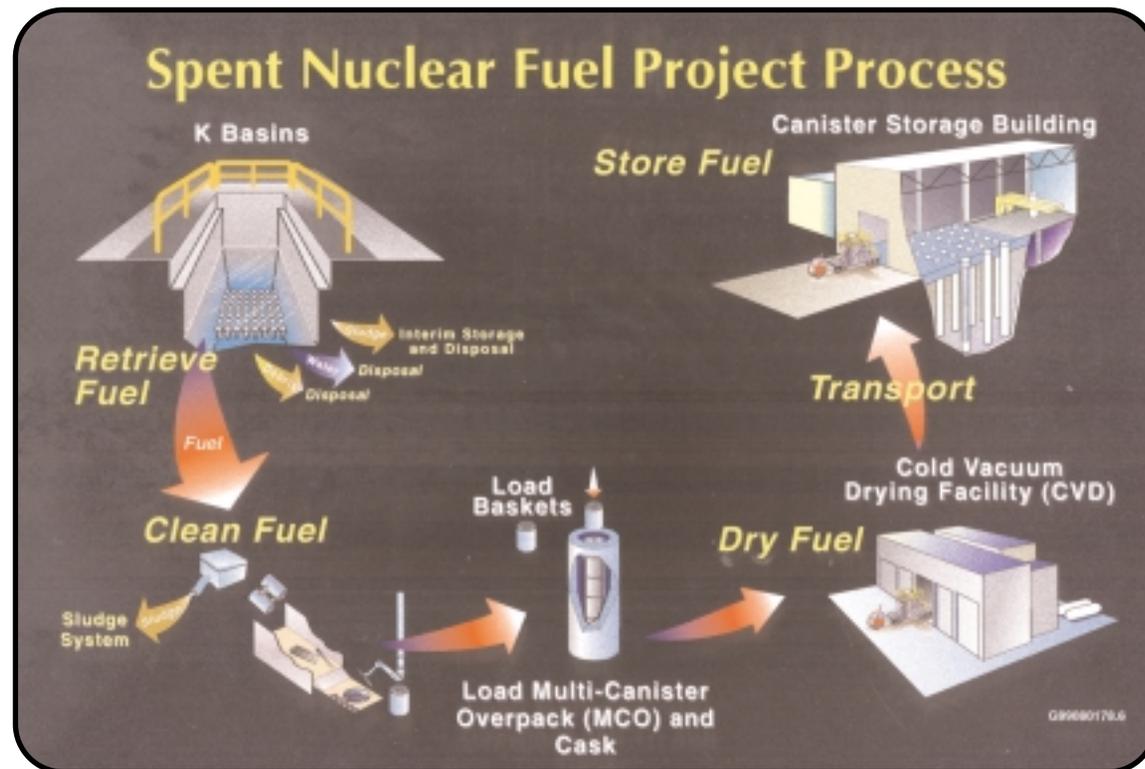
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The process that got under way this quarter initiated an important commitment to remove 2,300 tons of spent nuclear fuel from the river corridor and store it safely in Hanford's central plateau. Each MCO full of spent, or irradiated, fuel that leaves the 100 Area moves about 150,000 curies of radioactivity away from the shoreline. When the project is complete in 2007, about 95 percent of the radioactivity will have been removed from the river corridor.



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River Corridor Project

Cleanup work at the 324 Building this quarter included loading out two steel waste disposal boxes of mixed waste from the floor of B Cell, and shipping one of the boxes to the 200 Area for storage. To date, four of the planned 14 steel waste boxes have been shipped from the 300 Area, each of them moving up to 50,000 curies of radioactive material away from the nearby Columbia River, representing a major reduction in public risk. A grout container was also filled with pieces of B Cell's racks, equipment and other low-level waste needing removal so the remaining mixed waste on the cell floor can be cleaned out. Unexpected technical and mechanical issues kept the Project from completing the B Cell cleanout by November 30. The task is now scheduled for completion by the end of March.



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River Corridor Project

Plant Engineer Dave Schermerhorn used existing computers and modems to implement a timesaving, no-cost method to get data faster and prevent loss of important information at the 300-Area Treated Effluent Disposal Facility (TEDF). Data from monitors for air and wastewater from several 300-Area buildings now combine with real-time data at the TEDF to give a clearer and quicker picture of what has happened should a monitor alarm go off. About 17.5 million gallons of non-radioactive wastewater, enough to fill about 22 Olympic-size swimming pools, were treated at the TEDF this quarter. This is a fairly typical quarterly treatment volume for the Facility.



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Environmental Restoration Along the River

Along with Fluor Hanford's river corridor cleanup, eight reactors along the river shore are scheduled to be "cocooned" for interim safe storage of the reactor cores for up to 75 years. This work, performed by the Bechtel Hanford-led environmental restoration team, is 80 percent complete at the DR Reactor and F Reactor cocooning is 75 percent complete. Demolition has begun on the D and H reactor projects. Cocooning of C Reactor was complete in fiscal 1998.



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Environmental Restoration Along the River

The environmental restoration team also continues to remove contaminated materials from near the river. Most of the more than 2.5 million tons excavated to date consists of low-level and mixed-waste soil from liquid waste sites associated with Hanford's former production reactors. The materials have been safely disposed in the

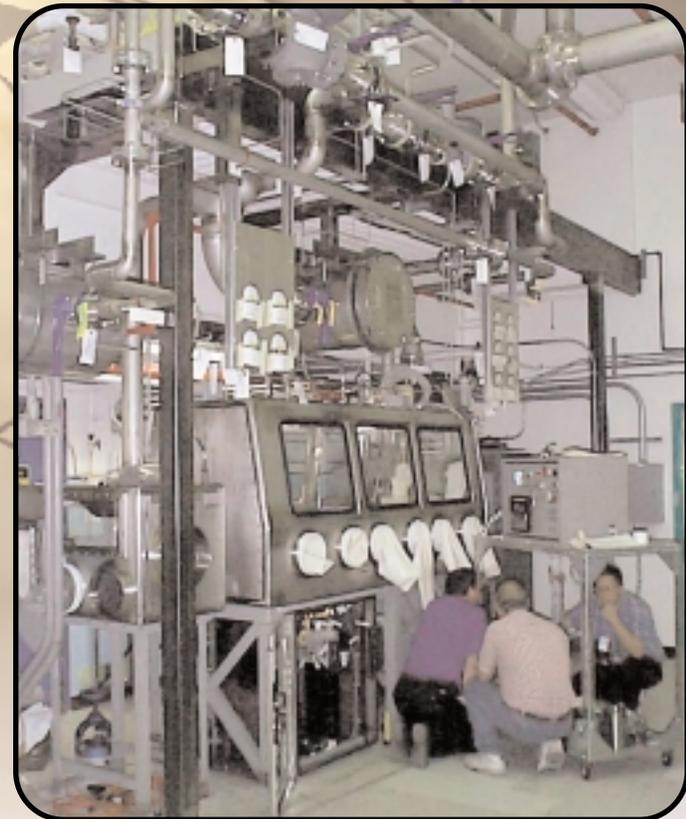
**E n v i r o n m e n t a l
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o f t h e E R D F , t h e n t o p p e d w i t h e i g h t
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t o p r e v e n t w i n d a n d w a t e r e r o s i o n .
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m a t e r i a l s a n d a s y s t e m t o c a t c h a n y l i q u i d s
t h a t d r a i n f r o m t h e w a s t e m a t e r i a l s .**



TRANSFORMING THE PLATEAU

Nuclear Material Stabilization

At the Plutonium Finishing Plant, the processing of plutonium metals was initiated six weeks ahead of a November scheduled start date. Early startup of this milestone effort supports a commitment to the Defense Nuclear Facilities Safety Board to complete packaging this spring of the metal inventory in containers that meet requirements for the safe, 50-year storage of stabilized plutonium materials. Through December, 12 percent of the inventory had been stabilized and packaged in containers with the new bagless transfer system, shown here undergoing final checks prior to startup in late September.



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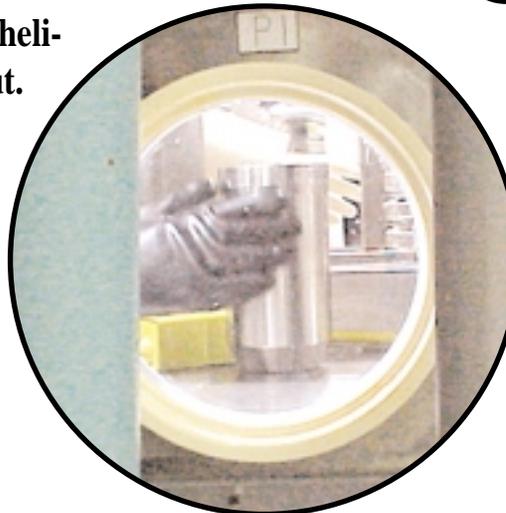
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Nuclear Material Stabilization

The new bagless transfer method allows workers to package stabilized plutonium material in special welded, stainless steel containers without taking it out of the glovebox. This significantly reduces worker radiation exposure and accelerates packaging. In these photos, a transfer can of stabilized material moves through an enclosed conveyor from the glovebox in which it was prepared toward the bagless transfer system glovebox. There, a nuclear process operator places the can into a long-term storage container.

The container is then purged with helium and automatically welded shut. The third photo shows the operator removing the safely sealed container, which will eventually be welded inside a second, outer can for added security during storage.



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Nuclear Material Stabilization

The rate of plutonium stabilization and packaging is expected to continue to accelerate with the installation of upgraded hardware and streamlined procedures. Recent improvements, many suggested by employees, are also reducing material handling and limiting worker exposure, which is increasingly important with so many plutonium stabilization operations under way at the same time. For example, Fluor Hanford radiation control technician Tony Hays devised a cradle to hold a



can of plutonium material for 90 seconds, rather than having a worker hold the can, while instruments measure the radioactivity in the material. Another employee designed the lead-shielded fabric bag, shown above, in which a can of plutonium material can be transported, cutting radiation exposure to the worker by 90 percent.



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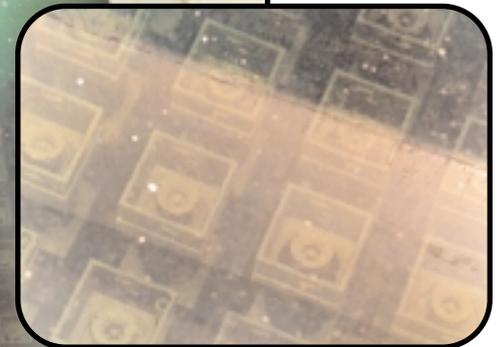
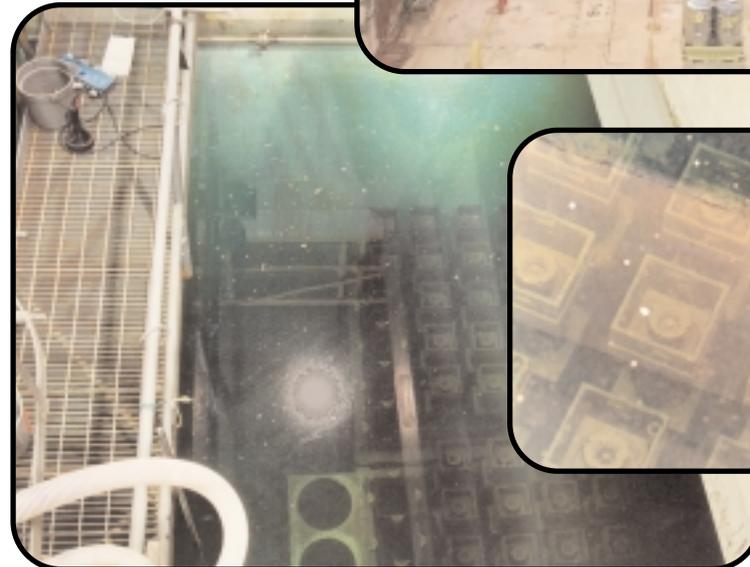
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Spent Nuclear Fuel Project/Waste Management

Removal of excess equipment from the canyon “deck” and of the contents in four canyon “cells” continue inside T Plant, in 200 West on the central plateau, in preparation to receive sludge from the K Basins, located near the Columbia River, in support of the Spent Nuclear Fuel Project. Another important preliminary step is to remove and dry nearly 16 metric tons of spent nuclear fuel from the Shippingport (PA) Atomic Power Station that have been in underwater storage at T Plant since the late 1970s. The 72 rectangular Shippingport fuel assemblies (inset) must be out of T Plant’s pool cell by August 2002 to allow time to clean and prepare the pool and four nearby cells to receive the K Basins sludge. The Tri-Party Agreement calls for all sludge to be removed from the K Basins by September 2004 and moved into T Plant in early 2005.



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Waste Management

The first shipment of mixed low-level waste requiring thermal treatment heads offsite to the local Allied Technology Group (ATG) facility. ATG completed construction and installation of a new plasma melter for this purpose, and is expected to treat more than 700 cubic meters of mixed waste from Hanford each year for five years. After treatment, the waste will be returned to Hanford for safe disposal in a mixed waste trench.



In support of the Office of River Protection, Fluor Hanford completed installation of a tie-in to the 200-Area Treated Effluent Disposal Facility from the future tank waste treatment plant.

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Environmental Restoration on the Plateau

In addition to Fluor Hanford's cleanup efforts on the Site's central plateau, a Bechtel Hanford-led team continues decontamination and decommissioning work at the Plutonium Concentration Facility, also known as 233-S, in the 200 West Area. All piping ties to the adjacent REDOX "canyon" facility have been removed. As shown here, safely removing contaminated pipes inside the Facility required workers to wear an extensive amount of protective clothing.



A composite image featuring a map of a region with a blue river, overlaid with various scenes of nature and human activity. The map shows a network of roads and two red rectangular areas. The scenes include a fox, a deer, a family by a river, a family walking, and cyclists.

PREPARING FOR THE FUTURE

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The Future

Volpentest HAMMER Training & Education Center

DOE Richland's HAMMER Program Manager Carolyn Ballard, flanked by U.S. Transportation Department officials, inked an agreement to provide and increase availability of quality training in the safe transport of hazardous, radioactive and mixed wastes. The agreement will help DOE and other organizations meet federal mandates.

Offsite shipments from Hanford now include the transuranic wastes being sent to the Waste Isolation Pilot Plant in New Mexico in special containers, called TRUPACT IIs, shown on a transport vehicle during a Washington State Patrol first-responder class at HAMMER. The new agreement with the Department of Transportation creates an innovative, cooperative partnership to deliver up-to-date training as waste streams are shipped in increasing numbers on our nation's highways.



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Volpentest HAMMER Training & Education Center

A national utility training site at HAMMER will meet the hands-on training needs of Hanford electrical workers, the Northwest Public Power Association (NWPPA), and Occupational Safety & Health Administration personnel, as well as regional fire departments and law-enforcement agencies. The NWPPA approved budget and construction plans for the 40-acre site.



A new rigging simulator was used for the first time to evaluate advanced rigging performance of Hanford riggers and their supervisors. HAMMER also sponsored and brokered training for a workshop this past quarter that met the Resource Conservation and Recovery Act, or RCRA, training needs of 180 Hanford workers and state Department of Ecology officials.

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Volpentest HAMMER Training & Education Center

A respiratory-protection mock-up was used to train T-Plant workers to safely enter a containment tent, where they could practice opening containers of low-level radioactive solid waste, inventorying the contents, and repacking the wastes in 55-gallon barrels. The life-like simulation included practice in event of emergency loss of air. Another realistic respiratory mock-up enabled 300-Area workers to better understand their task of monitoring air and paint lines for painters who would be coating the walls of a below-ground vault accessed only by a narrow entryway.



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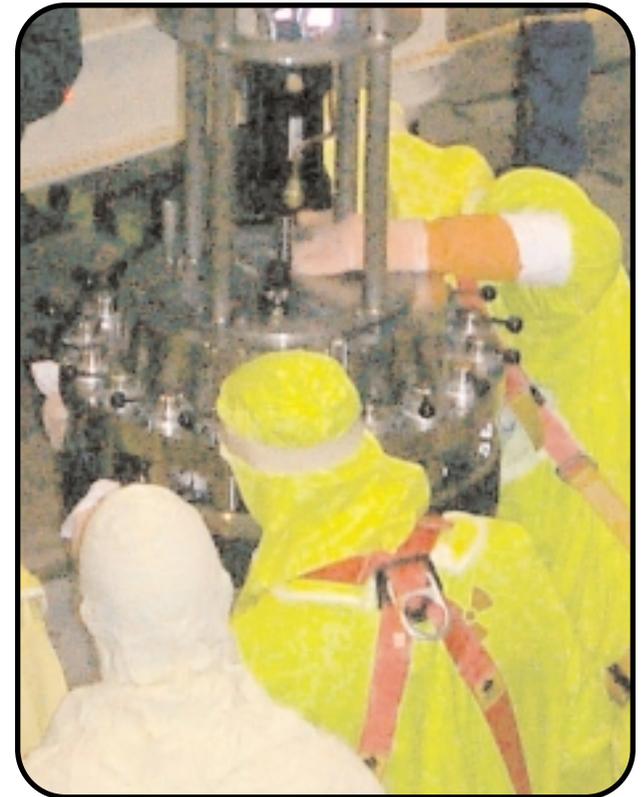
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Fluor Hanford engaged the Pacific Northwest National Laboratory (PNNL) to provide key laboratory analyses for the Spent Nuclear Fuel Project and answer gas purity questions related to helium, a key component in the process of drying and storing spent fuel from the K Basins. PNNL's involvement, through its gas analysis laboratory and prior experience with the Office of Civilian Radioactive Waste Management program, enabled the Project to fulfill specific quality assurance requirements and maintain a tight timetable to begin removing fuel from the Basins.

Technology



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Economic Transition

Local companies continue to benefit from Hanford's underutilized and excess equipment, such as this mobile drill being loaded on a flatbed for transfer to the Tri-Cities Asset Reinvestment Corporation (TARC). The latest firms assisted were Lotus Tech and Rockman Products. As a result, between them they will create up to 20 new jobs. Last quarter, more than \$1 million in assets were transferred to TARC for sale or reuse to help diversify the local economy.



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Economic Transition

Fluor provided financial assistance to the City of Kennewick in its successful effort to retain the long-time local Welch's juice processing operation. In addition to saving 165 Tri-City jobs, Welch's will create up to 60 new jobs by modernizing its Kennewick plant. Another grant from Fluor helped the Tri-Cities Enterprise Center renovate a business incubator facility in downtown Kennewick.



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Economic Transition

A surplus equipment center run by Fluor Hanford subcontractor DynCorp Tri-Cities Services moved out of a large former Hanford warehouse to allow an expanding local business to move in. Kaiser Aluminum & Chemical Corporation's Richland Specialty Extrusions operations is leasing the building from the Port of Benton and will bring on line two more extrusion presses, like the one shown below, and create 50 new jobs over the next five years. A local construction firm is currently renovating the building for this expansion.



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Community Involvement

Fluor Hanford employees, their Hanford co-workers and local DOE colleagues collectively donated a combination of 22,000 books or dollars for books to the Reading Foundation in this year's Thanks-4-Giving Book Harvest. The Book Harvest was just one of many Hanford holiday charitable and civic projects.

Below, Fluor Hanford Community Involvement Team members tackle a different kind of cleanup: bagging litter along two miles of the local interstate as part of Fluor Hanford's Adopt-A-Highway Program.



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Site Services

As the Hanford infrastructure footprint shrinks, Fluor Hanford subcontractor DynCorp Tri-Cities Services continues to help cut energy use and operational costs across the Site. Electrical utilities workers recently deactivated a substation, the fifth one they've de-energized in the past three years to eliminate excess capacity and redundant services. The latest shutdown will save \$41,500 a year. Crews have also removed or downsized 37 underused transformers, saving another \$10,000 in annual energy costs. Darren Idler and Jerry O'Neil are shown conducting an electrical zero-energy check before removing a transformer bank.

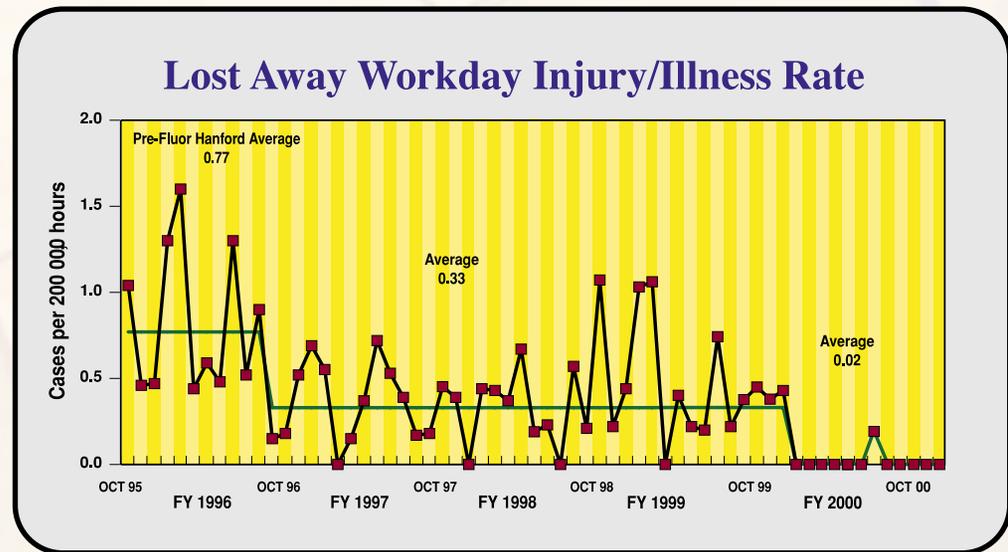


ENVIRONMENT, SAFETY & HEALTH

Fluor Hanford achieved a significant milestone by exceeding 11 million hours without a lost workday injury.

Contributing to the Fluor Project Hanford team's record 11 million hours were the following individual project and group records:

- **Spent Nuclear Fuel Project:** two million hours without a day lost to injury between April and November, during which two new facilities were completed and another finished extensive modifications – the K West Basin containing 28 million curies of radioactivity in 54,000 spent fuel assemblies.
- **Plutonium Finishing Plant:** in December, celebrated one year since the last lost workday injury; currently has logged nearly 1.2 million safe hours, believed to be the longest safety streak recorded at that facility.
- **Fast Flux Test Facility:** three years plus without a lost workday.
- **Site Services staff:** more than 2.3 million hours without a lost workday.
- **Waste Management and River Corridor projects and subcontractor DynCorp Tri-Cities Services:** each more than one million safe work hours.



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Fluor Hanford safeguards and security subcontractor Day and Zimmerman Protection Technology Hanford earned Voluntary Protection Program “Merit” status, an industry occupational health and safety standard awarded to only 555 businesses nationwide.



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Fluor Hanford assisted DOE in locally hosting a national Integrated Safety Management (ISM) “lessons learned” workshop. Workshop activities highlighted the role of the worker in sustaining ISM effectiveness at the activity level. There were more than 700 attendees from throughout the DOE complex at the two-day event.



Recovery efforts from last summer’s wildfire have concentrated on the 200 West Area near the Central Waste Complex. One thousand acres have been revegetated: 5,000 sagebrush tublings were planted on 10 acres, 820 acres were seeded with native grasses, and another 150 acres in a construction buffer zone were planted with non-native grasses and shrubs. Firebreaks have been created around roads throughout the Site.



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Restoring the River Corridor

While workers at the K West Basin continue the multi-year task of removing, drying and transporting spent fuel to safe storage in central Hanford, other Project workers will now design the water treatment and sludge removal systems for the K East Basin and begin constructing equipment to start removing fuel from that Basin two years from now.

The River Corridor Project will complete the shipment of about 235 metric tons of excess uranium billets to a DOE facility in Portsmouth, Ohio. Another 140 metric tons of uranium fuel and scrap at Hanford will be disposed in low-level waste burial grounds on Site and the remaining excess uranium (825 metric tons) will be stored, pending a decision on final disposition.

Meanwhile, in other efforts to restore Hanford's Columbia River corridor, Advanced Reactor Program workers will get cleanout and stabilization of the fuel transfer pit at the former Plutonium Recycle Test Reactor in the 300 Area under way. The work is scheduled for completion in April.

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Transforming the Central Plateau

Modifications to a storage vault at the Plutonium Finishing Plant begin this month to install criticality-safe and seismically qualified racks for storing stabilized plutonium materials. The changes are needed because of the increased capacity of containers that meet new, stringent standards for 50-year storage, which will be used in the outer can welding system, an over-packing operation scheduled to start up in April.

Some transuranic waste ash from DOE's Rocky Flats (CO) Site, which has been stored for years at the Plutonium Finishing Plant, is now being stabilized. The Waste Management Project will prepare the Central Waste Complex to receive the stabilized material and safely store it until it is shipped to the Waste Isolation Pilot Plant in New Mexico for final disposal.

Energy Secretary Bill Richardson announced in December that DOE's preferred alternative for meeting civilian nuclear research and isotope production needs does not include restarting the Fast Flux Test Facility (FFTF) at Hanford. A final decision regarding FFTF was expected as this report was going to press.

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Preparing for the Future

To support economic diversification and growth in the Tri-Cities, Fluor Global Location Strategies will assist the Tri-City Industrial Development Council with a community economic development leadership summit.

In December, the Volpentest HAMMER Training & Education Center was selected as the DOE Center of Excellence for beryllium training. In upcoming workshops, training professionals will assess existing DOE beryllium programs and agree on appropriate and uniform training. The process is expected to serve as a model for addressing future broad-based DOE training issues.

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Hanford Site Map

Hanford Facilities Featured in This Report

200 West Area

- Central Waste Complex
- Low-Level Burial Grounds
- Mixed Low-Level Waste Trench
- Plutonium Concentration Facility (233-S) and REDOX
- Plutonium Finishing Plant
- T Plant

100 Area

- Cold Vacuum Drying Facility
- K Basins (for K East and K West Reactors)
- Reactors C, D, DR, F and H

400 Area

- Fast Flux Test Facility

300 Area

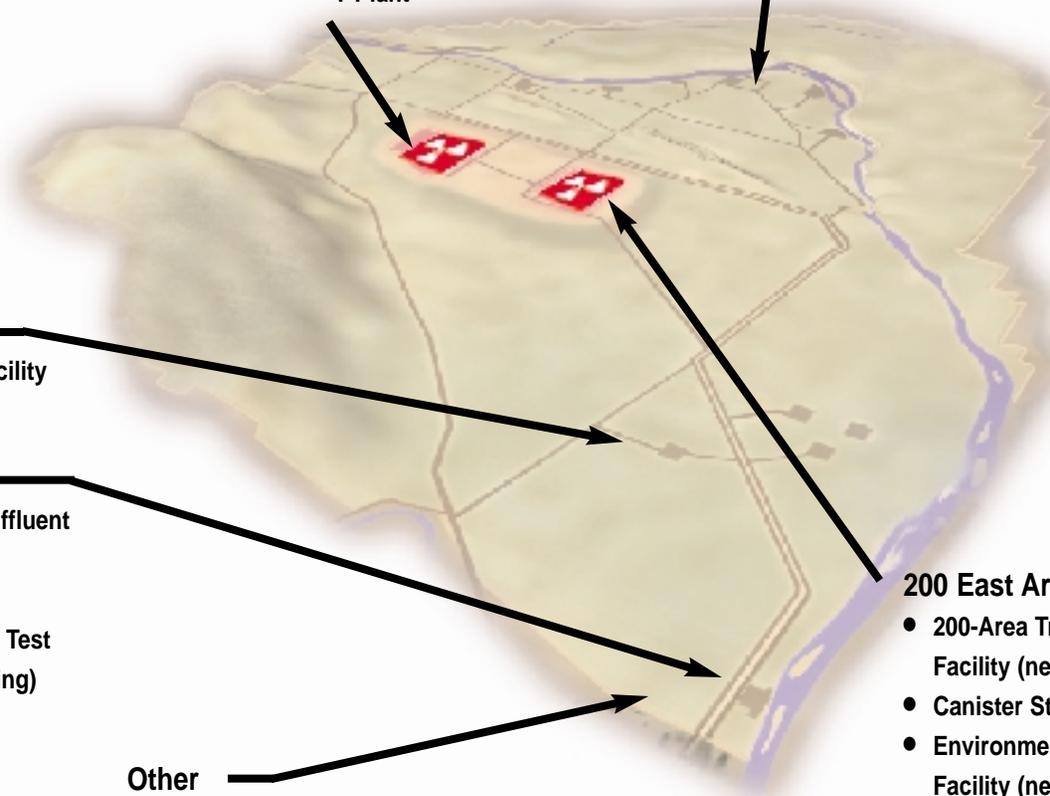
- 300-Area Treated Effluent Disposal Facility
- 324 Building
- Plutonium Recycle Test Reactor (309 Building)

200 East Area

- 200-Area Treated Effluent Disposal Facility (near 200 East)
- Canister Storage Building
- Environmental Restoration Disposal Facility (near 200 East)
- Low-Level Burial Grounds

Other

- Volpentest HAMMER Training & Education Center



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