



*The Low-Activity Waste Facility at Hanford's Waste Treatment and Immobilization Plant.*

*The U.S. Department of Energy (DOE) and contractor Bechtel National Inc. are safely and compliantly constructing the Waste Treatment and Immobilization Plant (WTP) and associated support facilities at the Hanford Site in southeastern Washington state, in preparation for immobilizing tank waste in glass for safe disposal.*

## Overview

As originally envisioned, the Hanford WTP would treat high-level and low-activity radioactive waste simultaneously. To begin treating waste as soon as practicable, DOE developed a sequenced program that would treat low-activity waste first, in 2025. DOE expects to begin treating high-level waste about a decade later.

The program is called direct-feed low-activity waste (DFLAW). It sends pretreated low-activity waste from Hanford's Tank Farms, where the waste is stored, directly to the Low-Activity Waste (LAW) Facility at the WTP.

In a process called vitrification, the low-activity waste will be sent to the LAW Facility and mixed with glass-forming materials and then fed into two 300-ton melters and heated to 2,100 degrees Fahrenheit. The melters are approximately 20 feet by 30 feet and 16 feet high. The glass mixture will then be poured into stainless steel containers, each of which holds 6.6 tons of waste.

Several WTP infrastructure facilities, collectively called the Balance of Facilities (BOF), have been modified to support the LAW Facility and Effluent Management Facility (EMF), which will process liquid secondary waste, called effluent, generated by the LAW Facility. When operational, the LAW Facility will produce up to five containers of waste each day, which will be disposed of at Hanford's Integrated Disposal Facility.

## Background

The Hanford Site, located in southeastern Washington state, was used to produce plutonium over a 40-year period, helping end World War II and playing a major role in the nation's defense efforts during the Cold War. As a result, 56 million gallons of radioactive and chemical wastes are now stored in 158 underground tanks on the Hanford Site. To address this challenge, DOE contracted Bechtel National Inc. to design and build the world's largest radioactive-waste treatment plant.

The WTP will use a process called vitrification to immobilize Hanford tank waste in glass. The glass form is stable and impervious to the environment. In this form, the waste's radioactivity will dissipate over hundreds to thousands of years.

## Construction Facts for Low-Activity Waste Facility

**SIZE:** 330 feet by 240 feet by 90 feet tall

**CONCRETE:** 28,500 cubic yards

**STRUCTURAL STEEL:** 6,200 tons

**HVAC DUCTWORK:** 943,500 pounds

**PIPING:** 103,000 feet

**ELECTRICAL CABLE:** 843,000 feet

**CRAFT HOURS TO BUILD:** 2,337,000 hours



# Waste Treatment and Immobilization Plant (cont.)

## Low-Activity Waste Facility Control Room

Workers safely monitor WTP systems from inside a computerized control room in an annex completed in 2019 as part of the plant's LAW Facility. The control room is the heart of the DFLAW process. In the control room, trained and qualified workers use sophisticated software to monitor and control systems for the Analytical Laboratory (LAB), LAW Facility, and BOF. Cold commissioning (testing), with 24/7 operation of the control room in the LAW Facility, is ongoing and expected to continue through 2023, followed by formal readiness and initial hot commissioning (actual work).



## Effluent Management Facility

The EMF will handle liquid secondary waste, called effluent, generated by the LAW Facility's treatment system.

During low-activity waste vitrification, effluent will be generated from melters and when transfer pipes are flushed. The effluent will go to the EMF processing building, where excess water will be evaporated, and the remaining concentrate sent back into the vitrification process.

The EMF contains three structures: a main processing building, an electrical powerhouse, and a utility systems building.



## Balance of Facilities

The various support utilities needed to support WTP operations include systems for electrical power distribution, backup power, compressed air, steam, chilled water, fire water, and communication and control, among others. These infrastructure facilities are collectively called the Balance of Facilities.

To support the DFLAW Program, certain BOF systems have been scaled down to levels appropriate to the program's lower operational demands, compared to capacities that will be needed during full plant operations. For example, the steam plant will use fewer boilers to support DFLAW, resulting in energy and cost efficiencies.



## Analytical Laboratory

The LAB's key function is to ensure the glass product produced by the LAW Facility will meet all regulatory requirements and standards. During DFLAW operations, LAB technicians will analyze approximately 3,000 waste samples each year.

Analyses will confirm the correct glass-forming "recipe" needed to produce a consistent glass product. Samples will also be taken throughout the vitrification process to confirm a high-quality glass product and sound process controls. The WTP facilities can be viewed using the self-guided [Hanford Virtual Tour](#).

