



Standard Specification for Uranium Hexafluoride Enriched to Less Than 5 % ²³⁵U¹

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^{ε1} NOTE—The table in Section 5.5 was corrected editorially in September 2004

1. Scope

1.1 This specification covers nuclear grade uranium hexafluoride (UF₆) that either has been processed through an enrichment plant, or has been produced by the blending of Highly Enriched Uranium with other uranium to obtain uranium of any ²³⁵U concentration below 5 % and that is intended for fuel fabrication. The objectives of this specification are twofold: (1) To define the impurity and uranium isotope limits for Enriched Commercial Grade UF₆ so that, with respect to fuel design and manufacture, it is essentially equivalent to enriched uranium made from natural UF₆; and (2) To define limits for Enriched Reprocessed UF₆ to be expected if Reprocessed UF₆ is to be enriched without dilution with Commercial Natural UF₆. For such UF₆, special provisions, not defined herein, may be needed to ensure fuel performance and to protect the work force, process equipment, and the environment.

1.2 This specification is intended to provide the nuclear industry with a standard for enriched UF₆ that is to be used in the production of sinterable UO₂ powder for fuel fabrication. In addition to this specification, the parties concerned may agree to other appropriate conditions.

1.3 The scope of this specification does not comprehensively cover all provisions for preventing criticality accidents or requirements for health and safety or for shipping. Observance of this specification does not relieve the user of the obligation to conform to all applicable international, federal, state, and local regulations for processing, shipping, or in any other way using UF₆ (see, for example, TID-7016, DP-532, and DOE O474.1).

1.4 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

2. Referenced Documents

2.1 ASTM Standards:²

C 761 Test Methods for Chemical, Mass Spectrometric, Spectrochemical, Nuclear, and Radiochemical Analysis of Uranium Hexafluoride

C 787 Specification for Uranium Hexafluoride for Enrichment

C 859 Terminology Relating to Nuclear Materials

C 1052 Practice for Bulk Sampling of Liquid Uranium Hexafluoride

C 1295 Test Method for Gamma Energy Emission from Fission Products in Uranium Hexafluoride

C 1561 Guide for the Measurement of Plutonium and Neptunium in UF₆

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

2.2 ANSI Standards:³

ANSI/ASME NQA-1 Quality Assurance Requirements for Nuclear Facility Applications

ANSI N14.1 Nuclear Materials—Uranium Hexafluoride—Packaging for Transport

2.3 U.S. Government Documents:

Inspection, Weighing, and Sampling of Uranium Hexafluoride Cylinders, Procedure for Handling and Analysis of Uranium Hexafluoride, Vol. 1, DOE Report ORO-671-1, latest revision⁴

Nuclear Safety Guide, U.S. NRC Report TID-7016, Rev. 2, 1978

Clarke, H. K., Handbook of Nuclear Safety, DOE Report DP-532⁴

Code of Federal Regulations, Title 10, Part 50, (Appendix B)⁴

¹ This specification is under the jurisdiction of ASTM Committee C26 on Nuclear Fuel Cycle and is the direct responsibility of Subcommittee C26.02 on Fuel and Fertile Material Specifications.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

⁴ Available from U.S. Government Printing Office Superintendent of Documents, 732 N. Capitol St., NW, Mail Stop: SDE, Washington, DC 20401.

Control and Accountability of Nuclear Materials, DOE Directive 5633.3B ⁴

2.4 Other Document:

The UF₆ Manual: Good Handling Practices for Uranium Hexafluoride, United States Enrichment Corporation Report USEC-651, latest revision⁵

3. Terminology

3.1 *Definitions of Terms Specific to This Standard*—Terms shall be defined in accordance with Terminology C 859 except for the following:

3.1.1 *Commercial Natural UF₆*—UF₆ from natural unirradiated uranium (containing 0.711 ± 0.004 g ²³⁵U per 100 g U).

3.1.1.1 *Discussion*—It is recognized that some contamination with reprocessed uranium may occur during routine processing. This is acceptable provided that the UF₆ meets the requirements for Commercial Natural UF₆ as specified in Specification C 787.

3.1.2 *Reprocessed UF₆*—any UF₆ made from uranium that has been exposed in a neutron irradiation facility and subsequently chemically separated from the fission products and transuranic isotopes so generated.

3.1.3 *Highly Enriched Uranium*—any form of uranium having a ²³⁵U content of 20 % or greater.

3.1.4 *Enriched Commercial Grade UF₆*—UF₆ enriched from Commercial Natural UF₆ or Derived Enriched UF₆ that meets the specification limits for Enriched Commercial Grade UF₆.

3.1.5 *Enriched Reprocessed UF₆*—UF₆ enriched from Reprocessed UF₆, any mixture of Reprocessed UF₆ and Commercial Natural UF₆ or Derived Enriched UF₆, exceeding the applicable limits of Sections 4 and 5 for Enriched Commercial Grade UF₆. The wide range of irradiation levels, cooling times, reprocessing, conversion, and enrichment processes, and fuel cycle choices for combination with unirradiated UF₆, together with the varying acceptance limits of different fuel fabrication facilities, make it not practical to specify the exact radionuclide composition of Enriched Reprocessed UF₆.

3.1.6 *Derived Enriched UF₆*—any UF₆ obtained from the blending of Highly Enriched Uranium with any other uranium.

3.2 For enriched UF₆ transactions, “buyer” usually represents the electric power utility company or the fuel fabricator, and “seller” usually represents the isotopic enrichment facility.

4. Safety, Health Physics, and Criticality Requirements

4.1 The UF₆ concentration shall not be less than 99.5 g UF₆ per 100 g of sample in order to limit the potential hydrogen content for nuclear criticality safety.

4.2 The total absolute vapor pressure shall not exceed the values given below:

380 kPa at 80°C (55 psia at 176°F), or
517 kPa at 93°C (75 psia at 200°F), or
862 kPa at 112°C (125 psia at 235°F)

Additionally, if a measurement is taken over solid UF₆, the vapor pressure shall not exceed the values given below:

50 kPa at 20°C (7 psia at 68°F), or
69 kPa at 35°C (10 psia at 95°F)

The purpose of the pressure check is to limit the hydrogen fluoride, air, or other volatile components that might cause overpressure when heating the shipping container, such as to obtain a liquid sample or withdraw the contents.

4.3 The total hydrocarbon, chlorocarbon, and partially substituted halohydrocarbon content shall not exceed 0.01 mol % of the UF₆. The reason for the exclusion of these materials is to prevent a vigorous reaction with UF₆ upon heating. It is essential that contamination of the UF₆ containers, such as by vacuum pump oil, be prevented since it is not practical to obtain a sample without heating the UF₆. An alternative means of demonstrating compliance with this requirement, other than by direct measurement, may be agreed upon between the parties concerned.

4.4 For Enriched Commercial Grade UF₆ meeting the requirements of Section 5, (1) the gamma activity from fission products is expected to be below the detection limits of the measurement methodology set forth in Test Method C 1295; and (2) the alpha activity from neptunium and plutonium is expected to be below the detection limits of commonly used measurement methodology (Guide C 1561). Therefore unless otherwise agreed upon between the buyer and seller, measurements are not required, except for Derived Enriched UF₆ resulting from blending with reprocessed uranium.

4.5 For Enriched Reprocessed UF₆, the gamma radiation from fission products shall not exceed 4.4×10^5 MeVBq/kgU (4.4×10^5 MeV/sec kgU). The measurements are to be made in accordance with Test Method C 1295, or equivalent.

4.5.1 For Enriched Reprocessed UF₆, the alpha activity from neptunium and plutonium shall be less than 3300 Bq/kgU (200 000 dpm/kgU). The measurements shall be made in accordance with Guide C 1561, or equivalent.

5. Chemical, Physical, and Isotopic Requirements

5.1 Both Enriched Commercial Grade UF₆ and Enriched Reprocessed UF₆ must meet the specification criteria except as differentiated in 4.4, 4.5, 5.4, and 5.5. For certain isotopes, including artificially created radioactive species, two groups of limits are set. Limits for Enriched Commercial Grade UF₆ are set so as to have no special impact on the use of this material in existing facilities. For Enriched Reprocessed UF₆, higher limits are indicated to correspond with Specification C 787, and lower limits may be agreed upon by the buyer and seller according to the composition of the feed material presented for enrichment.

5.2 The UF₆ content shall be reported as gUF₆/100 g sample.

5.3 The following impurity elements shall not exceed these values:

Element	µg/gU
Boron	4
Silicon	250

For fully substituted chlorofluorocarbons a maximum limit may be agreed upon between the parties concerned.

5.4 Enriched Commercial Grade UF₆ shall comply with the limits given in 5.5. For evaluating Enriched Commercial Grade

⁵ Available from United States Enrichment Corporation, 6903 Rockledge Drive, Bethesda, MD 20817.

UF₆, the measured concentration of ²³⁶U will be used as an indicator for contamination with reprocessed uranium, on the assumption that there is no opportunity for contamination with irradiated uranium that has not been processed to remove the majority of fission products. Uranium isotopic concentrations shall be determined and reported for ²³⁴U, ²³⁵U, and ²³⁶U.

5.5 Radionuclides—The following values represent limits obtainable from the enrichment of UF₆ feed materials at the corresponding limits of Specification C 787. For purposes of determining conformance with these limits, the observed values shall be rounded to the nearest significant digit indicated in accordance with the rounding method of Practice E 29. For example, for ²³⁴U in Enriched Commercial Grade UF₆ the observed value would be rounded to the nearest 0.1 × 10³ μg²³⁴U/g²³⁵U.

	Enriched Commercial Grade UF ₆	Enriched Reprocessed UF ₆
²³² U	0.0001 μg/gU, see 5.5.1, 5.5.2, and 5.5.3	0.050 μg/gU, see Note 1
²³⁴ U	11.0 × 10 ³ μg/g ²³⁵ U, see Note 2	2000 μg/gU, see Note 1
²³⁶ U	250 μg/gU, see 5.5.3	see Note 1
⁹⁹ Tc	0.01 μg/gU, see 5.5.4	5 μg/gU, see Note 1

5.5.1 If the ²³⁶U measurement result is less than 125 μg/gU, then measurement of ²³²U is not required unless agreed upon between the buyer and seller.

5.5.2 If the ²³⁶U measurement result is greater than 125 but less than 250 μg/gU, then measurement and reporting of ²³²U are required for routine acceptance of the UF₆.

5.5.3 The buyer may consider acceptance of the lot above 250 μg/gU on the basis of the total significance of all the measured levels of radionuclides to determine the suitability for intended use in the fuel fabrication and irradiation. If the ²³⁶U measurement result is greater than 250 but less than 500 μg/gU, then measurement of ²³²U and notification of results before shipment are required.

5.5.4 The buyer and seller may agree to waive the requirement to measure ⁹⁹Tc, provided that (1) the ²³⁶U content is less than 125 μg/gU; and (2) adequate capability to meet the ⁹⁹Tc limit for Commercial Natural UF₆ can be demonstrated through quality assurance records. Such records shall include the results of the seller's periodic measurements of ⁹⁹Tc in the UF₆.

NOTE 1—Enrichment of Reprocessed UF₆ feed material at the limit of Specification C 787 could be expected to reach these limits. Defining these limits does not imply that any fuel fabrication plant designed for Enriched Commercial Grade UF₆ could handle Enriched Reprocessed UF₆ without

dilution with Enriched Commercial Grade UF₆ and other special precautions. With respect to the variability of Reprocessed UF₆ from various fuel histories and the demands that would be placed on the fuel fabricators and users, it could be necessary for the seller and buyer to agree on lower limits after enrichment than implied by Specification C 787 feed limits.

NOTE 2—A ²³⁴U content greater than 10.0 × 10³ μg/g²³⁵U shall require agreement in advance between the parties (for example, supplier, receiver) to accept the material. It is recognized that some applications may not allow for the limit in the table due to licensing, regulatory, or contractual limitations.

6. Sampling

6.1 A representative sample of sufficient size to perform tests prescribed shall be taken while the material is liquid and homogeneous. Relevant sample procedures are given in Practice C 1052, USEC Report USEC-651, and DOE Report ORO-671-1.

6.2 All samples shall be clearly identified including the seller's lot number.

6.3 All containers used for a lot shall be positively identified as containing material from a particular homogeneous lot.

7. Test Methods for Chemical and Isotopic Analysis

7.1 Chemical and isotopic analysis shall conform to Test Methods C 761, or demonstrated equivalent, as mutually agreed upon between the buyer and seller.

8. Packaging, Handling, and Shipping

8.1 Procedures for packaging, handling, and shipping UF₆ are given in ANSI N14.1, USEC Report USEC-651, and DOE Report ORO-671-1 or appropriate national or international procedures.

8.2 Cylinders used for transport of Reprocessed UF₆ shall not be used for Enriched Commercial Grade UF₆ unless decontaminated internally before filling with Enriched Commercial Grade UF₆.

9. Quality Assurance

9.1 Quality assurance requirements shall be agreed upon between the buyer and the seller when specified in the purchase order. Code of Federal Regulations, Title 10, Part 50 (Appendix B) and ANSI/ASME NQA-1 are referenced as guides.

10. Keywords

10.1 low enriched uranium; nuclear fuel; uranium enrichment; uranium hexafluoride

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