



Designation: **C833—01 (Reapproved 2008) C833 – 13**

Standard Specification for Sintered (Uranium-Plutonium) Dioxide Pellets¹

This standard is issued under the fixed designation C833; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

INTRODUCTION

This specification is intended to provide the nuclear industry with a general standard for uranium-plutonium dioxide pellets for thermal reactor use. It recognizes the diversity of manufacturing methods by which uranium-plutonium dioxide pellets are produced and the many special requirements for chemical and physical characterization that may be imposed by the operating conditions to which the pellets will be subjected in specific reactor systems. It does not recognize the possible problems associated with the reprocessing of such pellets. It is, therefore, anticipated that the purchaser may supplement this specification with additional requirements for specific applications.

1. Scope

1.1 This specification covers finished sintered and ground (uranium-plutonium) dioxide pellets for use in thermal reactors. It applies to uranium-plutonium dioxide pellets containing plutonium additions up to 15 % weight. ~~This specification may not completely cover the requirements for pellets fabricated from weapons-derived plutonium weight (that is, 0.15 g Pu / g (U+Pu+Am)).~~

1.2 Pellets produced under this specification are available in four grades.

1.2.1 *Grade R*—²⁴⁰Pu content of (Pu+Am) (that is, g ²⁴⁰Pu / g (Pu+Am)) is at least 19 %.

1.2.2 *Grade F*—²⁴⁰Pu content of (Pu+Am) is at least 7 % and less than 19 %.

1.2.3 *Grade N1*—²⁴⁰Pu content of (Pu+Am) is less than 7 %.

1.2.4 *Grade N2*—²⁴⁰Pu / ²³⁹Pu does not exceed 0.10.

1.3 This specification does not include (1) provisions for preventing criticality accidents or (2) requirements for health and safety. Observance of this specification does not relieve the user of the obligation to be aware of and conform to all applicable international, federal, state, and local regulations pertaining to possessing, processing, shipping, or using source or special nuclear material. Examples of U.S. government documents are Code of Federal Regulations Title 10, Part 50—Domestic Licensing of Production and Utilization Facilities; Code of Federal Regulations Title 10, Part 71—Packaging and Transportation of Radioactive Material; and Code of Federal Regulations Title 49, Part 173—General Requirements for Shipments and Packaging.

1.4 The values stated in SI units are to be regarded as standard. No other units of measurement are included in this standard.

1.5 The following safety hazards caveat pertains only to the technical requirements portion, Section 4, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards*:²

C698 Test Methods for Chemical, Mass Spectrometric, and Spectrochemical Analysis of Nuclear-Grade Mixed Oxides ((U, Pu)O₂)

C753 Specification for Nuclear-Grade, Sinterable Uranium Dioxide Powder

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.

Current edition approved Dec. 1, 2008; Jan. 1, 2013. Published January 2009; January 2013. Originally approved in 1976. Last previous edition approved in 2004-2008 as C833—01; C833—01(2008). DOI: 10.1520/C0833-01R08; 10.1520/C0833-13.

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.

- C757 Specification for Nuclear-Grade Plutonium Dioxide Powder, Sinterable
- C859 Terminology Relating to Nuclear Materials
- ~~CH65 Test Method for Determining Plutonium by Controlled-Potential Coulometry in H₂SO₄ at a Platinum Working Electrode~~
- ~~C1204 Test Method for Uranium in Presence of Plutonium by Iron(II) Reduction in Phosphoric Acid Followed by Chromium(VI) Titration~~
- ~~C1206 Test Method for Plutonium by Iron (II)/Chromium (VI) Amperometric Titration~~
- C1233 Practice for Determining Equivalent Boron Contents of Nuclear Materials
- E105 Practice for Probability Sampling of Materials
- 2.2 *ANSI Standard*.³
- ANSI/ASME NQA-1 Quality Assurance Requirements for Nuclear Facility Applications
- 2.3 *U.S. Government Documents*.⁴
- USNRC Regulatory Guide 1.126 An Acceptable Model and Related Statistical Methods for the Analysis of Fuel Densification
- Code of Federal Regulations Title 10, Part 50 Domestic Licensing of Production and Utilization Facilities
- Code of Federal Regulations Title 10, Part 71 Packaging and Transportation of Radioactive Material
- Code of Federal Regulations Title 49, Part 173 General Requirements for Shipments and Packaging

3. Terminology

3.1 *Definitions*—Definitions shall be in accordance with Terminology C859.

4. Technical Requirements

4.1 *Chemical Requirements*—All chemical analyses shall be performed on portions of the representative sample prepared in accordance with Section 6. Analytical chemistry methods shall be as stated in Test Methods C698 (latest edition) or demonstrated equivalent as mutually agreed to between the buyer and the seller.

4.1.1 *Uranium and Plutonium Content*—Unless agreed upon by the buyer and seller, individual powders shall meet the requirements of Specifications C753 and C757, which also reference Test Methods ~~CH65~~, ~~C1204~~, and ~~C1206~~. The uranium and plutonium contents combined shall be a minimum of 87.7 % weight on a dry weight basis compensated for the Am-241 content. (Dry weight is defined as the sample weight minus the moisture content). The plutonium content shall be that specified by the buyer, up to the limits covered in this specification (15 %).

4.1.2 *Impurity Content*—The impurity content shall not exceed the individual element limit specified in Table 1 based on the heavy metal content (uranium plus plutonium). The summation of the contribution of each of the impurity elements listed in Table 1 shall not exceed 1500 µg/g (U + P)-Pu. If an element analysis is reported as “less than” a given concentration, this “less than” value shall be used in the determination of total impurities.

NOTE 1—Higher impurity limits should be acceptable for restricted burnups and linear power ratings if there is evidence to substantiate the relaxation. Higher impurity levels of 450 ppm aluminum, 250 ppm carbon, 250 ppm nitrogen, and 450 ppm silicon have been supported for burnups of less than 35 000 MWd/t. The extension of the burnup limit may be determined by agreement between the buyer and seller as supporting data are accumulated.

4.1.3 *Stoichiometry*—The oxygen-to-heavy metal ratio of sintered fuel pellets shall be within the range from 1.98 to 2.02. The nominal value and allowable tolerance shall be agreed upon between the buyer and seller.

4.1.4 *Moisture Content*—The moisture content limit is included in the total hydrogen limit (see Table 1).

TABLE 1 Impurity Elements and Maximum Concentration Limits

Element	Maximum Concentration Limit (µg/g of U + Pu)
Aluminum	250
Carbon	100
Calcium + magnesium	200
Chlorine	25
Chromium	250
Cobalt	100
Fluorine	25
Hydrogen (total from all sources)	1.3
Iron	500
Nickel	250
Nitride/nitrogen	75
Silicon	250

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁴ Available from U.S. Government Printing Office Superintendent of Documents, 732 N. Capitol St., NW, Mail Stop: SDE, Washington, DC 20401, <http://www.access.gpo.gov>.