



Designation: C1817 – 16

Standard Test Method for The Determination of the Oxygen to Metal (O/M) Ratio in Sintered Mixed Oxide ((U, Pu)O₂) Pellets by Gravimetry¹

This standard is issued under the fixed designation C1817; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope

1.1 This practice is an alternative method to Test Method C698 for the determination of the oxygen-to-metal atom ratio (O/M) in sintered mixed oxide fuel (MOX) pellets. The method presented in Test Method C698 is a one-step thermogravimetric method for determining O/M ratio in sintered MOX powders and pellets. As stated in Test Method C698, thermogravimetric methods using a two-step heating cycle are also satisfactory (1, 2).² The method presented in this test method is a two-step heating cycle method. This test method is applicable to sintered MOX pellets containing up to 10 weight percent PuO₂.

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

1.3 *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:³

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

C757 Specification for Nuclear-Grade Plutonium Dioxide Powder, Sinterable

C833 Specification for Sintered (Uranium-Plutonium) Dioxide Pellets

C859 Terminology Relating to Nuclear Materials

C1068 Guide for Qualification of Measurement Methods by a Laboratory Within the Nuclear Industry

C1672 Test Method for Determination of Uranium or Plutonium Isotopic Composition or Concentration by the Total Evaporation Method Using a Thermal Ionization Mass Spectrometer

D1193 Specification for Reagent Water

D1356 Terminology Relating to Sampling and Analysis of Atmospheres

2.2 ISO Standards:⁴

ISO 21484 Nuclear Fuel Technology – Determination of the O/M Ratio in MOX Pellets – Gravimetric Method – First Edition

3. Terminology

3.1 For definitions of terms used in this test method but not defined herein, refer to Terminology C859.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *average of the relative atomic mass*—the weighted average of the relative atomic mass of an element calculated as a function of its isotopic composition.

3.2.2 *mole fraction*—the ratio of the number of molecules (or moles) of a compound or element to the total number of molecules (or moles) present (Terminology D1356).

3.2.3 *MOX*—nuclear fuel composed of a mixture of uranium and plutonium oxides ((U, Pu)O₂).

3.2.4 *O/M*—ratio of the oxygen atoms divided by the metal atoms in the sample.

3.2.5 *relative atomic mass*—a dimensionless physical quantity, the ratio of the average mass of atoms of an element (from a single given sample or source) to 1/12 of the mass of an atom of carbon-12 (known as the unified atomic mass unit).

3.2.6 *scavenging*—the process of pushing a gas out by introducing a fresh flow in.

¹ This test method is under the jurisdiction of ASTM Committee C26 on Nuclear Fuel Cycle and is the direct responsibility of Subcommittee C26.05 on Methods of Test.

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² The boldface numbers in parentheses refer to a list of references at the end of this standard.

³ 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.

⁴ Available from International Organization for Standardization (ISO), 1, ch. de la Voie-Creuse, CP 56, CH-1211 Geneva 20, Switzerland, http://www.iso.org.

3.2.7 *sintering*—to increase the bonding in a mass of powder or a compact by heating below the melting point of the main constituent.

4. Summary of Test Method

4.1 The purpose of the analysis is to test the stoichiometry of the MOX pellet by the determination of the O/M ratio. The principle of the method is that one or a number of MOX pellets are heated under a specific set of atmospheric conditions in order to add or subtract oxygen molecules to the MOX pellets. This process results in an O/M ratio of 2 in the MOX pellets after heating. The mass of the oxygen molecules added to or subtracted from the MOX pellets to achieve an O/M ratio of 2 is quantified by weighing the MOX pellets before and after the heating step. Once the difference in mass is known, the number of atoms of oxygen added to or subtracted from the MOX pellets can be determined. The resulting data are used to calculate the O/M ratio in the pellets prior to heating.

4.2 Three or four MOX pellets are weighed before and after an oxidation-reduction heat treatment at specified time and temperature intervals.

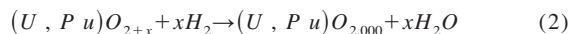
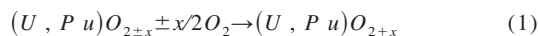
4.3 The heating and atmospheric conditions required to achieve an O/M ratio of 2 in the MOX pellets are as follows (3-5):

(1) Oxidation of the pellets in a current of air at $900 \pm 20^\circ\text{C}$ to increase the O/M ratio. There is no evidence that oxygen can be absorbed interstitially by plutonium dioxide to produce hyperstoichiometric oxide containing plutonium ions having a valency higher than four. On the contrary, uranium oxide can be hyperstoichiometric.

(2) Reduction of the pellets in a stream of argon/hydrogen gas at $900 \pm 20^\circ\text{C}$ to reduce the O/M ratio to 2. Under these conditions (temperature and reducing atmosphere), the O/M ratio is adjusted to 2. The choice of these parameters is based upon a compromise between selecting a temperature low enough to prevent reduction of plutonium oxide to a hypostoichiometric state but high enough to reduce hyperstoichiometric uranium oxide to UO_2 .

NOTE 1—The O/M ratio increases during the cooling process after the heat cycles described above unless it is done under Ar or Ar/H₂ atmosphere. So, control of the cooling atmosphere is needed.

4.4 The reactions involved are:



4.5 The calculation of the stoichiometry is based on the weight difference of the pellets before and after heat treatment and the mean atomic mass of the heavy metals in the MOX pellets (see Section 11 for details of the calculation).

5. Significance and Use

5.1 MOX is used as a nuclear-reactor fuel. This test method is designed to determine whether the O/M ratio meets the requirements of the fuel specification. Examples for establishing a fuel specification are given in Specification C833.

5.2 This method is suitable for all sintered MOX pellets containing up to 12 weight % PuO_2 when the UO_2 and PuO_2 meet the requirements of Specifications C753 and C757.

6. Interferences

6.1 Impurities in the sample may lead to inaccuracies in the determination of O/M ratios either due to loss of volatiles or gain due to redox reactions. Even inert impurities present in sufficiently high amounts compromise the accuracy of O/M ratios because the true mass of the ((U, Pu)O₂) subjected to the oxidation-reduction process remains unknown. When purified PuO_2 and UO_2 powders with maximum total impurity contents specified in Specifications C753 and C757 are used, the change in mass due to the non-volatile and volatile impurities is insignificant to the method. This method assumes that the requirements of these two standards are met and therefore does not take into account the impact of impurities. If impurity contents are higher than those specified in Specifications C753 and C757, an evaluation should be performed to determine their impact on the method. This test method assumes that pellets are sintered. It does not correct for moisture or volatile additives as the content of these impurities is negligible after sintering.

6.2 The crucibles if not clean can be a potential interference. If necessary, the crucibles are cleaned and fired before use as described in 10.1. If crucible cleanliness is tracked and if crucibles are cleaned when necessary, the potential for the crucibles to be a source of interference is insignificant.

6.3 If crucibles are made from materials that oxidize under the test conditions, they may prevent proper equilibration of the stoichiometry of the sample by consuming available oxygen. In addition, they would change weight and would impact the difference in mass calculation. This method assumes that the crucible is made out of a material that is inert under the test conditions, such as platinum alloyed with 20 % rhodium.

6.4 Weighing accuracy of the samples is critical to the method. If the balance meets the specification in 7.1, is calibrated in accordance with manufacturer's guidance, and is checked by procedure, the potential for the balance to be a source of error is insignificant.

6.5 Loss of weight due to pellet chipping would invalidate the analysis. Handle pellets with care.

6.6 The average of the relative atomic mass of the uranium and plutonium in the samples impacts the accuracy of the calculation. The average of the relative atomic mass of uranium and plutonium are measured by Thermal Ionization Mass Spectrometry (TIMS) in accordance with Test Method C1672 and this measured value is accounted for in the calculation.

7. Apparatus

7.1 *Analytical Balance*, with precision ± 0.1 mg.

7.2 *Tube Furnace*, capable of controlling temperatures $900 \pm 20^\circ\text{C}$ and fitted with a fused quartz tube chamber which allows for sweeping the chamber with various gasses.

7.3 *O/M Apparatus*—See Fig. 1. This apparatus is not typically commercially available and users of this test method must build a similar device.

NOTE 2—It is important that the thermocouple be located such that it can monitor the temperature in the zone in which the sample is placed, or can be calibrated to account for any physical offset. It is also important

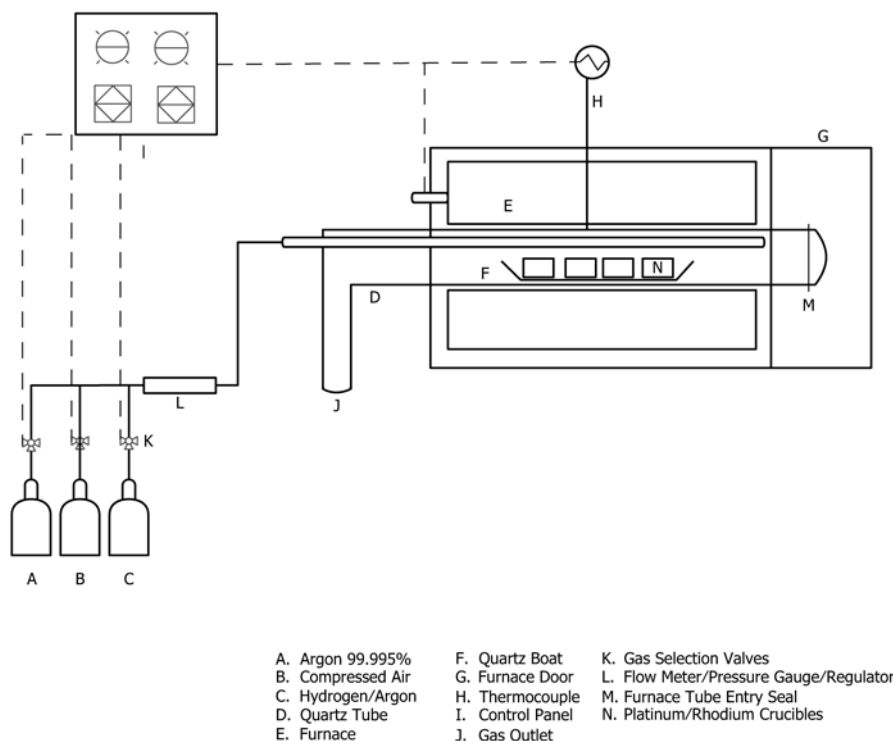


FIG. 1 O/M Apparatus

that the furnace is designed so that the temperature remains stable across the region in which the sample is placed. For safety reasons, it is important to ensure that the design of the furnace limits the possibility of mixing air with the hydrogen/argon gas mixture.

7.4 *Platinum sample crucibles*—alloyed with 20 % rhodium.

7.5 *Fused Quartz Boats (if needed)*, designed to hold multiple platinum sample crucibles if more than one sample is measured at the same time.

7.6 *Pair of Stainless Steel Tweezers*.

7.7 *Pair of Tongs (if using cleaning method 2 described in 10.1)*.

7.8 *Hot Plate (if using cleaning method 2 described in 10.1)*.

7.9 *Beaker (if using cleaning method 2 described in 10.1)*.

7.10 *Gas Flow Meter, Pressure Gauge, and Regulator*.

8. Reagents and Materials

8.1 *Purge Gases:*

8.1.1 *Argon*—Certified 99.995 % purity ($O_2 < 5 \text{ mg.kg}^{-1}$, $H_2O < 5 \text{ mg.kg}^{-1}$, $N_2 < 20 \text{ mg.kg}^{-1}$).

8.1.1.1 Flow rate: 16 litres/hour.

8.1.1.2 Pressure: 200 kPa.

8.1.2 *Air*—Filtered and dried (Suggested air treatment system features: filter efficiency $\geq 98 \%$ of $0.01 \mu\text{m}$, dew point $\leq 20^\circ\text{C}$, total hydrocarbons $\leq 5 \text{ mg.m}^{-3}$).

8.1.2.1 Flow rate: 12 litres/hour.

8.1.2.2 Pressure: 200 kPa.

8.1.3 *Argon/Hydrogen Mixture*—Certified 99.995 % purity with the total amount of impurities ($O_2 + H_2O + C_nH_m$) $< 10 \text{ mg.kg}^{-1}$. The gas mixture shall be (5 % $< H_2 < 7 \%$).

8.1.3.1 Flow rate: 16 litres/hour.

8.1.3.2 Pressure: 200 kPa.

8.2 *Liquid Reagents:*

8.2.1 *Water (if using cleaning method 2)*—Unless otherwise indicated, references to water shall be understood to mean laboratory accepted demineralized or deionized water in conformance with Specification **D1193**, Type 1.

8.2.2 *Nitric Acid (if using cleaning method 2)*—(16 M HNO_3) concentrated, specific gravity 1.42.

8.2.3 *Nitric Acid 7M (if using cleaning method 2)*—Add 440 mL of concentrated HNO_3 to 900 mL of DI water, dilute to a final volume of 1 litre.

8.3 *Reference Materials:*

8.3.1 There are no certified reference materials (MOX pellets) for the O/M ratio determination by the thermogravimetric treatment method (6).

9. Precautions

9.1 Because of the toxicity of plutonium, all operations should be performed within an approved glove box fitted with appropriate filters to contain any small particle of plutonium. A detailed discussion of the necessary precautions is beyond the scope of this test method. Personnel involved in these analyses should be familiar with safe handling practices (7, 8).

9.2 The furnace, sample tube, and sample crucibles are heated to $900 \pm 20^\circ\text{C}$. Extreme care must be exercised to avoid burns or injury by quartz in a glove box and to avoid breaching the primary confinement boundary.

9.3 Exercise appropriate caution when working with compressed gases.