

SECTION 15455
HELIUM/NITROGEN SYSTEM TUBING & COMPONENTS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the contract, including General and Supplementary Conditions, apply to this Section.
- B. Division 15050 Section "Basic Mechanical Materials and Methods" for commonly used joining materials.

1.2 SUMMARY

- A. This Section includes the gaseous helium and gaseous nitrogen piping or tubing specification.

1.3 SUBMITTALS

- A. Six (6) copies of the following shall be submitted in accordance with General and Supplementary Conditions.
 - 1. Equipment and Performance Engineering data
 - 2. Manufacturer's Catalog Data
 - 3. Certificates of Compliance
 - 4. As built drawing of the final tubing/piping configuration.
- B. Prior to fabrication or installation of tubing/piping, the Contractor shall furnish legible Certificates of Compliance signed by the material supplier stating that the tube, fittings, etc. are in compliance with the drawings and specifications. Separate Certificates shall be furnished for each group of like items.
 - 1. Certificates for tubing shall also show the results of chemical analysis and physical tests made on the mill run from which the tube material was obtained.
 - 2. Certificates for clamp type connectors shall verify that the design is in compliance with ANSI B31.3 and ANSI B31.1

1.4 QUALITY ASSURANCE:

- A. Provide listing/approval stamp, label, or other marking on piping made to specified standards.

1.5 APPLICABLE CODES, AND STANDARDS

- A. American National Standards Institute:
 - 1. ANSI B31.1 - Power Piping Code
 - 2. ANSI/ASME B31.3 - Process Piping Code
 - 3. ASME B36.10 - Welded and Seamless wrought steel pipe
 - 4. ANSI B36.19 - Stainless Steel Pipe
- B. American Society for Testing Materials
 - 1. ASTM A312 - Standard specification for seamless and austenitic stainless steel pipe
 - 2. ASTM A403-Wrought Austenitic Stainless Steel Pipe Fittings
 - 3. ASTM A269, "Standard Specification for Seamless and Welded Austenitic Stainless Steel Tubing for General Service"

- C. MIL STDS.
 - 1. MIL-STD-1246C - Military Standard Product Cleanliness Levels and Contamination Control Program

PART 2 - PRODUCTS

2.1 TUBE & FITTINGS

- A. Provide tubing materials and products in accordance with the Equipment Schedules located in the Appendix. Contractor shall make every effort to purchase tubing and fittings from the same manufacturer to limit the amount of spare parts inventory required by system operator.

2.2 JOINING MATERIALS

- A. Refer to Division 15 Section "Basic Mechanical Materials and Methods" for commonly used joining materials.

2.3 COMPONENT SOFTGOODS AND LUBRICANT MATERIALS

- A. Lubricants and softgoods (O-rings and gaskets) used shall be compatible with Gaseous Helium

2.4 BALL VALVES

- A. Characteristics and suggested models for each valve are given in the Equipment Schedules located in the Appendix. Contractor shall make every effort to purchase ball valves from the same manufacturer to limit the amount of spare parts inventory required by system operator.
- B. Ball Valve Characteristics (for valves located outside the utility vault)
 - 1. Stainless steel body construction design compliant with ASME B31.3 and ANSI B16.34 standards for the working pressure as indicated in the Equipment Schedule in the Appendix.
 - 2. Teflon, Kel-F or Vespel seats and bushings; Viton or Buna N seals with no metal to metal contact between moving parts.
 - 3. Bottom (opposite stem) "plug" loaded design with blowout proof stem.
 - 4. End connections shall be male 37 deg flared type tube ends.
 - 5. Suggested Manufacturers include:
 - a. High Gear
 - b. Whitey
 - c. Swagelok
- C. Ball Valve Characteristics (for valves located inside the utility vault)
 - 1. Stainless steel body construction design compliant with ASME B31.3 and ANSI B16.34 standards for the working pressure as indicated in the Equipment Schedule in the Appendix.
 - 2. Metal seats and bushings only allowed.
 - 3. Bottom (opposite stem) "plug" loaded design with blowout proof stem.
 - 4. End connections shall be male "Swagelok" tube thread when possible. If not available from manufacturer female NPT threads shall be used and adapted to male Swagelok
 - 5. Suggested Manufacturers include:
 - a. High Gear
 - b. Whitey
 - c. Swagelok

2.5 METERING VALVES

- A. Characteristics and suggested models for each valve are given in the Equipment Schedules located in the Attachment C. Contractor shall make every effort to purchase metering valves from the same manufacturer to limit the amount of spare parts inventory required by system operator.
- B. **Note:** Metering valves in Nitrogen service outside the target building will be subject to cryogenic temperatures. Model numbers provided in equipment schedules identify valves rated for cryogenic operation.
- C. Metering Valve Characteristics (for valves located outside the utility vault)
 - 1. Stainless steel body construction design compliant with ASME B31.3 and ANSI B16.34 standards for the working pressure as indicated in the Equipment Schedule in Attachment C.
 - 2. Teflon, Kel-F or Vespel packing and back up rings; Viton O-rings.
 - 3. End connections shall be male 37 deg flared type, socket welded or threaded as indicated on the equipment schedules.
 - 4. Suggested Manufacturers include:
 - a. Whitey 22, S, and M Series
 - b. Swagelok
 - c. Hi Gear
 - d. APCO
- D. Metering Valve Characteristics (for valves located inside the utility vault)
 - 1. Stainless steel body construction design compliant with ASME B31.3 and ANSI B16.34 standards for the working pressure as indicated in the Equipment Schedule in Attachment C.
 - 2. Metal to metal seats only
 - 3. End connections shall be male "Swagelok" tube thread when possible. If not available from manufacturer female NPT threads shall be used and adapted to male Swagelok.
 - 4. Suggested Manufacturers include:
 - a. Whitey 22, S, and M Series
 - b. Swagelok
 - c. Hi Gear
 - d. APCO

2.6 SOLENOID VALVES

- A. Characteristics and suggested models for each valve are given in the Equipment Schedules located in Attachment C. Contractor shall make every effort to purchase solenoid valves from the same manufacturer to limit the amount of spare parts inventory required by system operator.
- B. Solenoid Valve Characteristics (for valves located outside the utility vault)
 - 1. Stainless steel body construction design compliant with ASME B31.3 and ANSI B16.34 standards for the working pressure as indicated in the Equipment Schedule in Attachment C.
 - 2. Vespel seats, Viton seals.
 - 3. Direct acting type, 3-way, 2 position valves.
 - 4. Explosion proof in accordance with Class I group B & D, Division I or II per NEMA 7 with Class H porting.
 - 5. .06 seconds or less in valve response time.
 - 6. Furnished with manual override.
 - 7. End connections shall be male "Swagelok" tube thread when possible. If not available from manufacturer female NPT threads shall be used and adapted to male Swagelok.

8. Solenoid valves shall be potted and epoxy filled.
9. 24V Standard operation
10. Suggested Manufacturers include:
 - a. Marrotta Scientific Controls
 - b. APCO (US Para Plate)
 - c. ASCO

2.7 PRESSURE REGULATORS

- A. Characteristics and suggested models for each valve are given in the Equipment Schedules located in Attachment C. Contractor shall make every effort to purchase pressure regulators from the same manufacturer to limit the amount of spare parts inventory required by system operator.
- B. Pressure Regulator Characteristics
 1. Stainless steel body construction design compliant with ASME B31.3 and ANSI B16.34 standards for the working pressure as indicated in the Equipment Schedule in Attachment C.
 2. Stainless steel trim and piston with reinforced nylon diaphragm and Teflon liner.
 3. Kel-F seats with Viton or Teflon seals.
 4. End connections shall be male "Swagelok" tube thread when possible. If not available from manufacturer female NPT threads shall be used and adapted to male Swagelok.
 5. Suggested Manufacturers include:
 - a. Air Products
 - b. APCO
 - c. Tescom

2.8 CHECK VALVES

- A. Check valves shall be fabricated from 300 series stainless steel with stainless steel trim and Teflon seals. Contractor shall make every effort to purchase check valves from the same manufacturer to limit the amount of spare parts inventory required by system operator.
- B. Check valves shall be rated for same or higher working pressures as the tubing and be compatible with the temperature and fluid applications.
- C. End connections shall be male "Swagelok" tube thread when possible. If not available from manufacturer female NPT threads shall be used and adapted to male Swagelok.
- D. Suggested manufacturers include;
 1. Nupro CH series
 2. APCO Series 3505-3050
 3. Circle Seal

2.9 RELIEF VALVES

- A. Relief valve mechanical type, flow capacity and pressure conditions are as specified in the equipment schedules in Attachment C. Provide relief valves with mechanical configuration as specified in Attachment C and same or marginally higher relief capacity. Relief valves shall be rated for the tubing working pressure, application, fluid and temperature. Contractor shall make every effort to purchase relief valves from the same manufacturer to limit the amount of spare parts inventory required by system operator.
- B. All relief valve flow passages shall be 300 series stainless steel with stainless steel trim.
 1. Relief valves in helium service shall have stainless lined flow passages and stainless trim. Seat material may be Kel-F, or Vespel. Seal materials may be Teflon or Viton.

2. Support small poppet type relief valves from the inlet piping and orient the discharge away from the operator station.
 3. Protect open ends of small poppet valves at the ends of discharge tees with insect screens, designed to blow off if clogged.
- C. Suggested Manufacturers include:
1. Anderson Greenwood
 2. Nupro

2.10 FILTERS

- A. Provide filter housings and elements per the following requirements. Provide spare elements and replace original elements following completion of final leak checks and cleaning. Contractor shall make every effort to purchase filters from the same manufacturer to limit the amount of spare parts inventory required by system operator.
- B. Filters for gaseous helium
1. ASTM 304 or 316 series, stainless steel housing rated for working pressure, with upstream and downstream pressure taps. Filter housing configuration to be in-line or tee type (with replaceable element) as specified in the Equipment Schedule.
 2. End connections shall be male "Swagelok" tube thread when possible. If not available from manufacturer female NPT threads shall be used and adapted to male Swagelok.
 3. Nominal 100 micron filter element ratings are required. Elements must be made primarily from 300 series stainless steel. Woven mesh elements or pleated sintered metal elements with minimum 10 psig differential flow pressure rating, design flow differential pressure equal or less than 0.5 psig unless otherwise specified in the Equipment Schedule.
 4. Element to housing seal shall be Teflon O-ring Gaskets
 5. Suggested Manufacturers include:
 - a. Puroflow
 - b. Norman

PART 3 - EXECUTION

3.1 TUBING APPLICATIONS

- A. All tubing or piping shall be designed in accordance with ANSI B31.3.
- B. Transition and special fittings with pressure ratings at least equal to piping pressure rating may be used in applications, unless otherwise indicated.
- C. Tubing to be connected to distribution panels (provided by others) to be terminated with a female 37 deg flared connection of the size indicated on the drawings.

3.2 VALVE APPLICATIONS

- A. Equipment schedules and general arrangement views indicate valve type, end connection type, and approximate location to be used.

3.3 PIPING INSTALLATION, GENERAL

- A. Refer to Division 15050 Section "Basic Mechanical Materials and Methods" for basic piping installation.

3.4 JOINT CONSTRUCTION.

- A. All tubing or piping joints shall be designed in accordance with ASME B31.3. Joints outside the distribution panel (provided as GFE) shall be all welded per the requirements set forth in Section 18100 unless otherwise noted on the drawings.
- B. All Swagelok tube fittings shall be inspected with Swagelok Gap Inspection Gage.
- C. Tubing Supports shall be compression/clamping type designed to be mounted to an adjacent wall and capable of restraining multiple tubing runs with a single clamp. Suggested manufacturers include:
 - 1. B-Line
 - 2. Unistrut
- D. Piping and Tubing Supports shall be stainless steel. Support locations shall be commensurate with ASME B31.1 or as shown on drawings whichever indicates the most number of supports.

3.5 CLEANING

- A. Isolate factory cleaned components from piping segments prior to pipeline cleaning. Confirm that filter elements and filter have been cleaned prior to installing filter in piping system.
- B. All Helium and Nitrogen tubing and piping systems are to be cleaned to specified levels unless noted otherwise.
 - 1. Systems NOT to be included in the cleaning process are identified below:
 - a. 2" Sch 10 nitrogen vent line from dewar station vent piping downstream of bypass valve and vent valve to atmospheric vent discharge near LN2 storage area.
- C. Clean field assembled piping as indicated Attachment A to a level of 300A for Helium systems and 300 for Nitrogen systems. Sample with proof of successful cleaning shall be provided to the facility manager for approval.
- D. Contractor to submit, for approval, a cleaning plan similar in content and direction to the plan in attachment B. Contractor submitted plan shall be tailored specifically for the Helium system or for the Nitrogen system.

3.6 TESTING

- A. The sequence of required inspection for all pipe classes are as follows:
 - 1. Disassembly, cleaning, sample tests, and re-assembly
 - 2. Pneumatic Leak Test
 - 3. Cycle Valves
 - 4. Blowdown/System Drying and final cleanliness sampling
 - 5. Pneumatic Leak Test
- B. Pressure/Leak Test
 - 1. The Contractor shall perform a pneumatic pressure/leak test with gaseous helium in accordance with Attachment A.
- C. The Contractor shall reassemble all piping systems after cleaning. Extreme care shall be taken to preserve the cleanliness of all piping and components prior to and during re-assembly. A clean GN2 purge shall be maintained where feasible. It shall be the responsibility of the Contractor to maintain the cleanliness level for each piping system to the

requirements as stated in MIL-STD-1246C Military Standard Product Cleanliness Levels and Contamination Control Program.

- D. All valves in piping systems shall be cycled at ambient temperature and pressure.
- E. Blowdown/System Drying
 - 1. The Contractor shall blow all lines clear with high pressure nitrogen. The blowdown plan, pressure connection, and configuration shall be submitted by the supplier for approval. The blowdown shall be repeated until the line is free of particulate matter and dry.
 - 2. System piping shall be dried to the following dew points:
 - a. GHe -65°F @ atm pressure
- F. Final Leak Test
 - 1. The Contractor shall repeat the leak test identified in section B after the installation of new fittings.

APPENDIX - TUBING MATERIALS SPECIFICATIONS

TUBING/PIPING SPECIFICATION: HELIUM or NITROGEN, STAINLESS STEEL

Pressure	3000 psig
Temperature	0 to 100 F
Service	Helium Gas
Cleanliness	300A per MIL-STD-1246C
Tubing	¼" x .028" wall, ½" x .049" wall, and ¾" x .065" wall, 1" x .095" wall ASTM A312 TP 304L seamless stainless steel.
Pipe (for LN2 and Nitrogen vent line use only)	1" and 2", Sch 10, ASTM A312 TP 304L seamless stainless steel with bevel ends per ANSI B36.19
Fittings	ASTM A403 Sch 10S 304L Butt Weld compliant with ANSI B16.9, all welds shall be long radius
Bends	6 Pipe diameters or greater per ANSI B31.1
Joint Inspection	Inspect all joint fittings with Swagelok Gap Inspection Gage where applicable. 10% of all welded joints shall be inspected in accordance with ASME B31.3 all welding shall be per section 18100.

Attachment A

Pressure and Leak Testing Plan For Helium and Nitrogen Systems

**Pressure and Leak Testing Plan to be submitted as part of the WBS
1.6.6 work effort.**

Attachment B

Cleaning Specification for Helium/Nitrogen Tubing Systems and Components

Cleaning, Inspection and Testing
of Stainless Steel Tubing & Piping
Installed at Spallation Neutron Source
Oak Ridge, TN

FIELD CLEANING PROCESS GUIDELINES

APPROVAL PAGE

FIELD REVISIONS

Revision	Reason for Revision	Date
NC	NEW	TBD

1.0 GENERAL

This procedure describes the precision cleaning process and contamination control measures for tubing/piping surface interiors to fulfill the specification requirements for field cleaning the installed tubing and piping systems.

2.0 SCOPE OF WORK

The field process involves removal and reinstallation of associated components (by others), and precision cleaning the interior significant surface of various sized stainless steel tubing and piping. The interior surface of tubing and piping systems will be chemically cleaned in accordance with this procedure to meet specification requirements, dried with filtered gaseous nitrogen to a specified dew point (-65°F @ atm pressure), sealed and blanketed with the specified gas to a positive pressure of 3 – 5 psig, where possible.

3.0 ASSOCIATED DOCUMENTS

The documents listed below form a part of this procedure to the extent indicated by reference to them or to specifications associated with them.

3.1 SNS DRAWINGS (Latest Revisions are Applicable)

- West Yard Tubing and Piping Drawings to be provided here

3.2 Government and/or Customer Specifications

- MIL-STD-1246C, “Product Cleanliness Levels and Contamination Control Program”.
- ARP 598B, The Determination of Particulate Contamination in Liquids by the Particle Count Method.

4.0 APPLICABLE MATERIALS

MIL-P-27401, GR B, Typ 1	Nitrogen
MIL-B-81705, TY II	Polyethylene Sheet or Bag
PPP-T-66E, TYP I CL B,	Tape, Pressure Sensitive Vinyl
O-N-350	Nitric Acid 35%
TT-I-735	RCS Reagent Grade Isopropyl Alcohol
MiraChem 750	Aqueous Based Alkaline Detergent (or equivalent)
Deionized Water	

5.0 CONTROL LIMITS

- 5.1 The control limits of solutions used herein shall be as referenced in Section 16, Cleaning and Test Parameters. These solution control limits are based on manufacturers recommendations, specification guidance, and the combined experience and expertise of cleaning personnel knowledgeable in the specialized area of cleaning, flushing and processing tubing and piping systems.
- 5.2 Control limits of processing fluids used herein shall be as referenced in Section 16, Cleaning and Test Parameters. These processing fluid control limits are based on manufacturers recommendations, specification guidance, and the combined experience and expertise of cleaning personnel knowledgeable in the specialized area of cleaning, flushing and processing tubing and piping systems.
- 5.3 Environmentally controlled areas in the field including; mobile cleanrooms, work stations, and mobile labs shall be certified to standard controls and meet FED-STD-209 to the extent necessary for contract compliance. Controlled work areas generally follow the disciplines of Class 100,000 clean; however, some environmental parameters, if approved, may be less stringent.
- 5.3.1 Cleanroom operations include: precision cleaning of cleaning contractor valves, instruments, gauges, hoses, fittings, flanges, seals, gaskets, etc. The verification of cleanliness samples taken from piping, NVR and particle counts, etc., and precision packaging to specified levels of cleanliness.

6.0 INSPECTION PROCEDURES AND SAMPLING METHODS

- 6.1 Inspection procedures shall be in accordance with CPP 3003, Section 3.0. Sampling methods will be per common liquid sampling methods and Arp598B.

7.0 CONTROL OF TUBES/PIPES AND TUBING/PIPING ASSEMBLIES

- 7.1 Control of tubes/pipes and tubing/piping assemblies refers to completed tubes/pipes and tube/pipe assemblies and all installed fittings and components being chemically processed during the cleaning and inspection of a tubing/piping system. Any damage or distortion to significant surfaces, including interior surface and flanged tube/pipe ends or other tube/pipe fittings shall be recorded in the remarks section of this procedure and brought to the attention of cleaning contractor Quality Control Field Representative and the cognizant SNS representative.

8.0 FIELD CLEANING REQUIREMENTS

- 8.1 This procedure shall not be used for installed systems, components, or assemblies where complete removal of cleaning, flushing, and rinsing fluids cannot be assured, and/or degradation of components may occur. Such systems shall be disassembled by others prior to cleaning to the extent that entrapment areas are eliminated, and sensitive components are removed.

- 8.2 Systems or subsystems subjected to component removal or any other disassembly to facilitate field cleaning shall have their integrity restored during reassembly/ reinstallation according to the established requirements for proof pressure, leak test, electrical bonding and grounding, and fabrication/installation.
- 8.3 No fluid shall be used or introduced in the system during or after acceptance testing except those specified herein, without prior written customer approval.

9.0 FIELD ENVIRONMENTAL CONTROLS

9.1 This section establishes the minimum field contamination control requirements for installed tubing/piping. The cleanliness of such systems shall not be compromised by improper contamination control techniques during any operation in which the system is opened to an uncontrolled environment. Localized clean operations or entrance to clean systems may be conducted in several ways, any of which are acceptable provided the following requirements are met:

- a. Area Cleanup: The area in which the reinstallation is to be performed shall undergo stringent housecleaning. Prior to this cleaning, all loose or extraneous equipment shall be removed from the area.
- b. Controlled Environment Enclosure: A temporary “enclosure” (cleaned to the same level as the component or system) shall be placed around the open portion of the clean system to preclude contaminating the open system (or installation part) by exposure to the uncontrolled environment.
- c. System Purge: A purge with inert gas shall be established in the system prior to opening or removing clean seals. A purge shall be provided from both directions when installing components between cleaned portions of the system. The purge shall prevent foreign materials from entering the system. Vents open to the atmosphere do not require a purge. The purge gas shall be filtered to exceed system cleanliness level requirements. The gas flow rate shall be such that a positive pressure from the system to the environment shall prevail. The purge shall continue until installation is complete and the system is closed.

NOTE: When a gas purge is not used, the open system lines shall be protected by approved seals per the specification requirements of MIL-STD-1246C.

- d. Enclosure Operations: No operations shall be conducted in a clean enclosure unless the system purge and filtered air inputs are “on”. “Operations” include the presence of properly clothed personnel, unsealing of clean-packaged components, opening or closing the system, installing or removing components from clean systems, etc. Personnel in walk-in style clean enclosures during installation operations involving clean systems shall wear cleanroom attire.

Special attention shall be given to all surfaces contacted by hand. Clean gloves, clothing, and tools are mandatory. Vacuum cleaning and wiping of all hardware and the processing area is essential for assembly and disassembly of clean components or systems.

10.0 FIELD CLEANING EQUIPMENT

- 10.1 All measuring and test equipment used for acceptance purposes shall be checked prior to use for evidence of proper calibration, including a current calibration label with the date calibrated, the date the item is due for calibration, and evidence of acceptance by the person performing the calibration. Measuring and test equipment which do not have evidence of current calibration shall not be used.
- 10.2 Measuring and test equipment shall be selected so the upper range limit of the item characteristic being checked falls within the upper two-thirds of the test equipment which is being used to take the reading and accurate within 1% of full scale.
- 10.3 Equipment selected for the cleaning process shall be visibly clean so as not to introduce undue contamination into the system being cleaned. Equipment selected for testing of previously cleaned systems shall be of equal or greater cleanliness than the system being tested.
- 10.4 Equipment selection shall be based on system compatibility, adequate flow rates, sufficient pressure outputs, reservoir capacities, etc. No equipment shall be used which appears to be unsafe or which is not rated for the service and pressures of the process.
- 10.5 Equipment connecting directly to system piping or components shall be in good condition and undamaged at all sealing areas. Flanges and fittings shall be correct and not damaged or corroded so as to cause damage or introduce corrosion into system piping or components. Only wrenches of the proper type and size shall be used on piping flanges.

11.1 HAZARDOUS WASTE MANAGEMENT

- 11.1 Industrial and/or hazardous waste generated during cleaning operations shall be handled in accordance with the provisions of the SNS Hazardous Waste Management Guidelines.

12.0 FIELD OPERATIONS SAFETY

- 12.1 All personnel working at or performing operations during the field cleaning and testing process shall observe all safety rules as described in the cleaning contractor's Safety Program.

- 12.2 Field supervisors shall ensure that all personnel working directly on any field cleaning or testing operations are provided the necessary personal protective equipment necessary for the type of work being performed and that each person is familiar with its use and/or operation.
- 12.3 Field supervisors shall ensure that prior to the start of each job a “stand-up” safety meeting is conducted with all personnel involved with the operation. Field supervisors shall discuss safety standards particular to the job and ensure that each person knows and understands the safety requirements of the job at hand, has the proper personal protection equipment needed to safely accomplish all operations, and verify that personnel performing the cleaning and/or tests are familiar with the methods and requirements of the job.
- 12.4 The Field Supervisor of the job shall advise personnel working in the area that cleaning and/or testing is in process via paging system, signs, safety flagging or tape, or other suitable means as approved by SNS Safety.
- 12.5 Field Supervisors are responsible for ensuring that all test set-ups are correct and that proper pressures will be used for the system to be tested. Flagging must be present at initiation and termination valves, and at any vents or openings which might discharge cleaning solutions or contaminated waste around personnel working in the area.
- 12.6 Field Supervisors are responsible for performing a walk around of the cleaning and/or test site prior to the beginning of any operation to ensure that all equipment being used and the piping system is correctly set up and safety procedures have been followed.

13.0 NOTIFICATION OF SNS PERSONNEL

- 13.1 Notification will be made to SNS Inspection, Safety or Environmental personnel (as may be required) to the start of system flushing operations.

14.0 FIRE PREVENTION AND FIRE EXTINGUISHERS

- 14.1 Based on the fire potential of the job, Field Supervisors shall ensure that sufficient fire protection and extinguishing equipment are properly located at the site.

16.0 CLEANING AND TEST PARAMETERS (Example to be proposed by Contractor)

PRECLEAN FLUSH

Cleanliness Requirements: DEGREASE pH requirements: H2O base only 6 – 8
Cleaning Media: MIRACHEM 750 Media Temperature: 120 – 180°F
Solution Strength: 15 – 25% / VOL Estimated Waste: _____
Duration: 2 – 4 HOURS Method: FLUSH
Rinse Media: DEIONIZED WATER* Drying Media: VISUAL DRY

*NOTE: Those systems not requiring an analysis for nonvolatile residue (NVR) may be sampled for cleanliness after the final deionized water rinse of the above operation. If the results are satisfactory there is no need to flush with IPA. Drying of the lines shall be performed to the requirements stated below.

Cleanliness Requirement: MIL-STD-1246C Drying requirement: -65.0°F
Flushing Media: ISOPROPYL ALCOHOL Media Temperature: AMBIENT
—
Solution Strength: 100% Estimated Waste: _____
Duration: 30 MINUTES (MINIMUM) Method: FLUSH
—

Specific system cleanliness level shall be as specified per contract requirements.

Rinse Media: No Rinse Required Drying Media: GN2

CLEANLINESS LEVELS SPECIFIED FOR SNS SYSTEMS:

MIL-STD-1246C

Helium	LEVEL	300A
Vacuum	LEVEL	300

Activated Cooling Water 300

(System walkdown to be completed prior to performing work)

Cleaning Contractor System Walkdown Signoff:

(Name)

(Date)

Adequate Support: Yes No Boundary Verification: Yes No

COMMENTS:

17.0 OPERATIONAL WORK INSTRUCTIONS (Example only)

OPER.	DESCRIPTION OF WORK	NTS	CUST	DATE
17.1	Verify proper calibration of all gauges and test equipment to be used during cleaning and test.			
17.2	<p>Safety Meeting: Conduct Safety meeting with all personnel involved with job. Discuss safety standards particular to the job and ensure that personal protection equipment is issued and in use.</p> <p>Ensure that adequate fire protection is available as needed.</p>			
17.3	Verify with SNS personnel that all systems are complete and ready for cleaning.			
17.4	<p>Locate and identify tubing/piping to be cleaned.</p> <p>Disassemble tubing/piping as required from main system and isolate for cleaning and test as required.</p> <p>Loop tubing/piping in series with appropriate spools, flex hoses or whips, use new/clean gaskets, o-rings or seals, clean test fittings and flushing hose connections to cleaning/test equipment.</p> <p>Verify that all connections are properly made with proper gaskets and torqued correctly.</p>			
17.5	<p style="text-align: center;">PRECLEAN FLUSH</p> <p>Ensure the media holding tank is of sufficient volume for system to be cleaned.</p> <p>Mix MIRACHEM 750 at 15 to 25% by volume, balance D.I. water.</p> <p>Heat flushing media to specified temperature for preclean. Maintain temperature throughout flushing cycle.</p> <p>Fill system and vent excess air. Circulate for required duration.</p> <p>Start Time: _____ Ending Time: _____</p>			

OPER.	DESCRIPTION OF WORK	NTS	CUST	DATE
17.6	<p>Carefully blow back flushing media to mixing tank with GN2 using back flow connection points specified per cleaning contractor.</p> <p style="text-align: center;">CAUTION</p> <p>Do not exceed 50 psig during blow back. Always use the lowest pressure possible during this operation.</p>			
17.7	<p style="text-align: center;">RINSE/FLUSH</p> <p>Fill system with filtered (10 μ) D.I. water and flush until proper pH (6 – 8) is obtained using litmus paper. Check for residual soap by filling sample jar with rinse water and shaking to check for foaming.</p> <p style="text-align: center;">pH _____</p>			
17.8	<p>If the system being cleaned does not require an analysis for NVR perform operation 17.11 followed by drying to required dewpoint. If particulate analysis is satisfactory proceed from operation 17.11.</p>			
17.9	<p>Crack all flanges and fittings, open low point drains and remove as much excess flushing media as possible. Reconnect all flanges and fittings, close low point drains.</p> <p>Purge system with filtered, dry GN2 to visual dry.</p>			
17.10	<p style="text-align: center;">FINAL CLEAN & FLUSH</p> <p>Fill system with final flushing media and vent excess air from lines. Ensure that vented media is caught in waste container for disposal.</p> <p>Circulate flushing media at specified GPM through 10 μ (minimum) filter for a minimum of 30 minutes.</p> <p>Start Time: _____ Ending Time: _____</p>			

OPER.	DESCRIPTION OF WORK	NTS	CUST	DATE
17.11	<p style="text-align: center;">SYSTEM SAMPLING</p> <p>Obtain a bagged and precision cleaned container of sufficient volume for the collection of media sample.</p> <p>Exercise caution when extracting sample and ensure that no outside contamination is introduced during this operation.</p> <p>Extract 500 ml of final flushing media from pipe system and send to lab for analysis in accordance with the cleanliness requirements stated in Section 16 of this procedure for Final Clean & Flush of the tubing/piping listed in Section 15.</p> <p>Certification results of lab test: Pass Fail*</p> <p>Certification Report #: _____</p> <p> </p> <p>*If the lab results indicate that the system does not yet meet the requirements for cleanliness as specified, reflush for an additional 20 minutes and resample as required until an acceptable level is obtained.</p> <p>Record results of reflushing and resampling if the system did not pass with the first sample drawn.</p> <p>Certification results of lab test: Pass Fail*</p> <p>Certification Report #: _____</p>			
17.12	<p>Carefully blow back final flushing media to mixing tank using filtered GN2.</p> <p style="text-align: center;">CAUTION</p> <p>Do not exceed 500 psig during blow back. Always use the lowest pressure possible during this operation.</p>			

OPER.	DESCRIPTION OF WORK	NTS	CUST	DATE
	<p style="text-align: center;">CAUTION: CLEAN SYSTEM</p> <p style="text-align: center;">System is now considered precision clean do not open system to uncontrolled environment when draining system of flushing media. Do not introduce contamination during this operation.</p> <p>Crack all flanges and fittings, open low point drains and remove as much excess flushing media as possible. Tighten all flanges and fittings, close low point drains.</p> <p>Purge system with filtered (10 μ), dry GN2 to specified dew point. Check with dew point meter following mfr instructions.</p> <p>Check dew point at system end point or low point. Continue until specified dew point is reached.</p> <p>Specified Dew Point: Accept Reject</p>			
17.13	<p style="text-align: center;">CAUTION: CLEAN SYSTEM</p> <p>Maintain field environmental control, protect system openings in accordance with the requirements of this procedure. Minimize the actual time the system is open.</p> <p>Disconnect all flushing hoses, fittings and test connections using proper environmental controls. Maintain clean per specification requirements by immediately capping or bagging ends to maintain cleanliness level.</p> <p>NOTE: Poly bags, end caps and fittings used to cover tube or pipe ends shall be at least as clean as the system cleanliness requirement.</p>			
17.14	<p style="text-align: center;">SYSTEM BLANKET</p> <p>Upon completion of tubing/piping cleaning, and component reinstallation when required, establish a GN2 blanket pressure of 3-5 psig. Vents or drains open to the atmosphere do not require a blanket.</p>			

OPER.	DESCRIPTION OF WORK	NTS	CUST	DATE
	<p>_____</p> <p>_____</p> <p>_____</p> <p>_____</p> <p>Signature below signifies acceptance of the completed tubing and/or piping systems specified in this document.</p> <p>_____</p> <p>_____</p> <p>SNS Field Representative</p> <p style="text-align: right;">Date</p> <p>Signature below certifies that the tubing and/or piping systems specified in this document have been cleaned and processed in accordance with the requirements of the contract.</p> <p>_____</p> <p>_____</p> <p>Cleaning Contractor</p> <p style="text-align: right;">Date</p>			

NOTE: *The double polyethylene 6-mil bags/film used for primary and secondary sealing on cleaned systems is not intended as a permanent seal. Extremes in temperature cause the polyethylene to deteriorate over time and the tape adhesive to fail and come loose. Condensation between the bags is common and does not signify loss of cleanliness in the*

system. It is advisable that permanent connections be made or hard caps, plugs, flanges, etc., are installed as soon as possible.

Attachment C

Equipment Listing

EQUIPMENT SCHEDULE: HELIUM GAS SYSTEM

Component Number	Vendor Model Number	Description
HV	Hi Gear MSXKB12T	3/4" ball valve, 6000 psi rated, MS Series, full port ball valve, 316 stainless body and trim, Kel F seats, buna N seals, Ends per 3/4" MS 33649-12, lever handle
HV	Hi Gear MSXKB16T	1" ball valve, 6000 psi rated, MS Series, full port ball valve, 316 stainless body and trim, Kel F seats, buna N seals, Ends per 1" MS 33649-16, lever handle
PI-	WINTERS P1193-4FF	0-5000 psig gauge, 4" Dial, stainless case, stainless socket and tube, 1/4" MNPT back mount, panel mounted, front flange
BBV-	PARKER/IVES LS2VSA20M/NP	Block and Bleed/two valve manifold, 316 stainless steel, two bonnets on front face, panel mount, 1/4" FNPT inlet, outlet and vent
CV-	APCO 3505-3050X-16S	Check Valve, 1" Male FlaredTube connections, 316 Stainless Steel, Buna N Seats,

EQUIPMENT SCHEDULE: NITROGEN SYSTEM

Component Number	Vendor Model Number	Description
HV-	APCO 5080 XC16P	1" Cryogenic globe valve, NPT connections, SS construction
HV-	Worcester 2" NC4466PMSE	2" Cryogenic Ball valve, NPT connections, SS construction, Non-extended stem style

END OF SECTION 15455