

MMR™-Unit

Graphite Material

Specification

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CONFIGURATION CONTROL

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Document Approval

Action	Designation	Name	Signature	Date
Preparer	Designer	J Potgieter		13/08/2021
Comments Reviewer	VP Fuel and Materials	M Davies		13/08/2021
Approver	President USNC Power	M Mitchell		20/08/2021

CONTENTS

ABBREVIATIONS.....	4
DEFINITIONS	5
1. INTRODUCTION	6
1.1. PURPOSE	6
1.2. SCOPE	6
1.3. DOCUMENT LAYOUT	6
2. MATERIAL MANUFACTURING REQUIREMENTS	7
2.1. MATERIAL DESIGNATION	7
2.2. RAW MATERIALS	7
2.2.1. Fillers	7
2.2.2. Forming Lot	7
2.3. MANUFACTURING REQUIREMENTS.....	7
2.3.1. Formulation.....	7
2.3.2. Forming	7
2.3.3. Nominal billet dimensions	7
2.4. MATERIAL PROPERTIES	7
3. QUALITY ASSURANCE.....	9
3.1. GENERAL REQUIREMENTS.....	9
3.2. QUALITY CONFORMANCE INSPECTION.....	9
3.2.1. Responsibility of Inspection	9
3.2.2. Minimum Inspection Requirements	9
3.3. SAMPLING AND CUTTING.....	9
3.4. REJECTION AND REWORK	10
3.5. CERTIFICATION	10
3.6. PRODUCT MARKING AND IDENTIFICATION	10
3.7. PACKAGING, STORAGE AND TRANSPORT	10
3.8. DOCUMENTATION REQUIREMENTS.....	11
4. DESIGN DATA NEEDS.....	12
4.1. AS-MANUFACTURED PROPERTIES.....	12
4.2. IRRADIATED PROPERTIES	12
4.3. OXIDIZED PROPERTIES.....	13
4.4. CHEMICAL PROPERTIES	14
REFERENCES.....	15

EXHIBITS

Exhibit 4-1: Fluence-Temperature envelope	13
Exhibit 5-1- Controlled Substances [2]	14

ABBREVIATIONS

This list contains the abbreviations used in this document.

Abbreviation or Acronym	Definition
ASME	American Society of Mechanical Engineers
ASTM	American Society for Testing and Materials
CSA	Canadian Standards Association
CTE	Coefficient of Thermal Expansion
IIHP	Isomolded, Isotropic- High Purity
MMR™	Micro Modular Reactor
USNC	Ultra Safe Nuclear Corporation
TBD	To be determined

DEFINITIONS

Billet- A graphite artifact with dimensions sufficient to meet the Purchasers requirements.

Charge- Billets of a single grade that have been placed together in a furnace for graphitisation.

Production Lot- Specified number of billets made in accordance with this specification.

Purchaser- The Purchaser is the party that provides the requirements for the manufacture of the raw graphite material and who is responsible for ensuring the quality standards of the Supplier are sufficient.

Supplier- The Supplier is responsible for the manufacture of the raw graphite material. This includes the procurement of raw materials and the processing of these raw materials into the finished product.

1. INTRODUCTION

1.1. PURPOSE

The purpose of this document is to provide a specification for the graphite material for use within the USNC MMR(TM) Unit Core Graphite Assembly.

1.2. SCOPE

This specification covers the manufacturing of the raw graphite material, testing, packaging and transportation requirements as well and record keeping.

1.3. DOCUMENT LAYOUT

This document includes an introduction, followed by the material and manufacturing requirements for graphite, the quality assurance requirements and the data needs for the specified material.

2. MATERIAL MANUFACTURING REQUIREMENTS

2.1. MATERIAL DESIGNATION

The graphite provided by the Supplier shall be a fine grained, high purity, isotropic, isomolded nuclear graphite in accordance with ASTM D 7219- “Standard for Isotropic and Near Isotropic Nuclear Graphite” [1] class IIHP(Isomolded, Isotropic- High Purity) and [2] Subsection HH.

The material requirements provided within this specification are in addition to the requirements of those stated in [1] and [2] Subsection HH, and shall take preference should a contradiction arise.

2.2. RAW MATERIALS

2.2.1. Fillers

The maximum filler particle size used in the mix formulation shall be 100 µm.

2.2.2. Forming Lot

It is preferred that the graphite material used for an MMR(TM) Unit Core Graphite Assembly shall come from the same forming lot.

2.3. MANUFACTURING REQUIREMENTS

2.3.1. Formulation

The mix formulation and recycle green mix fraction in the filler shall be recorded and reported to the Purchaser.

2.3.2. Forming

The green mix shall be formed by iso-molding.

2.3.3. Nominal billet dimensions

A billet size that is appropriate shall be developed and justified by Supplier and agreed upon by the Purchaser before any order is placed as a result of this specification.

2.4. MATERIAL PROPERTIES

Each graphite production lot shall be tested and shall conform to the following physical, mechanical and chemical property requirements in accordance with [1].

Property	Unit	Required value/mean	Desired value/mean	Maximum Standard Deviation ⁷
Density	kg/m ³	1750 ¹	>1800	30
Coefficient of thermal expansion ^{3,6}	10 ⁻⁶ °C ⁻¹	5.5 ²	<5	0.15
Thermal conductivity ^{3,5}	W/m.K	110 ¹	>120	4
Isotropy ratio ²		1.1		
Tensile strength ^{3,4}	MPa	25 ¹	>27	1
Compressive strength ^{3,4}	MPa	80 ¹	>83	3
Flexural strength	MPa	60 ¹	>61	5
Dynamic elastic modulus ^{3,4}	GPa	9.5 < E < 11.5	10	0.5
Boron equivalance ²	ppm	0.4	< 0.4	0.15
Ash content ²	ppm	10	< 10	1

(1) – Minimum allowable value, (2) - Maximum allowable value, (3) With- Grain, (4) Against-Grain, (5) Measured at room temperature, (6) Mean value when measured over range of 25°C to 500°C, (7) Allowable deviations are grain-independent.

3. QUALITY ASSURANCE

3.1. GENERAL REQUIREMENTS

The Supplier shall be responsible for establishing, documenting, implementing, and maintaining a Quality Assurance Program in accordance with CSA N299.3-16 [3] and ASME BPVC Section III Division 5 [2] Subsection HAB.

The Suppliers Quality Assurance Program shall be audited by the Purchaser for compliance with [3] and [2] Subsection HAB before any order of material is placed as a result of this specification.

3.2. QUALITY CONFORMANCE INSPECTION

3.2.1. Responsibility of Inspection

The Supplier shall be responsible for the authorized inspection of graphite billets in compliance with [2] Subsection HAB, and [3]. The Quality Assurance Program created by the Supplier shall detail the inspection of items. This shall cover at least:

- The responsible authorized inspection personal.
- Any inspection hold and witness points during manufacture.
- Any hold or witness points that require additional interaction with the Purchaser or other parties.

The Supplier shall develop and document a testing and inspection plan that shall require acceptance by the Purchaser. The testing and inspection plan shall be audited by the Purchaser for compliance with [3] and [2] Subsection HAB before any order of material is placed as a result of this specification.

3.2.2. Minimum Inspection Requirements

Graphite billets shall be visually inspected for external flaws. The allowable size, type and number of flaws that are allowable shall be developed and justified by the Supplier and agreed upon by the Purchaser.

All graphite billets shall be non-destructively tested to screen for internal defects. The allowable size, type and number of internal flaws as well as the testing method shall be developed and justified by the Supplier and agreed upon by the Purchaser.

3.3. SAMPLING AND CUTTING

A statistical sampling and cutting plan shall be developed and justified by the Supplier and agreed upon by the Purchaser.

3.4. REJECTION AND REWORK

Undamaged portions of the billets that have been damaged may be used provided that the undamaged section meets all other requirements of the Material Specification subject to internal inspection of the undamaged portion.

3.5. CERTIFICATION

The Supplier shall provide a Certified Material Test Report that affirms the contents of the report are correct and accurate and that all test results and operations performed by the Supplier or its subcontractors are in compliance with the Material Specification.

The Supplier shall transmit all certifications required by [2] Subsection HAB-3862, received from other material organizations or suppliers to the Purchaser in English.

When specific times or temperatures of heat treatment are required by the Material Specification, they shall be reported.

The Quality Systems Certificate number and expiration date shall be shown on the Certified Material Test Report.

3.6. PRODUCT MARKING AND IDENTIFICATION

Graphite billets may be marked by any method that will not result in harmful contamination or sharp discontinuities and that will sufficiently identify the billet. Vibroetching is the preferred method of marking, however laser engraving is also permitted.

The marking shall indicate the axis of forming.

3.7. PACKAGING, STORAGE AND TRANSPORT

The detailed procedures for packaging, storage and transport shall be developed by the Supplier and shall be included in the Suppliers Quality Assurance Program.

The graphite billets shall be packaged and stored in a manner that prevents contamination by moisture, dust, oil, grease or any other contaminant that may damage the billet with reference to the materials listed in Exhibit 4-2.

The graphite billets shall be packaged and stored in such a manner that mechanical damage is prevented.

The use of non-powdered gloves or other suitable precautions shall be implemented to prevent contamination during handling.

Provisions shall be made for the use of shock monitors during transportation.

The identification of billets shall be repeated on the packaging.

3.8. DOCUMENTATION REQUIREMENTS

The Supplier shall provide adequate documentation as required by [2] and [3] in English. This includes, but is not limited to:

- A Quality System Manual that describes the Quality Assurance Program for manufacturing graphite, which shall include all procedures and processes.
- A testing and inspection plan.
- Quality assurance records
- A Manufacturing Specification including a Quality Assurance specimen extraction plan.
- A manufacturing schedule.
- A material qualification report/s
- Production records.
- Inspection records covering batch, billet and sample inspections.
- Material acceptance certificates.

4. DESIGN DATA NEEDS

The Supplier shall supply the Purchaser with a datasheet that includes all required material data for the specified grade. All data provided shall be in compliance with [1] and [2] Subsection HHA and shall consider sample orientation.

4.1. AS-MANUFACTURED PROPERTIES

The following as-manufactured properties of the material shall be provided by the Supplier:

- Tensile strength, temperature dependent,
- Compressive strength,
- Flexural Strength,
- Elastic modulus (dynamic), temperature dependent,
- Elastic modulus (static),
- Poisson's ratio,
- Coefficient of thermal expansion, temperature dependent,
- Critical stress intensity factor (K_{Ic}),
- Density,
- Thermal conductivity, temperature dependent,
- Mean grain size,
- Weibull modulus, threshold stress and characteristic strength,

Temperature dependent values are required at at-most 200°C increments from room temperature to at least 1200°C. The mean and standard deviation of each property shall be provided.

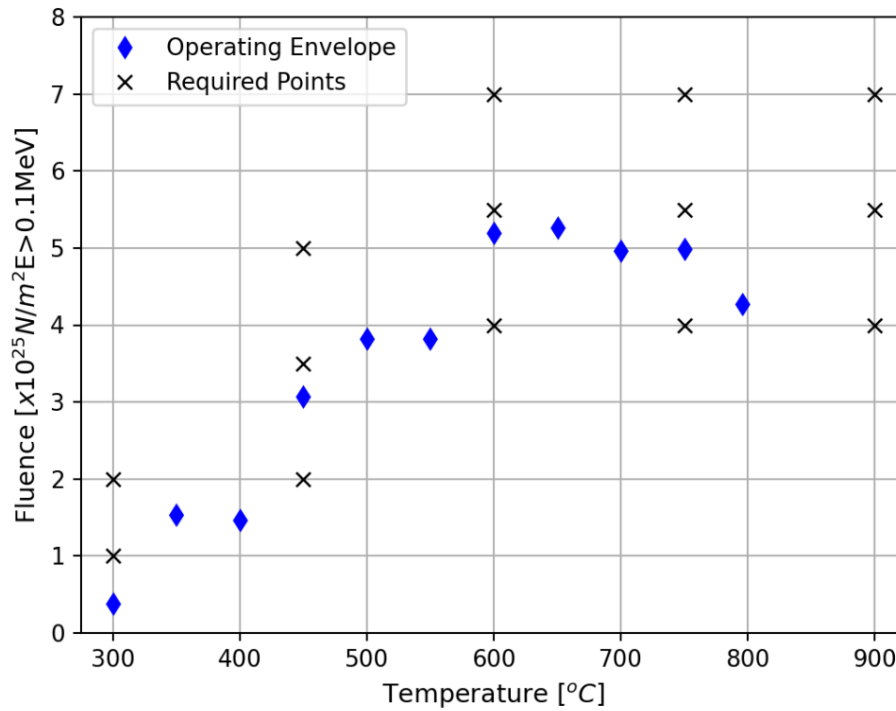
4.2. IRRADIATED PROPERTIES

The irradiation response of the following properties of the material shall be provided by the Supplier:

- Thermal conductivity, temperature dependent,
- Dimensional change (including volume change),
- Creep coefficients,
- Coefficient of thermal expansion, temperature dependent,
- Tensile strength, temperature dependent,
- Dynamic Elastic modulus,

Irradiated properties shall be provided at the points displayed in Exhibit 4-1. Post-irradiated temperature dependent values are required at at-most 200°C increments from room temperature to at least 1200°C. The mean and standard deviation of each property shall be provided.

Exhibit 4-1: Fluence-Temperature envelope



4.3. OXIDIZED PROPERTIES

The following physical properties shall be provided by the Supplier:

- Gas Permeability
- BET Surface Area
- Open Porosity
- Pore Size distribution
- The reaction rates as a function of temperature, pressure, time and impurity concentration.

The following post-oxidation properties of the material shall be provided by the Supplier:

- Tensile strength - temperature dependent,
- Dynamic elastic modulus,
- Thermal conductivity - temperature dependent,

Temperature dependent values are required at at-most 200°C increments from room temperature to at least 1200°C. Oxidated material properties shall be measured up to 10% oxidative weight loss in 2% increments. The mean and standard deviation of each property shall be provided.

The requirements for the oxidized properties of the material post-irradiation are TBD.

4.4. CHEMICAL PROPERTIES

The concentration of the substances within as-manufactured billets stated in Exhibit 4-2 shall be provided by the Supplier.

Exhibit 4-2- Controlled Substances [2]

Neutron Absorbing	Oxidation-Promoting	Activation Relevant	Metallic Corrosion Relevant	Fissile Elements
Boron	Aluminium	Antimony	Chlorine	Thorium
Cadmium	Barium	Cadmium	Mercury	Uranium
Chlorine	Calcium	Cesium	Sulfur	
Dysprosium	Copper	Chlorine		
Europium	Iron	Cobalt		
Gadolinium	Lead	Europium		
Gold	Magnesium	Gadolinium		
Indium	Manganese	Iron		
Iron	Nickel	Lithium		
Mercury	Potassium	Molybdenum		
Nickel	Silicon	Nickel		
Rhenium	Silver	Nitrogen		
Rhodium	Sodium	Scandium		
Samarium	Titanium	Silver		
Titanium		Tantalum		
Tungsten		Terbium		
Vanadium		Thorium		
		Uranium		
		Dysprosium		

REFERENCES

- [1] ASTM, "D 7219-Standard Specification for Isotropic and Near-Isotropic Nuclear Graphites," 2008.
- [2] ASME, "Boiler and Pressure Vessel Code, Section III, Division 5," 2019.
- [3] Canadian Standards Association, "Quality assurance program requirements for the supply of items and services for nuclear power plants, Category 3," 2016.