






**LOW LEVEL WASTE REPOSITORY STUD REPAIR GUIDANCE DOCUMENT**

**Summary**

Subject to the foregoing this Guidance Note should be read in conjunction with the LLW Repository Ltd IP-2 ISO Container Operational Documentation. Notwithstanding any other term of this Guidance Note, this Guidance Note is intended only to support the Container Design Operational Documentation by explaining the basis of the condition requirements and providing additional information. Nothing in this Guidance Note shall be legally binding upon the Operator of the LLW Repository Ltd and all Terms and Conditions between such Operator and the Customer for the repair of Studs. In the event of any conflict between the provisions of the Guidance Note and any Stud Repair Conditions, the Container Design Approval Conditions shall prevail in all respects.

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<b>Prepared by</b>		
		<b>Tom Branthwaite Packaging Services Support LLW Repository Ltd</b>
<b>Checked by</b>		
		<b>R E Millington Package Design Authority LLW Repository Ltd</b>
<b>Approved by</b>		
		<b>Marc Flynn Transport &amp; Logistics Manager LLW Repository Ltd</b>



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## Introduction

This document has been prepared to provide guidance on the repair of sheared lid clamp studs on the LLW Repository Ltd Type IP-2 ISO freight containers. This paper does not address repair options for containers that have sustained damage to structural members.

## PART A – General Requirements

Any repairs to LLWR IP-2 ISO freight containers must be pre-authorized by LLWR via an Operational Concession (OC). The LLWR Packaging Services Team will process the application for an OC on the customer's behalf, using the information provided by the Customer (see section A1 of this Guidance Note).

### A1 – Operational Concession Application Process

To ensure successful authorisation of an Operational Concession, customers must provide the following information to the Packaging Services Team:

- Serial Number of the damaged container
- Photographs of the damaged stud
- An annotated sketch of the damaged area showing the location of the stud on the container, giving any dimensions and detailing any additional relevant information (e.g. note areas of damage to the paint around the stud).

For any queries please contact the LLW Repository Ltd Transport and Logistics Team [www.transportandlogistics@llwrsite.com](mailto:www.transportandlogistics@llwrsite.com).

## PART B – Procedure for Sheared Stud Replacement

- B1 Replacement studs must be obtained from LLWR to ensure compliance with the correct specification.
- B2 This procedure should be followed when replacing a sheared stud.
- B3. Determine area to fit the new stud (Recommended position to be approximately 50mm from the edge of the weld of the failed stud).

**Note: -The old stud is not to be refitted but to be returned to LLWR for examination (if deemed necessary) or discarded.**

- B4 Remove paint finish to expose bare metal approximately 80mm diameter around the area where the new stud is to be fitted.
- B5 Weld the new stud in accordance with an approved weld procedure.

**Note: Weld procedure must be approved by LLWR before welding commences**

- B6 Carry out soapy bubble under vacuum test to the old stud position, the new stud position and HAZ in accordance with an approved procedure (Acceptance criteria – Zero bubbles).



- B7 Carry out pressure test to the adjacent orifice seal interspace in accordance with PAA G001 Issue2
- B8 Make good the paint at the repair. **Please refer to Guidance PAAGN18 Painting of IP-2 Rated Containers.**
- B9 On satisfactory completion of the repair and testing, a report/reports shall be raised covering repair, NDT and pressure testing. Copies must be submitted to T & L Team.

**Note: - This report shall be deemed to confirm that the container is returned to service under the provision of the Package Authority Certificate.**

### **PART C – References**

Ref 1. PAA G001

Ref 2. PAAGN18