



Specification D-0101
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**SPECIFICATION
FOR
PREPACKAGED MgO BACKFILL**



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For

U.S. Department of Energy

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U. S. DEPARTMENT OF ENERGY
WASTE ISOLATION PILOT PLANT

SPECIFICATION D-0101
Prepackaged MgO Backfill

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SPECIFICATION D-0101 RECORD OF REVISION

ECO/REV#/DATE	PAGES AFFECTED	REVISION DESCRIPTION
8613 Rev. 0 5-23-97	All	Specification Created
8852 Rev. 1 12-18-97	2	Revised 3.3.1.3; deleted CAA test and reaction time, added reference to Attachment 1.
	5	Added 3.5.3.4 to require marking date of fill on sacks. Deleted text and title of 5.1 and 5.1.1 requiring a QA program complying with NQA-1, moved 5.2 Submittals to 5.1.
	10 & 11	Added Attachment 1, specifying the reactivity test equipment and procedure.
9724 Rev. 2 03-08-00	2, 3, 4, 6, Attachment A & B	Reduced the min bulk density to 87 lb/ft ³ , increased the super sack height from 24.5 to 25.5 inches, and increased the super sack weight from 4,100 to 4,200 lbs.
9753 Rev. 3 04-04-00	2	Clarify material requirements.

1.0 SCOPE

This specification covers the definition of the pre-packaged backfill material to be emplaced in the underground areas at the Waste Isolation Pilot Plant (WIPP). The backfill material will be Magnesium Oxide (MgO), furnished in two bulk package configurations; a super sack and a mini sack. The super sack shall be shipped on a support sheet.

2.0 APPLICABLE DOCUMENTS

The requirements of this specification have precedence over all referenced documents. Where this specification appears to conflict with the requirements of a referenced document, such conflicts shall be brought to the attention of the purchaser for resolution.

2.1 REFERENCES

The codes, specifications, and standards referred to by number or title form a part of this specification. They are not furnished with the contract documents.

Code of Federal Regulations:

Title 29, Part 1910 Occupational Safety and Health
(29 CFR 1910) Standards

Title 30, Part 57 Safety and Health Standards -
(30 CFR 57) Metal and Non-Metal Underground Mines

Waste Isolation Pilot Plant, Waste Isolation Division

WP 13-1 Quality Assurance Program Description
Section 1.3 Quality Improvement
Section 1.5 Records
Section 2.1 Work Processes
Section 2.3 Procurement
Section 2.4 Inspection and Testing
Section 3 Assessment Requirements

3.0 PRODUCT AND DESIGN REQUIREMENTS

3.1 GENERAL REQUIREMENTS

3.1.1 The materials and packaging shall conform to this specification. The packaging shall be capable of transporting the backfill material without breaking or a loss of contents.

- 3.1.2 The vendor shall provide an MSDS for each MgO material.
- 3.1.3 The vendor shall provide an MSDS and flame spread, smoke generation, and decomposition product information for all materials used in the super sacks and mini sacks.

3.2 FUNCTIONAL REQUIREMENTS

- 3.2.1 Supplier filled super sacks will be handled during transportation to the WIPP, at receipt and during material handling operations on support sheets. Refer to Figure 3.1 for the emplaced position of the super sack.
- 3.2.2 Supplier filled super sacks are to be placed on a vendor furnished support sheet which will be suitable for the application when placed on the waste stack.
- 3.2.3 A filled "Super Sack" and its support sheet will be placed on top of one of four waste containers; Standard Waste Box (SWB), 7-pack of 55 gallon drums (Figure 3.3), Ten Drum OverPack (TDOP), or a 4-pack of 85 gallon overpack drums (Figure 3.4). The filled super sack must be able to retain its contents for a period of two years after emplacement without rupturing from its own weight.

3.3 MATERIAL REQUIREMENTS

3.3.1 Backfill Material Requirements

- 3.3.1.1 The sum of magnesium oxide (MgO) plus calcium oxide (CaO) shall be a minimum of 95%, with MgO being no less than 90%. The remainder of the material shall not contain any items considered hazardous to people or the environment.
- 3.3.1.2 Backfill material shall be of a dry granular form, which shall contain less than 0.5% particles which would be retained on a Tyler 3/8 inch sieve (3/8" x down).
- 3.3.1.3 Backfill material shall be tested for reactivity as outlined in Attachment B, and shall meet the temperature rise listed in the test procedure.
- 3.3.1.4 The backfill material which is used to fill super sacks and mini sacks shall have a minimum loose bulk density of 87 lb/ft³.

3.3.2 Backfill super sack Material Requirements

- 3.3.2.1 The super sack shall be constructed of woven polypropylene material, with a minimum weight of 8.0 ounces per square yard, coated or

uncoated. Assembly shall be by normal bag fabrication methods; i.e. sewing, gluing, etc. Alternate materials and/or fabrication methods are acceptable subject to approval by WID Engineering prior to shipment. Poly Vinyl Chloride (PVC) material is not acceptable.

- 3.3.2.2 The assembled (empty) dimensions of the super sack shall be a hexagon which is nominally 61 inches across the flats (a 61 inch inscribed circle) by 25.50 inches high (47.6 ft³). The super sack shall be constructed such that it retains its shape well enough to not deform beyond a 65 inch hexagon with 12 inch radius corners after filling and shipping.
- 3.3.2.3 The assembled super sack shall have the capacity to transport a minimum of 4,200 pounds of a material with a loose bulk density as specified in Section 3.3.1.4. The super sack shall be designed to comply with the requirements of the Flexible Intermediate Bulk Container Association (FIBCA), including a safety factor of five to one (5:1) on the working load.
- 3.3.2.4 Any fill opening shall be closed to prevent leakage of material during shipping and handling. No discharge opening is required.
- 3.3.2.5 The super sack shall provide a barrier to atmospheric moisture and carbon dioxide (CO₂) which is equivalent to or better than that provided by a standard commercial cement bag. If required, an independent liner may be added. The liner may be a separate part or attached to the super sack at the manufacturer's option.

3.3.3 Backfill mini sack Material Requirements

- 3.3.3.1 The mini sack shall be constructed of woven polypropylene material, coated or uncoated. Assembly shall be by normal bag fabrication methods; i.e. sewing, gluing, etc. Alternate materials and/or fabrication methods are acceptable subject to approval by WID Engineering prior to shipment. Poly Vinyl Chloride (PVC) material is not acceptable
- 3.3.3.2 The empty mini sack shall have the shape of a frustum of a cone, with a nominal bottom diameter of 5.75 inches, a nominal overall length of 33 inches, and a nominal top diameter of 3 inches (0.30 ft³ volume).
- 3.3.3.3 The assembled mini sack shall have the capacity to transport a minimum of 27 pounds of MgO with a loose bulk density as specified in Section 3.3.1.4.
- 3.3.3.4 An integrally connected hook which is suitable to support the weight

of the filled mini sack, i.e. a commercial steel "S" hook, shall be provided on each bag. The hook shall be of a size to fit over the lifting clip on the SWB (See Figures 3.2 and 3.3). The hook and its connection shall be positioned on the outer diameter of the mini sack such that the bottom of a filled sack is not more than 35.50" below the top of the SWB lift clip.

3.3.3.5 Any fill opening shall be closed to prevent leakage of material during shipping and handling. No discharge opening is required.

3.3.3.6 The mini sack shall provide a barrier to atmospheric moisture and carbon dioxide (CO₂) which is at least comparable to that provided by a standard commercial cement bag. If required, an independent form-fitted liner may be added. The liner may be a separate part or attached to the mini sack at the manufacturer's option.

3.4 FABRICATION REQUIREMENTS

3.4.1 The supplier shall provide backfill containers which comply with the requirements for super sacks as outlined in Sections 3.3.2 above. The super sack shall be filled with $4,200 \pm 50$ pounds of backfill material as specified in Section 3.3.1 above.

3.4.2 The supplier shall provide backfill containers which comply with the requirements for mini sacks as outlined in Sections 3.3.3 above. The mini sack shall be filled with 26 ± 1.0 pounds of backfill material as specified in Section 3.3.1 above.

3.5 PACKAGING AND SHIPPING REQUIREMENTS

3.5.1 Filled backfill containers shall be delivered to the WIPP site by commercial carrier. Shipment racks and containers will be provided by the purchaser. These will be in the form of stackable/collapsible racks for the super sacks (one per rack) and stackable/collapsible wire baskets for mini sacks (approx. 140 mini sacks per container).

3.5.2 All items shall be packaged as required to provide protection from damage during shipping and handling.

3.5.3 Each individual backfill container shall be clearly labeled with the following information:

3.5.3.1 The backfill material name as it appears on the Material Safety Data Sheet (MSDS).

3.5.3.2 All applicable hazard warnings.

3.5.3.3 The backfill material manufacturer's name and address. If the vendor supplying the filled backfill containers is not the backfill material manufacturer, the both the backfill material vendor's name and address and the name and address of the vendor supplying the filled containers shall also appear on each container.

3.5.3.4 The date the backfill container was filled with backfill material.

4.0 FIELD EXECUTION

4.1 INSPECTION

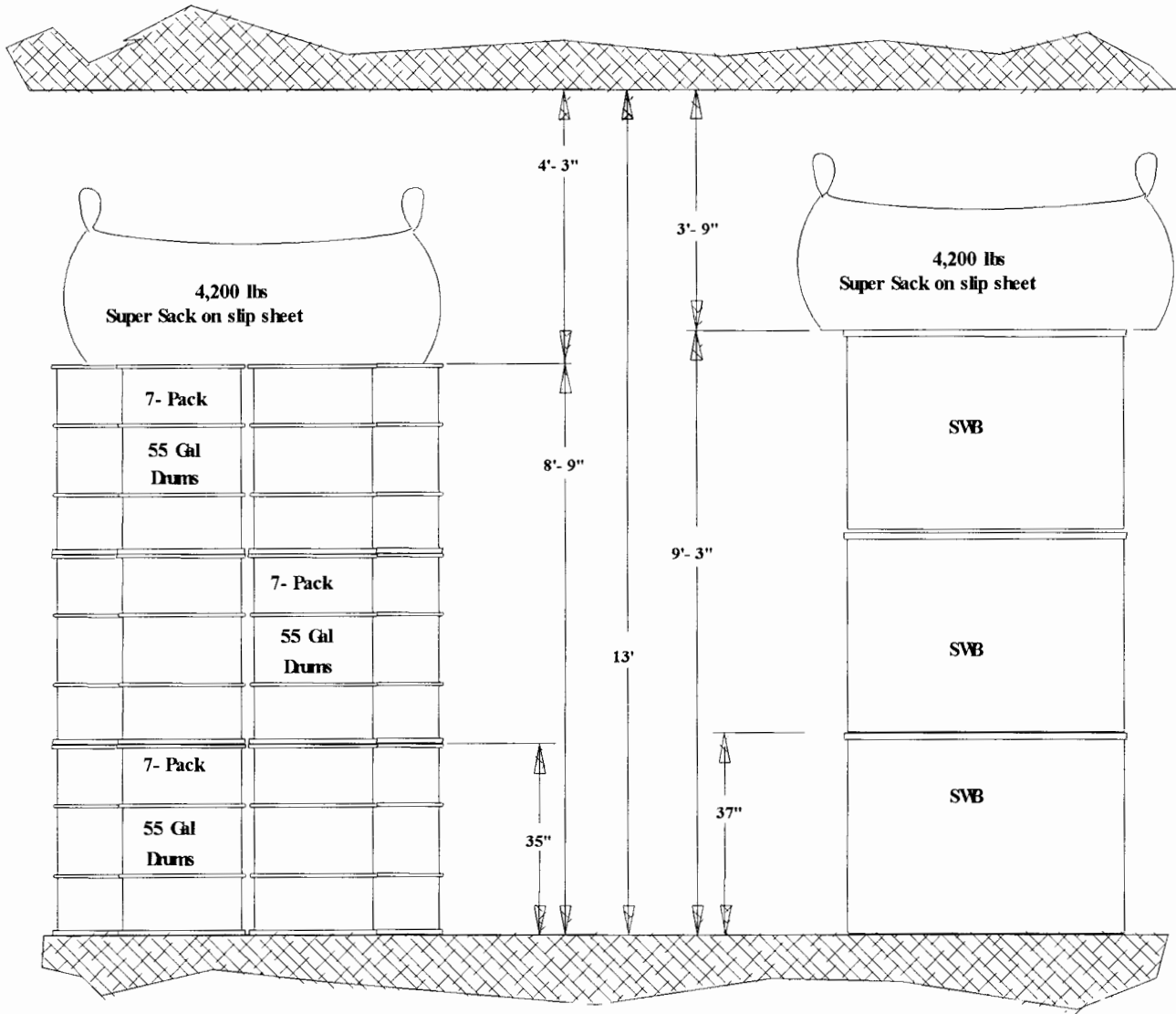
All shipments of backfill containers will undergo random receiving inspection at the WIPP for the stated criteria by WID personnel for shipping damage, for compliance with specifications, and for any other abnormality.

5.0 QUALITY ASSURANCE REQUIREMENTS

5.1 SUBMITTALS

5.1.1 The supplier shall provide a certified material composition analysis and an MSDS with each shipment.

Figure 3.1



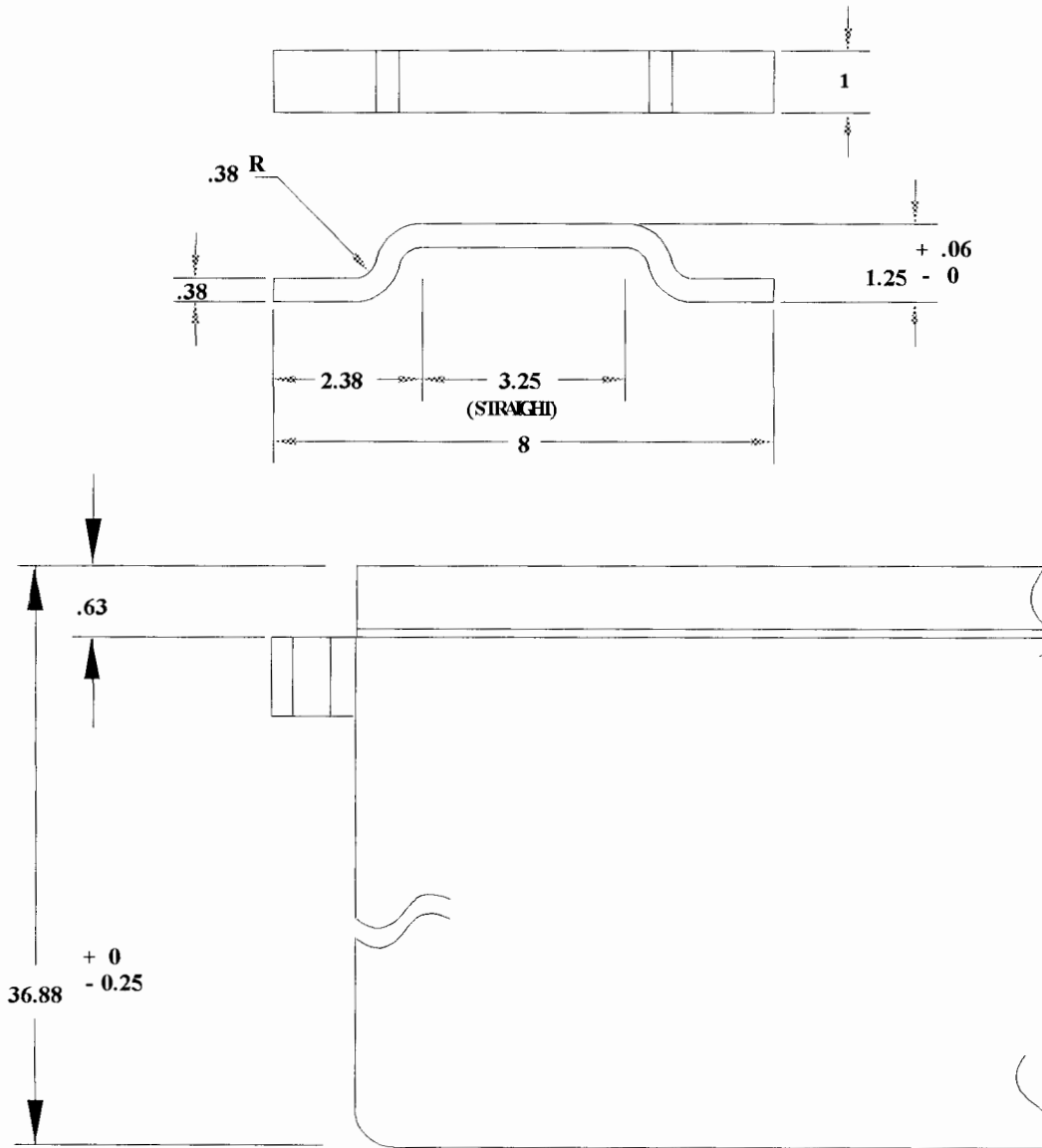


Figure 3.2

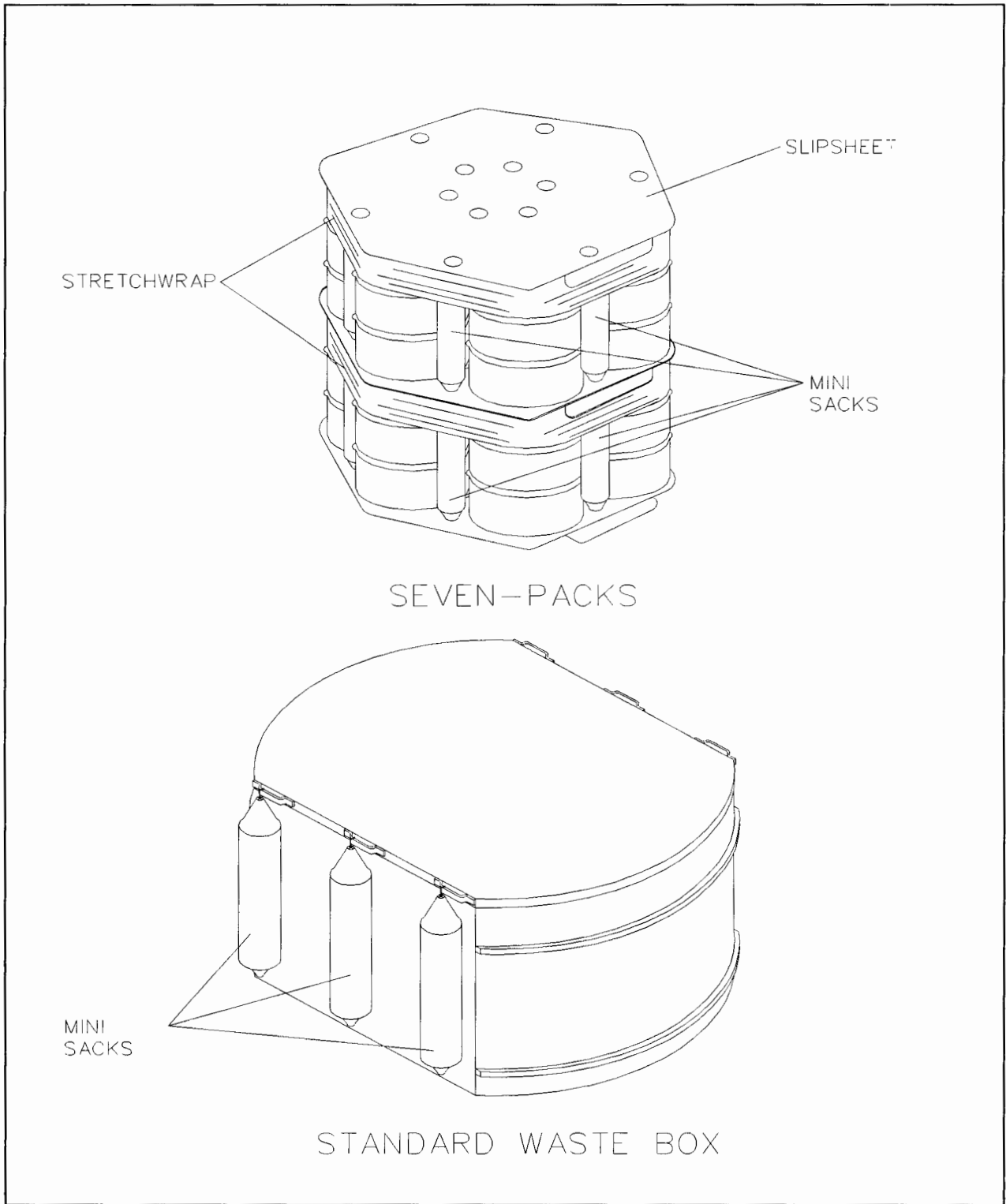
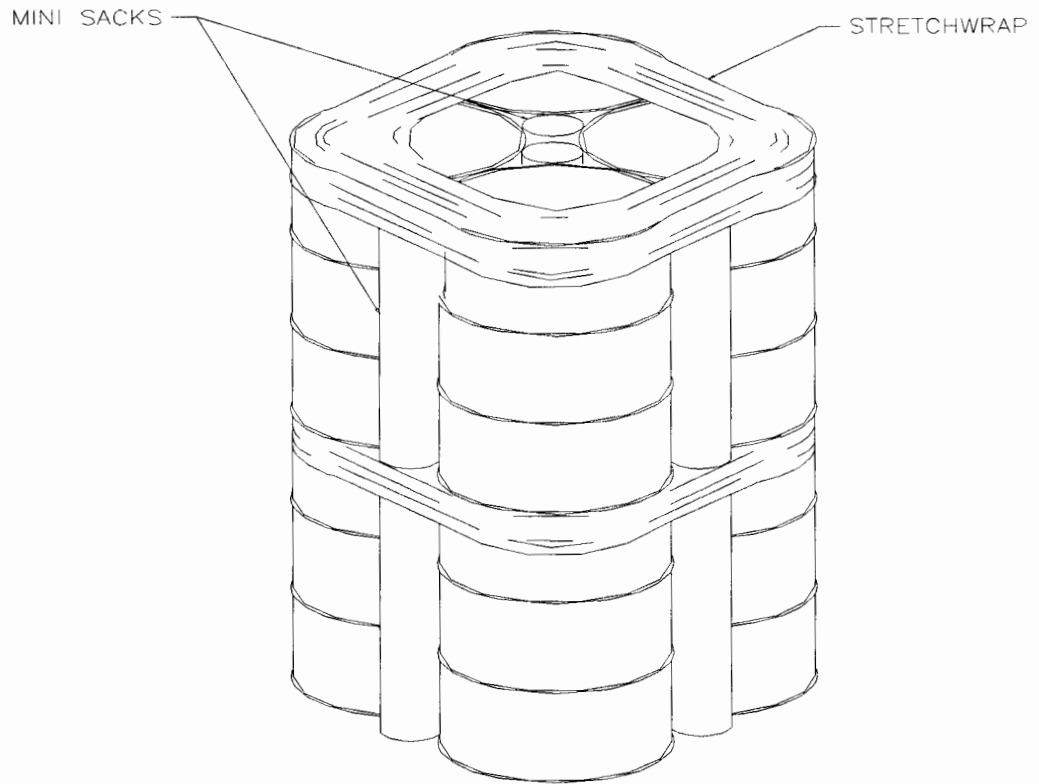
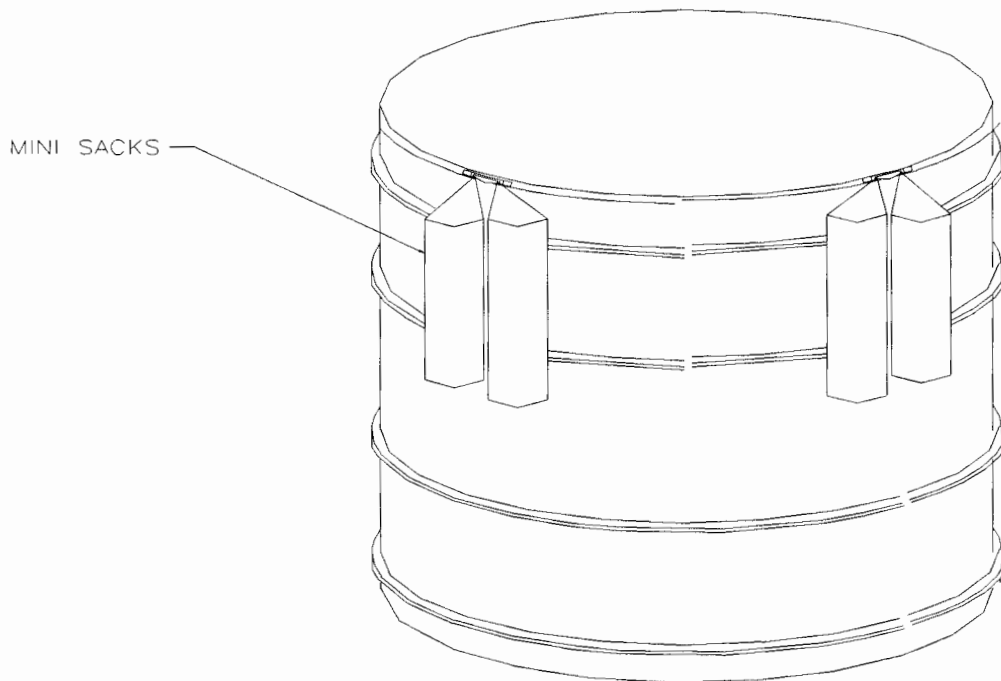


Figure 3.3



4 PACKS OF
85 GALLON OVERPACK



TEN DRUM
OVER PACK

Figure 3.4

ATTACHMENT A - Document Submittal Requirements

DOCUMENT SUBMITTAL REQUIREMENTS

SUBMIT DOCUMENTS PRIOR TO THE POINTS INDICATED BY THE CODE BELOW:

F – FABRICATION
 T – TESTING
 S – SHIPMENT

C – CONSTRUCTION/INSTALLATION
 A – FINAL ACCEPTANCE

Document Requirements	See Paragraph	For Approval	For Record
1. MSDS for Bag Material	3.1.3		A
2. MSDS for MgO Material	3.1.2		A
3. MgO certified material composition analysis	5.1.1		A

Detailed MgO Reactivity Acceptance Test Procedure

Equipment Needed:

1. A drying oven able to sustain a temperature of approximately 100°C.
2. An NIST-traceable partial-immersion thermometer (or electronic equivalent) able to measure temperatures from 20°C to at least 55°C, with increments of 0.1°C, for measuring MgO solution temperature rise. A second NIST-traceable full-immersion thermometer (or electronic equivalent) with increments of 1°C for measuring room air temperature. A third NIST-traceable full- or partial-immersion thermometer, depending on oven configuration (or electronic equivalent) with increments of 1°C for measuring oven air temperature.
3. A means of supporting the thermometer in a 400 mL beaker so that the fluid level will be at the immersion mark on the thermometer.
4. An analytic balance accurate to within ± 0.01 g, calibrated with NIST traceable standards.
5. A plastic-coated magnetic stir bar 1-3 inches in length and a stir plate to drive it.
6. A source of deionized water.
7. A source of ACS Reagent Grade 85% phosphoric acid.
8. 400-mL glass beakers.
9. Stopwatch (optional).
10. Scientific notebook (or suitable alternative which provides permanent archiving of recorded information).

Procedure:

1. Mix one liter of 20% $\pm 0.1\%$ phosphoric acid (by weight) from deionized water and reagent grade 85% phosphoric acid. After mixing, allow the temperature to return to within 3°C of room temperature (20 to 30°C).
2. Dry at least 60 g of as-received MgO pellets. The sample should be either dried overnight or until it is verified that the center of the MgO mass has been at approximately 100°C for at least half an hour. Verify the drying temperatures using an NIST-traceable thermometer. Pellets should be at room temperature (20 to 30°C) before being tested.
3. Weigh 300 ± 0.5 g of 20% phosphoric acid into a glass 400 mL beaker. Record the weight in the scientific notebook (or suitable alternative).

Detailed MgO Reactivity Acceptance Test Procedure

4. Place a piece of insulating cardboard on the stir plate and then place the beaker on the cardboard. Put a stir bar in the solution and initiate stirring so that a dimple about 1-2 cm deep forms in the center of the beaker.
5. Put the thermometer in the phosphoric acid to the immersion line and fix it in this position so that it cannot change during the remainder of the test.
6. Note the temperature and do not proceed until it has stabilized (e.g., does not change by more than 1°C in two minutes). Record the temperature once it has stabilized.
7. Weigh 18.00 ± 0.1 g of pre-dried as-received MgO pellets. Record the weight in the scientific notebook (or suitable alternative).
8. Add the MgO to the phosphoric acid and note the starting time of the experiment to the nearest second. Alternatively, start the stopwatch.
9. At one-minute intervals, record the temperature in the scientific notebook (or suitable alternative). Continue taking temperature measurements until the temperature starts to fall (about 30-35 minutes).
10. Perform three replicates of this procedure.

To be acceptable, the average maximum temperature rise observed in the three replicates must be at least 20°C.