

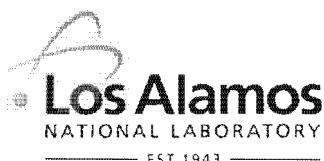
LA-UR-08-*6209*

Approved for public release;
distribution is unlimited.

Title: ~~PAPER~~: THE STATUS OF THE LANSCE
REFURBISHMENT PROJECT (LANSCE-R)

Author(s): John Erickson, AOT-DO
Kevin Jones, AOT-DO
Michael Strevell, PP-SRTR

Intended for: XXIV International Linear Accelerator Conference,
September 29-October 3, 2008
Victoria, BC, CANADA



Los Alamos National Laboratory, an affirmative action/equal opportunity employer, is operated by the Los Alamos National Security, LLC for the National Nuclear Security Administration of the U.S. Department of Energy under contract DE-AC52-06NA25396. By acceptance of this article, the publisher recognizes that the U.S. Government retains a nonexclusive, royalty-free license to publish or reproduce the published form of this contribution, or to allow others to do so, for U.S. Government purposes. Los Alamos National Laboratory requests that the publisher identify this article as work performed under the auspices of the U.S. Department of Energy. Los Alamos National Laboratory strongly supports academic freedom and a researcher's right to publish; as an institution, however, the Laboratory does not endorse the viewpoint of a publication or guarantee its technical correctness.

STATUS OF THE LANSCE REFURBISHMENT PROJECT

John L. Erickson, Kevin W. Jones and Michael W. Strevel
Los Alamos National Laboratory, Los Alamos, NM 87545, U.S.A.

Abstract

The Los Alamos Neutron Science Center (LANSCE) accelerator is an 800-MeV proton linac that drives user facilities for isotope production, proton radiography, ultra-cold neutrons, weapons neutron research and various sciences using neutron scattering. The LANSCE Refurbishment Project (LANSCE-R) is an ambitious project to refurbish key elements of the LANSCE accelerator that are becoming obsolete or nearing end-of-life. The conceptual design phase for the project is funded and underway. The 5 year, \$170M (US) project will enable future decades of reliable, high-performance operation. It will replace a substantial fraction of the radio-frequency power systems (gridded tubes and klystrons) with modern systems, completely refurbish the original accelerator control and timing systems, replace

obsolete diagnostic devices, and modernize other ancillary systems. An overview of the LANSCE-R project will be presented. The functional and operating requirements will be discussed, the proposed technical solutions presented, and the plan for successful project execution while meeting annual customer expectations for beam delivery will be reviewed.

INTRODUCTION

The LANSCE User Facility accelerator is capable of simultaneously accelerating protons or negative hydrogen ions to beam powers of up to 800 kW. A beam switchyard allows tailored time-structured beams to be delivered to the five distinct experimental areas.

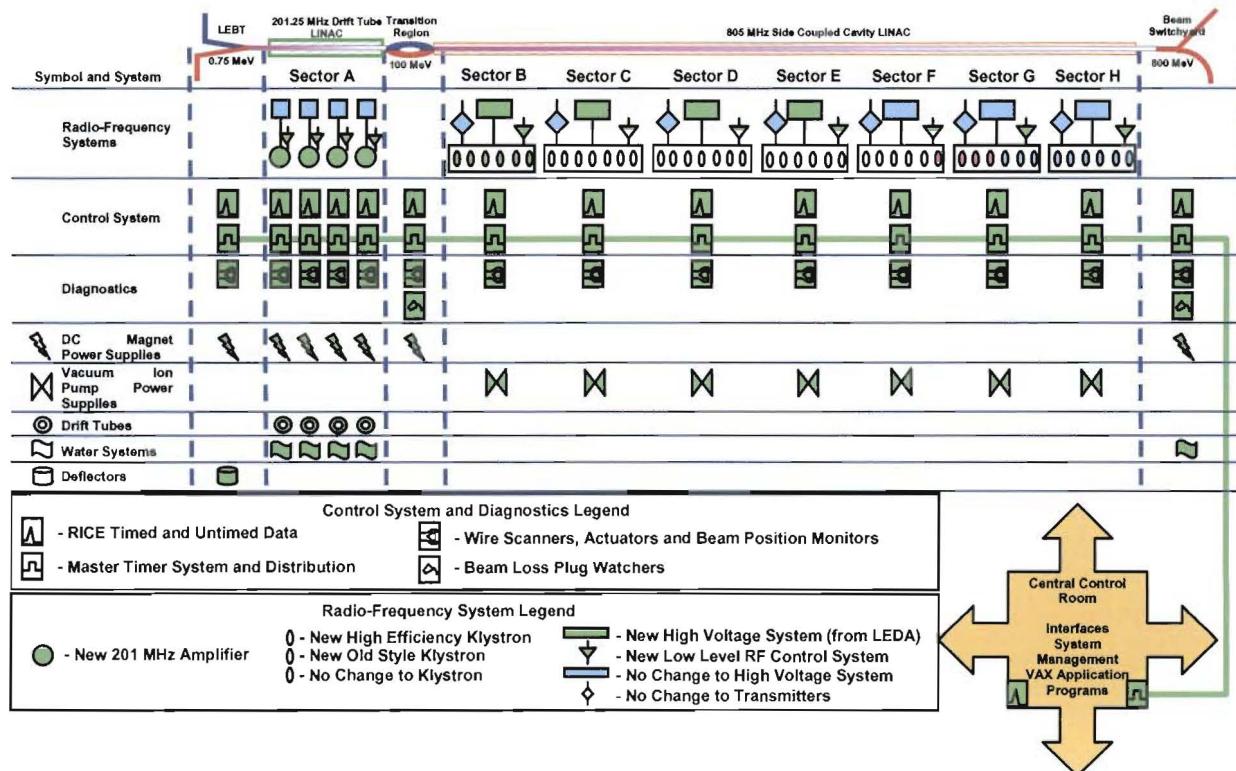


Figure 1: A summary diagram showing the scope of LANSCE-R.

Vision and Goals

LANSCE produces one of the highest beam currents in the world of medium energy protons to irradiate experimental targets directly or to produce intense pulses of spallation neutrons. LANSCE performs state-of-the-art experiments in proton radiography, nuclear science, and materials science.

Our goal is to provide safe, secure, environmentally-compliant, cost-effective performance in beam delivery that meets or exceeds metrics prescribed by our customers.

The LANSCE Refurbishment Project (LANSCE-R) ensures that the LANSCE User Facility will continue to be the premier neutron science facility at Los Alamos National Laboratory, providing NNSA with critical data

in support of its Defense Programs mission. A schematic of the project scope is shown in Figure 1.

Assumptions

Operation of the scientific program will continue during the refurbishment project in a tailored way to meet customer expectations to the extent possible while simultaneously implementing the refurbishment project during scheduled operational outages. Refurbishment elements will be pre-assembled, staged, and tested to the greatest extent possible prior to possible multi-shift installation evolutions.

STRATEGIES AND PROJECTS

Implementation Strategies

The overall implementation strategy is to integrate ongoing LANSCE User Facility operation with the execution of the LANSCE-R project. The operations organization for LANSCE is both well established and strong. Capital projects have a successful history of integration with the operating facility. The recent experience of integrating the construction of the Isotope Production Facility is an example of strong cooperation between a project and the operating facility.

The overall success of both LANSCE Operations and the LANSCE-R Project rests on the ability of the responsible organizations to retain and, where appropriate, develop the skilled technical staff needed to support ongoing operations, maintenance and related improvements as well as the conceptual, preliminary and final designs of LANSCE-R sub-systems, oversight of component procurement, acceptance testing, pre-installation assembly and testing, and final installation and commissioning.

The following key operational elements are essential for the integrated model to be successful:

- A commitment to schedule at least 3,000 hours of beam operation for users each fiscal year from FY2008 through FY2014 and beyond, with appropriate allocation of sole-use and beam development time.
- No more than one cold-start facility turn-on in each fiscal year.
- An appropriate distribution of extended outages of several months duration to accommodate both a modular approach to LANSCE-R sub-system installation and other operations-funded system improvements as well as appropriate cool-down times for routine maintenance on activated equipment in areas such as the Proton Storage Ring and the IL Target.
- A disciplined approach to configuration management for accelerator and beam delivery systems to minimize return to service after short and extended outages.

- Continuous certification of the Radiation Security System to minimize the time required for resumption of production beam operation.

The following elements are essential for LANSCE-R to be successful:

- Proposed equipment and system upgrades are focused on those current LANSCE capabilities required to support Weapons Program needs.
- A design, acquisition, and assembly strategy that optimizes preparation for focused equipment installation during scheduled operational outages.
- An appropriate balance between refurbishment of the LANSCE User Facility real property and installed equipment through the Facility Infrastructure Recapitalization Program (FIRP) and refurbishment of essential accelerator sub-systems through the LANSCE-R project.
- A project execution time line that permits performance of the full scope of work in no more than five to seven years.

Facility and Infrastructure Projects

Weapons Program GPP funding and the Facility Infrastructure Recapitalization Program (FIRP) have effectively been used at the LANSCE User Facility to replace Radioactive Liquid Waste handling, cooling towers, and the chilled water plant to ensure that the real property and installed equipment remain capable of supporting long term operation through 2020. These projects have been completed on schedule and within budget, with the work being carefully planned within extended accelerator maintenance outages. Additional work is needed, and replacement of electrical distribution system and certain process water systems are being undertaken in FY09.

A strong FIRP program is essential to underpin the ongoing success of LANSCE operations and the refurbishment scope planned in LANSCE-R. Out-year projects (FY09-FY11) encompass multiple electrical distribution system upgrades, process cooling water upgrades, roof replacements, and HVAC replacements.

LANSCE-R Preferred Scope

The preferred scope that was included to support the Mission Need for the LANSCE-R Project will enhance cost effectiveness by system refurbishments or improvements that reduce operating costs and will improve decreasing facility reliability by replacing systems that have an impact of 15% or greater on reliability for those systems.

The full LANSCE-R project will also eliminate the following sources of operational inefficiencies that should improve operational effectiveness:

- Single-point failures with an estimated time to repair of greater than 30 days,
- Equipment that is beyond its predicted end-of-life that could severely impact facility operations,

- Obsolete equipment for which no spare parts are available,
- ES&H or code compliance issues necessary to continue safe operation.

The baseline refurbishment project consists of replacing the 201 MHz RF systems, updating about 75% of the 805 MHz RF systems, modernizing the control system, and replacing or refurbishing a variety of diagnostics and accelerator subsystems.

The RF and power supply scope includes the following:

- Magnet Power Supplies – Approximately 12 different power supply replacement projects.
- Pulsed Power – Solid State Replacement for Ground Level Deflectors
- 201 MHz RF for the Drift Tube Linac – All new 201 RF except for High Voltage
- Low Level RF – All new LLRF in the 201 MHz and 805 MHz subsystems
- 805 MHz Klystrons – 4 sectors of new high efficiency klystrons and 1.5 sectors of new old style klystrons (leaving 1.5 sectors of klystrons not replaced)
- High Voltage Power Systems – 4 sectors of new high voltage systems.

The Controls replacement scope is limited to the replacement of the control and instrumentation functions implemented by the RICE systems, DEC MicroVAX and workstation computer systems, and application software that comprise the current LANSCE Control System (LCS). The LCS provides control and data monitoring for most devices in the LINAC and for some of its associated experimental-area beam lines. The overall Control and Instrumentation scope includes the following:

- Replace Linac Beam Position Monitors and incorporate phase measurements
- Replace the Delta T system
- Replace 95 Wire scanners in the linac
- 18 IR loss monitor systems & 5 GD systems
- Replace VAXs and VAX applications
- Replace RICE systems (Remote Instrumentation Control Equipment systems)
- Replace Master Timer System.

The accelerator sub-systems scope includes:

- Cooling Water distribution and monitoring
- Vacuum system equipment and monitoring
- Linear accelerator copper structures, Drift Tubes.

The preferred scope being proposed is a self-consistent approach to maintaining reliability and addressing single point failures in the LANSCE facility that serves the NNSA/SSP Defense Programs mission. It generally assumes that the current facility capability will be maintained. LANSCE-R includes only scope to support NNSA/SSP mission research at 120 Hz and 625 μ s beam gate. It only includes beam delivery elements common to pRad, WNR and Lujan Center that all have NNSA/SSP mission deliverables. It does not include refurbishment of equipment /systems from the end of the accelerator to

WNR and the Lujan Center, including Line D and the PSR. In addition, LANSCE-R does not include equipment changes to support current or future H⁺ operations to Isotope Production or Area A/MTS. This approach is consistent with guidance received from NNSA.

IMPLEMENTATION OF A SEVEN-YEAR PLAN FOR FY09-FY15

Operations Objectives for Project:

- Operate for approximately 3,000 hours exclusive of development, documentation, and sole use operation consistent with operations in FY2008.
- Retain key staff required to perform both operations and LANSCE-R implementation at the same time.

LANSCE-R Current Year – FY2008-9

- Conduct the agreed-upon scope of work for conceptual design and obtain approval of the final CD-1 Critical Decision. This will include project management, project controls, and technical writing in support of the CD-1 package development.

LANSCE-R Future Years – FY2010-15

Given the funding scenario that is ultimately determined, we will manage the work to be accomplished in each annual outage (each an identified subproject) to achieve the highest priority items first within budget and funding profile constraints, while making progress on all sub-projects.

Integration of new hardware will occur during the extended outages that occur each calendar year. These will be approximately 6 months in duration and will be integrated into the operating schedule well in advance. Installation, checkout and commissioning of the first module of upgraded 201 MHz RF systems will take place in FY12 with the next two modules to follow as soon as possible after that.

Each outage will constitute a sub-project in itself that can be integrated with planned routine plant maintenance and scheduled FIRP projects. Each annual outage will include required activities with checkout and verification of interlock systems, operations manual updates, and commissioning time commensurate with extent of changes. For example, LLRF system testing requires availability of cooling water, RF power, and control system interfaces.

Ancillary system upgrades will be planned to minimize disruption, and will begin with systems that have the least impact to gain experience and improve project estimation for more complex installations. For example, network infrastructure should be put in place and commissioned before final upgrades are made to the Master Timing system. High voltage system work for refurbishment of the 805 MHz systems should precede acquisition and installation of new or rebuilt klystrons.