

U.S. Department of Energy ORDER

Washington, D.C.

DRAFT
DOE O 452.2E

DRAFT Revision 1 July 2014

SUBJECT: NUCLEAR EXPLOSIVE SAFETY

1. PURPOSE. This Department of Energy (DOE) Order establishes requirements to implement the nuclear explosive safety (NES) elements of DOE O 452.1E, *Nuclear Explosive and Weapon Surety Program*, for routine and planned nuclear explosive operations (NEOs).
2. CANCELLATION. DOE O 452.2D, *Nuclear Explosive Safety*, dated 4-14-09 and DOE M 452.2-1A, *Nuclear Explosive Safety Manual*, dated 4-14-09. Cancellation of a directive does not, by itself, modify or otherwise affect any contractual obligation to comply with the directive. Contractor requirements documents (CRDs) that have been incorporated into or attached to a contract remain in effect until the contract is modified to either eliminate requirements that are no longer applicable or substitute a new set of requirements.
3. APPLICABILITY.
 - a. Departmental Elements. Except for the exclusion in paragraph 3c, this Order applies to all those Departmental elements that are involved in performing, managing, overseeing, or directly supporting NEOs or associated activities, including those created after the Order is issued. (Go to <http://www.directives.doe.gov/pdfs/reftools/org-list.pdf> for the most current listing of Departmental elements.)

The Administrator will ensure that NNSA employees and contractors comply with their respective responsibilities under this Order. Nothing in this Order shall be construed to interfere with the NNSA Administrator's authority under section 3212(d) of Public Law (P.L.) 106-65 to establish Administration-specific policies, unless disapproved by the Secretary.
 - b. DOE Contractors.
 - (1) Except for the exclusions in paragraph 3c, the Contractor Requirements Document (CRD), Attachment 1, sets forth requirements of this Order that will apply to contracts that include the CRD.
 - (2) This CRD must be included in all contracts that involve performing, managing, overseeing, or directly supporting NEOs or associated activities.

- (3) Attachments 2 through 5 apply to both federal and contractor employees. These attachments must be included along with the CRD in all contracts that involve performing, managing, overseeing, or directly supporting NEOs or associated activities.
- (4) NNSA Field Element managers are responsible for notifying contracting officers of which contracts are affected. Once notified, contracting officers are responsible for incorporating the CRD and Attachments 2 through 5 into each affected contract.

c. Exclusions.

- (1) This Order does not apply to unscheduled events such as those requiring Accident Response Group action. DOE O 151.1C, *Comprehensive Emergency Management*, dated 11-02-05, addresses emergency NES occurrences. The senior energy official, or higher authority, will determine when to transition from emergency management directives to this Order.
- (2) The following Departmental elements are excluded: Office of the Chief Financial Officer, Office of the Chief Information Officer, Office of Civilian Radioactive Waste Management, Office of Congressional and Intergovernmental Affairs, Office of Economic Impact and Diversity, Energy Information Administration, Office of Electricity Delivery and Energy Reliability, Office of Energy Efficiency and Renewable Energy, Office of Environmental Management, Office of Fossil Energy, Office of Hearings and Appeals, Office of Human Capital Management, Office of Intelligence and Counterintelligence, Office of Legacy Management, Office of Management, Office of Nuclear Energy, Office of Policy and International Affairs, Office of Public Affairs, Office of Science, Bonneville Power Administration, Southeastern Power Administration, Southwestern Power Administration, and Western Area Power Administration.
- (3) In accordance with the responsibilities and authorities assigned by Executive Order 12344, codified at 50 USC sections 2406 and 2511 and to ensure consistency through the joint Navy/DOE Naval Nuclear Propulsion Program, the Deputy Administrator for Naval Reactors (Director) will implement and oversee requirements and practices pertaining to this Directive for activities under the Director's cognizance, as deemed appropriate.

4. REQUIREMENTS

- a. Nuclear Explosive Safety Program. NEOs require special consideration because of the potentially unacceptable consequences of an accident or unauthorized act. The NES program outlined in this section supports the requirement that NEOs must be designed and conducted in a manner that meets the NES Standards of DOE O 452.1E or successor directive. It includes the following: NES Rules

(general and supplemental NESRs), formal NES evaluations, fundamental NEO process requirements (procedures, facilities, equipment, and people), requirements for onsite and offsite transportation (mobile NEOs), sustaining requirements (positive verification, change control and configuration management), requirements for nuclear explosive-like assemblies (NELAs), and permanent marking of nuclear explosives and NELAs.

(1) General Nuclear Explosive Safety Rules (NESRs). The general NESRs set forth in this paragraph are mandatory for all NEOs.

(a) Nuclear Explosive Safety Evaluation. NEOs must not be performed until a NES evaluation has been completed and findings for which a NES standard has not been met have been closed.

(b) Nuclear Explosive Operating Procedures. NEOs must be performed in accordance with approved written procedures.

(c) One-Point Safety.

1 The probability of achieving a nuclear yield greater than 4 pound of TNT equivalent in the event of a one-point initiation of the nuclear explosive's high explosive must not exceed one in a million (1E-06).

2 Tooling and equipment must be evaluated to ensure that their use does not cause a one-point safety violation of a nuclear explosive certified to be one-point safe.

3 If it is determined that a nuclear explosive no longer meets the one-point safety criteria, all assembly/disassembly production plant operations (including onsite transportation) and offsite transportation with that nuclear explosive must be discontinued in a safe manner. Before operations with that nuclear explosive can be resumed, a path forward must be developed, a NES evaluation must be completed and findings for which a NES standard has not been met must be closed.

4 NEOs involving a nuclear explosive not certified to be one-point safe must be conducted at the Nevada National Security Site (NNSS), except as authorized in accordance with paragraph 4a(1)(c)2, above.

(d) Nuclear Explosive Areas (NEAs).

1 Authorized energy sources must be identified and documented. Unauthorized energy sources must not be available in an NEA during NEOs.

provide the basic foundation to ensure that NEOs are designed and conducted in a manner that meets human usability guidelines as well as the NES standards of DOE O 452.1E.

NEOs shall apply established research in human factors and ergonomics.

- (5) Procedures. Written procedures (paper or electronic) control the interactions among the nuclear explosive, the operating facility, equipment, and personnel.
 - (a) Design agencies must review and concur with original issues of procedures for NEOs and associated activities.
 - (b) All written procedures for NEOs must place proper emphasis on preventing accidents and detecting abnormal conditions by accomplishing the following.
 - 1 Comply with design specifications and technical requirements.
 - 2 Clearly state cautions and warnings.
 - 3 Identify appropriate points to interrupt work safely.
 - 4 Include generic contingency procedures directed toward quickly achieving a safe and stable nuclear explosive configuration to be applied in response to all unexpected situations not covered by other written procedures.
 - 5 Incorporate human factors considerations.
- (6) Two-Person Concept. Organizations responsible for NEOs and associated activities and facilities must establish and implement the two-person concept as specified in Attachment 2 of this Order.
- (7) Facilities. Facilities used for nuclear explosive operations must be characterized, evaluated, and specifically approved for that use.
- (8) Equipment. Organizations responsible for NEOs and associated activities and facilities must verify that all equipment used in NEAs (including tooling, testers, and other mechanical and electrical equipment) meet the following requirements. Attachment 3 of this Order specifies additional requirements for electrical equipment used in NEAs.
 - (a) Design specifications and technical requirements must be documented.
 - (b) Designs must ensure nuclear explosives will remain in a safe condition should a system or component of the tool/equipment fail.

- (c) Each item used in an NEO must be specifically approved for that operation. Unapproved movable items must be excluded from the NEA. Positive measures must be used to preclude use of facility equipment that is not approved for the NEO and impracticable to remove.
 - (d) Equipment intended to apply energy to a nuclear explosive must incorporate features that limit application of energy to a known safe level.
 - (e) Energetic equipment intended for use in NEAs by emergency responders (e.g., fire department personnel, security force, radiological protection) must be evaluated and characterized with respect to potential hazards.
- (9) Maintenance of Facilities, Tooling, and Other Equipment. Organizations responsible for NEOs and associated activities and facilities must review maintenance programs and activities for impact on NES. Maintenance implementation plans must include a detailed description of maintenance activity control and approval, including limitations on materials that are allowed in NEAs.
- (10) Personnel. Each organization responsible for and/or involved in NEOs and associated activities must implement training, qualification, and certification programs for personnel that manage, oversee, perform, or directly support these operations and activities.

In addition to the requirements in 10 CFR Part 712, *Human Reliability Program*, and DOE O 426.2, *Personnel Selection, Training, Qualification, and Certification Requirements for DOE Nuclear Facilities*, annual training for personnel assigned to nuclear explosive duty must include the following NES-specific topics.

- (a) Responsibilities associated with custody of nuclear explosives.
 - (b) Use of general and supplemental NESRs, site/facility and program-specific safety requirements, and other controls associated with NEOs.
 - (c) The purpose, objective, and responsibilities of the two-person concept for operations.
 - (d) Explosive safety appropriate for assigned responsibilities.
- (11) Transportation of Nuclear Explosives. Nuclear explosive transportation is a mobile NEO and involves a mobile NEA. Requirements specified for NEOs and NEAs elsewhere in this Order apply.

- (a) Organizations responsible for NEOs and associated activities and facilities must establish requirements and procedures to ensure safe onsite transportation of nuclear explosives.
 - (b) Offsite transportation of nuclear explosives is performed by OST and begins when the loaded conveyance is closed and ends with the opening of the conveyance at its destination.
 - (c) Transportation operations and shipping configurations, including all items in the conveyance, are subject to the NES evaluation requirements of paragraph 4a(1)(a) and 4a(3).
 - 1 Nuclear explosives must be transported in conveyances specifically reviewed and approved through the NES evaluation process.
 - 2 Criteria must be established for protecting nuclear explosives during transportation. The criteria and restraint designs for specific nuclear explosive configurations must be reviewed and approved through the NES evaluation process.
- (12) Mixed Venues. Nuclear explosives must not be transported or staged with any other assembly that could be mistaken for a nuclear explosive.
- Exception: Nuclear explosives and NELAs may be collocated in Pantex radiography and vacuum chamber bays, provided that operations comply with the NELA standards in paragraph 4.a.(17) and have been evaluated by a NESSG.
- (13) Positive Verification.
- (a) Organizations responsible for NEOs and associated activities and facilities must develop and implement a verification process to ensure use of qualified personnel who are fit for duty, operationally ready facilities, correct equipment that is current in any required calibration and preventive maintenance, and current approved procedures.
 - (b) The configuration and condition of a nuclear explosive and its safety features must be known or determined as early as practical during any planned NEO.
- (14) Change Control. Organizations responsible for NEOs and associated activities and facilities must establish and implement a NES change evaluation process in accordance with NA SD 452.2, *Nuclear Explosive Safety Evaluation Processes*, or successor directive. This NES evaluation is separate and independent from the unreviewed safety question process

required by 10 CFR Part 830, *Nuclear Safety Management*, and must be completed before approval and implementation of the change.

All proposed changes to authorized NEOs, including the following, are subject to the NEO change control process.

- (a) Proposals that may have direct NES implications (e.g., procedural, equipment, or facility changes to an approved NEO).
 - (b) Proposals that may have indirect NES implications (e.g., changes or new activities that could impact the foundation established by previous NES Master Studies).
 - (c) Changes in knowledge affecting an approved NEO (e.g., new understanding of a potential threat to NES or new data regarding the response of a nuclear explosive to a stimulus).
- (15) Anomalous Unit Determination and Processing. An anomalous unit might be created or discovered in the course of NEOs performed by NNSA or its contractors, or might be received from DoD in a known anomalous condition.

The OST NEO change control process must ensure anomalous units accepted for transport are safe to ship and that any special handling, receiving, or staging requirements are known and accepted in advance by the receiving organization.

The following apply to anomalous units at the production agency.

- (a) The production agency Process Engineer, production agency NES representative, and design agency System Engineer collectively have the authority to declare a unit anomalous. A unit in question is treated as an anomalous unit unless there is unanimous agreement otherwise among the three.
- (b) Before operations with the anomalous unit can be resumed, the NEO change control process must be completed in accordance with paragraph 4a(14). A design agency engineering release (e.g., SIER, IER, or SXR, as appropriate) must be developed as input to the change control process.

1 The responsible design agencies must specifically review the engineering release for impact on NES. A NESSG-certified member from the design agency must be involved in the review. This review must be documented in the engineering release.

2 Transportation operations, if applicable, must be specifically addressed in the engineering release. Offsite transportation operations are subject to the Office of Secure Transportation (OST) NEO change control process.

(c) A decision to resume other activities in the facility must include consideration of possible interactions with the anomalous unit.

(16) Configuration Management.

(a) Organizations responsible for NEOs and associated activities and facilities must develop and implement a configuration management program incorporating elements applicable to NEOs and associated activities and facilities.

(b) To ensure consistency with design requirements and the safety basis, the configuration management program must specifically include the following:

1 control of the physical configuration of a nuclear explosive and its components; the tooling, equipment, and procedures used in NEOs and associated activities; and the interface with the facilities in which these operations and activities are conducted;

2 unique identification of special tooling and equipment used in NEOs;

3 positive identification of tooling and equipment requiring calibration/testing within a calibration/testing control program; and

4 incorporation of approved changes into all affected documents (including design documents, drawings, procedures, and safety basis documents) and programs (including maintenance and training).

(17) Nuclear Explosive-Like Assemblies (NELAs).

(a) Nuclear Explosive-Like Assembly Standards. All NELA operations must meet the following qualitative NELA standards.

1 There must be positive measures to prevent accidental/inadvertent, or deliberate unauthorized assembly of a nuclear explosive in place of a NELA configuration.

- 2 There must be positive measures to prevent accidental/inadvertent, or deliberate unauthorized transfer of a nuclear explosive in place of a NELA configuration.

In the context of these NELA Standards, the term "prevent" is applied as described for the Nuclear Explosive Surety Standards in DOE O 452.1E.

- (b) Nuclear Explosive-Like Assembly Requirements. Organizations responsible for NELA operations must implement the NELA requirements in Attachment 4 of this Order.
- (18) Marking Instructions. Nuclear explosives and NELAs must be marked to distinguish configurations capable of a nuclear detonation from those that are not. Organizations responsible for NEOs or NELA operations must implement the marking requirements in Attachment 5 of this Order.
- b. Independent Oversight. The Associate Administrator for Safety and Health executes independent oversight of the implementation of this Order and associated NNSA Supplemental Directives by NNSA personnel. This oversight may be carried out through execution of NNSA NES evaluations, independent assessments, or other appropriate mechanisms. On an annual basis, the Office of the Associate Administrator for Safety and Health will summarize its oversight activities, along with any recommendations for changes in the NES program in a report to the NNSA Deputy Administrator for Defense Programs and the Assistant Deputy Administrator for Stockpile Management. A copy of this report will be provided to the NNSA CTA and CDNS for information.
- c. Exemptions. Exemptions must be requested when release is sought from a requirement in this Order or successor directives. The exemption process is outlined in DOE O 251.1C, *Departmental Directives Program*, dated 1-15-09, or successor directive. The approval authority is the Deputy Administrator for Defense Programs with concurrence from the Central Technical Authority.
- d. Records. Records (documentation) must be maintained in accordance with National Archives and Records Administration-approved DOE or site-specific records retention and disposition schedules in accordance with DOE O 243.1B Chg 1, *Records Management Program*, dated 07-08-13.
- e. Implementation. This revision does not involve substantive administrative or programmatic changes from the previous directives, DOE O 452.2D and DOE M 452.2-1A. An implementation plan is not required. This revision is effective upon issuance.

5. RESPONSIBILITIES.

- a. Deputy Administrator for Defense Programs.
 - (1) Ensures implementation of NES Programs.
 - (2) Approves exemptions to this Order.
- b. NNSA Field Element Managers responsible for NEOs. Provide oversight of NNSA M&O Contractors.
- c. Associate Administrator for Safety and Health. Provides independent oversight of the implementation of this Order and associated Supplemental Directives by NNSA personnel.
- d. Director, Office of Nuclear Weapon Stockpile.
 - (1) Provides federal leadership for project teams formed to develop nuclear explosive operations at NNSA production agencies.
 - (2) Ensures that NNSA nuclear explosive operations are designed in a manner that satisfies the NES Program requirements.
- e. Director, Office of Nuclear Weapon Surety and Quality.
 - (1) Manages the NNSA NES evaluation processes.
 - (2) Provides support to NNSA Field Element Offices as needed for NES oversight of the NNSA M&O Contractors.

6. DEFINITIONS. Definitions from DOE O 452.1E, or successor directive are not repeated here.

- a. Access. The proximity to a nuclear explosive that allows the opportunity to divert, steal, tamper with, and/or damage the nuclear explosive in spite of any controls that have been established to prevent such unauthorized actions.
- b. Anomalous Unit. A configuration in a nuclear explosive operation that has any of the following:
 - (1) Damage or other condition not identified as a credible deviation or otherwise explicitly addressed in an approved technical operating procedure.
 - (2) Damage or other condition that results in an unanalyzed configuration or a configuration not covered by a NES evaluation.
 - (3) Other damage or condition potentially adverse to nuclear explosive safety.

- c. Custody of Nuclear Explosives. Responsibility for access to and control of nuclear explosives.
- d. Dummy Pit. A component or set of components designed to simulate a live pit, but which does not contain fissile material and cannot therefore create a nuclear explosive if placed in the central cavity of an implosion system. A "high-fidelity" dummy pit is one that also has dimensions representative of a live pit.
- e. Electrical Equipment. Includes items that contain or use an electrical energy source and the interface (if any) with the nuclear explosive (NE). For Category 1 electrical equipment (as defined in Attachment 3 of this Order), this includes associated adapters, test cables, switch boxes, etc. For some Category 2 electrical equipment (as defined in Attachment 3 of this Order), this includes a mechanical connection to the NE and associated electrical isolation feature.
- f. Facility. Any equipment, structure, system, process, or activity that fulfills a specific purpose.
- g. Human Factors. A scientific discipline that applies knowledge about human abilities, characteristics, and limitations to design of tasks, equipment, and environments.
- h. Human Reliability Program (HRP). A program established by 10 CFR 712 to ensure that individuals who occupy positions affording access to certain materials, nuclear explosive devices, facilities, and programs meet the highest standards of reliability and physical and mental suitability.
- i. Main Charge. The high explosive whose explosive energy implodes the pit.
- j. Mock High Explosive. A material that is designed to simulate the main charge high explosive, but which is non-detonable and clear or colored pink.
- k. Nuclear Explosive Duty. Work assignments that allow custody of a nuclear explosive or access to a nuclear explosive device or area.
- l. Nuclear Explosive-Like Assembly (NELA). An assembly that is not a nuclear explosive but represents a nuclear explosive in its basic configuration (main charge HE and pit) or any higher level of assembly up to a fully assembled weapon configuration. A NELA does not contain an arrangement of HE and fissile material capable of producing a nuclear detonation but (if inadequately controlled) has the potential for component or unit substitution resulting in accidental, inadvertent, or deliberate unauthorized assembly or transfer of a nuclear explosive in place of a NELA. A NELA represents a nuclear explosive in the U.S. Nuclear weapons program, including assemblies for development, testing, training, or other purposes.
- m. Nuclear Explosive Operation Associated Activities. Activities directly associated with a specific nuclear explosive operation, such as work on a bomb nose or tail

subassembly, even when physically separated from the bomb's nuclear explosive subassembly.

- n. Nuclear Explosive Safety Rules (NESRs). Requirements that significantly contribute to minimizing the possibility of nuclear detonation or high explosive detonation/deflagration in nuclear explosive operations.
- o. One-Point Safe Nuclear Explosive. A nuclear explosive that, in the event a detonation is initiated at any one point in the high explosive system, presents no greater probability than one in a million of producing a nuclear detonation.
- p. Permanent Marking. A durable method, normally by metal deformation, indicating on an external area of an assembly whether it is a nuclear explosive or a nuclear explosive-like assembly.
- q. Safety Basis. A safety basis for a DOE nuclear facility is documented in a documented safety analysis and the hazards controls for the nuclear facility.
- r. Two-Person Concept (TPC). TPC is implemented to ensure no lone individual has unrestricted access to a nuclear explosive or other crucial asset as specified by this Order.

7. REFERENCES. The following list contains references that are relevant to this Order.

- a. DOE O 151.1C, *Comprehensive Emergency Management System*, dated 11-2-05, which addresses responses to unplanned events.
- b. DOE O 243.1B Chg 1, *Records Management Program*, dated 07-08-13, which provides a framework for managing information in accordance with Department policy and National Archives and Records Administration-approved DOE record schedules.
- c. DOE O 226.1B, *Implementation of Department of Energy Oversight Policy*, dated 04-25-11, which provides direction for implementing DOE P 226.1A, Department of Energy Oversight Policy, dated 5-25-07, which establishes DOE policy for assurance systems and processes established by DOE contractors and oversight programs performed by DOE line management and independent oversight organizations.
- d. DOE O 232.2 Chg 1, *Occurrence Reporting and Processing of Operations Information*, dated 03-12-14, which provides requirements for categorizing and reporting non-emergency NES occurrences.
- e. DOE O 231.1B *Environment, Safety, and Health Reporting*, Administrative Change 1, dated 11-28-12, sets forth a minimum set of occurrence reporting requirements for DOE/NNSA elements and contractors and includes categorizing occurrences related to safety, environment, health, or operations; notifying DOE; and developing follow-up reports.

- f. DOE O 251.1C, *Departmental Directives Program*, dated 1-15-09, which details the process for requesting exemptions from directives requirements.
- g. DOE O 360.1C, *Federal Employee Training*, dated 07-06-11, which establishes requirements and assigns responsibilities for DOE Federal employee training, education, and development under the Government Employees Training Act of 1958, as amended.
- h. DOE O 414.1D Chg 1, *Quality Assurance*, dated 05-08-13, which ensures that the quality of DOE/NNSA products and services meets or exceeds the customers' expectations.
- i. DOE O 420.1C, *Facility Safety*, dated 12-04-12, which establishes the DOE/NNSA facility safety for nuclear safety design, criticality safety, fire protection, and natural phenomena hazards mitigation.
- j. DOE STD 1212-2012, *Explosives Safety*, dated June 2012, which describes DOE's explosives safety requirements applicable to operations involving the development, testing, handling, and processing of explosives or assemblies containing explosives.
- k. DOE O 452.1E, *Nuclear Explosive and Weapon Surety Program*, dated XX-XX-XX, which establishes requirements and responsibilities for the DOE Nuclear Explosive and Weapon Surety Program.
- l. NA SD 452.2, *Nuclear Explosive Safety Study Processes*, dated XX-XX-XX, which provides requirements and guidance for nuclear explosive safety studies, operational safety reviews, and nuclear explosive safety change evaluations.
- m. DOE O 461.1B, *Packaging and Transportation for Offsite Shipment of Materials of National Security Interest*, 12-20-10.
- n. DOE O 426.2 Chg 1, *Personnel Selection, Training, Qualification, and Certification Requirements for DOE Nuclear Facilities*, dated 07-29-13, which establishes selection, qualification, and training requirements for management and operating contractor personnel involved in the operation, maintenance, and technical support of DOE/NNSA Category A and B reactors and nonreactor nuclear facilities.
- o. DOE STD 1020-2012, *Natural Phenomena Hazards Analysis and Design Criteria for DOE Facilities*, dated December 2012, sets performance goals that define a credibly initiated design based scenario. If a safety SSC meets a performance goal requirement based on DOE STD 1020 criteria, the SSC credibly controls the NPH-initiated hazard.
- p. DOE-STD-1073-2003, *Configuration Management Program*, dated October 2003, which defines the objectives of a configuration management process for

DOE nuclear facilities (including activities and operations) and provides detailed examples and supplementary guidance on methods to achieve those objectives.

- q. DOE-STD-1104-96, *Review and Approval of Nuclear Facility Safety Basis Documents (Documented Safety Analyses and Technical Safety Requirements)*, dated February 1996, which describes DOE review and approval of documented safety analyses and Technical Safety Requirements for existing Hazard Category 1, 2, and 3 nuclear facilities that document their safety basis in accordance with 10 CFR 830.
- r. DOE-STD-3009-94, *Preparation Guide for U.S. Department of Energy Nonreactor Nuclear Facility Documented Safety Analyses*, dated XXX 2014, which describes a Safety Analysis Report preparation method that satisfies 10 CFR 830 requirements.
- s. DOE-DP-STD-3016-2006, *Hazard Analysis Reports for Nuclear Explosive Operations*, dated May 2006, which clarifies the requirements and provides guidance for conducting hazard analyses and preparing Hazard Analysis Reports for nuclear explosive operations and associated activities.
- t. 10 CFR Part 712, *Human Reliability Program*, which establishes the policies and procedures for the DOE, including NNSA, human reliability program (HRP). The HRP is a security and safety reliability program designed to ensure that individuals who occupy positions affording access to certain materials, nuclear explosive devices, facilities, and programs meet the highest standards of reliability and physical and mental suitability.
- u. 10 CFR Part 820, *Procedural Rules for DOE Nuclear Activities*, which sets forth procedures to govern the conduct of persons involved in DOE nuclear activities and, in particular, to achieve compliance with the DOE Nuclear Safety Requirements by all persons subject to those requirements.
- v. 10 CFR Part 830, *Nuclear Safety Management*, which governs the conduct of DOE contractors, DOE personnel, and other persons conducting activities (including providing items and services) that affect, or may affect, the safety of DOE nuclear facilities. v. Title 32 of P.L. 106-65, the National Nuclear Security Administration Act, dated October 5, 1999, as amended, which established a separately organized agency within the Department of Energy.
- w. Joint Department of Energy/Department of Defense (DOE/DoD) Technical Publication 20-7, *Nuclear Safety Criteria*, dated 01-02-02.
- x. Joint DOE/DoD Technical Publication 35-51 Chg. 10, *General Instructions Applicable to Nuclear Weapons*, dated 08-14-08.
- y. Joint DOE/DoD Technical Publication 45-51 Chg. 2, *Transportation of Nuclear Weapons Materiel, General Shipping and Limited Life Component Data (LLC)*, dated 08-01-07.

- z. Joint DOE/DoD Technical Publication 45-51A Chg. 5, *Transportation of Nuclear Weapons Materiel (Supplement), Shipping and Identification Data for Stockpile Major Assemblies*, dated 03/20/2007.
8. CONTACT. Questions concerning this Order should be addressed to the Associate Administrator for Safety and Health, 202-586-3885.



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Secretary of Energy

CONTRACTOR REQUIREMENTS DOCUMENT

DOE O 452.2D, *NUCLEAR EXPLOSIVE SAFETY*

This Contractor Requirements Document (CRD) establishes the requirements for Department of Energy (DOE) contractors, including National Nuclear Security Administration (NNSA) contractors, whose contracts involve the performance, management, oversight, or direct support of DOE/NNSA nuclear explosive operations (NEOs) or associated activities.

Regardless of the performer of the work, the contractor is responsible for complying with the requirements of this CRD. The contractor is responsible for flowing down the requirements of this CRD to subcontractors at any tier to the extent necessary to ensure the contractor's compliance with the requirements.

Attachments 2 through 5 apply to both federal and contractor employees. These attachments must be included along with the CRD in all contracts that involve performing, managing, overseeing, or directly supporting NEOs or associated activities.

All contractors with this CRD incorporated in their contracts must comply with the following requirements to support the Nuclear Explosive Safety Program.

1. General Nuclear Explosive Safety Rules (NESRs). Contractors must ensure that NEOs under their purview are designed and performed in a manner that satisfies the following General NESRs.
 - a. Nuclear Explosive Safety Evaluation. NEOs must not be performed until a NES evaluation has been completed and findings for which a NES standard has not been met have been closed.
 - b. Nuclear Explosive Operating Procedures. NEOs must be performed in accordance with approved written procedures.
 - c. One-Point Safety.
 - (1) The probability of achieving a nuclear yield greater than 4 pound of TNT equivalent in the event of a one-point initiation of the nuclear explosive's high explosive must not exceed one in a million (1E-06).
 - (2) Tooling and equipment must be evaluated to ensure that their use does not cause a one-point safety violation of a nuclear explosive certified to be one-point safe.
 - (3) If it is determined that a nuclear explosive no longer meets the one-point safety criteria, all assembly/disassembly production plant operations (including onsite transportation) and offsite transportation with that nuclear explosive must be discontinued in a safe manner. Before operations with that nuclear explosive can be resumed, a path forward

must be developed, a NES evaluation must be completed and findings for which a NES standard has not been met must be closed.

- (4) NEOs involving a nuclear explosive not certified to be one-point safe must be conducted at the Nevada National Security Site (NNSS), except as authorized in accordance with paragraph 1c(3), above.

d. Nuclear Explosive Areas (NEAs).

- (1) Authorized energy sources must be identified and documented.

Unauthorized energy sources must not be available in an NEA during NEOs.

- (2) Ignition sources in NEAs must be identified and eliminated or reasonably minimized and controlled to prevent adverse interaction with combustible/flammable materials and the nuclear explosive.
- (3) Combustible and flammable materials in NEAs must be identified and eliminated or reasonably minimized and controlled to prevent adverse interaction with the nuclear explosive.

e. Electrical Testing. Except as authorized in accordance with paragraph 1f, Anomalous Units, nuclear explosives must not be subjected to —

- (1) redundant electrical tests, or
- (2) electrical troubleshooting (i.e., to confirm the existence of a fault or aid in fault isolation) except with authorized test equipment and procedures that have been subjected to a NES evaluation and found to be acceptable for the specific application.

f. Anomalous Units.

- (1) If it is determined that a nuclear explosive is no longer in a condition covered by a NES evaluation or explicitly addressed in an approved written procedure, all operations with that nuclear explosive and in the associated facility must be discontinued in a safe manner, resulting in a safe and stable nuclear explosive configuration.
- (2) Restart of operations on the anomalous unit and other activities in the affected facility must be in accordance with paragraph 15 below.

2. Supplemental Nuclear Explosive Safety Rules. Contractors may propose supplemental NESRs to support specific tests, operations, or characteristics of a nuclear explosive.

3. Nuclear Explosive Safety Evaluations. Contractors must ensure that all NEOs under their purview are covered by an approved NES evaluation and request and support NES

evaluations as needed. NES evaluation requirements are specified in NA SD 452.2, *Nuclear Explosive Safety Evaluation Processes*, or successor directive.

4. Human Factors. Contractors must incorporate human factors principles into NEO procedures, processes, facilities, and equipment, including Category 1 electrical equipment, starting with the NEO design and development phase and maintained throughout the lifecycle of NEOs. Given the human-centric nature of NEOs, human factors principles provide the basic foundation to ensure that NEOs are designed and conducted in a manner that meets human usability guidelines as well as the NES standards of DOE O 452.1E.

NEOs shall apply established research in human factors and ergonomics, including human-system interface design, human cognition and perception, stress and workload, anthropometry and workspace design, environmental factors, training, and human error.

5. Procedures.
 - a. Contractors responsible for NEOs and associated activities and facilities must follow approved written procedures (paper or electronic) for all NEOs to control interactions among the nuclear explosive, the operating facility, equipment, and personnel.
 - b. Contractors must ensure design agency concurrence with original issues of procedures for NEOs and associated activities.
 - c. Proposed changes to procedures must be assessed by the contractor NEO change control process.
 - d. Contractors must ensure NEO procedures place the proper emphasis on preventing accidents and detecting abnormal conditions by accomplishing the following—
 - (1) comply with design specifications and technical requirements,
 - (2) clearly state cautions and warnings,
 - (3) identify appropriate points to safely interrupt work,
 - (4) include generic contingency procedures directed toward quickly achieving a safe and stable nuclear explosive configuration to be applied in response to all unexpected situations not covered by other written procedures, and
 - (5) incorporate human factors considerations.
6. Two-Person Concept. Contractors responsible for NEOs and associated activities and facilities must establish and implement the two-person concept in accordance with Attachment 2 of DOE O 452.2E, *Nuclear Explosive Safety*, or successor directive, to ensure no lone individual has access to a nuclear explosive.

7. Facilities. Contractors must ensure that facilities used for nuclear explosive operations are characterized, evaluated, and specifically approved for that use.
8. Equipment. Contractors responsible for NEOs and associated activities and facilities must ensure that all equipment used in NEAs (including tooling, testers, and other mechanical and electrical equipment) meet the following requirements. Attachment 3 of DOE O 452.2E, *Nuclear Explosive Safety*, or successor directive, specifies additional requirements for electrical equipment used in NEAs.
 - a. Design specifications and technical requirements are documented.
 - b. Designs must ensure that the nuclear explosive remains in a safe condition should a system or component of the equipment fail.
 - c. Each item used in an NEO must be specifically approved for that operation.

Unapproved movable items must be excluded from the NEA. Positive measures must be used to preclude use of facility equipment that is not approved for the NEO and impracticable to remove.
 - d. Equipment intended to apply energy to a nuclear explosive must incorporate features that limit application of energy to a known safe level.
 - e. Energetic equipment intended for use in NEAs by emergency responders (e.g., fire fighters, medical personnel, security force) must be evaluated and characterized with respect to potential hazards.
9. Maintenance of Facilities, Tooling, and Other Equipment. Contractors responsible for NEOs and associated activities and facilities must review maintenance programs and activities for impact on NES. Maintenance implementation plans must include a detailed description of maintenance activity control and approval, including limitations on materials that are allowed in NEAs.
10. Personnel. Contractors responsible for and/or involved in NEOs and associated activities must implement training, qualification, and certification programs for personnel that manage, oversee, perform, or directly support these operations and activities.

In addition to the requirements in 10 CFR Part 712, *Human Reliability Program*, and DOE O 426.2, *Personnel Selection, Training, Qualification, and Certification Requirements for DOE Nuclear Facilities*, contractors must provide annual training for personnel assigned to nuclear explosive duty must include the following NES-specific topics.

- a. Responsibilities associated with custody of nuclear explosives.
- b. Use of general and supplemental NESRs, site/facility and program specific safety requirements, and other controls associated with NEOs.
- c. The purpose, objective, and responsibilities of the two-person concept for operations.

- d. Explosive safety appropriate for assigned responsibilities.
11. Transportation of Nuclear Explosives. Nuclear explosive transportation is a mobile NEO and involves a mobile NEA. Requirements specified for NEOs and NEAs elsewhere in this CRD apply.
 - a. Contractors responsible for NEOs and associated activities and facilities must establish requirements and procedures to ensure safe onsite transportation of nuclear explosives.
 - b. Transportation operations and shipping configurations, including all items in a conveyance, are subject to the NES evaluation requirements of paragraphs 1a and 3 of this CRD.
 - (1) Contractors must ensure nuclear explosives are transported in conveyances specifically reviewed and approved through the NES evaluation process.
 - (2) Contractors must ensure appropriate criteria are established for protecting nuclear explosives during transportation. Contractors must ensure the criteria and restraint designs for specific nuclear explosive configurations are reviewed and approved through the NES evaluation process.
 12. Mixed Venues. Contractors responsible for NEOs must not transport or stage nuclear explosives with any other assembly that could be mistaken for a nuclear explosive.

Exception: Nuclear explosives and NELAs may be collocated in Pantex radiography and vacuum chamber bays, provided that operations comply with the NELA standards in paragraph 17 and have been evaluated by a NESSG.
 13. Positive Verification.
 - a. Contractors responsible for NEOs and associated activities and facilities must develop and implement a verification process to ensure use of qualified personnel who are fit for duty, operationally ready facilities, correct equipment that is current in any required calibration and preventive maintenance, and current approved procedures.
 - b. Contractors must ensure the configuration and condition of a nuclear explosive and its safety features are known or determined as early as practical during any planned NEO.
 14. Change Control. Contractors responsible for NEOs and associated activities and facilities must establish and implement a NES change evaluation process in accordance with NA SD 452.2, or successor directive. This NES evaluation is separate and independent from the USQ process required by 10 CFR Part 830, *Nuclear Safety Management*, and must be completed before approval and implementation of the change.

Contractors must ensure that their change control process captures all proposed changes to approved NEOs including the following:

- a. Proposals that may have direct NES implications (e.g., procedural, equipment, or facility changes to an approved NEO).
- b. Proposals that may have indirect NES implications (e.g., changes or new activities that could impact the foundation established by previous NES Master Studies).
- c. Changes in knowledge affecting an approved NEO (e.g., new understanding of a potential threat to NES or new data regarding the response of a nuclear explosive to a stimulus).

15. Anomalous Unit Determination and Processing. An anomalous unit might be created or discovered in the course of NEOs performed by NNSA or its contractors, or might be received from DoD in a known anomalous condition.

Contractors must support the OST NEO change control process to ensure anomalous units accepted for transport are safe to ship and that any special handling, receiving, or staging requirements are known and accepted in advance by the receiving organization.

The following apply to anomalous units at the production agency

- a. The production agency Process Engineer, production agency NES representative, and design agency System Engineer collectively have the authority to declare a unit anomalous. A unit in question is treated as an anomalous unit unless there is unanimous agreement otherwise among the three.
 - b. Before operations with the anomalous unit can be resumed, the NEO change control process must be completed in accordance with paragraph 14. A design agency engineering release (e.g., SIER, IER, or SXR, as appropriate) must be developed as input to the change control process.
 - (1) The responsible design agencies must specifically review the engineering release for impact on NES.
 - (2) Transportation operations, if applicable, must be specifically addressed in the engineering release. Offsite transportation operations are subject to the Office of Secure Transportation (OST) NEO change control process.
 - (3) A decision to resume other activities in the facility must include consideration of possible interactions with the anomalous unit.
16. Configuration Management. Contractors responsible for NEOs and associated activities and facilities must develop and implement a configuration management program incorporating elements applicable to NEOs and associated activities and facilities. To ensure consistency with design requirements and the safety basis, the configuration management program must specifically include the following:

- a. control of the physical configuration of a nuclear explosive and its components; the tooling, equipment, and procedures used in NEOs and associated activities; and the interface with the facilities in which these operations and activities are conducted;
- b. unique identification of special tooling and equipment used in NEOs;
- c. positive identification of tooling and equipment requiring calibration/testing within a calibration/testing control program; and
- d. incorporation of approved changes into all affected documents (including design documents, drawings, procedures, and safety basis documents) and programs (including maintenance and training).

17. Nuclear Explosive-Like Assemblies (NELAs).

- a. Nuclear Explosive-Like Assembly Standards. Contractors responsible for NELA operations must ensure those operations meet the following qualitative NELA standards.
 - (1) There must be positive measures to prevent accidental/inadvertent, or deliberate unauthorized assembly of a nuclear explosive in place of a NELA configuration.
 - (2) There must be positive measures to prevent accidental/inadvertent, or deliberate unauthorized transfer of a nuclear explosive in place of a NELA configuration.

In the context of these NELA Standards, the term "prevent" is applied as described for the Nuclear Explosive Surety Standards in DOE O 452.1E.

- b. Contractors responsible for NELA operations must implement the NELA requirements in accordance with Attachment 4 of DOE O 452.2E, or successor directive.

18. Marking Instructions. Nuclear explosives and NELAs must be marked to distinguish configurations capable of a nuclear detonation from those that are not. Contractors responsible for NEOs or NELA operations must permanently mark nuclear explosives and NELAs in accordance with the instructions in Attachment 5 of DOE O 452.2E or successor directive.

19. Records. Contractors must maintain records (documentation) in accordance with National Archives and Records Administration-approved DOE or site-specific records retention and disposition schedules (See CRD to DOE O 243.1, *Records Management Program*, dated 2-3-06 or successor directive).

TWO-PERSON CONCEPT REQUIREMENTS

This Attachment applies to both Federal and contractor organizations.

1. BASIC REQUIREMENTS.

The two-person concept (TPC) is implemented to ensure no lone individual has unrestricted access to a nuclear explosive. A TPC team must be in the nuclear explosive area (NEA) when a nuclear explosive is not protected by a dual-lock system or other NES-approved security system. The TPC is also required in the Metrology Laboratory as specified in Attachment 3 paragraph 2.c of this Order and for certain NELA assembly steps as specified in Attachment 4 paragraphs 3 and 4 of this Order. NNSA Field Element Offices may also require TPC protection for other operations.

Each person on a two-person concept team must—

- a. be certified in the Human Reliability Program,
- b. have authorized access to the NEA,
- c. have technical knowledge of the task being performed,
- d. be knowledgeable of pertinent safety and security requirements, and
- e. be in a position to detect incorrect or unauthorized acts and take appropriate action.

2. IMPLEMENTATION OPTIONS.

The two-person concept may be implemented using either zone coverage or person-to-person coverage.

a. Zone Coverage.

Zone coverage is a term used to identify two-person concept implementation that meets the basic requirements of paragraph 1 without the additional requirements specified to protect configurations that require person-to-person coverage.

b. Person-to-Person Coverage.

Person-to-person coverage is the more stringent form of the two-person concept. Person-to-person coverage is designed to protect configurations that are particularly vulnerable to inadvertent acts (errors of omission or commission) or deliberate unauthorized acts.

- (1) Configurations requiring person-to-person coverage must be determined based on specific system characteristics. The application of person-to-

person coverage allows recognition of the protection provided by design safety features [such as insensitive high explosive (IHE), coded-signal-controlled detonators, and unique-signal-operated strong-link devices] and physical protection (such as closed shipping and storage containers and specially designed covers).

- (2) Configurations requiring person-to-person coverage include the following:
 - (a) Exposed conventional high explosive (CHE) main charge in an NEA.
 - (b) Main charge high explosives (HEs), both CHE and IHE, with accessible detonator cable assemblies in an NEA.
 - (c) Nuclear explosives connected to Category 1 electrical equipment. (Category 1 electrical equipment is described in Attachment 3, paragraph 2, of this Order.)

3. WHEN TO APPLY PERSON-TO-PERSON COVERAGE.

- a. Assembly/Disassembly Operations Involving Conventional High Explosive.
 - (1) For assembly operations involving CHE main charge, person-to-person coverage of the CHE components must begin when the CHE container is opened in an NEA.
 - (2) Coverage continues until the nuclear explosive is in a configuration in which the application of design-specific environmental stimuli or unique or coded signals is necessary for nuclear detonation or detonation of the main charge HE.
 - (3) For disassembly operations, this requirement applies in reverse.
- b. Assembly/Disassembly Operations Involving Insensitive High Explosive.
 - (1) For assembly operations involving IHE main charge, person-to-person coverage must be provided for main charge components located in an NEA, and assemblies containing these components, that have accessible detonator cables attached.
 - (2) Coverage continues until the nuclear explosive is in a configuration in which the application of design-specified environmental stimuli or unique or coded signals is necessary for nuclear detonation or detonation of the main charge HE.
 - (3) For disassembly operations this requirement applies in reverse.
- c. For purposes of person-to-person coverage, systems with installed and unactuated (safe/reset) mechanical safe and arm detonators are not considered to have

accessible detonator cables. Configurations with physical protection that precludes immediate and unrestricted access to the configuration by a lone individual are not considered to be exposed. When such physical protection is in place, zone coverage provides adequate protection for configurations that would otherwise require person-to-person coverage.

4. HOW TO APPLY PERSON-TO-PERSON COVERAGE.

When a configuration requires person-to-person coverage, a qualified two-person concept team must be either working on or controlling access to the configuration. Specific person-to-person coverage requirements are as follows.

- a. Lone individuals must not be allowed within the immediate vicinity (approximately 6 feet) of a configuration that requires person-to-person coverage.
- b. The two people providing person-to-person coverage must each be responsible for the safe conduct of the operations.
- c. During the performance of operations on a configuration requiring person-to-person coverage—
 - (1) the two-person concept team must be in the immediate vicinity of the configuration;
 - (2) each person on the two-person concept team must observe all operations, ensure that only authorized operations are performed, and ensure that operations are performed correctly; and
 - (3) a reader-worker process that includes the following must be incorporated.
 - (a) The procedure must be read aloud, the operation must be performed, and the completion of the operation must be documented in the stated sequence.
 - (b) One of the two people performing the operation may read the procedure aloud to the other person provided that both people can move away from the immediate vicinity of the configuration while the reading is accomplished.
 - (c) If both people cannot move away from the immediate vicinity of the configuration while the reading is accomplished, then a third person must read the procedure aloud to the other people.
 - (4) Based on an approved NES evaluation, other means to achieve the person-to-person coverage objective may be authorized.

- d. When operations are not being performed on a configuration requiring person-to-person coverage—
 - (1) the two-person concept team must be in the immediate vicinity of the configuration when another individual is in the immediate vicinity of the configuration.
 - (2) the two-person concept team is not required to be in the immediate vicinity of the configuration when other individuals are not in the immediate vicinity of the configuration. However, team members must remain in a position to directly observe the approach of any individual to the configuration.
- e. Only one configuration requiring person-to-person coverage is allowed in a vacated bay or cell. This requirement does not apply to emergency evacuations.

ELECTRICAL EQUIPMENT REQUIREMENTS

This Attachment applies to both Federal and contractor organizations.

1. BASIC REQUIREMENTS.

For purposes of defining electrical equipment requirements, this Order categorizes electrical equipment used in NEAs as Category 1, Category 2, or Category 3. Electrical equipment categorization is intended to ensure that controls are implemented commensurate with the various levels of potential electrical threat.

2. CATEGORY 1 ELECTRICAL EQUIPMENT.

Electrical equipment intended for connection to an electrical circuit of a nuclear explosive or HE subassembly is referred to as "Category 1 electrical equipment." Category 1 electrical equipment must be clearly identified and meet the following minimum requirements.

a. General Requirements.

- (1) Category 1 electrical equipment must have a safety requirements document that identifies the safety features.
- (2) Category 1 electrical equipment must use the lowest practical values of internal and output currents and voltages.
- (3) Category 1 electrical equipment must not apply unacceptable stimuli as the result of a single-point failure.
- (4) Each item of Category 1 electrical equipment must have safety characteristics independent of the nuclear explosive's safety features.
- (5) Each item of Category 1 electrical equipment and its interface with a nuclear explosive require the performance and documentation of a comprehensive safety analysis, including consideration of relevant abnormal environments.
- (6) Each drawing issue of Category 1 electrical equipment and its interface with a nuclear explosive requires a completed NES evaluation.
- (7) Procedures must be established to operate, control, calibrate, maintain, and store Category 1 electrical equipment.
- (8) A record of approved Category 1 electrical equipment must be established and maintained. The record must identify each item of Category 1 electrical equipment by its unique designation and/or part number and

associate it with the nuclear explosives for which it is authorized and the NES evaluations that examined its specific applications.

b. Computer-Controlled Electrical Equipment.

- (1) Software must not be relied upon to assure the safe state of the unit under test. If software is used to achieve a safe state then a separate means of verification must also be employed.
- (2) Testers must be designed such that software is incapable of causing safety feature bypass.
- (3) Software failure must not compromise the safety attributes of the equipment or unit under test.

c. Two-Person Concept.

Category 1 electrical equipment requires two-person concept protection. (The TPC is delineated in Attachment 2 of this Order.)

- (1) Person-to-person coverage is required during calibration and all operations that afford internal access to Category 1 electrical equipment and associated cables and adapters, and while Category 1 electrical equipment is connected to a nuclear explosive.
- (2) Zone coverage is required for fully assembled Category 1 electrical equipment and associated cables and adapters when that equipment is not protected by a dual-lock system or other NES-approved security system.

3. CATEGORY 2 ELECTRICAL EQUIPMENT.

Electrical equipment that is not intended for connection to an electrical circuit of a nuclear explosive or HE subassembly but makes mechanical connection to, or could come in contact with, a nuclear explosive or HE subassembly is referred to as "Category 2 electrical equipment." Category 2 electrical equipment must be clearly identified and meet the following minimum requirements.

a. General Requirements.

- (1) Category 2 electrical equipment must not be connected to the electrical circuitry of a nuclear explosive.
- (2) Category 2 electrical equipment must be positioned in a manner to preclude contact with a nuclear explosive except when a mechanical connection is required to perform its intended and authorized function.
- (3) The potential for inadvertent connection between the Category 2 electrical equipment and the nuclear explosive circuitry must be minimized.

b. Positive Electrical Isolation.

Positive electrical isolation must be established and demonstrated for Category 2 electrical equipment that makes a mechanical connection to a nuclear explosive. Electrical isolation must account for both normal and credible abnormal conditions (such as equipment faults or lightning strikes). The electrical isolation scheme used must be clearly identified and documented using one of the following subcategories, listed in priority order.

- (1) Path-on isolation reducing leakage or fault current from electrical energy sources associated with the equipment to a defined safe value. This must be verified annually.
- (2) Path-off isolation reducing leakage or fault current from electrical energy sources associated with the equipment to a defined safe value. This must be verified annually.
- (3) An electrical isolation scheme requiring at least two independent failures before exposing the nuclear explosive to unacceptable leakage or fault current from electrical energy sources associated with the equipment. Each failure mechanism must be identified.

c. Records.

A record of approved Category 2 electrical equipment must be established and maintained. The record must identify each item of Category 2 electrical equipment by its unique designation and/or part number and associate it with the nuclear explosive operations for which it is authorized.

4. CATEGORY 3 ELECTRICAL EQUIPMENT.

Moveable and facility electrical equipment used in an NEA that is not intended for connection to an electrical circuit of a nuclear explosive or HE subassembly and does not make mechanical connection to, and cannot come in contact with, a nuclear explosive or HE subassembly is referred to as "Category 3 electrical equipment."

5. NES EVALUATIONS AND CHANGE CONTROL.

Electrical equipment used in NEAs and proposed changes to electrical equipment, procedures, and interfaces with a nuclear explosive are subject to the NES evaluation and NEO change control processes required by this Order and detailed in NA SD 452.2, *Nuclear Explosive Safety Evaluation Processes*.

NUCLEAR EXPLOSIVE-LIKE ASSEMBLY (NELA) REQUIREMENTS

This Attachment applies to both Federal and contractor organizations. The following requirements support the NELA standards defined in paragraph 4a(17)(a) of this Order.

1. NUCLEAR EXPLOSIVE-LIKE ASSEMBLY DEFINITION.

An assembly with all the following attributes is considered a NELA.

- a. Designed or intended to represent a nuclear explosive in the U.S. nuclear weapons program in its basic configuration (main charge HE and pit) or any higher level of assembly up to a fully assembled weapon configuration.
- b. Lacks an arrangement of HE and fissile material capable of producing a nuclear detonation but (if inadequately controlled) has the potential for component or unit substitution resulting in accidental, inadvertent, or deliberate unauthorized assembly or transfer of a nuclear explosive in place of a NELA.
- c. Resembles a nuclear explosive to the degree that it can be mistaken for a nuclear explosive (without any disassembly). Availability of a simple visual inspection (such as a viewing port to internal components) is adequate to assure that an item would not be mistaken for an actual nuclear explosive.
- d. Possesses weight such that the NELA cannot be readily distinguished from the nuclear explosive it represents.

2. NUCLEAR EXPLOSIVE-LIKE ASSEMBLY TYPES.

There are three types of NELAs:

- a. A "High Explosive NELA" contains live HE main charge and dummy pit, void, or other non-nuclear items in place of the live pit.
- b. An "Inert-with-Live-Pit NELA" contains a live pit and mock HE, void, or substitute non-explosive material in place of the main charge.
- c. An "Inert NELA" contains mock HE, void, or substitute non-explosive material in place of the main charge and a dummy pit, void, or other non-nuclear items in place of the live pit.

3. ASSEMBLY/DISASSEMBLY OF NUCLEAR EXPLOSIVE-LIKE ASSEMBLIES.

NELAs must not be assembled or disassembled in close proximity to nuclear explosives where components may be interchanged. A two-person concept team is required to perform all assembly/disassembly operations on Inert-with-Live-Pit NELAs.

4. VERIFICATION OF NUCLEAR EXPLOSIVE-LIKE ASSEMBLY COMPONENTS BEFORE ASSEMBLY.

a. High Explosive Nuclear Explosive-Like Assemblies.

High Explosive NELAs and Inert-with-Live-Pit NELAs must not be assembled or disassembled in close proximity where components may be interchanged.

Verification requirements of this section are not necessary for NELA configurations for which physical dimensions preclude substitution of a live pit.

(1) High-Fidelity Dummy Pit Verification Requirements.

- (a) Before assembly into a High Explosive NELA, the pit must be verified by radiation detection means to verify the absence of radioactive material. If radiation is detected, the pit must be assayed by using gamma spectrometry/multi-channel analyzer to verify the absence of fissile material. This verification must be either performed or observed by a two-person concept team.
- (b) After dummy pit verification, the pit must be controlled until the pit is assembled into the basic NELA configuration. This control must be achieved by a two-person concept team or a dual-lock or other NES-approved security system.
- (c) An auditable record of radiation detection verification of the high-fidelity dummy pit must be available.

(2) Main Charge High Explosive Introduction Sequence.

The high-fidelity dummy pit verification must be accomplished before introduction of the main charge HE and dummy pit into the same immediate assembly area of the High Explosive NELA.

b. Inert-with-Live-Pit Nuclear Explosive-Like Assemblies.

Inert-with-Live-Pit NELAs and High Explosive NELAs must not be assembled or disassembled in close proximity where components may be interchanged.

(1) Mock High Explosive Verification Requirements.

- (a) All mock HE used in place of live main charge HE must be non-detonable and must be clear or colored pink. Where possible, preference must be given to noncombustible formulations. Live main charge HE must not be colored pink.
- (b) Pink mock HE used in place of live main charge HE must be chemically verified before assembling the NELA. Clear mock HE

refers to LEXAN or similar inert substance and does not require chemical verification.

- (c) An auditable record of chemical verification of the mock HE must be available.

(2) Mock High Explosive Two-Person Concept Verification Requirements.

- (a) In addition to the mock HE verification requirements, another chemical verification of all mock HE used in place of live main charge HE must be accomplished before assembly into an

Inert-with-Live-Pit NELA. This verification must be either performed or observed by a two-person concept team.

- (b) After the mock HE two-person concept verification, the mock HE must be controlled until the mock HE is assembled into the basic NELA configuration. This control must be achieved by a

two-person concept team or a dual-lock or other NES-approved security system.

- (c) An auditable record of two-person concept chemical verification of the mock HE must be available.

(1) Live Pit Introduction Sequence.

The mock HE verifications required by paragraphs 4c(1) and 4c(2) must be accomplished before introduction of the live pit and mock HE into the same immediate assembly area of the Inert-with-Live-Pit NELA.

c. Inert Nuclear Explosive-Like Assemblies.

Repetition of verification requirements of this section is not necessary for repeated disassembly and reassembly training operations provided the mock HE and high-fidelity dummy pit remain in a training area where main charge HE and live pits are not authorized.

Verification requirements of this section are not necessary for NELA configurations for which physical dimensions preclude substitution of live main charge and pit components.

(1) Mock High Explosive Verification Requirements.

- (a) All mock HE used in place of live main charge HE must be non-detonable and must be clear or colored pink. Where possible, preference must be given to noncombustible formulations. Live main charge HE must not be colored pink.

- (b) Pink mock HE used in place of live main charge HE must be chemically verified before assembling the NELA. Clear mock HE refers to LEXAN or similar inert substances and does not require chemical verification.
 - (c) An auditable record of chemical verification of the pink mock HE must be available.
- (2) High-Fidelity Dummy Pit Verification Requirements.
- (a) Before assembly into an Inert NELA, the pit must be verified by radiation detection means to verify the absence of radioactive material. If radiation is detected, the pit must be assayed by using gamma spectrometry/multi-channel analyzer to verify the absence of fissile material. This verification must be either performed or observed by a two-person concept team.
 - (b) After dummy pit verification, the pit must be controlled until the pit is assembled into the basic NELA configuration or until the pit is delivered into an assembly area where live pits are not authorized. This control must be achieved by a two-person concept team or a dual-lock or other NES-approved security system.
 - (c) An auditable record of radiation detection verification of the high-fidelity dummy pit must be available.

5. OFFSITE TRANSPORTATION OF NUCLEAR EXPLOSIVE-LIKE ASSEMBLIES.

a. Inert-with-Live-Pit NELA Transfer Restriction.

A configuration assembled as an Inert-with-Live-Pit NELA must not be transferred to the custody of the Department of Defense.

b. Identification Requirements.

NELAs that are shipped between DOE sites must be identified externally (e.g., stencil or tag) with the following information.

- (1) NELA contents identified as one of the following.
 - (a) High Explosive NELA.
 - (b) Inert-with-Live-Pit NELA.
 - (c) Inert NELA.
- (2) Name and agency of responsible person at the shipping location.

(3) Name and agency of person who authorized the shipment at the receiving location.

c. Permission to Ship Between DOE Agencies.

The shipping agency must obtain permission from the receiving agency to ship before shipment of a NELA.

d. Nuclear Explosive-Like Assembly Survey Before Transfer.

(1) Before offsite transfer of a NELA, the NELA must be surveyed in its shipping configuration by radiation detection means to verify the absence or presence of fissile material. Anomalies or ambiguities detected by radiation detection means must be resolved before shipment.

(2) An auditable record of this survey must be available.

e. Nuclear Explosive-Like Assembly Survey Upon Receipt.

(1) Upon receipt of a NELA, the NELA must be surveyed in its shipping configuration by a radiation detection means to verify the absence or presence of fissile material. Anomalies or ambiguities detected by radiation detection means must be resolved before release.

(2) An auditable record of this survey must be available.

MARKING REQUIREMENTS

This Attachment applies to both Federal and contractor organizations. Nuclear explosives and NELAs must be permanently marked in accordance with the following requirements. Additional markings such as serial numbers and configuration identification may also be required by design agencies.

1. PERMANENT MARKING LEGENDS.

a. Nuclear Explosives.

A "NUCLEAR" permanent marking legend must be applied to nuclear explosives (i.e., units containing a live pit and an HE main charge).

b. Nuclear Explosive-Like Assemblies.

(1) High Explosive Nuclear Explosive-Like Assemblies. The "HIGH EXPLOSIVE" permanent marking is applied to a NELA containing live main charge HE and a dummy pit, void, or other non-nuclear items in place of the live pit.

(2) Inert-with-Live-Pit Nuclear Explosive-Like Assemblies. The "INERT-WITH-LIVE-PIT" permanent marking is applied to a NELA containing a live pit and mock HE, void, or substitute non-explosive material in place of the live main charge HE, and a live pit.

(3) Inert Nuclear Explosive-Like Assemblies. The "INERT" permanent marking is applied to a NELA containing mock HE, void, or substitute non-explosive material in place of the live main charge HE and a dummy pit, void, or other non-nuclear items in place of the live pit.

Note: Using the permanent marking "INERT" or "INERT WITH LIVE PIT" does not preclude the presence of materials that may present a hazard to personnel.

2. PERMANENT MARKING LOCATION.

Nuclear explosives and NELAs must be permanently marked on an external surface.

- a. The permanent marking must be on a part that encloses the live main charge or mock HE.
- b. The marking location must be specified by the applicable design agency.

3. PERMANENT MARKINGS.

Nuclear explosives and NELAs must be marked in accordance with the following requirements. The particular marking method must be specified by the applicable design agency.

- a. The permanent marking method must produce the most durable mark possible, consistent with acceptable deleterious effect on the material to which the marking is applied.
 - (1) The preferred marking methods are mechanical engraving (with or without fill) and impression-die stamping.
 - (2) Other acceptable methods are impression freehand, impression sandblast, and surface conversion.
- b. The preferred marking size is ¼-inch characters with ¼-inch spacing between lines, if space permits.

4. PERMANENT MARKING OBLITERATION.

When a nuclear explosive or NELA is altered or disassembled to the point that its permanent marking is no longer valid, the permanent marking must be obliterated in accordance with the following requirements.

"INERT" markings need not be obliterated provided they are intended to be used for future assembly into "INERT" NELAs and positive measures are in place to maintain the NELA standards.

- a. Methodology.
 - (1) The preferred method of obliteration is overprinting the letter "X" on each letter of the permanent marking legend using the same permanent marking method as that used to apply the original marking.
 - (2) If obliteration by overprinting is not feasible for technical reasons, the permanent marking must be removed using a method specified by the applicable design agency.
- b. Components That Will Be Reassembled.

Permanent marking need not be obliterated on marked components that will be reassembled into the same configuration in accordance with the following requirements.

- (1) General Requirements.
 - (a) After the marked component is removed, the disassembled components must be controlled until the disassembled components

and marked component are reassembled into the same configuration.

- (b) Prior to final assembly of a nuclear explosive or NELA, verification of the permanent marking(s) shall be performed and documented by two HRP certified personnel. Dual (or concurrent) verification is acceptable.
- (c) Positive measures must be in place to ensure that NELA permanently marked components are not inadvertently introduced into areas where nuclear explosive assembly or disassembly operations are ongoing.

(2) Nuclear Explosives.

Nuclear explosive components must not be assembled or disassembled in close proximity to NELAs, where components may be interchanged.

(3) Nuclear Explosive-Like Assemblies.

NELAs must not be assembled or disassembled in close proximity to nuclear explosives, where components may be interchanged.

- (a) High Explosive Nuclear Explosive-Like Assemblies. High Explosive NELAs must not be assembled or disassembled in close proximity to Inert or Inert-with-Live-Pit NELAs, where components may be interchanged.
- (b) Inert-with-Live-Pit Nuclear Explosive-Like Assemblies. Inert-with-Live-Pit NELAs must not be assembled or disassembled in close proximity to High Explosive or Inert NELAs, where components may be interchanged.
- (c) Inert Nuclear Explosive-Like Assemblies. Inert NELAs must not be assembled or disassembled in close proximity to High Explosive or Inert-with-Live-Pit NELAs, where components may be interchanged.