

# Challenges and Opportunities Facing Nuclear Power Group

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Engineering Association / TVA Joint Designated Union Representative Training

June 8, 2011

#### **Agenda**

- Challenging Fiscal Year
  - Five Re-fueling Outages
  - Fukushima Event
  - Tornado Damages and BFN three units forced outage
  - NRC issuance of Red Finding for BFN
  - Approval of Multi Skilling MOU
  - NEI's Best of the Best Top Industry Practice Award
  - ➤ OHI Survey
- Fleet Focus Progress
  - Corrective Action and Human Performance
  - Equipment Reliability
  - Work Management and Outage Execution
  - Governance and Oversight
  - Training
  - Talent Management and Alignment
- NPG Culture of Excellence

#### Japanese Tsunami



#### **Fukushima Daiichi Status**

# **Fukushima Daiichi Nuclear Power Plant Before the Accident** At the time of the earthquake Reactors 1, 2 and 3 operating Reactors 4, 5 and 6 shutdown for maintenance, inspection, refueling

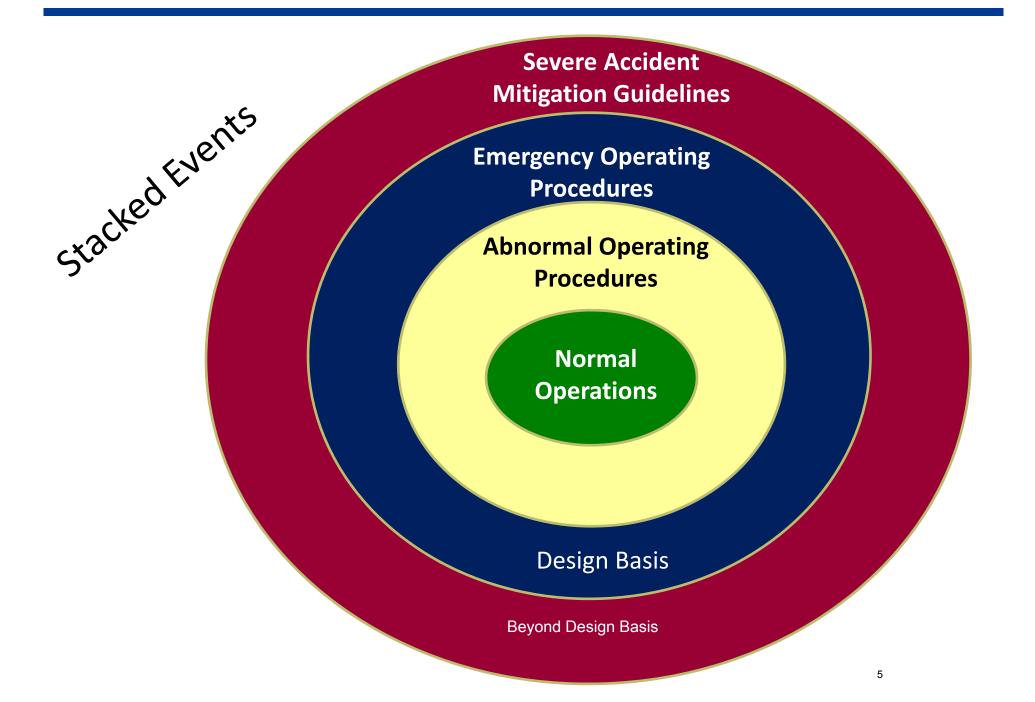
## **Centralized Response**

 Establish a TVA-wide centralized response center with satellite site response teams



- Understand events from Japanese reactors
- Assess readiness for design basis events
- Communicate accurate and timely information
- Evaluate vulnerabilities to 'stacked' events
- Provide short, intermediate, and long-term recommendations for TVA sites

#### **TVA Reviews**



#### **Stakeholder Communications**

# Proactively communicating with internal and external stakeholders

- Employee meetings
- Discussions with federal, state, and local officials
- Presentations to Tennessee,
  Alabama EMAs
- Media interviews
- Media event at Browns Ferry







# The Storms of April 2011



#### A Record Outbreak



Three waves of storms struck the southeast April 26 & 27

In the TVA region, a reported 153 tornadoes devastated entire communities

An estimated 330 people were killed across the southeast— 230 in Alabama

NOAA reports 226 tornadoes in the southeast over 24 hours—the most in one event

## Damage to TVA Region

The TVA transmission system suffered the worst damage in its history

337 transmission structures damaged; 96 lines out of service

128 customer connection points interrupted

850,000 customers lost service

Several TVA plants shut down



#### **Effects on Browns Ferry**

- ◆Lost most off-site power; all 3 units shut down safely
- Declared an Unusual Event
- Diesel generators powered shutdown cooling and reactors stayed in a safe shutdown condition
- ◆Re-established off-site power 5 days after storms
- ◆Rebuilding the 500-kV system will take months and may limit Browns Ferry's output

# Rapid Restoration

4,000 workers labored 24/7 to restore service

#### Within 5 days:

- 121 of 128 customer connections were restored
- Most large industries had some power supply

Full repair of the 500-kV system may take months





# BFN Three Unit Forced Outage April / May 2011



Major Material/ER Upgrades

#### RHR Angle Globe Valve repairs completed

- > 3-FCV-74-52 Lp I LPCI Outbd Injection Valve
- > 3-FCV-74-66 Lp II LPCI Outbd Injection Valve
- ➤ 1-FCV-74-52 Lp I LPCI Outbd Injection Valve

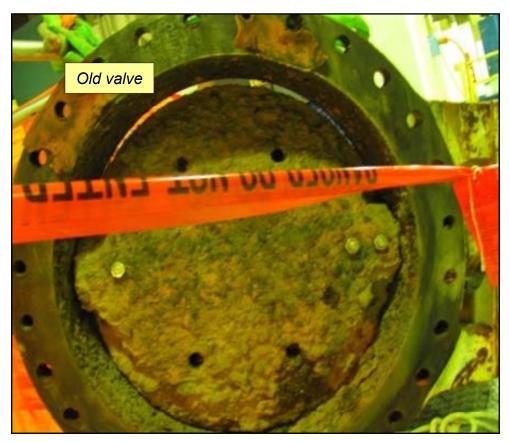






This will resolve RIS 2005 (91-18) non-conformance issue for ALL BFN Units.

#### 14 Raw Cooling Water Valves replaced





A number of valves were noted to be leaking by over a thousand gallons per minute. Many of the leaks were unisolable and required a 3-unit shutdown to safely perform repairs. On initial system restoration, Operations personnel noted header pressure was easily maintained with fewer pumps in service (only 4 of 13).

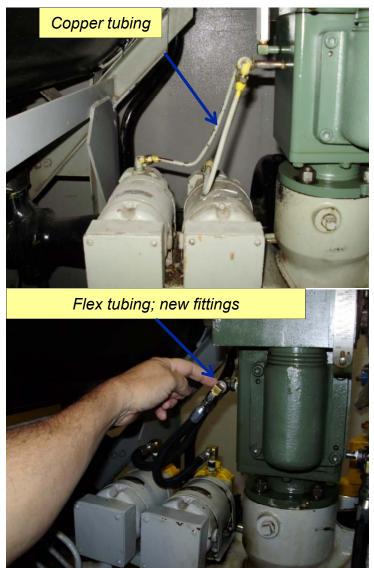
## **Channel Diesel Fire Pump Engine replaced**



## **Emergency Diesel Generators**

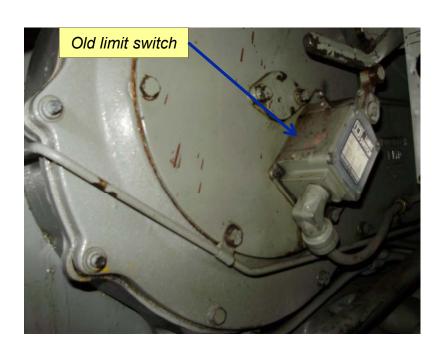
Governor modification

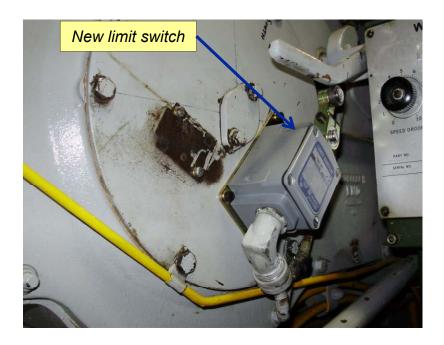




#### **Emergency Diesel Generators**

Over speed switch replacements- emergent degraded component

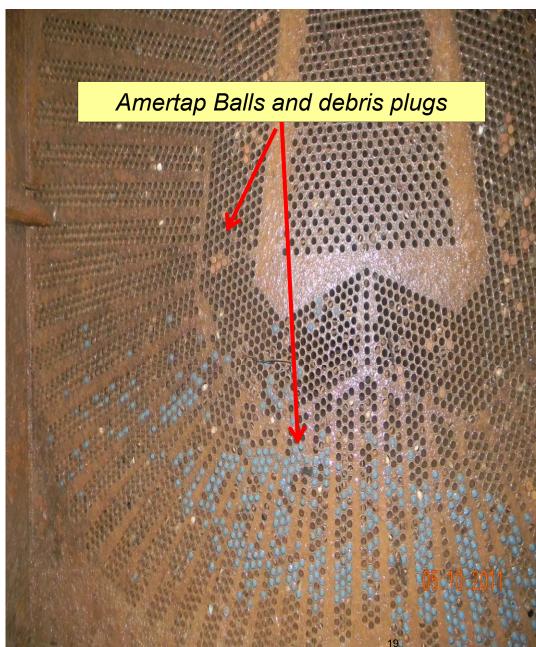




#### **Water boxes - Before Cleaning**



Loose debris



#### Water boxes After Cleaning

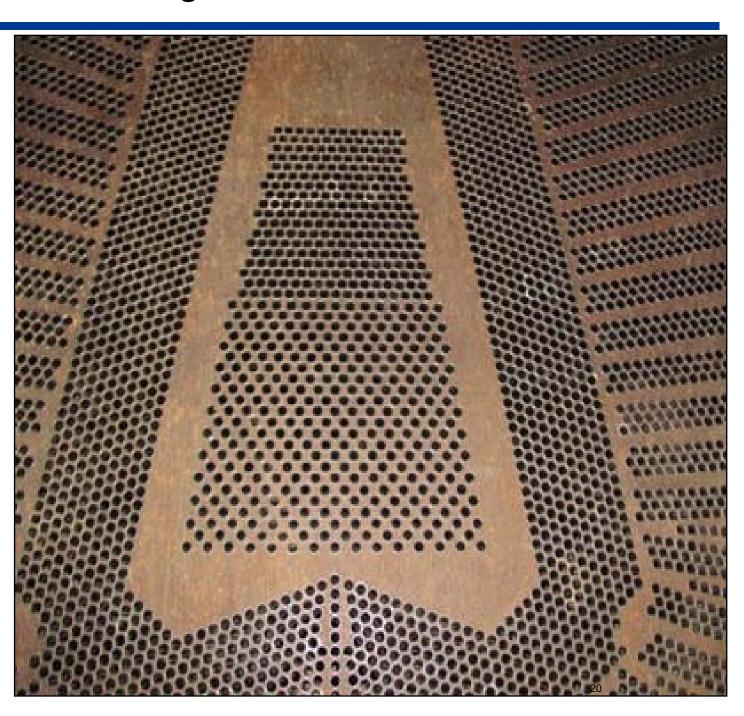
U1 –

Four water boxes cleaned

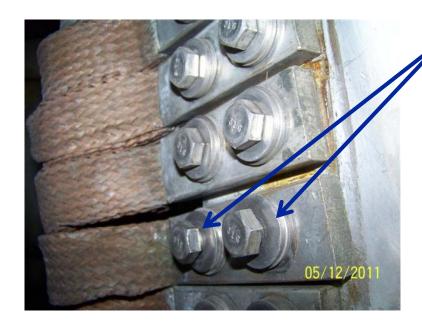
U2 – One water box cleaned; one tube plugged

U3 –

Six water boxes cleaned



#### ISO-Phase Bus Duct cooling Inspections on Unit 1 &3



Bus Duct inspection and cleaning found loose

... and missing bolted connections – potential for imminent failure with catastrophic results



# Over 200 work orders have been completed to improve reliability and performance

- Completed "3B" (including GL 91-18 issue with high vibes) and "A" D/G2 & 6 year PMs –
- Resolved GL 91-18 issues replaced Control Bay Chiller Transformers and replaced C3 EECW pump
- ◆Unit 3 RCIC EGM replacement— Maintenance Rule A(1) system
- License renewal inspections on embedded RHRSW piping which required a dual unit shutdown
- Refurbished Unit preferred MG set (Unit 2)
- Amertap system repairs
- All units will be returned to service after several years of disrepair; All units operational for summer peak
- Standby Gas Treatment Cable Replaced
- ◆To perform work on-line would required entry into a short duration shutdown LCO on all 3 units.

# Over 200 work orders have been completed to improve reliability and performance (Cont'd)

- ◆3A1 HP Heater Shell repair
- Would require deep down power and removal of heater string to repair
- Performed extent of condition Pulsed Eddy Current Testing on the Unit 3 #1, 2, and 3 FWHs
- ◆14 OWAs and 9 Control Room deficiencies corrected and 3 ODMIs were resolved
- Cleared alarm for Unit 2 Reactor vessel head seal leakage
- Repaired Unit 2 Reactor feed pump seal injection leaks
- Control Room Filter replacement
- ◆long standing issue that avoids a 3 unit short duration shutdown LCO
- ◆U2 Steam Packing Exhauster motors refurbished high vibration on both motors
- ◆U1 HPCI alignment Turbine/Pump high vibrations
- ◆Off-gas Stack Damper replacement- required 3 unit outage
- ◆ Security Diesel Generator Upgrade new voltage regulator

#### **Browns Ferry NRC RHR Valve Red Finding**

#### Background:

- ➤On Monday, April 4, 2011 TVA and the U.S. Nuclear Regulatory Commission met in Atlanta at a Regulatory Conference to discuss an apparent violation that was identified in the most recent Browns Ferry quarterly inspection report ending Dec. 31, 2010.
- The NRC made a preliminary determination that the violation was greater than Green, which is a finding of greater than very low safety significance.
- ➤On May 9, 2011 the NRC concluded the finding should be characterized as Red, a finding of high safety significance that requires additional NRC inspection of the plant.

#### **Browns Ferry NRC RHR Valve Red Finding**

#### **Key Points:**

- ➤ The violation resulted from a Residual Heat Removal valve failing to open during the Unit 1 scheduled refueling outage in October 2010
- ➤TVA reported the failure to the NRC
- ➤ We fixed the valve during that outage and have conducted further analysis and tests to understand the extent of the problem and possible mitigating conditions
- ➤ We also completed an evaluation of the functionality of that same valve type on all Browns Ferry units
- ➤ TVA continues to take action to ensure the safety and reliability of the residual heat removal system valves on all three Browns Ferry units. Browns Ferry is currently upgrading its fire protection program to the NRC endorsed performance based standard (NFPA 805)

#### **Browns Ferry NRC RHR Valve Red Finding**

#### Key Points (cont'd)

- ➤ During the Unit 2 refueling outage, workers welded in eight large gussets on two valves of the type that failed on Unit 1 to further strengthen them.
- During the ongoing forced outage of all three units, the remaining three valves of this type were inspected and, if necessary, strengthened.
- ➤ TVA worked with industry-leading engineering and design firms to determine what caused the valve problem on Unit 1 and its safety significance. TVA concluded the valve disc would have lifted and provided full flow had the system been required to perform its intended safety function.
- The TVA and third-party root cause analysis determined the problem was in the manufacturing of the valve and was not related to human performance.
- These valves also worked properly on April 27 when all units at Browns Ferry safely shut down following severe weather that damaged the TVA's transmission system

#### **IP 95003 Violation/Driver**

#### Performance Deficiency

- ◆NRC determined that TVA's failure to implement an in-service testing (IST) program in accordance with ASME Code precluded the timely identification that the RHR Loop II subsystem was unable to fulfill its safety function due to a failure of LPCI outboard injection valve 1-FCV-74-66. The NRC concluded that TVA's IST program inadequacy was well within its purview, and represents a performance deficiency.
- ◆This performance deficiency, which is the basis for the violation, is that the IST Program was deficient in that it did not result in identification of the valve failure.
- ◆This finding is characterized as RED, a finding of high safety significance that will require additional NRC inspection, Inspection Procedure 95003.

#### **IP 95003 Attributes**

- I. Review of Performance Deficiency
  - Root Cause
  - Extent of Cause
  - Extent of Condition
- II. Assessment of Corrective Action Program
  - Identification
  - Assessment
  - Corrective Action
- III. Assessment of Performance Around Cornerstone
  - Design
  - Human Performance
  - Procedure Quality
  - Equipment Performance
  - Configuration Control
- IV. 3<sup>rd</sup> Party Assessment of Safety Culture
  - Comprehensive
  - Method to collect and analyze data
  - Results and conclusions

## IP 95003 Team Make-up

- Corporate Driven
- Strong License Component
- Site Engagement
- External Support
- Oversight Arm
- Communication Support
- Admin/Project Support

#### **Multi-Skilling MOU**

- ◆On March 3<sup>rd</sup> the Tennessee Valley Trades and Labor Council and TVA signed an agreement that will increase the level and depth of specialty skills of craft
- ◆For me, this partnership for success started about four years ago . . . March 2007 . . . when I was serving as executive sponsor for the Maintenance and Modifications Peer Team.
- ◆This agreement will result in craft becoming our subject matter experts on equipment they work on and being able to better support initiatives to drive equipment reliability, which leads to safer, more reliable plants

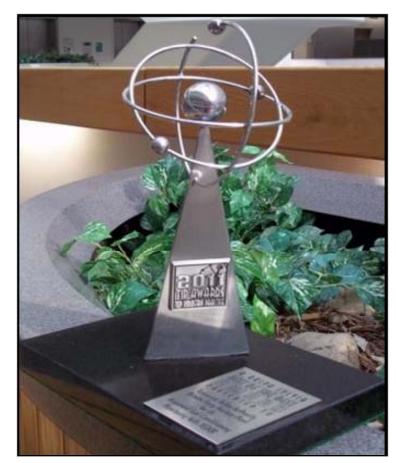
#### **Multi-Skilling MOU**

- In addition, this new agreement provides a pay compensation for these employees becoming experts in their specialty area
- This agreement will allow us to significantly reduce our dependency on long-term contractors and vendors
- ◆That's because we will have the "go-to" experts right there on our team, in our fleet, and as part of our company

# NPG Receives NEI's Best of the Best Top Industry Practice (TIP) Award

Employees at the NPG and Browns Ferry were honored with the B. Ralph Sylvia "Best of the Best" Award for developing a state-of-theart method to detect reactor fuel rod defects and prevent costly fuel leaks. The team also took the NEI Top Industry Practice (TIP) award for the nuclear fuels category. Team members:

Mike Keck, Greg Storey, Jim Lemons, David Marsh, and Rod De La Garza



#### **Organizational Health Index Survey**

- ◆Our fleet has more than 385 key indicators we use to monitor our performance, but none of those targets, charts, and trends can give us the perspective that you can
- ◆In addition to understanding where our fleet stands regarding to excellence, we must also know how aligned we are, how well we work together and communicate with each other, how we achieve and sustain high levels of performance, and how we can have some fun while at work.
- These are things only you can tell us, and hopefully have told us through the OHI Survey
- The OHI results are to be presented to me and the leadership team later this month
- ◆We will roll them out to each organization and put initiatives in place to address them and monitor and measure our progress achieving the desired results

# **Progress on Five Fleet Focus Areas**

#### Fleet Focus – Corrective Actions and Human Performance

#### **Corrective Action Program (CAP)**

- Actions Completed
  - —CAP-101 Training for all workers, integrated as part of NEE
  - —Qualitative performance measures in place
  - —Dedicated Department PI Coordinators
  - —Dashboard in POD to improve visibility of Root Cause status
- Moving Forward
  - —Specialized training for CARB and PSC members
  - —Improve coding and trending of issues

#### Fleet Focus – Corrective Actions and Human Performance

#### **Human Performance (HU)**

- Actions Completed
  - —Department MRMs across the fleet
- Moving Forward
  - —Human Performance Summer Initiative
  - —Initial Human Performance Fundamentals training as part of NEE
  - -Expand use of Technical Human Performance
  - —Observation Program Improvements
  - —Procedure/Work Package Quality
  - —Process Rigor

#### **Human Performance Summer Initiative**

- Standardize COO Approach to Human Performance
  - —All operating business units trained on standard Human Performance tools
- Heighten awareness of transmission system vulnerability
- Special Focus on 3 Tools
  - —June: Stop When Unsure
  - —July: Pre-job Briefing
  - —August: Two-Minute Rule
- Metrics to compare performance between business units

- Fleet wide Material Condition Improvement Plan (MCIP)
  - 21 BFN system reviews completed, 0 In progress, 22 scheduled
  - —7 WBN system reviews completed, 3 in progress, 8 scheduled
  - 10 SQN reviews completed, 9 in progress, 4 scheduled
  - —375 key issues identified of which 115 are complete
  - —216 enhancement issues identified of which 27 are complete
  - Process requires fleet challenge for quality
  - —75 system reviews per site to be performed
- Examples of results:
  - Terry Turbines Governors (AFW/HPCI/RCIC) control obsolescence issue – now on business plan to replace
  - LCV diaphragm replacements
  - Main feedwater water hammer issue resolved
  - AFW solenoid upgrades
  - Comprehensive SQN switchyard redesign to eliminate dual unit trip vulnerability

- Fleet wide Material Condition Improvement Plan (Continued)
  - Spring completions:
    - SQN Unit 2 Make before break start board modification & start bus replacement I/P
      - Added assurance with bus power source changes
      - Higher confidence for Units to perform CSST work during outages
      - Resolved degraded bus insulation condition potential phase to phase short
      - Resolved bus duct water intrusion potential
    - WBN Unit 1 ERCW TCV upgrade
      - Resolves "fail open" condition to control room TCVs
      - Allows Control room chiller TCVs to be modulated during loss of power events
        - Maintains higher flow to other ERCW components margin increase
    - WBN Unit 1 main feedwater piping drain upgrade
      - Resolves a known severe water hammer condition when feedwater is shutdown/isolated
    - BFN Unit 2 stator cooling water temperature controller upgrade
      - Resolves a current obsolete controller issue
      - Resolves a single point vulnerability for plant trip/runback
      - Allows TCV to fail to a preset position



# Sequoyah Spare CSSTs





BFN RHR Angle Globe Valve repairs completed



This will resolve RIS 2005 (91-18) non-conformance issue for ALL BFN Units.

- Utilization of Engineering Excellence Plan (driven by peer team supports CNO strategy)
  - Functional Evaluations/Operability Determination Input
    - New fleet procedure
    - Fleet challenge required
    - Training in development through licensing
    - Process implementation after change management
  - Long Term Asset Management
    - Capital Spares business case developed
    - Developing long term major maintenance plans (WBN lead)
    - Central printed circuit card facility
  - Engineering Knowledge and Skills Assessment
    - Fundamental exam given
    - Incorporating results into Training Program
- Critical Component Failures
  - Preventive Maintenance Optimization (PMO) of components in progress to ensure right maintenance on the right components. (BFN lead, WBN and SQN in progress)

- Expanding use of new predictive tools to ensure excellent performance between PMs
  - Baker testing of motors
    - Deploying for baseline testing in the fleet
    - Found rotor bar issue in BFN "A" motor driven fire pump when vibration signature indicated a bearing issue.
    - Used during WBN RFO10 to troubleshoot Motor Driven Auxiliary Feed water Motor 1A when vibrations increased after refurbishment to rule out motor problem.
  - RULER: The Remaining Useful Life Evaluation Routine (Ruler) instrument (WBN Pilot)
    - Determines the concentrations of antioxidants in new and used oils in order to monitor the depletion rates of the antioxidant protection
    - Recently used to determine that SQN's MTOTs needed a varnish removal system and new oil.
- Fleet Engineering focus on PdM watchlist equipment has reduced average cycle time on the list by three weeks

- Equipment Reliability Site Clock Process
  - Clock resets require report out by system engineer at morning POD fleet call for immediate learning's for the fleet
  - Quarterly rolling average of clock resets decreasing
- Systematic self-assessments utilizing INPO "how to" guides
- Strengthened corporate and site engineering organization structure
- GOES model
- INPO AP 913 ER model built into fleet processes
- Common fleet process
  - Results
    - SQN comprehensive switchyard upgrade in progress to eliminate dual unit trip vulnerability (significant work completed during Fall 2010 refuel outage, I/P on Unit 2)
    - BFN cooling tower 7 work is in progress, to be operational June 2011
    - BFN Unit 2 automatic voltage regulator
    - WBN Unit 1 automatic voltage regulator

## **Equipment Reliability Strategy**

- Kicked off Site ER MRMs in February there will be 3 per year per site
  - > Evaluate the effectiveness of the organization in achieving equipment excellence.
  - Review the effectiveness of continuous improvement initiatives as well as specific site abnormal or unexplained conditions
  - Foster behaviors that promote a zero tolerance for unexpected equipment failures
  - ➤ Provide strong oversight of site activities, ensuring that people, processes and equipment support superior performance.
  - Provide the opportunity for discussion on process/program implementation, looking at successes and problems.

## **Equipment Reliability Strategy**

- Outage System Windows
- What controls Outage Program & System Windows NPG-SPP-7.2.1
- ◆What is an Outage Window?
  - A sequence of activities which form the work scope or evolution
  - Operation, clearance /tagging, maintenance, testing, etc
- —Why is it important?
  - Allows the Outage Control Center (OCC) to focus on upcoming window closures
  - A communication tool for the window owner to engage the team
  - Identify and create needed recovery plans for success
  - Opportunity for teams to look ahead and challenge required recovery plans
  - Focuses on getting the planned/discovery outage work completed with quality
  - The next operating cycle(s) absolutely depend on it
  - It affects us personally

# **Outage System Windows**

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ohn Moore	Geoffrey McClain	Geoffrey McClain	Ed Kirby	Daryl Jackson	Ed Kirby	
Robert Lowery	Bob Lowery	Bob Lowery	Dale Jones	Stewart Wetzel	Kelli Harvey	
SYS# 027	SYS # 034	SYS # 035	SYS # 047	SYS#063	SYS# 064	
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Daryl Jackson	Daryl Jackson	Chris Reischman	Ron Beck	Jamle Ford	Andrew Payton	
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Original Activites: 76	Original Activites: 161	Original Activites: 100	Original Activites: 160	Original Activites: 766	Original Activites: 227	
Expected Remaining: 23	Expected Remaining: 36	Expected Remaining: 40	Expected Remaining: 58	Expected Remaining: 147	Expected Remaining: 32	
Actual Remaining: 36	Actual Remaining: 53	Actual Remaining: 64	Actual Remaining: 83	Actual Remaining: 234	Actual Remaining: 39	
Claire Holt	Phil Porter	Phil Campbell	Phil Campbell	Weaver Burton	Weaver Burton	
Dale Jones	Drew Mitchell	John Lacasse	John Lacasse	Mindy Roy	Mindy Roy	
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Control Rod Drive	Rx Protection System	Main Transformers	Main Generator	120-V AC Inst & Ctrl PWR		
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expected Remaining: 21	Expected Remaining: 1	Expected Remaining: 5	Expected Remaining: 56	Expected Remaining: 3	1	
ctual Remaining: 77	Actual Remaining: 7	Actual Remaining: 11	Actual Remaining: 68	Actual Remaining: 3	<b>→</b>	
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### **Governance and Oversight**

#### Highlights

- —Surveillance instruction tracking
- —Radiological performance during outages
- —Completion of planned outage work scopes
- Improved execution of Ready-Ready process and staging of materials

#### Hard Spots

- —Cycle planning
- —Ownership of AP 928 changes to work management process
- —Outage planning
- —Outage schedule adherence

### Fleet Focus: Governance and Oversight

- New Memorandum of Understanding on Specialty Training
- New Memorandum of Understanding on Permanent Maintenance Training Instructors
- The agreement created 27 new, permanent trades and labor instructor positions which previously were filled temporarily by trades and labor personnel selected from the Maintenance and Operations
- Ownership of unit supervisors driving reactivity management related equipment repairs
- Successfully in-processed over 3,600 applicants for spring refueling outages
- Developed innovative "Craft Incentive" agreement with the TVTLC that was used successfully this spring for outage in-processing
- Revitalization of local Health and Safety Committees with union steward buy-in and active participation

#### Fleet Focus: Training

- BFN Operations Training Accreditation Renewal
- 22 new Licensed Operators since December, with 14 taking exams in June and 91 in the pipeline thereafter
- 98% pass rate on NRC LOR requalification exams
- 29 new instructors completed INPO certification
- ◆86 new Maintenance technicians in training/qualification
- 6 new Chemistry technicians in training/qualification
- ◆18 new Engineers in training/qualification
- ◆16 Chattanooga State RP graduates started internship
- 12 Chattanooga State NLO students started internship at WBN/SQN

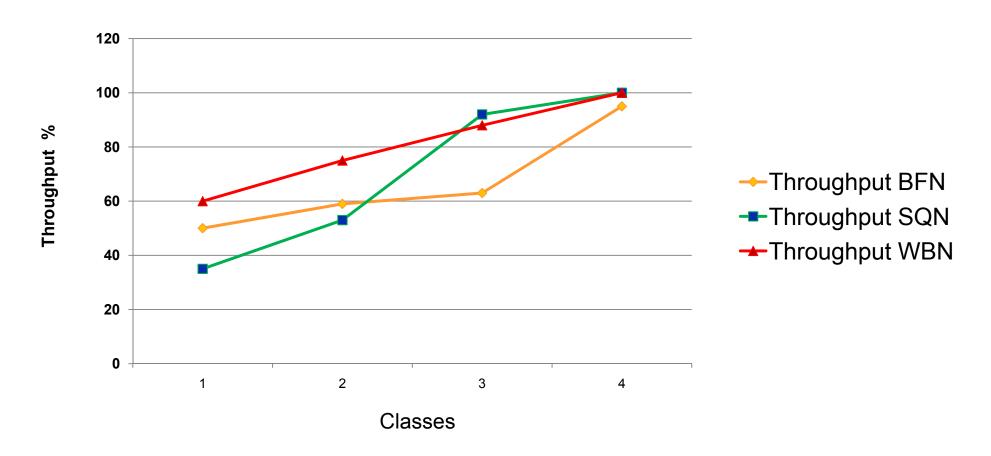
#### Fleet Focus: Training

- ◆NRC accepted WBN dual unit license training plan
- SOER 10-2 critical thinking training
- Leadership development training piloted
- Central In-Processing supported all 3 spring outages
- NANTeL materials upgraded to support outage inprocessing
- New video for Human Performance Tool usage is in final production
- TVA received "Training Excellence Award" for Chattanooga State RP program

## Fleet Focus: Training

#### Throughput

Most recent four classes at each site, including those currently in progress



## Fleet Focus: Talent Management and Alignment

- Completed eight rounds of 9-Box and Succession Planning
- Continue to meet our goal of 80% internal and 20% external hires
- COO Strategic Talent Reviews
- Strong leadership team across the fleet
- More rigor placed on developmental activities
- SRO Certs, INPO Assignments, Strategic Rotations
- Implementation of Deep Dive Program
- Quarterly Fleet Employee Focus (Business Plan) reviews and biannual "First Line Supervisor and Above" meeting
- Continue the STS Leadership Assessments

#### NPG FY '11 To-Date Ratio of Internal/External Hires

#### **NPG Fiscal Year 2011 Ratio of Internal/External Hires**

#### **Supervising Managers - Through May 13, 2011**

Organization	External	Internal	Total	% Internal
0.8424.01.	External		- Cui	70 IIICIIIII
NPG BFNP	5	28	33	85%
NPG Corp	9	13	22	59%
NPG CORP Security	0	14	14	100%
NPG SQNP	6	16	22	73%
NPG WBNP	1	29	30	97%
NPG WBNP Unit 2	0	1	1	100%
Total	21	101	122	83%

#### **NPG Culture of Excellence**

◆ **Purpose**: Create and sustain a Culture of Excellence within NPG that is demonstrated by a continuous quest for excellence.

◆ Definition: NPG Culture of Excellence is our values and behaviors as modeled by our leaders and internalized by our members

#### **Expectations for Culture of Excellence**

- We are Aligned
- We Engage our Employees
- We internalize and demonstrate the Leadership Fundamentals
- ◆We Always Strive To Be Better
- We Use The Accountability Model

#### Using the Accountability Model

#### Clear Expectations

- Senior Mgmt Sets Expectations and Required Behaviors
- Roll out in Development Class

# Assess and Develop Skills

- Perform STS Leadership Assessment
- Develop IDPs and Monitor Progress

# Feedback and Evaluate

- Mentoring & Coaching
- Oral Boards

#### Consequences

- Succession Planning
- Performance Improvement Plan

### Our Challenges Remain as...

- Accountability on Financial Management
- Equipment Reliability
- Outage Planning and Execution
- Browns Ferry Power Red Finding
- Watts Bar 2-unit site integration

#### Mission

To serve TVA and the people of the Valley through energy, environment, and economic development by producing safe, reliable, and cost-effective electricity from clean nuclear power.





#### Nuclear Fleet Business Plan Milestones to Excellence

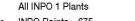
FY 15 FY 14 FY 11 FY 12 FY 13





- INPO Points 640
- Non-fuel O&M 14.30 mills/kWh
- Operating Capacity Factor 96.3%
- Average Refueling Outage Days 26





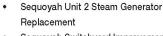
- INPO Points 675
- Non-fuel O&M 13.00 mills/kWh
- Operating Capacity Factor 97.9%

Browns Ferry, Sequoyah, Watts Bar -

Average Refueling Outage Days - 24



- Watts Bar Unit 2 Start-up
- Sequoyah INPO 1
- INPO Points 561
- Browns Ferry INPO 2
- Non-fuel O&M 13.70 mills/kWh
- Operating Capacity Factor 93.8%
- Average Refueling Outage Days 31



- Sequoyah Switchyard Improvements
- Watts Bar INPO 1
- INPO Points 618
- Non-fuel O&M 15.21 mills/kWh
- Operating Capacity Factor 94.3%
- Average Refueling Outage Days 29





- Watts Bar INPO 1
- INPO Points 573
- Non-fuel O&M 16.27 mills/kWh
- Operating Capacity Factor 95.4%
- Average Refueling Outage Days 31



