



# Design of nuclear plants

Reactor technology

Lecture 1

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Operation of nuclear reactors (lecturer: Mr. Szabolcs Czifrus)	....
Reactor technology (lecturer: I. Boros)	1. Main NPP types, reactor generations. Advanced NPP types
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	3. PWR main systems (primary, secondary systems), safety systems
	4. Containment systems
	5. Cooling of NPPs
	6. BWR, PHWR, other types
	7. exotic reactors (fast breeders, etc.)

# Nuclear energy at present

- Share of nuclear in electricity production (2011 -> 2014):

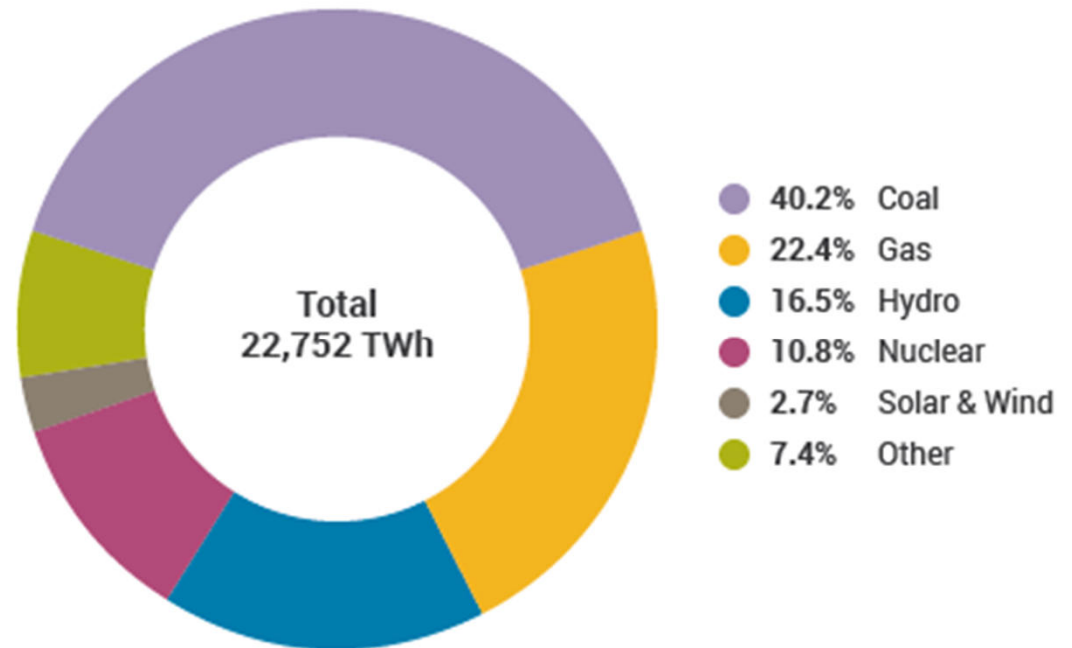
world 16% → 11%

EU 35% → 27%

Hungary 36% → 53%

- 448 NPP units operate worldwide
- 57 units under construction
- Design lifetime of most units expires between 2015 and 2030

World Electricity Production 2012



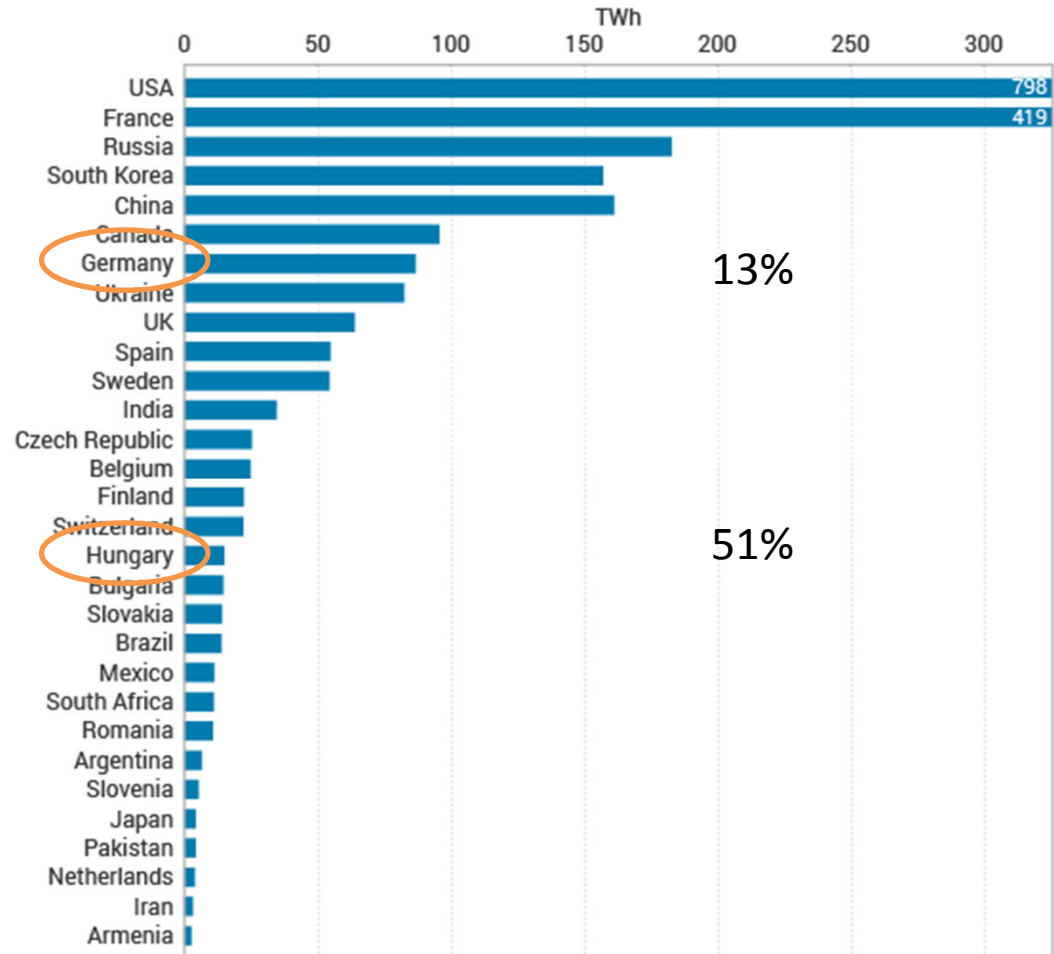
Source: IEA Electricity Information 2014

# Nuclear energy at present

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world	16%	→	11%
EU	35%	→	27%
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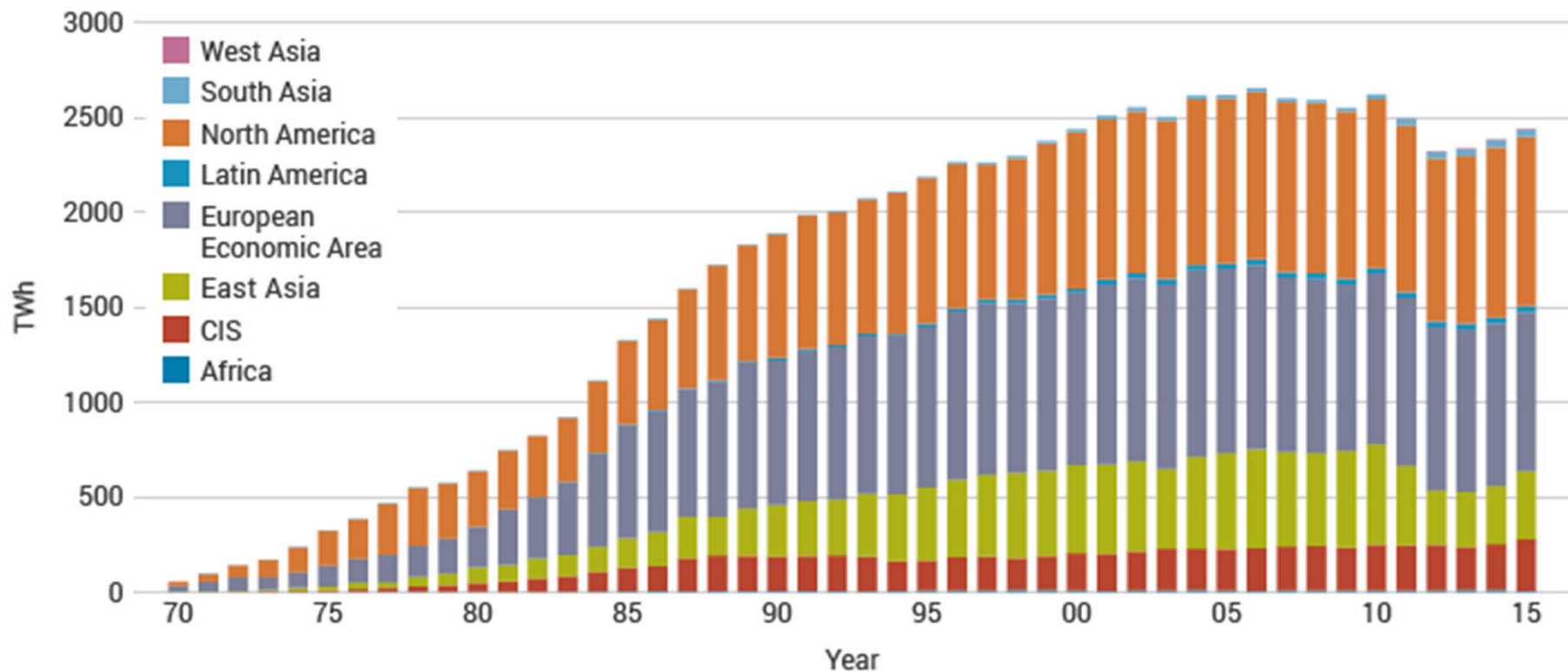
Nuclear Generation by Country 2015



Source: IAEA PRIS Database

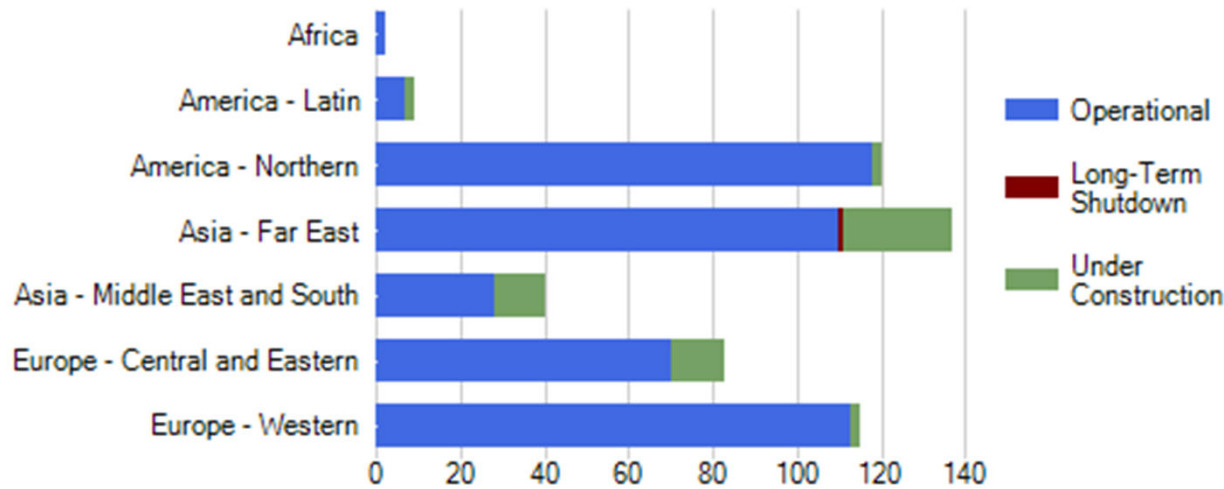
# Trends in nuclear industry

## Nuclear Electricity Production

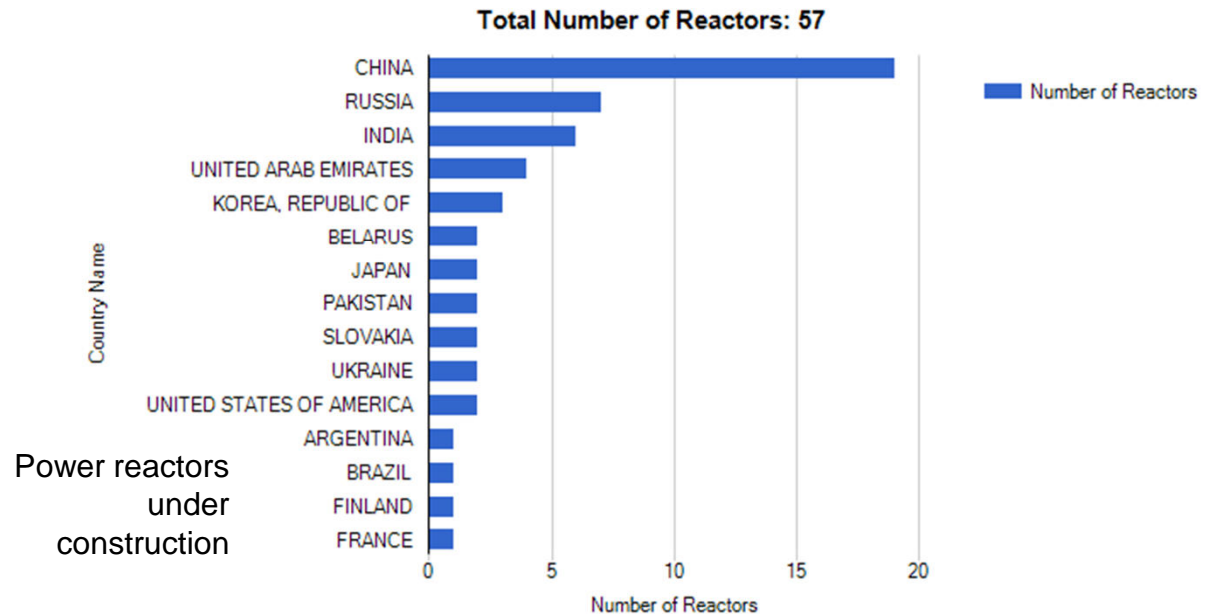


Source: IAEA PRIS

# Trends in nuclear industry



Source: IAEA



# **BASICS OF NUCLEAR TECHNOLOGY**

# Nuclear fission

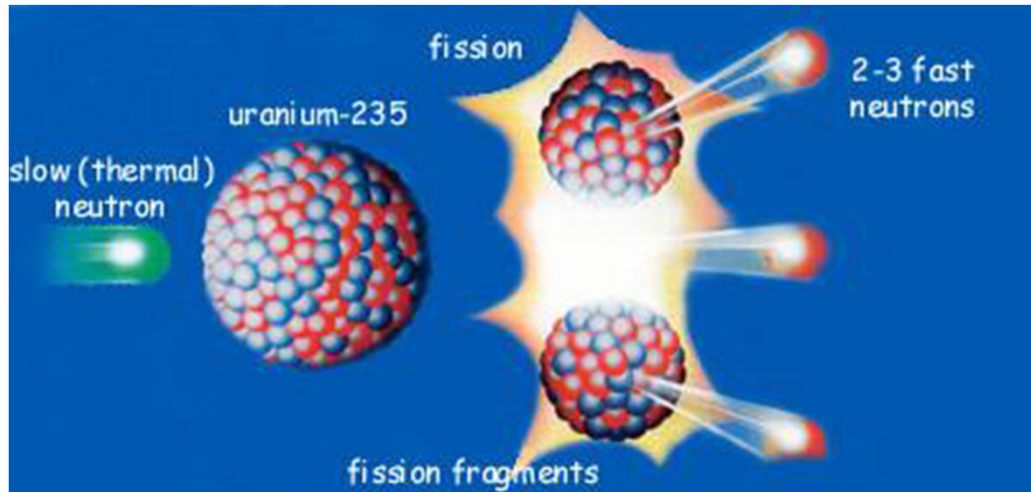
- In certain isotopes, spontaneous or induced fission of the nucleus can occur
  - Induced fission: effect of bombardment of thermal neutrons
- Uranium isotopes in nature

$^{234}\text{U}_{92}$  ( 0.006%)

$^{235}\text{U}_{92}$  (0.714%)

$^{238}\text{U}_{92}$  (99.28%)

- Enrichment for nuclear power reactors <5% (U-235)



Source: NPP Paks, IAEA

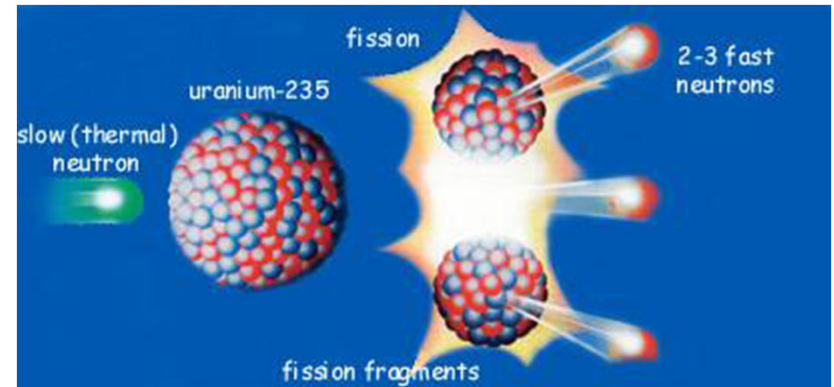


# Nuclear fission

- U-235: fission generated by thermal neutrons can take place
- In average, 2.4 fast neutrons are produced in every fission
  - A small part of these neutrons are delayed (for U-235:  $\beta=0.64\%$ ), with a maximum release time of 60 s (prompt neutrons: up to  $10^{-14}$  s)
  - Delayed neutrons are extremely important in control of the chain reaction

*ENERGY DISTRIBUTION FOR FISSION INDUCED BY THERMAL NEUTRONS*

Source: NPP Paks, NRC



Source	Energy MeV
Fission product kinetic energy	168
Neutron kinetic energy	5
Fission gammas (instantaneous)	5
Fission gammas (delayed)	6
Fission product betas	7
Total available as heat	191
Neutrino energy (not available as heat)	11
<b>TOTAL</b>	<b>202</b>

# Nuclear fission

- For different neutron-nucleus interactions:
- Microscopic cross section for nuclear reactions (for one given nucleus, and for 1 unit of neutron flux)

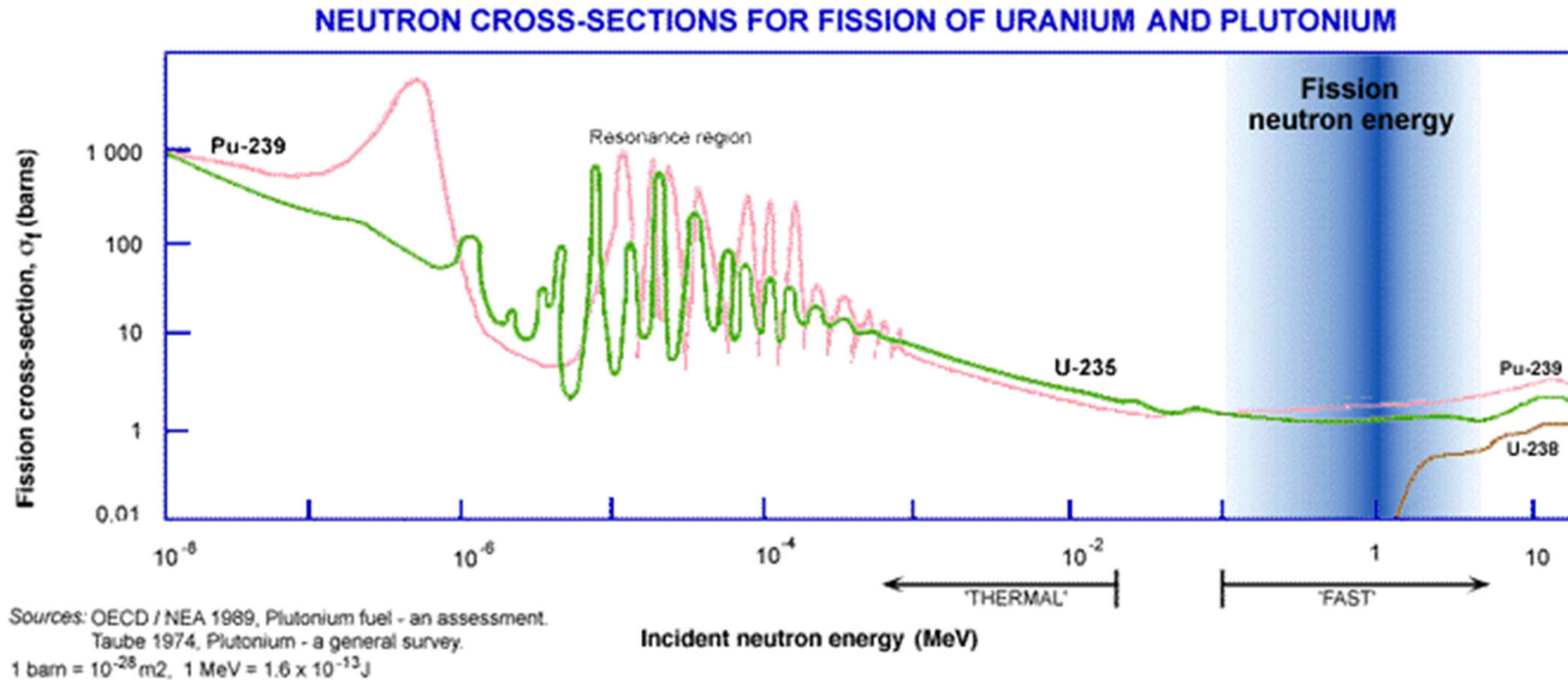
$$\sigma_t = \sigma_s + \sigma_a = \sigma_{elastic} + \sigma_{inelastic} + \sigma_{fission} + \sigma_{capture}$$

- Where t: total, s: scattering, a: absorption
- Unit: barn ( $10^{-24} \text{ cm}^2$ )
- Macroscopic cross section (for a given material):

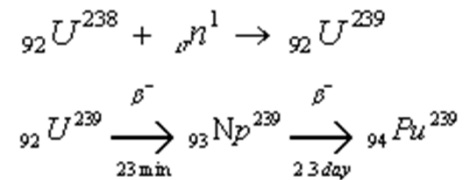
$$\Sigma_t = \sum_i n_i \sigma_{ti}$$

- Where i is for all nuclei,  $n_i$ : number of nuclei by unit volume
- Unit: 1/cm

# Nuclear fission



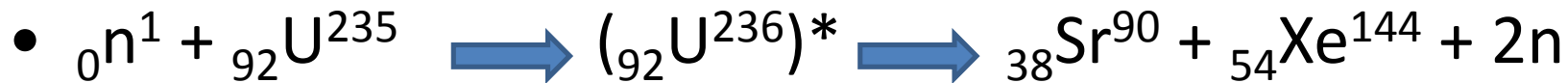
- Production of Pu-239 in thermal reactors:



# Nuclear fission

- Fission fragments, fission products

- A typical fission reaction:

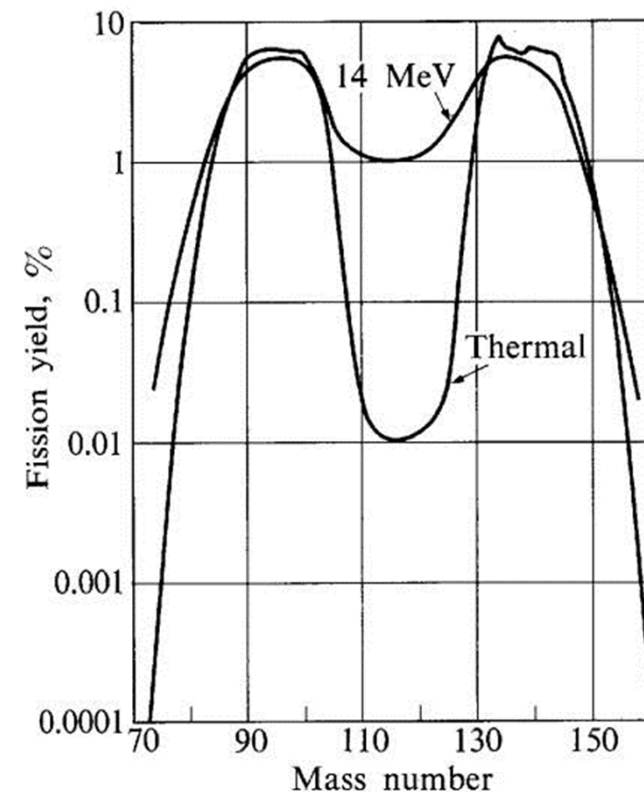


- Fission yield

- Important fission products:

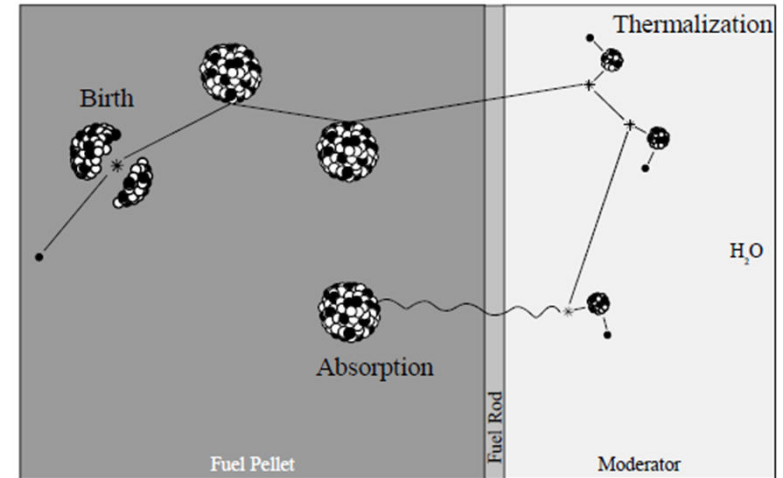
  - I-133, Sr-90, Cs-137 etc.

- (+ don't forget the trans-uranium isotopes!)

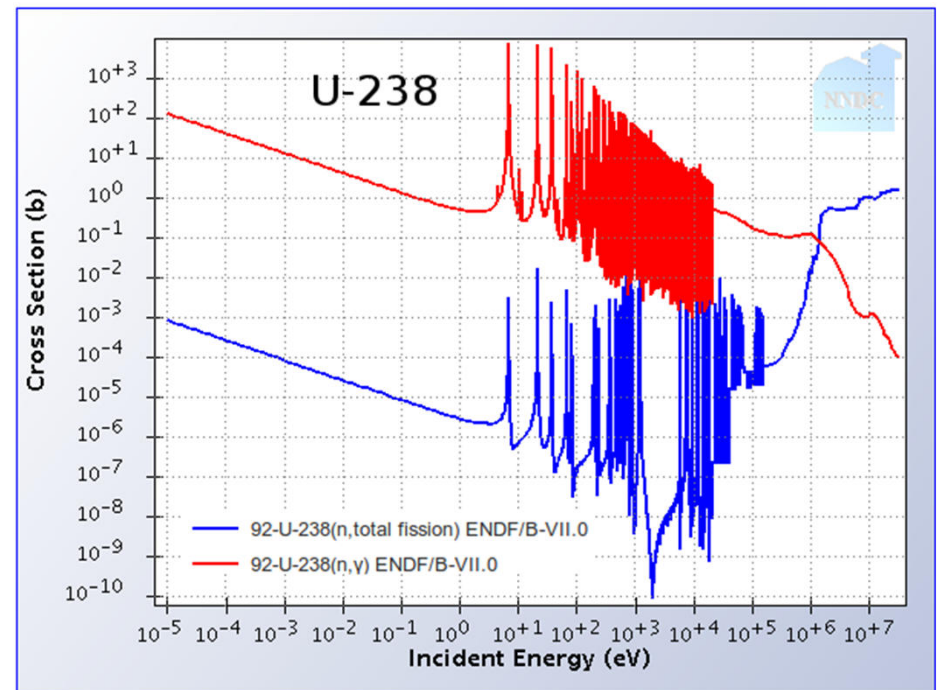


# Nuclear fission

- Neutrons can be thermalized (slow down by scattering) and cause further fission
- Moderator materials
- Requirement: to reach thermal energy without being absorbed (by U-238 OR by the moderator itself)
  - > Having as few collision as it is possible



Neutron Life Cycle



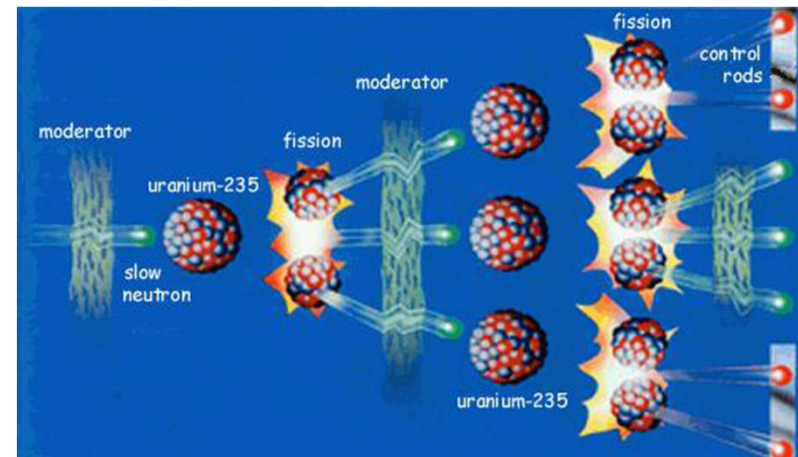
# Moderator materials

Moderator parameters	H <sub>2</sub> O	D <sub>2</sub> O	Graphite
moderation path length [cm]	5.74	10.93	19.7
neutron absorption cross section [barn]	0.66	0.0026	0.0045

- Advantages and disadvantages of different materials
- Deuterium or graphite moderator: operation possible with natural uranium
- For H<sub>2</sub>O moderator enrichment of U-235 is necessary

# Nuclear fission

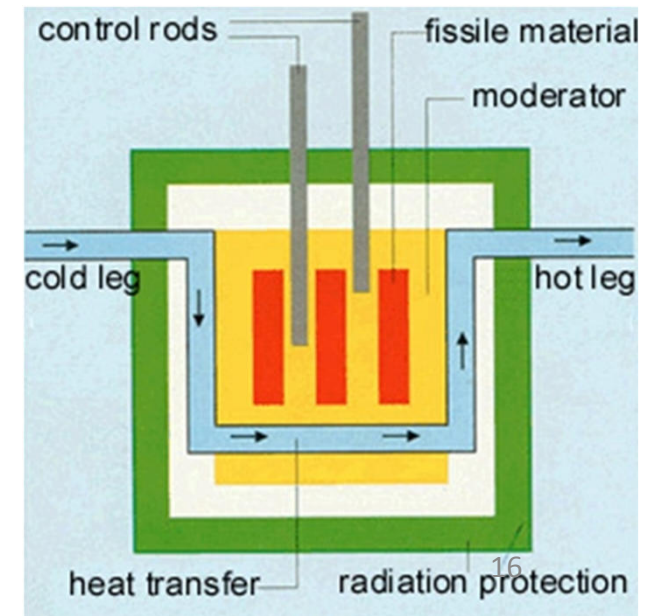
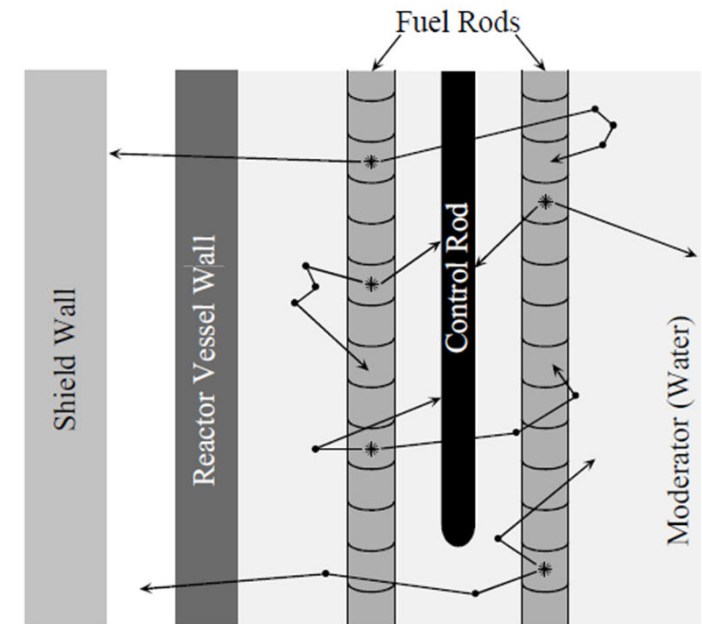
- Chain reaction
  - Series of fission becomes self-sustaining
  - Multiplication factor:  $k_{\text{eff}}$
  - Reactivity:  $\rho = (k-1)/k$
  - Critical, subcritical, supercritical chain reaction



# Nuclear reactors

Source: NPP Paks, NRC

- Neutrons in nuclear fuel
  - Scattering (slow down)
  - Absorption
  - Escape
  - Fission generation
- Thermal nuclear reactors
  - Fuel – fissile material, usually U or Pu (or MOX)
  - Moderator – with good slowdown parameters + small absorption ( $H_2O$ ,  $D_2O$ , C)
  - Reactivity control – neutron absorbing material (B, Cd)
  - Cooling ( $H_2O$ ,  $D_2O$ ,  $CO_2$ , He)
  - Radiation protection (concrete, water, boric acid, etc.)



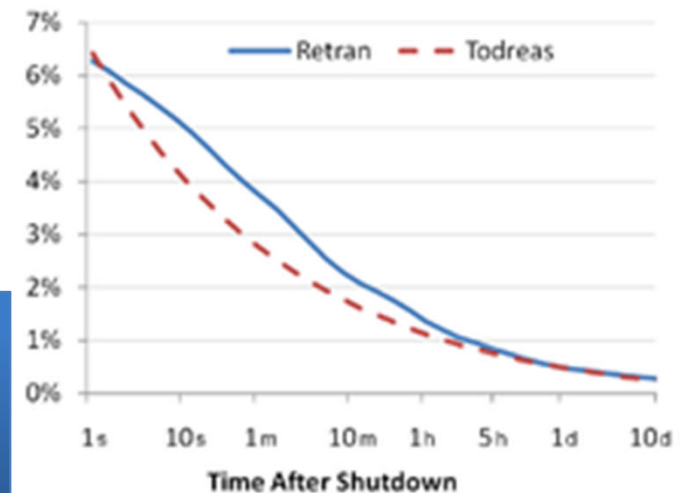


# Why is nuclear safety so important?

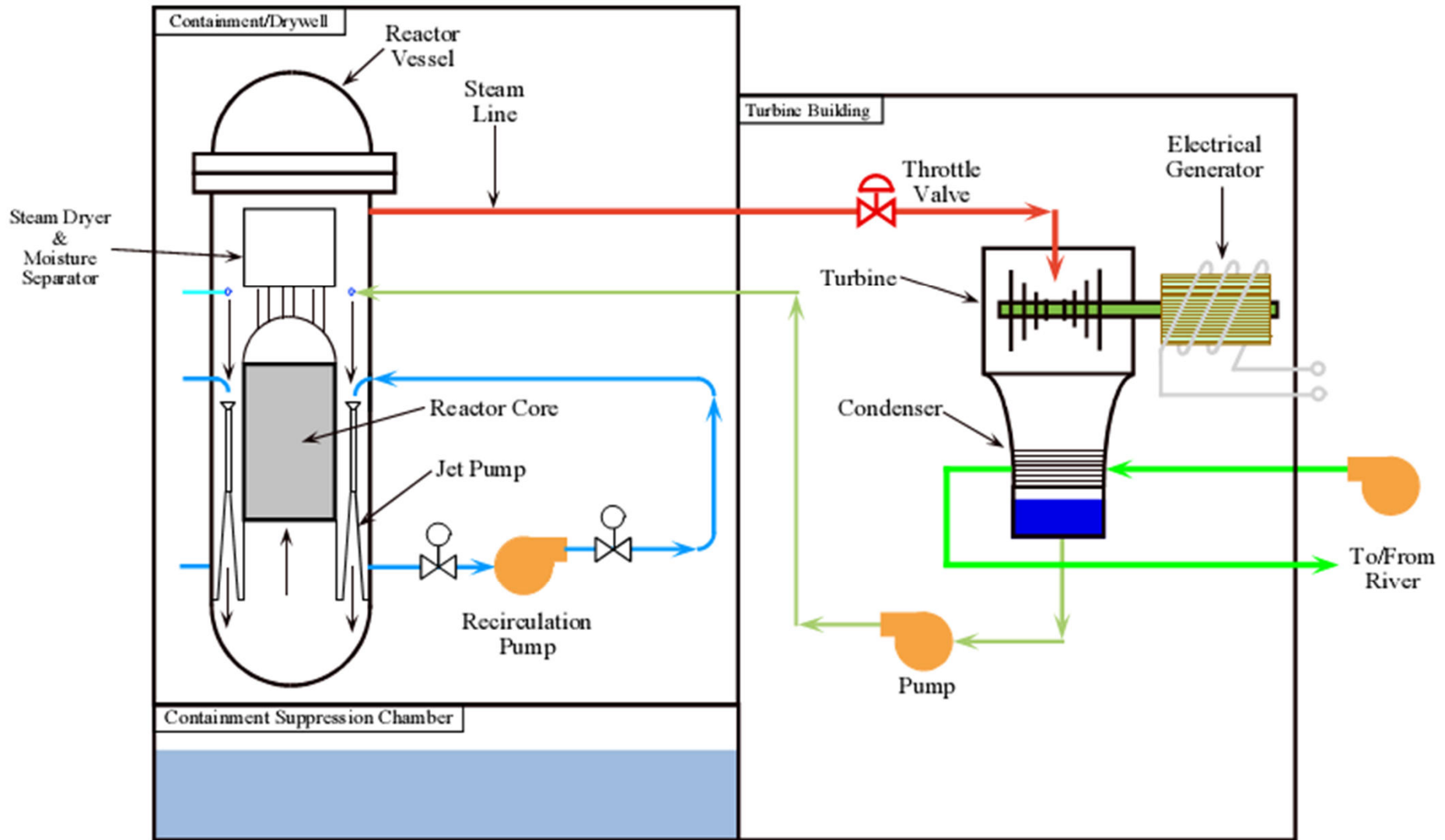
- Specific risks of nuclear reactors (compared to other plant types):
  - Large amount of fissile material in the core
  - Large quantity of radioactive materials in the core
  - Significant energy release for a long time after shut down.

	Core, 2 h after shutdown	Spent fuel	Primary system	Gaseous effluents
Rare gases	$10^7$ TBq	$10^6$ TBq	$3 \cdot 10^2$ TBq	$2 \cdot 10^2$ TBq
Iodine	$2 \cdot 10^7$ TBq	$10^6$ TBq	20 TBq	
Caesium	$10^7$ TBq	$2 \cdot 10^4$ TBq		

Safety depends on appropriate **confinement** of radioactive materials, **control** of the chain reaction and efficient **cooling** of the core!

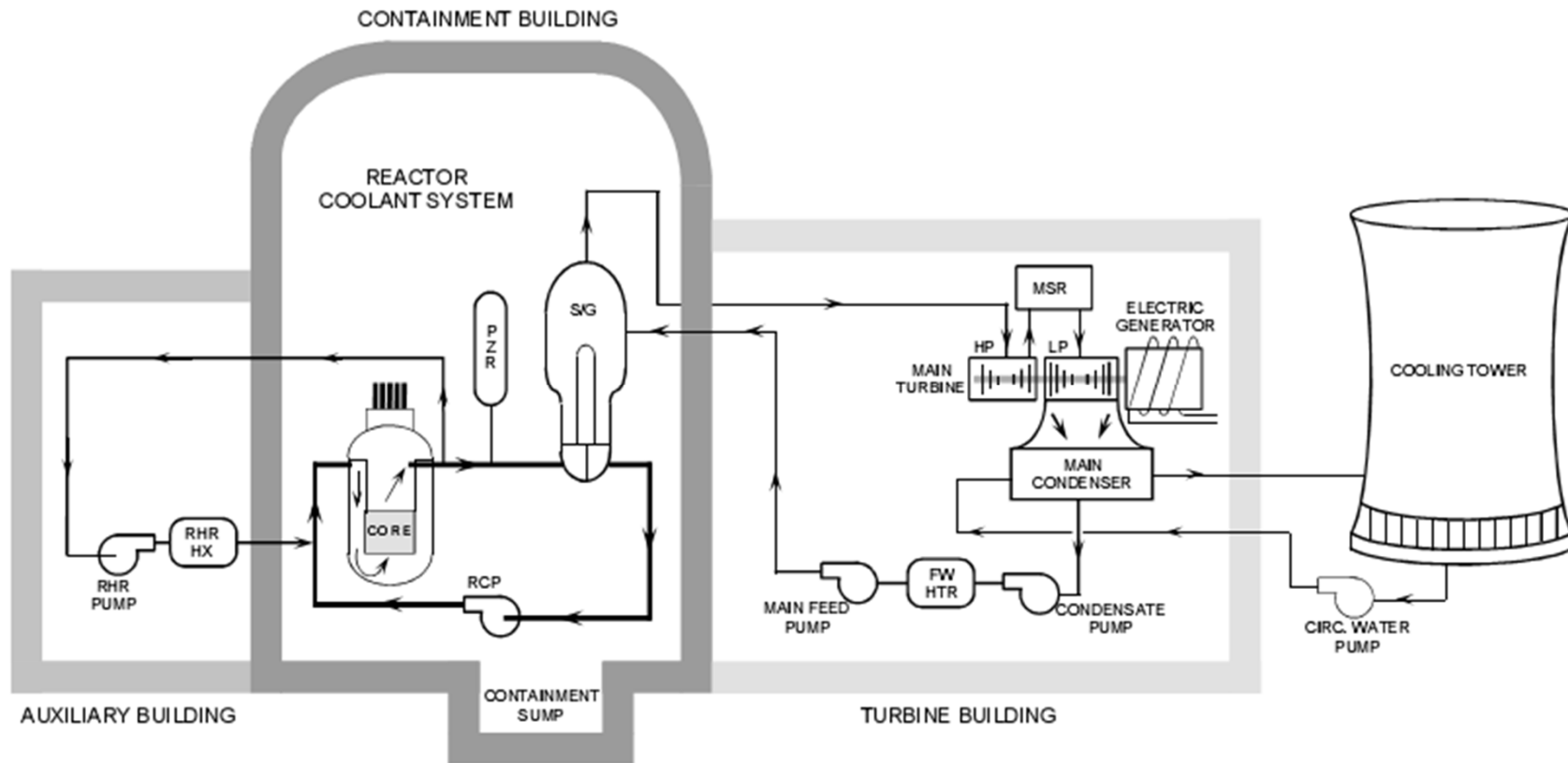


# Boiling Water Reactor (BWR)



Source: NRC

# PWR design



Source: NRC

- Two cooling circuits (loop  $\neq$  circuit!)
- Primary parameters set to avoid boiling ( $p_{pr}$ : 130-160 bar,  $T_{pr}$ : 260-300°C)
- Secondary circuit: classic water-steam coolant regime (Rankine-cycle at about 50-65 bar pressure)

# Nuclear energy at present

Reactor Type ▲	Reactor Type Descriptive Name	Number of Reactors	Total Net Electrical Capacity [MW]
BWR	Boiling Light-Water-Cooled and Moderated Reactor	78	75208
FBR	Fast Breeder Reactor	3	1369
GCR	Gas-Cooled, Graphite-Moderated Reactor	14	7720
LWGR	Light-Water-Cooled, Graphite-Moderated Reactor	15	10219
PHWR	Pressurized Heavy-Water-Moderated and Cooled Reactor	49	24634
PWR	Pressurized Light-Water-Moderated and Cooled Reactor	290	272450
Total		449	391600

Source: IAEA



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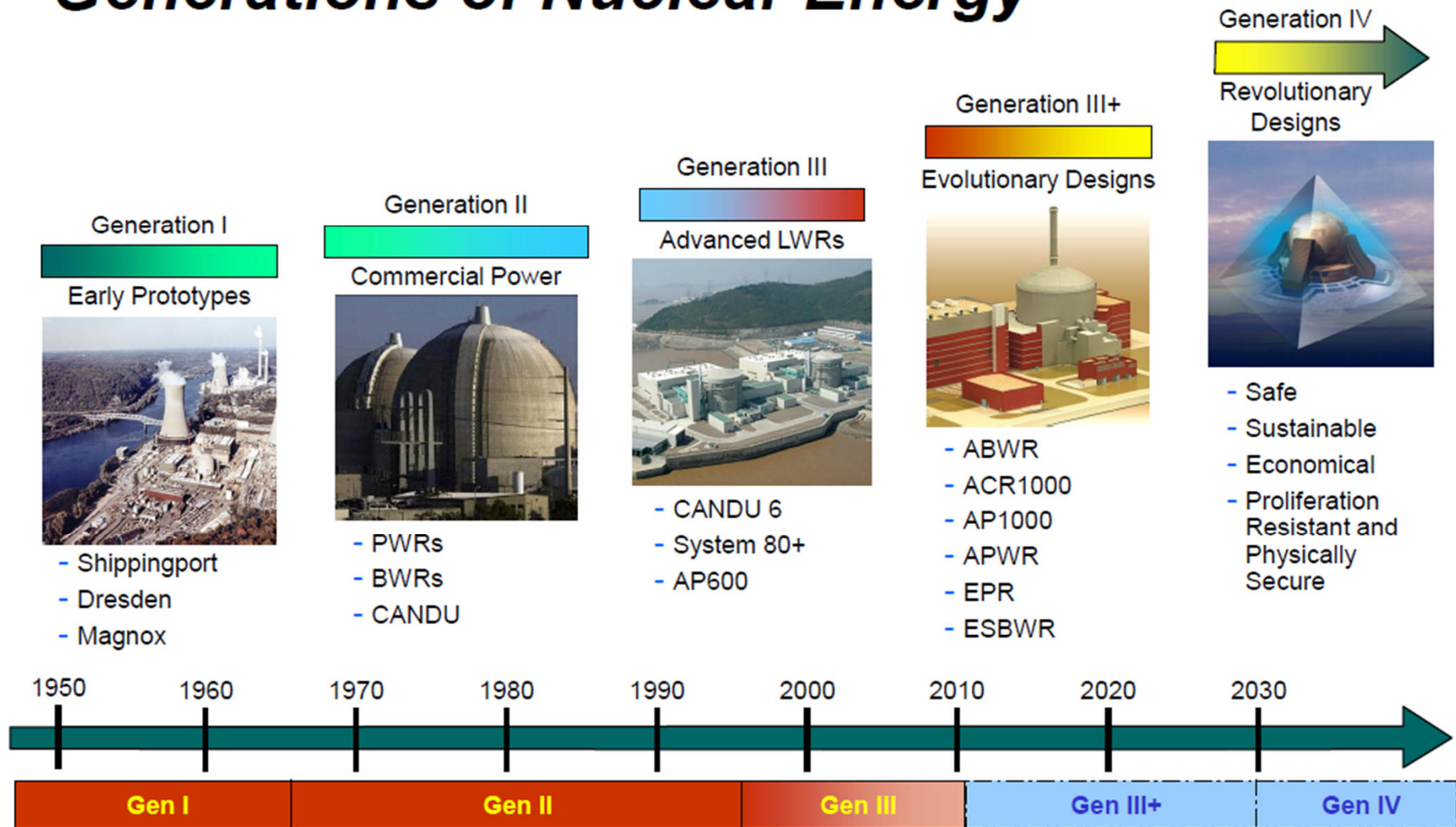


Reactor technology

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# REACTOR GENERATIONS

# Generations of Nuclear Energy

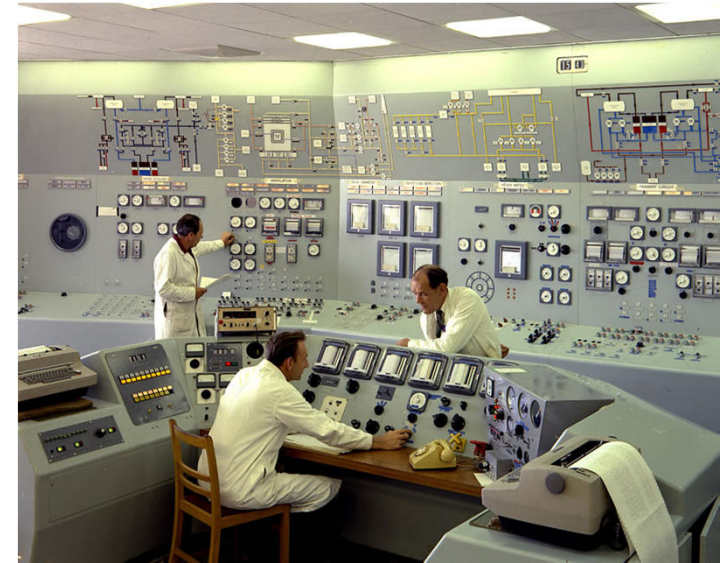


Source: Gen IV Forum

# First generation NPPs

- Prototype reactors of 50s and 60s
- Low unit capacity (<250 MW)
- Small series, rather individual reactors (except Magnox)
- Safety deficiencies (lack of containment, poor emergency cooling etc.)
- Exotic types:
  - FBR – Fermi I
  - GCR – Magnox
  - HWGCR - Monts D'Arree
  - SGHWR – Winfrith

FBR –	Fast Breeder Reactor
GCR –	Gas Cooled Reactor
HWGCR –	heavy water gas cooled reactor
SGHWR –	steam generating HWR



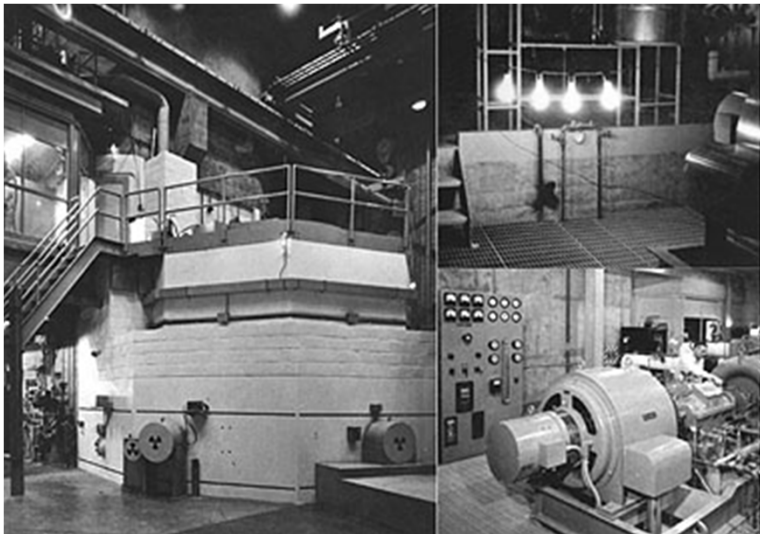
*Control room of Winfrith SGHWR  
(1967-90, 100 MWe)*



*Decommissioning of Winfrith SGHWR*

# First generation NPPs

- **EBR (Experimental Breeder Reactor)**
- Licensed in 1951 – the first electricity generating reactor of the world, but not an NPP
- Fast reactor
- Fuel: uranium enriched to 94%
- Coolant: liquid Na-K



Source: INL

- $P_{th}=1400$  kW,  $P_e=200$  kW.
- Supplied the lighting of a building of National Reactor Testing Station



# First generation NPPs

- 27 July, 1954: **Obninsk NPP** connected to the grid
- Ancestor of later RBMK reactor type
  - Graphite moderated, channel-type, boiling water reactor
- 5 MW  $P_e$
- Shutdown in 2002



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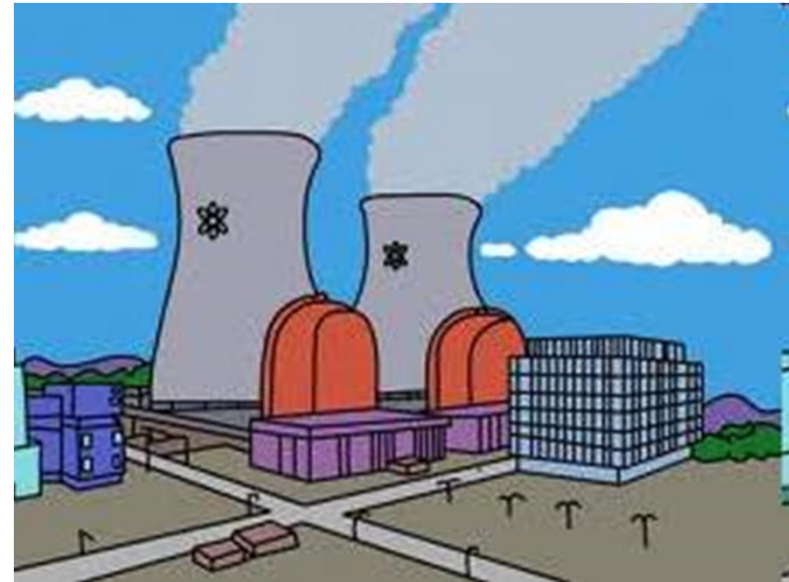


Reactor technology

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# Second generation NPPs

- Most of the operating NPPs
- Commercial types, with large series
- Mainly light water (LWR: BWR/PWR) or heavy water (PHWR) reactor types
- Developed from the operational experiences of first generation reactors (the safe, economical types were kept)
- Same standardization can be observed, but the units have more non-series parameters



LWR – Light Water (cooled and moderated) Reactor  
BWR – Boiling Water Reactor  
PWR – Pressurized Water Reactor  
PHWR – Pressurized Heavy Water Reactor

# A typical Generation II NPP: Paks NPP, VVER-440

- VVER-440/V213
- Paks NPP: 4 Units, with an electric output of 500 MW (per unit)
- Connected to the grid:
  - unit 1: December 28, 1982,
  - unit 2: September 6, 1984,
  - unit 3: September 28, 1986,
  - unit 4: August 16, 1987.

- Originally planned lifetime: 30 years
- Now a lifetime-extension program is in progress (+20 years)

Table 1-1: Main technological parameters of the units

Parameter	Value
Thermal power of reactor	1,485 MW
Primary coolant volume flow rate	42,000 m <sup>3</sup> /h
Primary pressure	123 bar
Primary circuit cold leg temperature	267 °C
Primary circuit hot leg temperature	299.5 °C
Shutdown boric acid concentration	13.5 g/kg
Fresh steam pressure	46 bar
Fresh steam mass flow rate	2,940 t/h
Fresh steam temperature	255 °C

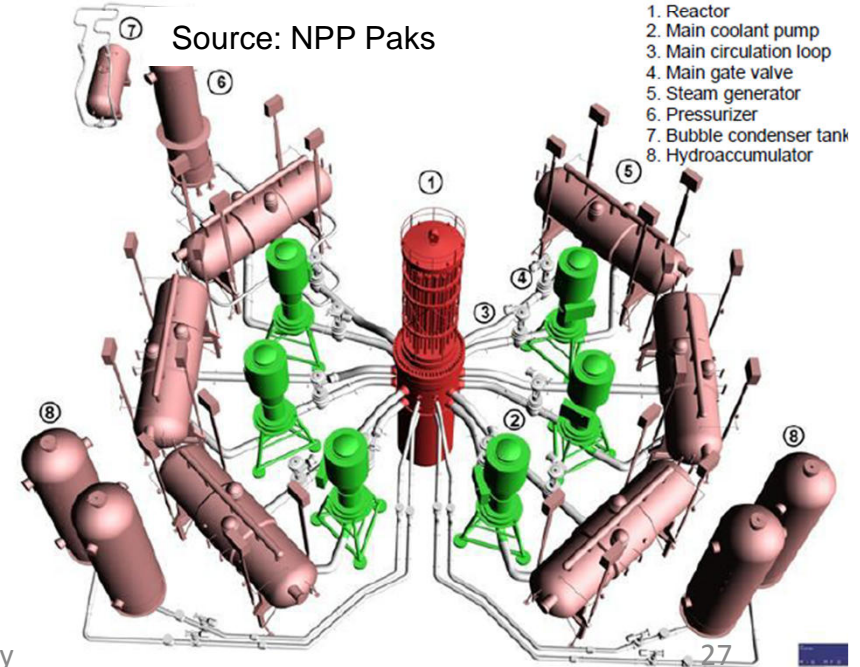
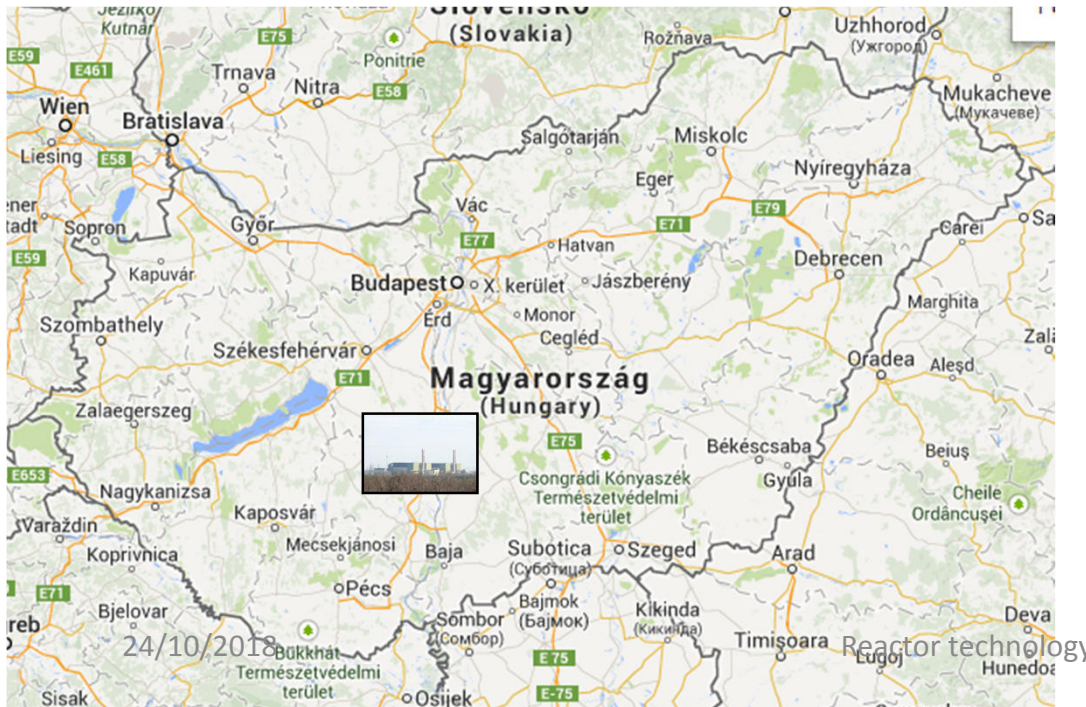
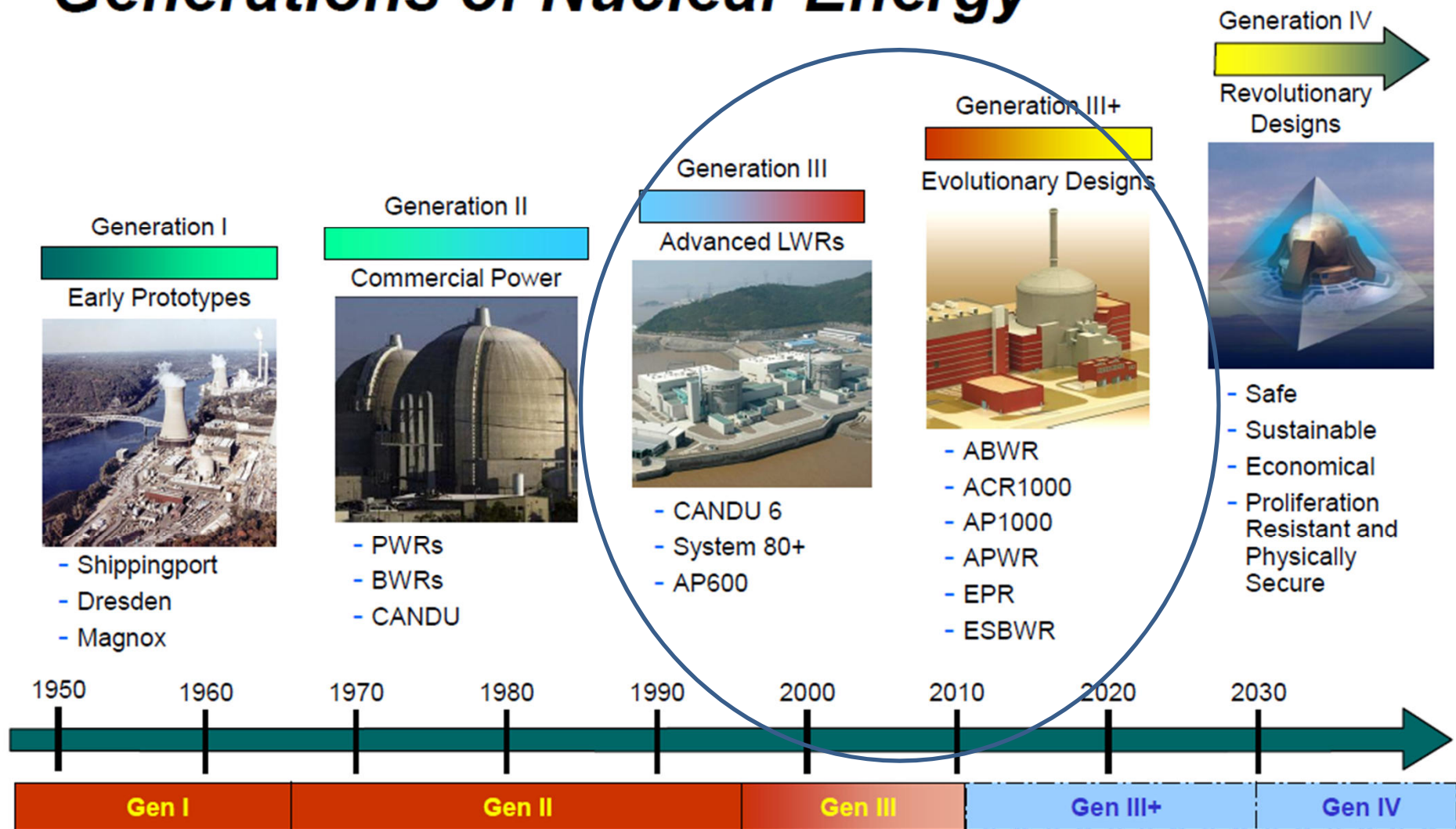


Figure 1-6: Arrangement of main equipment in the primary circuit

# Generation III nuclear plants

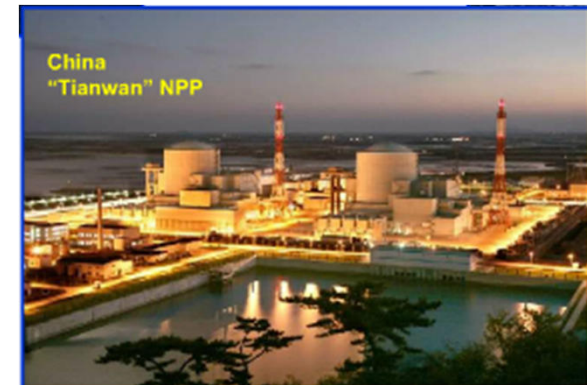
# Generations of Nuclear Energy



Source: Gen IV Forum

# Generation III NPPs

- Advanced reactors, being deployed between 2000 and 2030
- Developed from Gen II designs (evolutionary and innovative types)
- Tendency of development:
  - Economically more competitive types
    - decreasing of construction costs.
    - Simplification, standardization, modular construction, large unit size, shorter construction period, etc.
  - Improvement of safety
    - decreasing the probability and consequences of accidents.
    - Development of active and passive safety systems.
  - Non-proliferation objects
    - with engineering or administrative means
  - Sustainable development



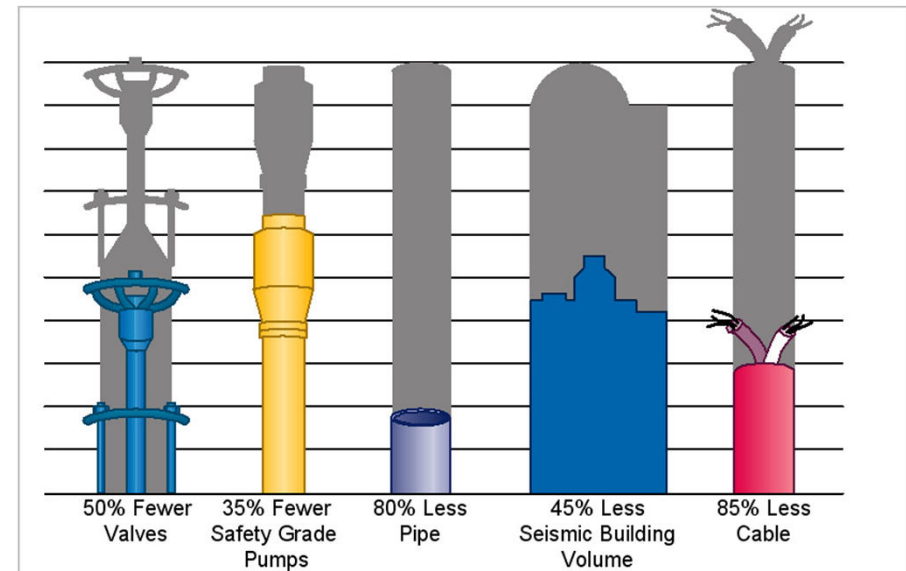
# Generation III NPPs

- **Economic competitiveness**

- At nuclear: the **45-75%** of generating costs are construction costs.
- At coal this ratio is 15-40%.
- Nuclear investments are capital-demanding because of the high construction costs and long construction period
- Investors have to take long rate of return into account
- Costs can be cut back with cogeneration (district heat, hydrogen production, sea water desalination)

Means for competitiveness (examples):

- Unit size increase, construction time decrease
- Standardization, serial products
- More units per sites
- Modularization
- Passive systems
- Reducing the number of components



AP1000 – Source: Westinghouse

# Generation III NPPs

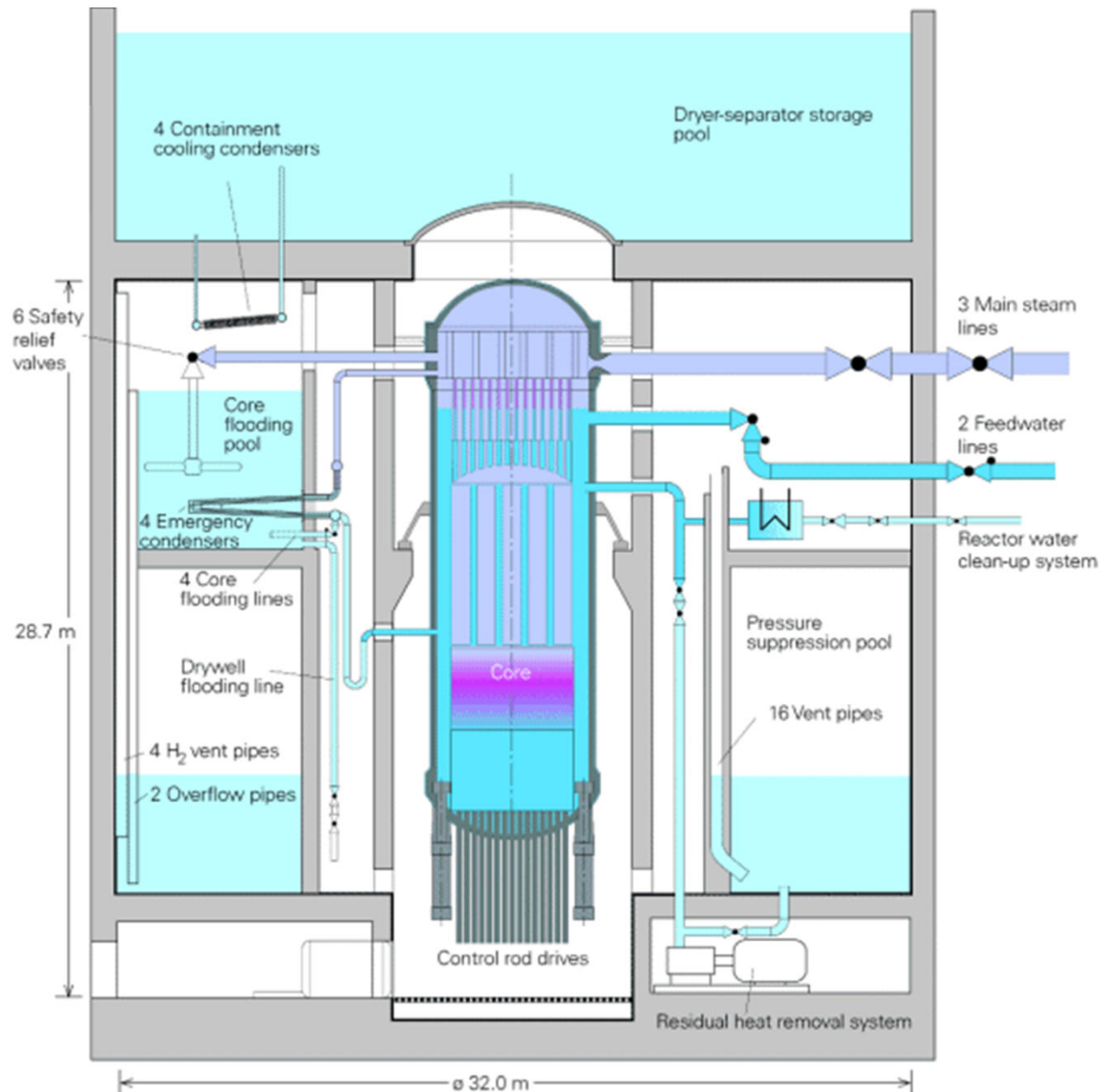
- Safety improvement
  - Objective:
    - **To decrease the probability and consequences of accidents**
    - **To eliminate the possibility of large off-site release (maintaining the hermetic containment)**
  - Means: advanced active and passive safety systems, reducing the **core damage frequency (CDF) and large release frequency (LRF)**
- **Passive safety systems**
  - Based on physical processes, operating without outer action or energy sources
  - Heat removal from primary circuit and containment by processes driven by gravity, natural circulation and compressed (high pressure) gas
  - Heat sink: evaporation pool or air cooling
- Other engineering tools
  - Larger water volumes (pressurizer, steam generator), lower power density, negative reactivity coefficients -> **larger margins and time constraints**
  - **Reliable, redundant and diverse systems** with **physical separation**
  - More robust **containments**, defense against external risks (double wall containment)
  - Management of severe accidents (corium cooling + handling)

IAEA requirements: INSAG-12, 1999:

- For operating plants, the CDF target is  $10^{-4}$  /year. (The probability of considerable off-site release could be reduced by an order with emergency procedures.)
- **For new NPPs the CDF target is  $10^{-5}$  /year**
- For new NPPs only limited consequences are allowed



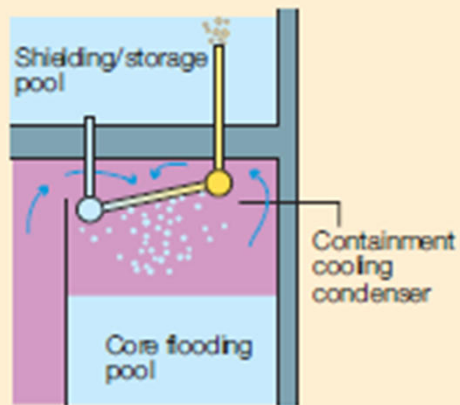
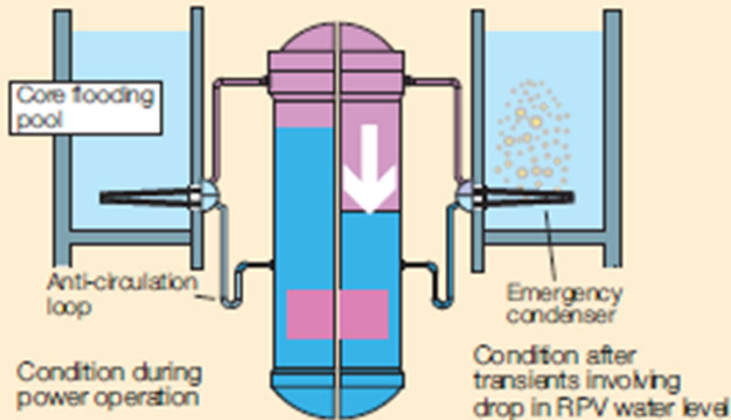
# Passive safety of Generation III



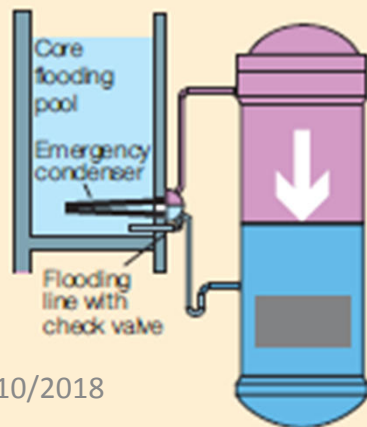
Passive systems of Kerena by Areva (former SWR-1000 of Siemens-Framatome)

# Passive safety of Generation III

- Example: SWR-1000: advanced boiling water reactor
- $P_{el}=1250$  MW
- Passive safety systems
  - Emergency condensers
  - Containment cooling condenser
  - (Core flooding system)



Source: Areva



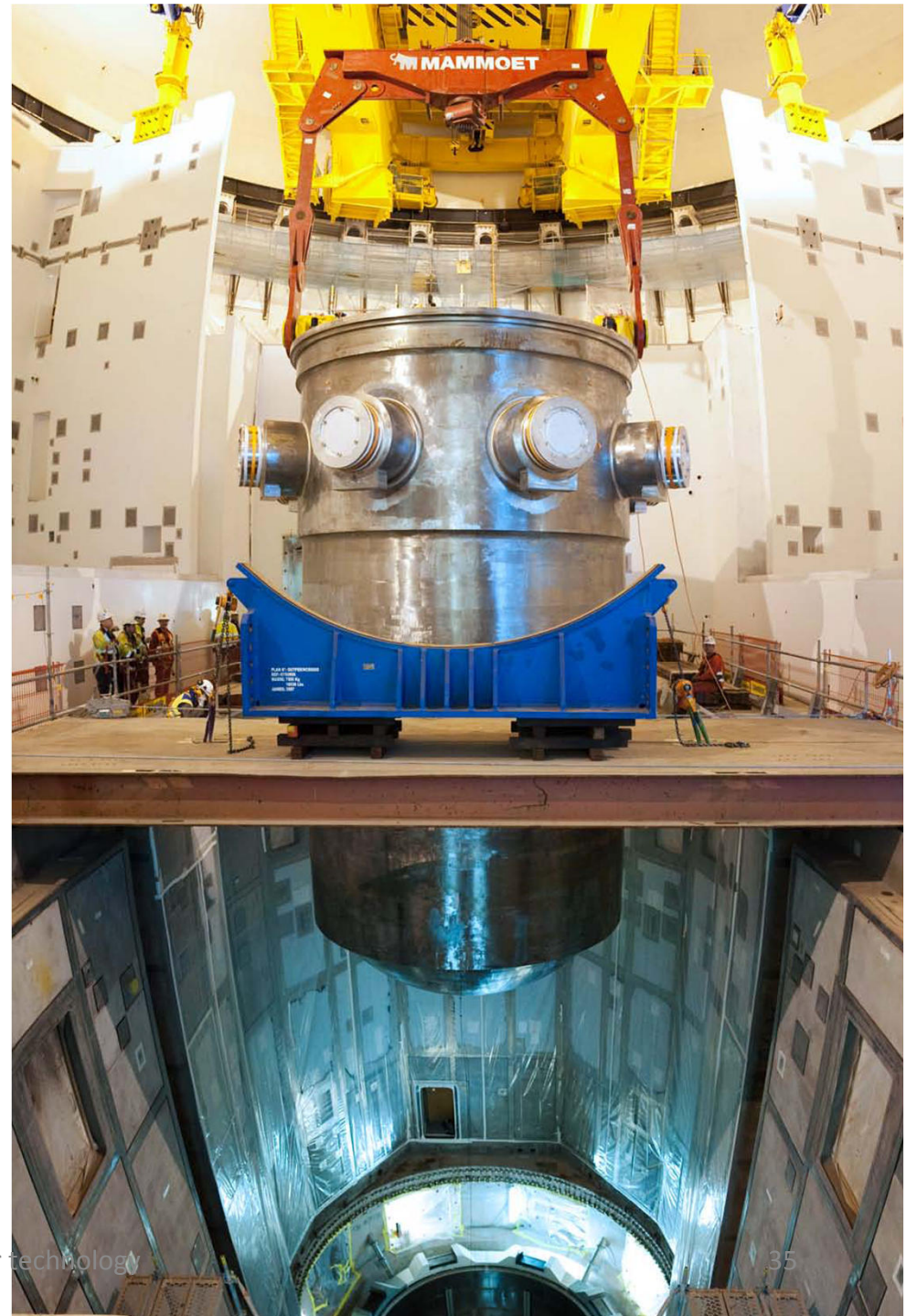
*An example for passive safety systems: the former SWR-1000 of Siemens-Framatome (now Kerena)*

# Generation III at present

- Operating Gen3 units at present:
  - ABWR: 2 units in Japan – temporary shut down
  - APR-1400: Shin Kori 3 (Korea)
  - VVER-1200: Novovoronezh-II-1 (Russia), Leningrad II-1 (Russia)
  - EPR: Taishan
  - AP1000: Sanmen-1, 2, Haiyang-1, 2 (China)
- Under construction:
  - ABWR
    - Taiwan: Lungmen-1, -2
    - Japan: Shimane-3
  - EPR
    - Finland: Olkiluoto-3
    - France: Flamanville-3
    - China: Taishan-1 and -2
  - APR-1400
    - South-Korea: Shin-Kori-4
    - United Arab Emirates
  - AP-1000
    - China: Sanmen-1, 2, Haiyang-1, 2
    - USA: Vogtle-3 and 4, [Virgil C. Summer -2 and -3](#)
  - VVER-1200
    - Russia: LNPP-2, NVNPP-2
    - Belarus: Astravets
  - ACPR1000, Hualong One
    - Yangjiang, Hongyanghe, Tianwan, Fuqing, Fangchenggang

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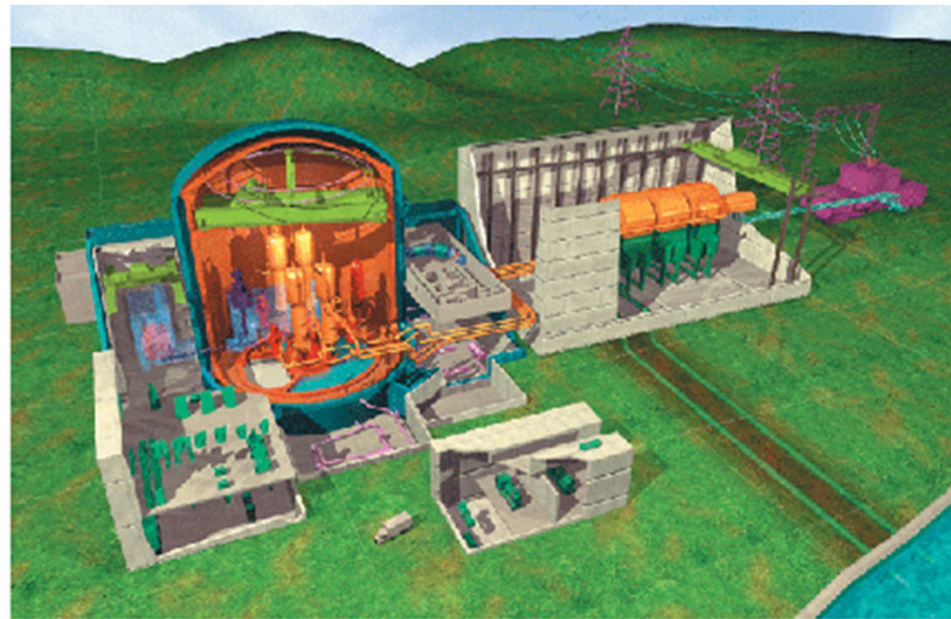
Reactor technology



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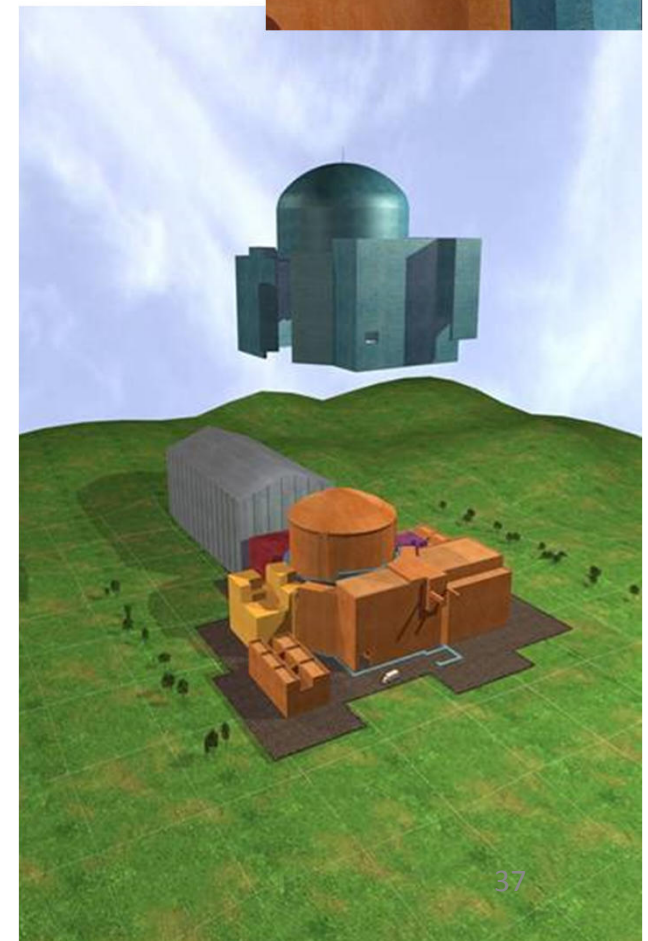
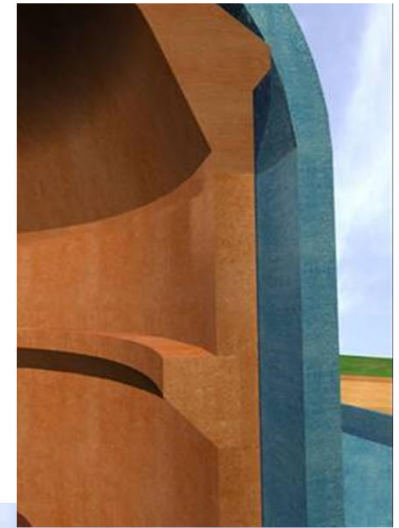
# EPR

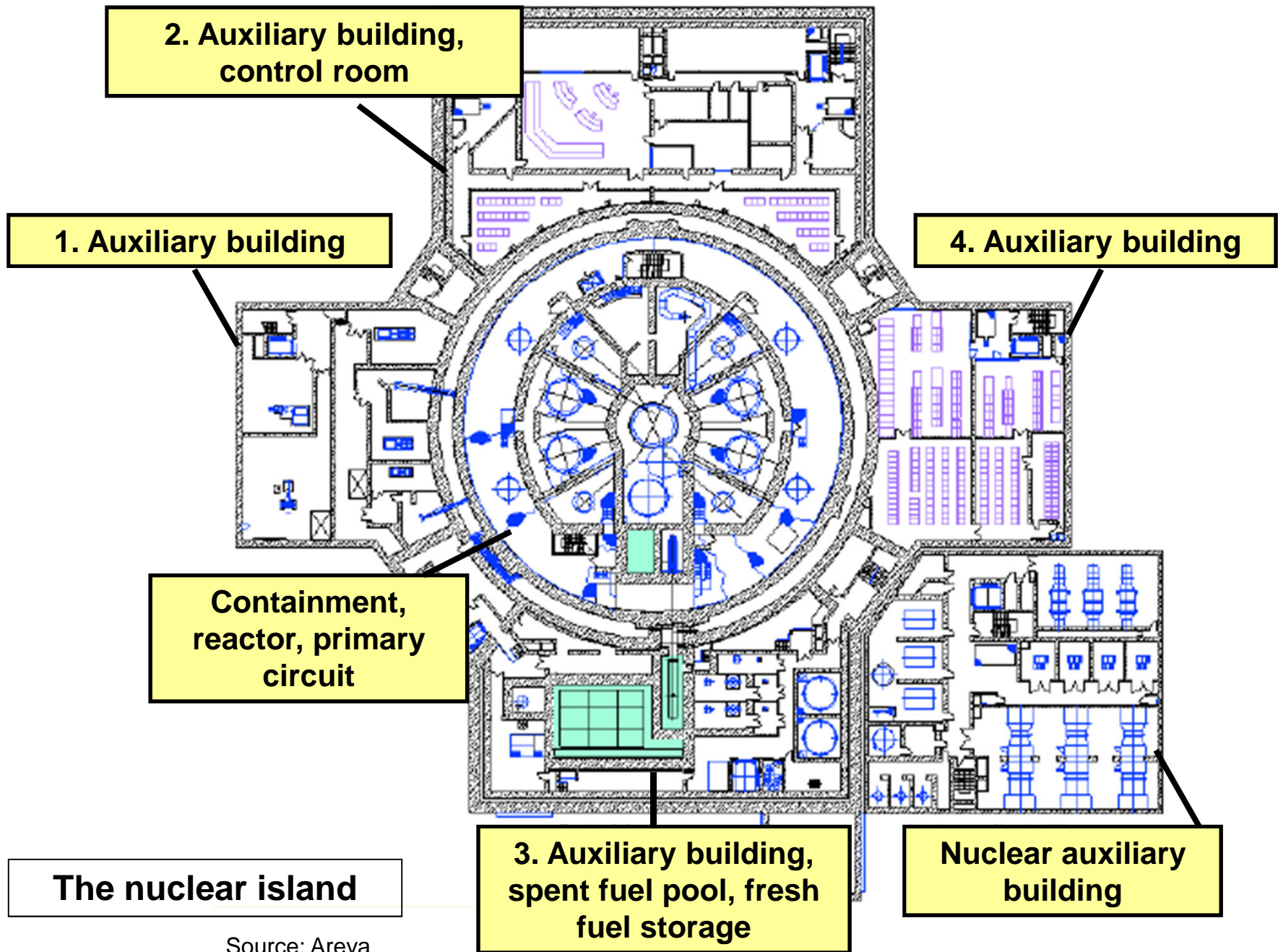
- EPR – European Pressurized Water Reactor
- At the moment:
  - 4 units under construction (2 in China, 1 in Finland, 1 in France)
- Generation III, evolutionary design developed on the basis of the French N4 and the German Konvoi types
- PWR
- Thermal power:  
~4500 MW
- Electric output:  
~1600-1650 MW
- Efficiency:  
36-37% (2nd generation PWRs: ~ 33%)



# EPR

- Primary circuit:
  - Operational pressure: 154 bar
  - Input/output temperature: 296/327 °C
  - 4 primary loops
- Secondary circuit:
  - Operational pressure: 78 bar
  - Fresh steam temperature: 290 °C
  - 1 HP + 3 LP turbine
- Double wall hermetic containment, designed to withstand the crash of a large passenger airplane

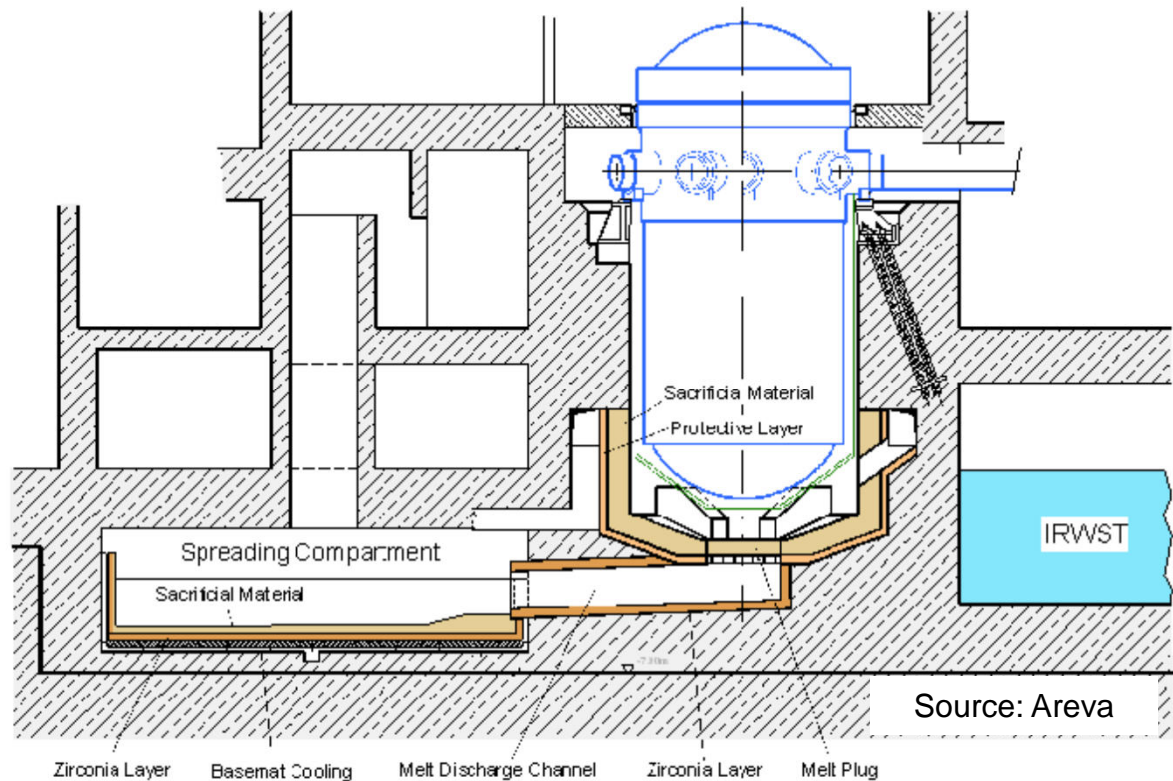




Source: Areva

# EPR safety systems

- Safety philosophy: to prevent off-site consequences with:
  - Improving accident prevention systems.
  - Tools: simplification, physical separation, reducing the possibility of human failure
- Decrease the consequences of severe accidents – tools: containment cooling, corium catching and cooling, cooling of basemat from below
- **CDF:  $10^{-6}$  / year**, frequency of large release is even lower
- 6 m thick concrete basemat
- Double wall containment, the outer wall covers the 2. and 3. auxiliary buildings as well



*Corium spreading area*

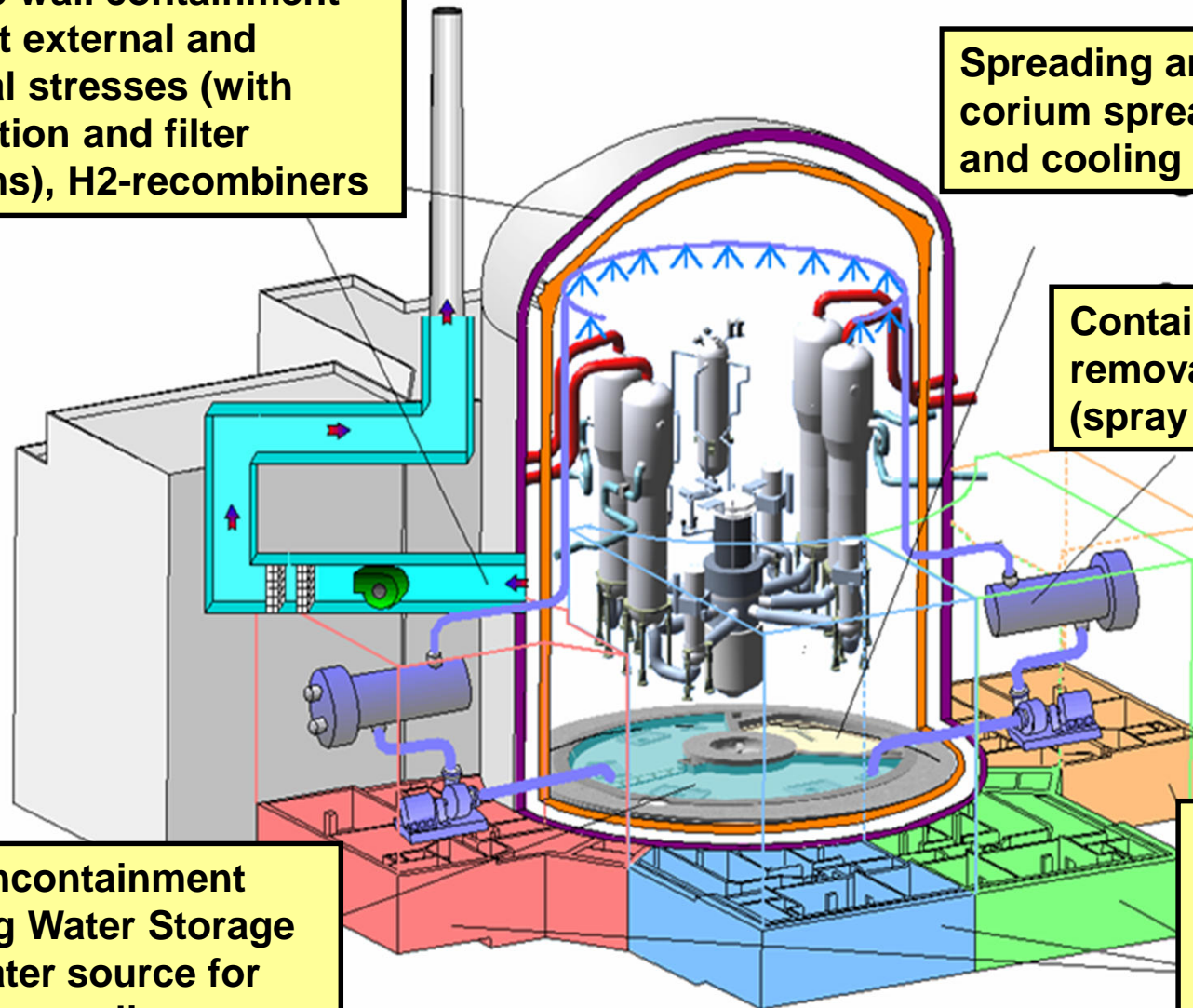
Double wall containment against external and internal stresses (with ventilation and filter systems), H<sub>2</sub>-recombiners

Spreading area for corium spreading and cooling

Containment heat removal system (spray system)

4-fold redundancy at main safety systems, physical separation (E.g. for aircraft-crash or fire)

IRWST (Incontainment Refuelling Water Storage Tank): water source for emergency cooling systems and for corium cooling in severe accidents



Source: Areva  
Reactor technology



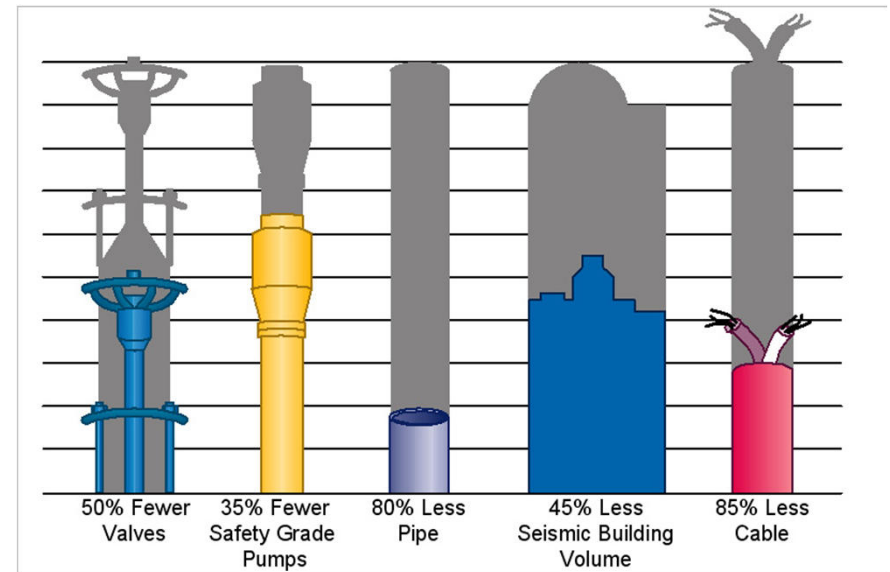
# Olkiluoto-3, the first EPR unit

- December 2003: Owner TVO selected the AREVA EPR™ design to be built at Olkiluoto
  - Turn-key contract: **3.2 billion** euro
- Original plan: start of construction in 2004, start of commercial operation in **2009** (5 years construction time).
  - July 2005: Start of construction, first concrete pouring
  - June 2010: Installation of the reactor pressure vessel in the reactor building
  - November 2011: Installation of heavy components of the primary cooling system complete
- Now: start of commercial operation in ~~2015 or 2016~~ **2018**, costs **~8 billion** euro
- Various problems including project-coordination, dialogue with authority, quality problems



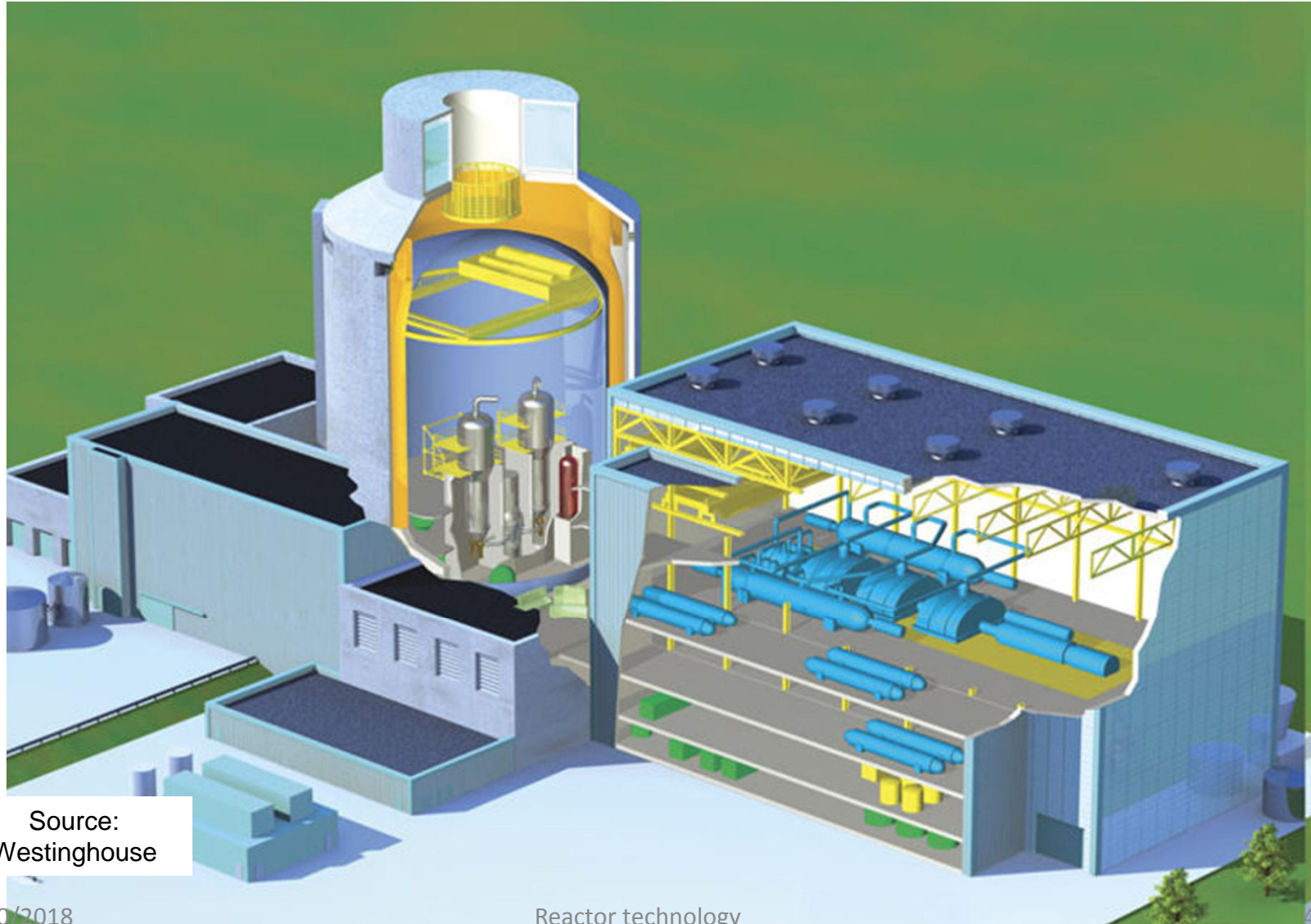
# AP1000

- AP1000 – Advanced Passive Plant, Westinghouse
- Under construction:
  - 2 Units at Sanmen NPP, China (February 2008)
  - 2 Units at Haiyang NPP, China (July 2008)
  - 2 Units at Vogtle NPP, USA (February 2012)
  - 2 Units at Virgil C Summer (March 2012)
- PWR with two loops
- Electric output: 1117 MWe
- Passive safety systems
  - Simplified systems with less component than present PWRs
- NRC design certification in 2005
- **CDF=5,09x10<sup>-7</sup> / year** according the PSA analysis
- Modular construction (transport by rail or by ship)
- Planned construction time: 36 months (☺)
- 18 month campaign
- 60 years planned lifetime



AP1000 – Source:  
Westinghouse

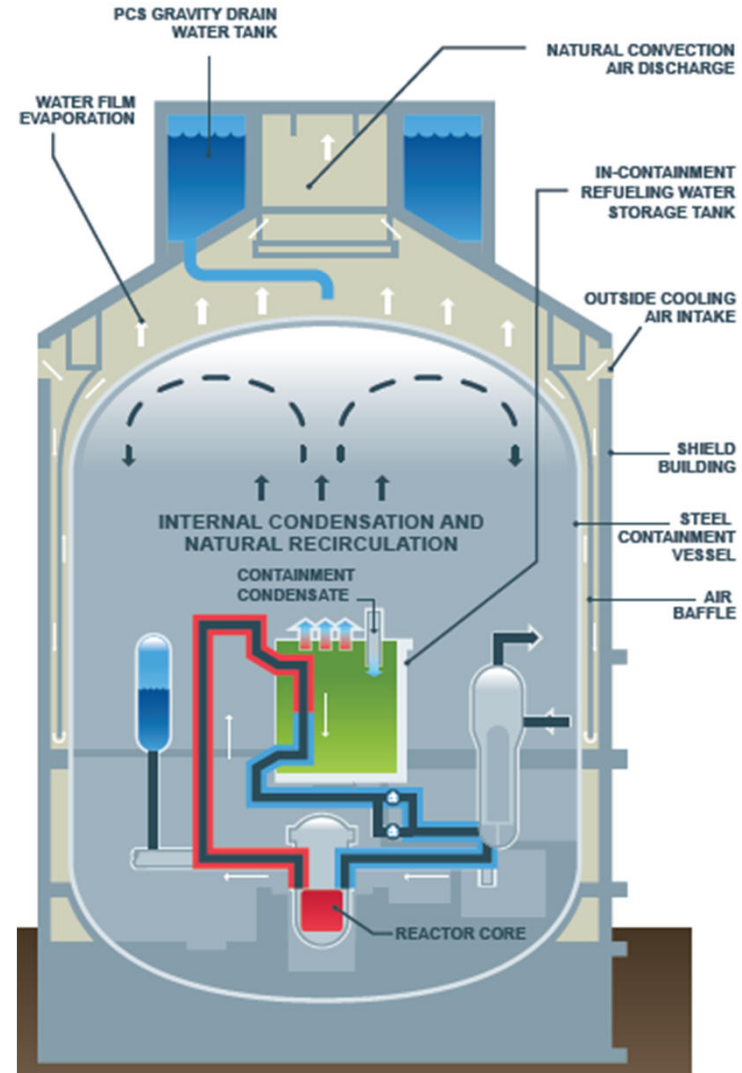
# AP1000



Source:  
Westinghouse

# AP1000

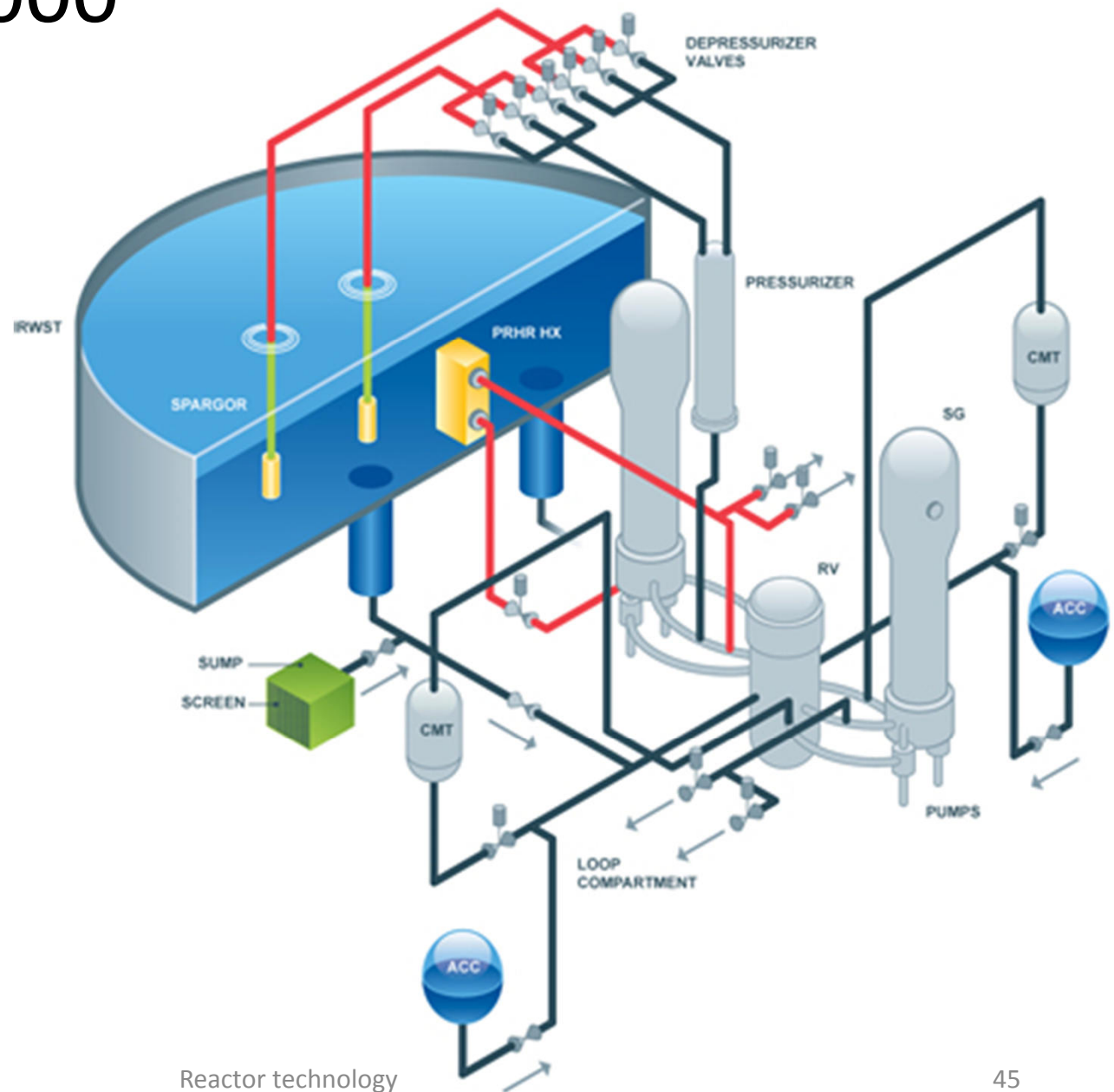
- **Passive safety systems:** no operator action is necessary in the first 72 hours of a DBA (including SBO)
- Passive core cooling system for LOCA, remanent heat removal, automatic depressurization and coolant injection
- **Passive Containment Cooling System**
- Main control room emergency habitability system – for 11 people for 72 hours
- Containment isolation – 60% less penetration



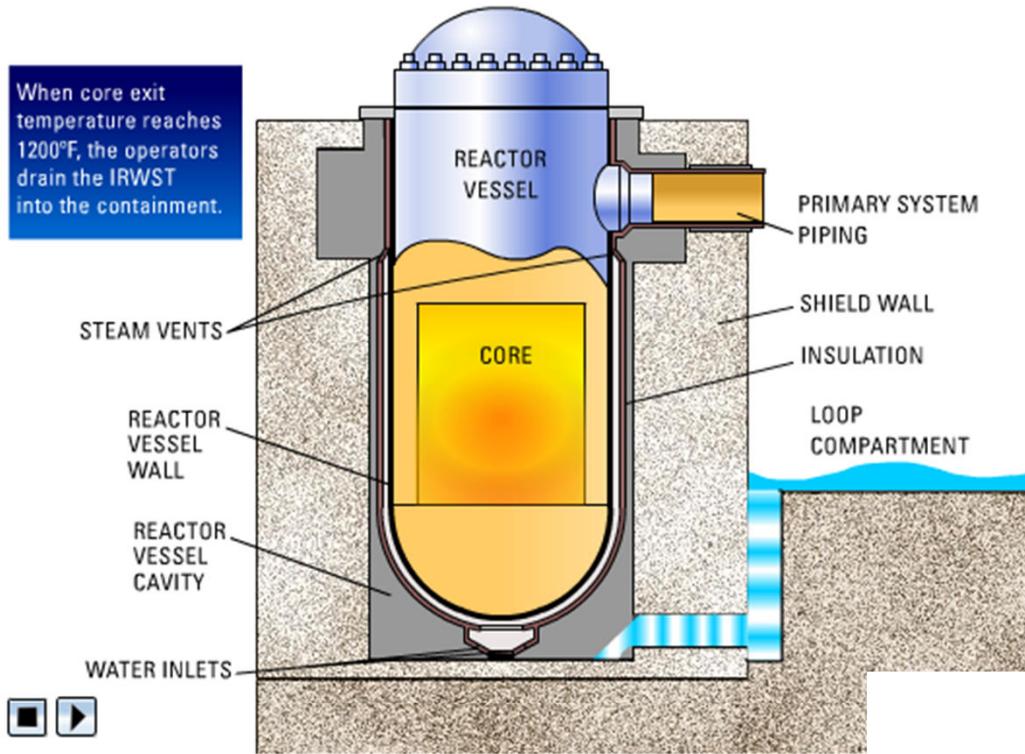
Source:  
Westinghouse

# AP1000

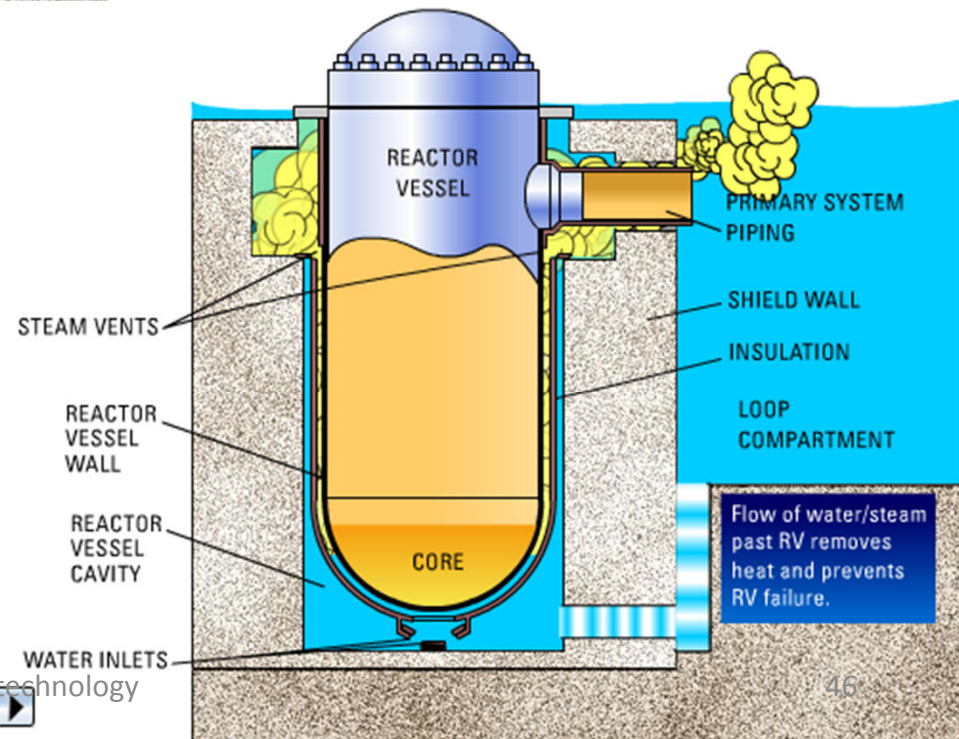
- Passive safety systems



# AP1000 pressure vessel outer flooding



- Severe accident management: preventing RPV failure in case of core melting (outer RPV flooding system)

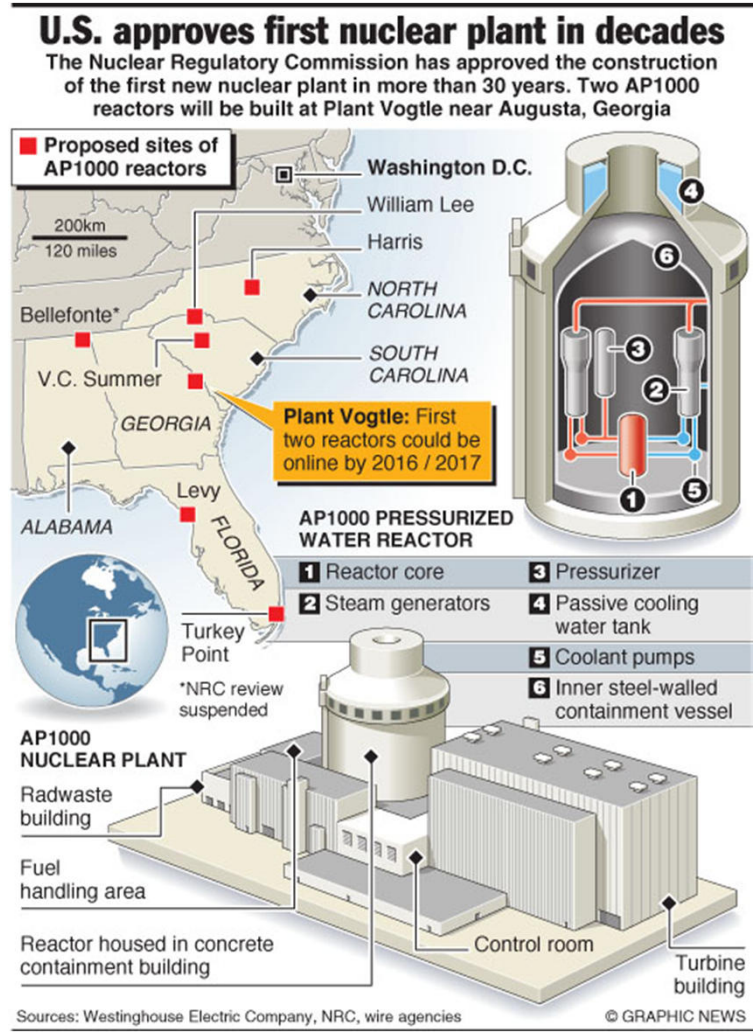


# AP1000 - Vogtle

- USA: last construction license was issued in 1978
- New licensing system (separated design assessment and site permit, combined construction and operation license) no combined license issued until 2012
- February 2012: NRC issued combined license for Southern Company for the construction of two AP1000 units at the Vogtle site, where 2 PWR units are operating (votes 4:1)
- According to the schedule, the new units could start in ~~2016-2017-2017-2018~~ 2019-2020

**Original**  
 Cost: 4.8 bn \$  
 Completion 2016/2017

**Revised**  
 Cost: 5.045 bn \$  
 Completion 2019/2020

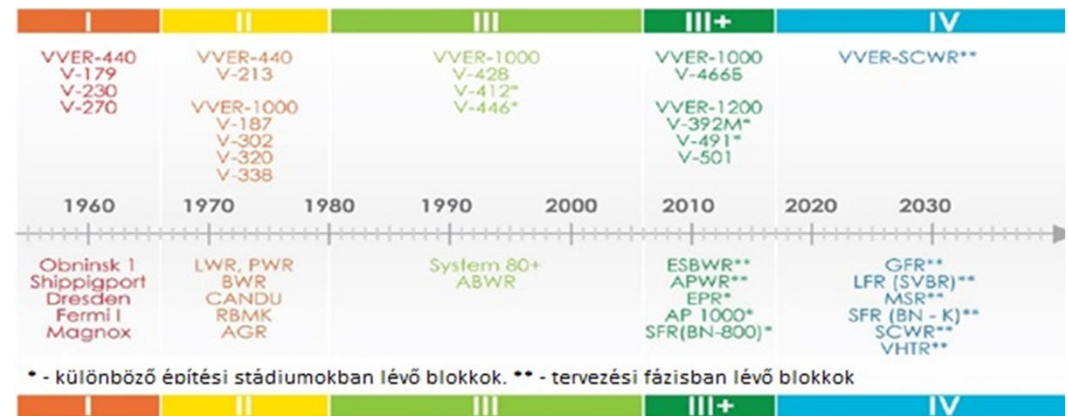


# VVER-1200

- Hidropress
- PWR
- Based on VVER-1000 (AES-91 and AES-92) models
  - AES-91: Tianwan
  - AES-92: Kudankulam
- Generation III+
- Nominal gross power: 1200 MW
- 60 years lifetime for the main equipment
- Load following capability
- **CDF < 6x10<sup>-7</sup> /reactor.year**
- LRF (Large release frequency) < 10<sup>-7</sup> /reactor.year



Kudankulam NPP

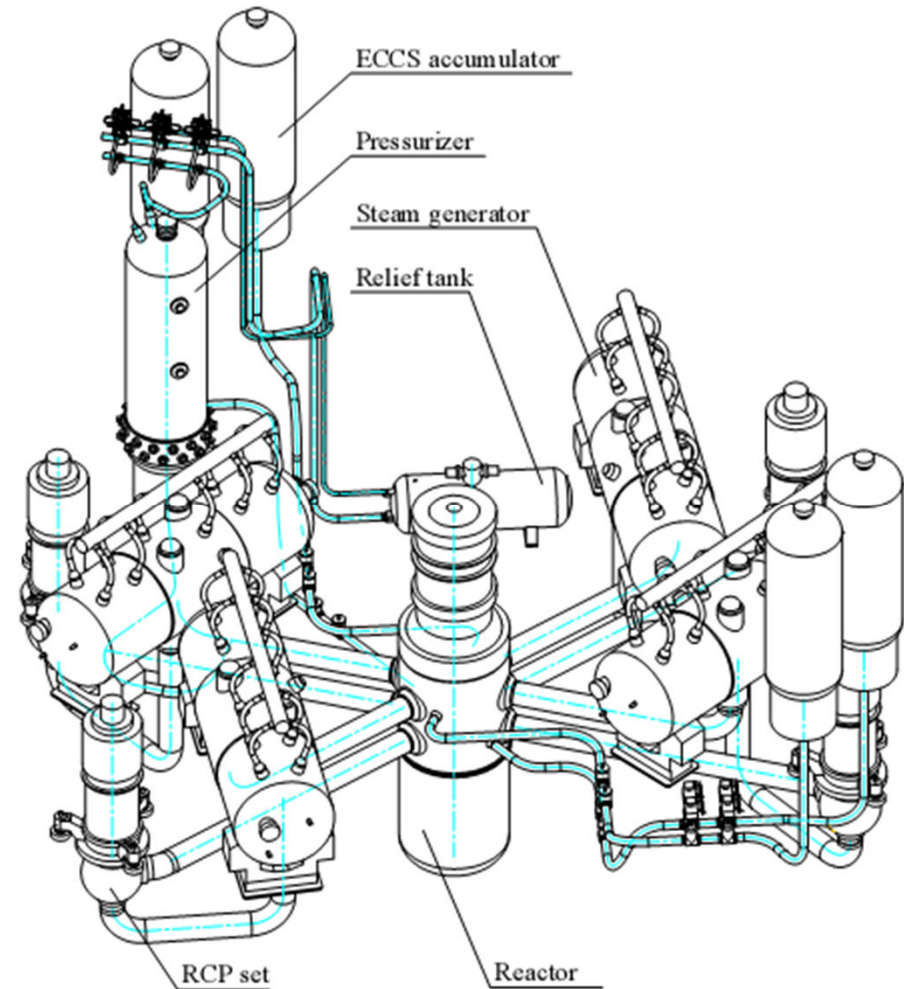




# VVER-1200 (AES 2006)

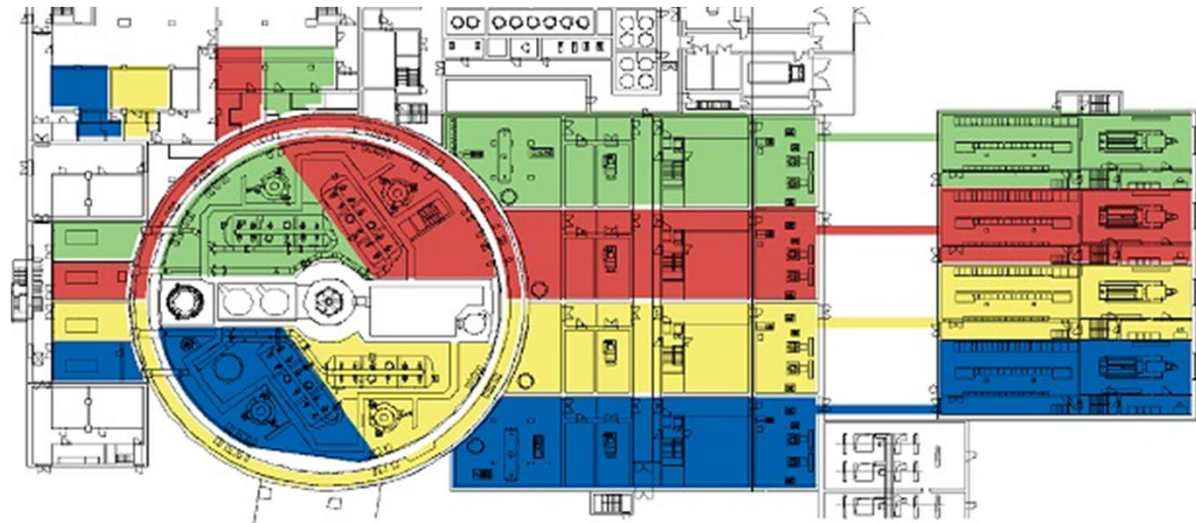
- Models (same parameters, different safety solutions):
  - **V392M** – developed by the Moscow design institute (in operation and under construction in Novovoronezh)
  - **V491** – developed by the St. Petersburg design institute (under construction in the Leningrad-II NPP, in Belarus NPP, in Baltic NPP), planned at Paks NPP

<u>Operational parameters</u>	
Efficiency	33,9%
Pressure of primary circuit	162 bar
Temperature of primary coolant	298-328 °C
Steam pressure	68 bar
Steam temperature	283 °C
Initial enrichment	4,79%
Burnable poison	Gd2O3



# VVER-1200 V491 safety systems

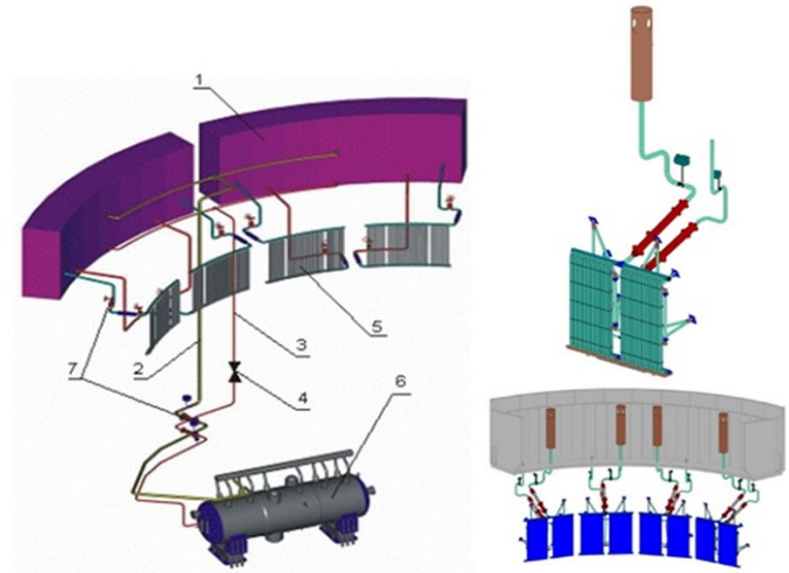
- Application of European Utility Requirements and safety philosophy (DBC, DEC conditions)
- Designed to resist external hazards (e.g. wind, tornado, snow pressure, seismic effects – 0.25 g maximal PGA)
- Active systems: 4x100% redundancy, physical separation
- Passive safety systems



Four branches of the active safety systems

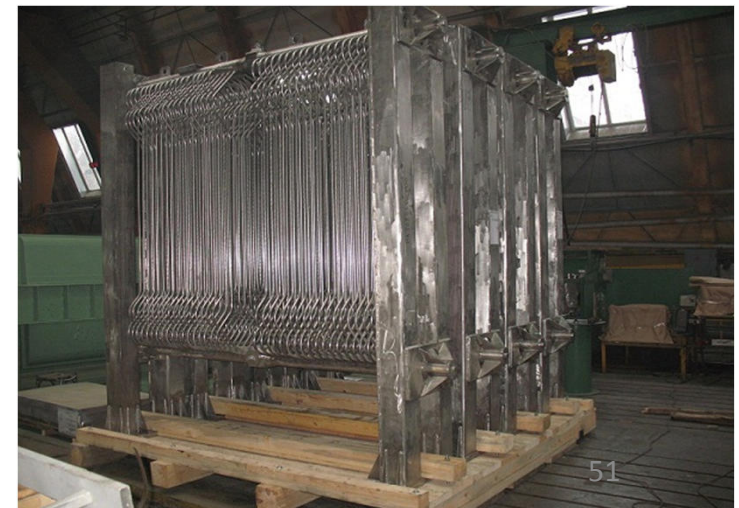
# VVER-1200 V491 safety systems

- Active safety systems (ECCS, CS, emergency boron injection system, residual heat removal system, emergency feedwater system, etc.)
- Localization systems
  - Double wall cylindrical containment made of prestressed concrete,
  - Steel cladding (liner) on the inner surface of the internal wall
  - Leakage rate: 0.2% for 24 hours
  - $P_d$ : 5 bar  $T_d$ : 150 °C
- Passive systems (BDBA)
  - Hydroaccumulator (59 bar)
  - Passive containment heat removal
  - Passive SG cooling
    - Experimental and numerical tests
  - Passive autocatalytic H-recombiners (1000 kg H<sub>2</sub>)



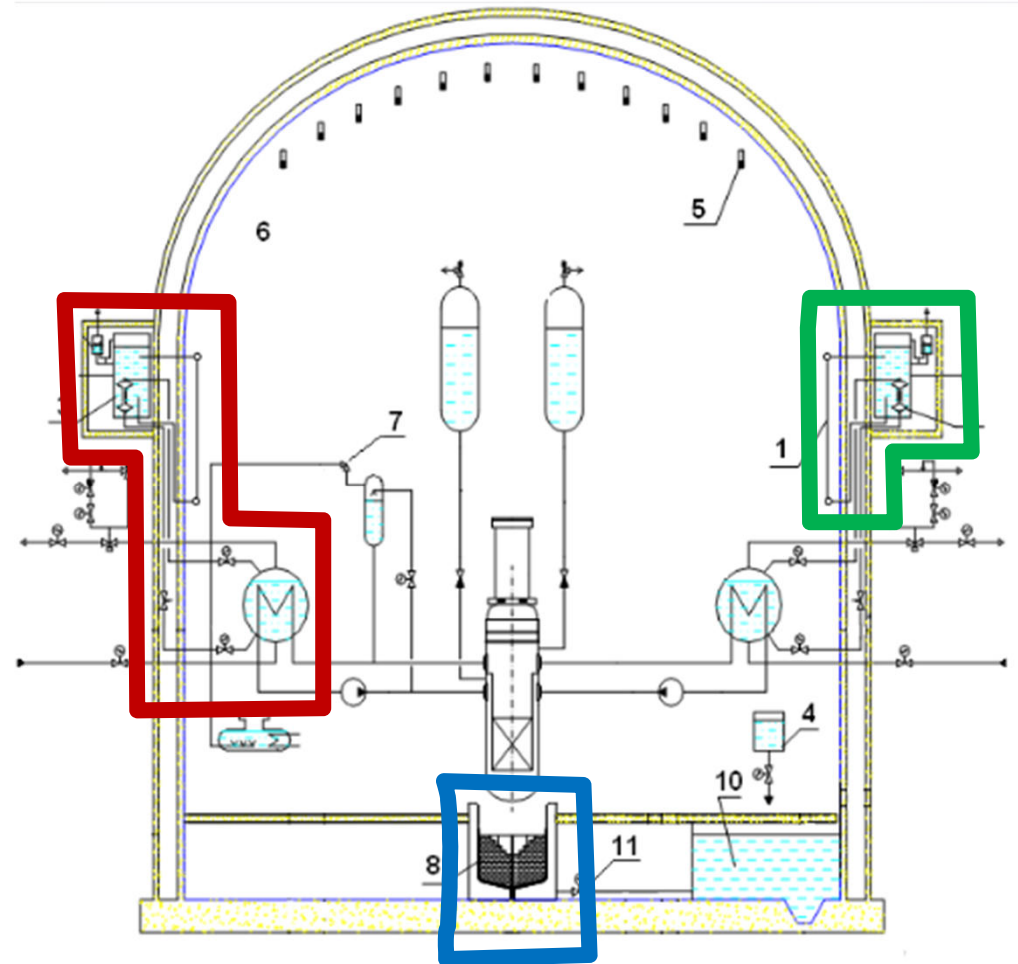
Passive SG cooling system

Heat exchanger of PHRS-SG



# VVER-1200 / V491

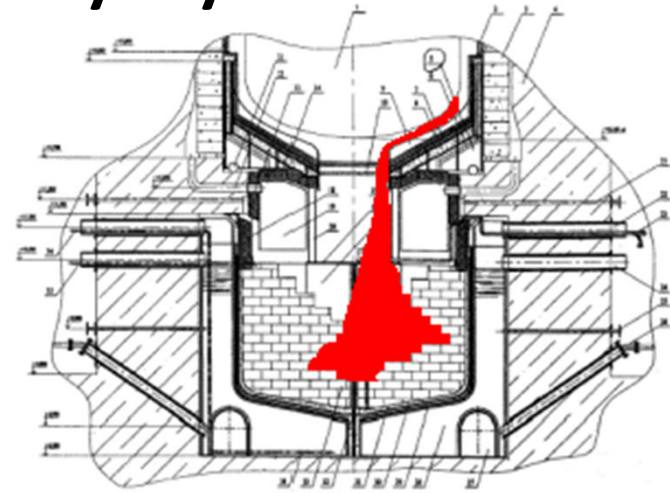
- 1- passive containment cooling system
- 2- passive heat removal system (PHRS SG)
- 3- PHRS tank
- 4- emergency chemical addition
- 5- hydrogen recombiner
- 6- hydrogen monitoring transmitter
- 7- pressurizer safety valve
- 8- core catcher
- 9- SPF water supply
- 10- borated water tank
- 11- core catcher closing valve



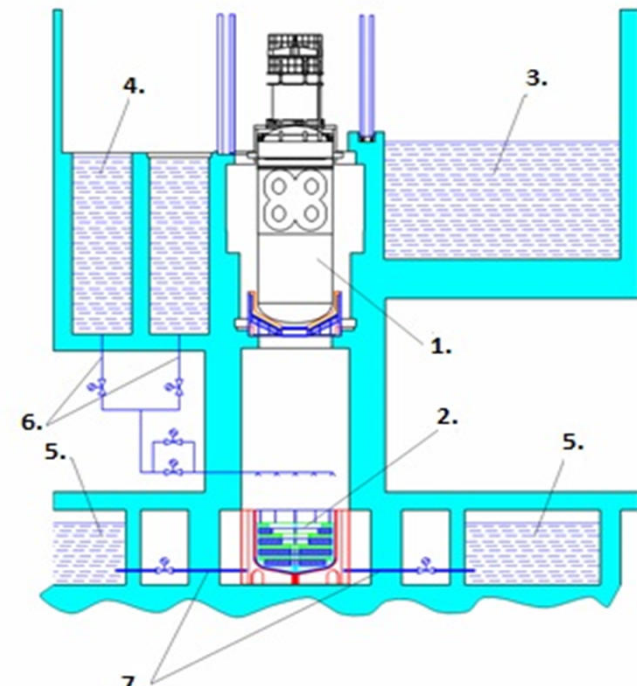
Source: Atomstroyeksport

# VVER-1200 V491 safety systems

- Severe accident management: core catcher – introduced in Tianwan NPP
  - Large size core catcher to minimize the corium thickness
  - Preventing re-criticality
  - Outer cooling with natural circulation (passive)
  - Corium can be flooded
  - Because of the thick corium layer, 1 year is necessary for full solidification
- Mass: 150 t, height: 6 m
- Al<sub>2</sub>O<sub>3</sub>-Fe<sub>2</sub>O<sub>3</sub> mixture as sacrificial material (200 t)
- Double wall core catcher



VVER core catcher



# VVER-1200 V491 safety systems

- Core catcher



Installation of the core catcher at the Leningrad-II NPP (unit 1)

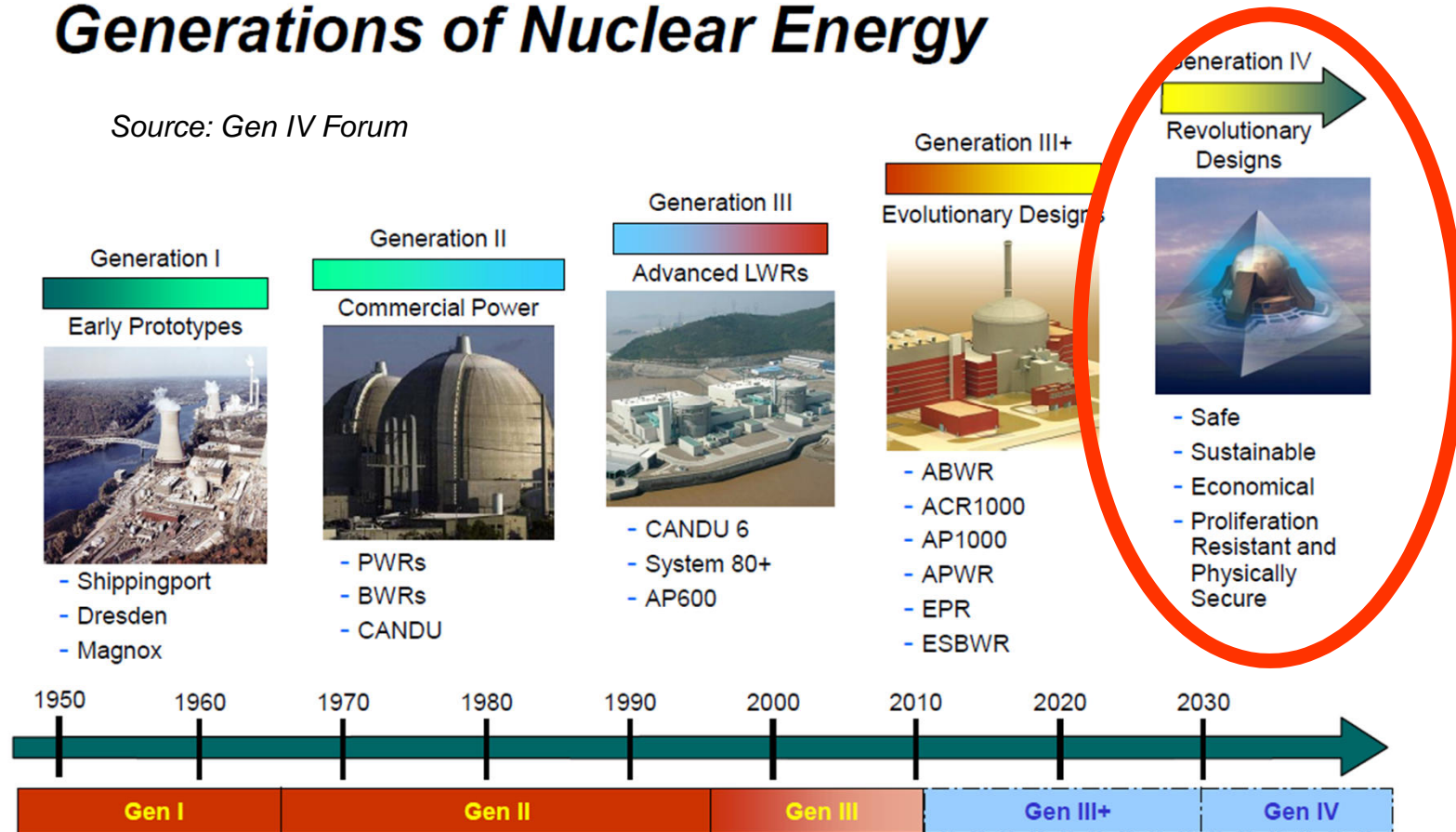


Sacrificial material of the core catcher

# Generation IV reactors

## Generations of Nuclear Energy

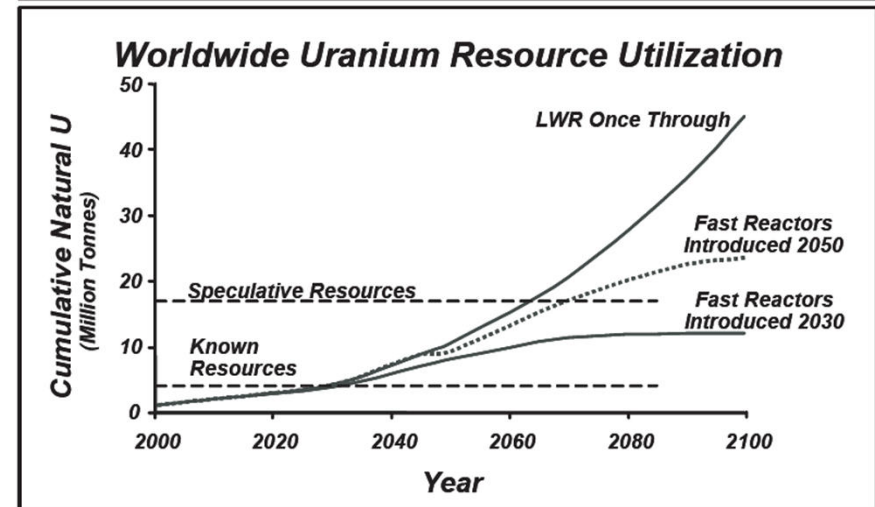
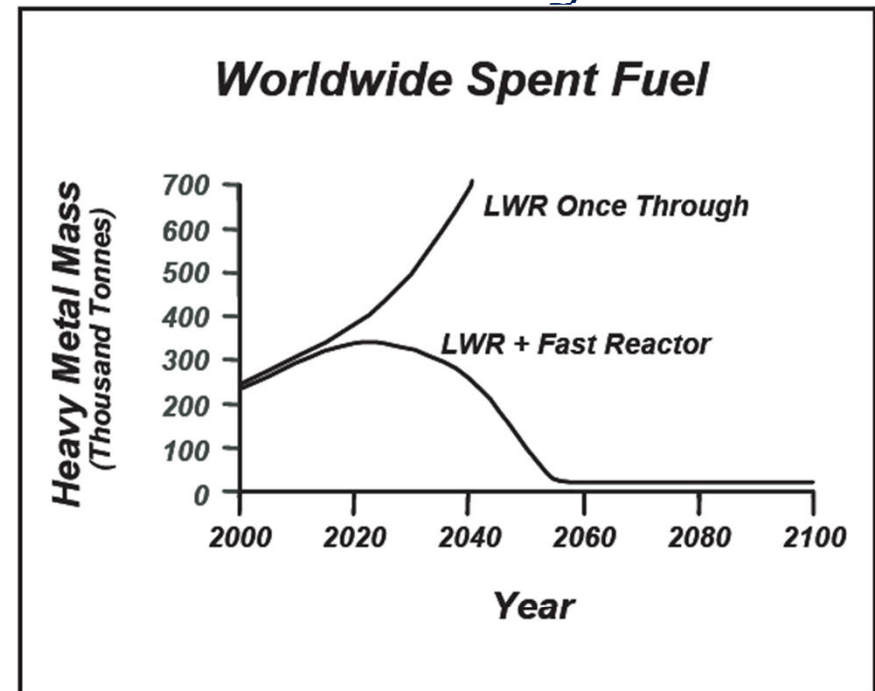
Source: Gen IV Forum



- Generation IV: reactor designs to be deployed from 2030
- Designs developed based on all operational and safety experiences
- Main goal is to ensure the sustainable electricity generation (coupled heat and electricity generation, hydrogen production, seawater desalination)

# Fuel cycle and sustainability

- Expectations for open fuel cycle (with the present electricity generation)
  - Largest amount of waste – but still less than in case of other energy sources
  - Amount of waste is limiting the use of nuclear energy: many final disposals are necessary in the next decades
  - Most unfavorable utilization of the resources: the known resources will be depleted before the end of the century

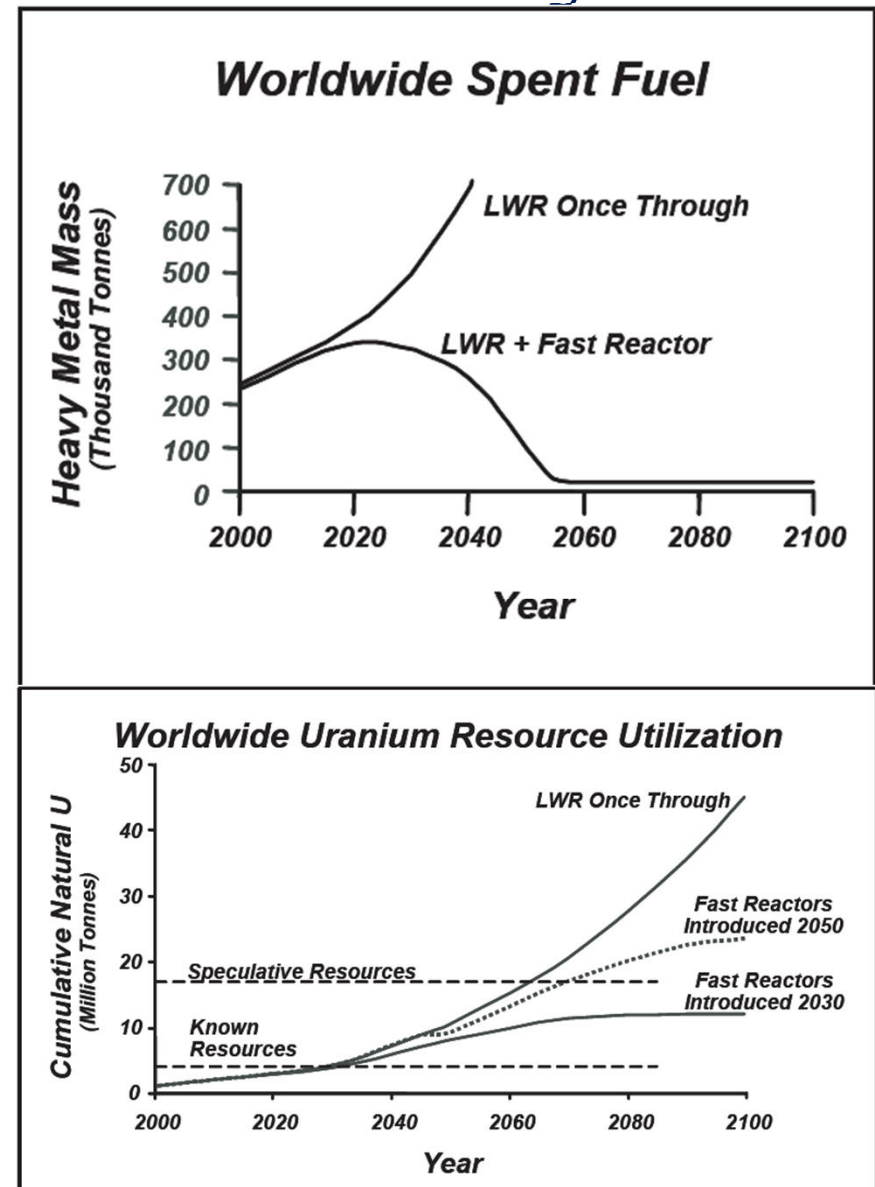


Effect of fast reactor introduction on the fuel utilization  
Source: GenIV



# Fuel cycle and sustainability

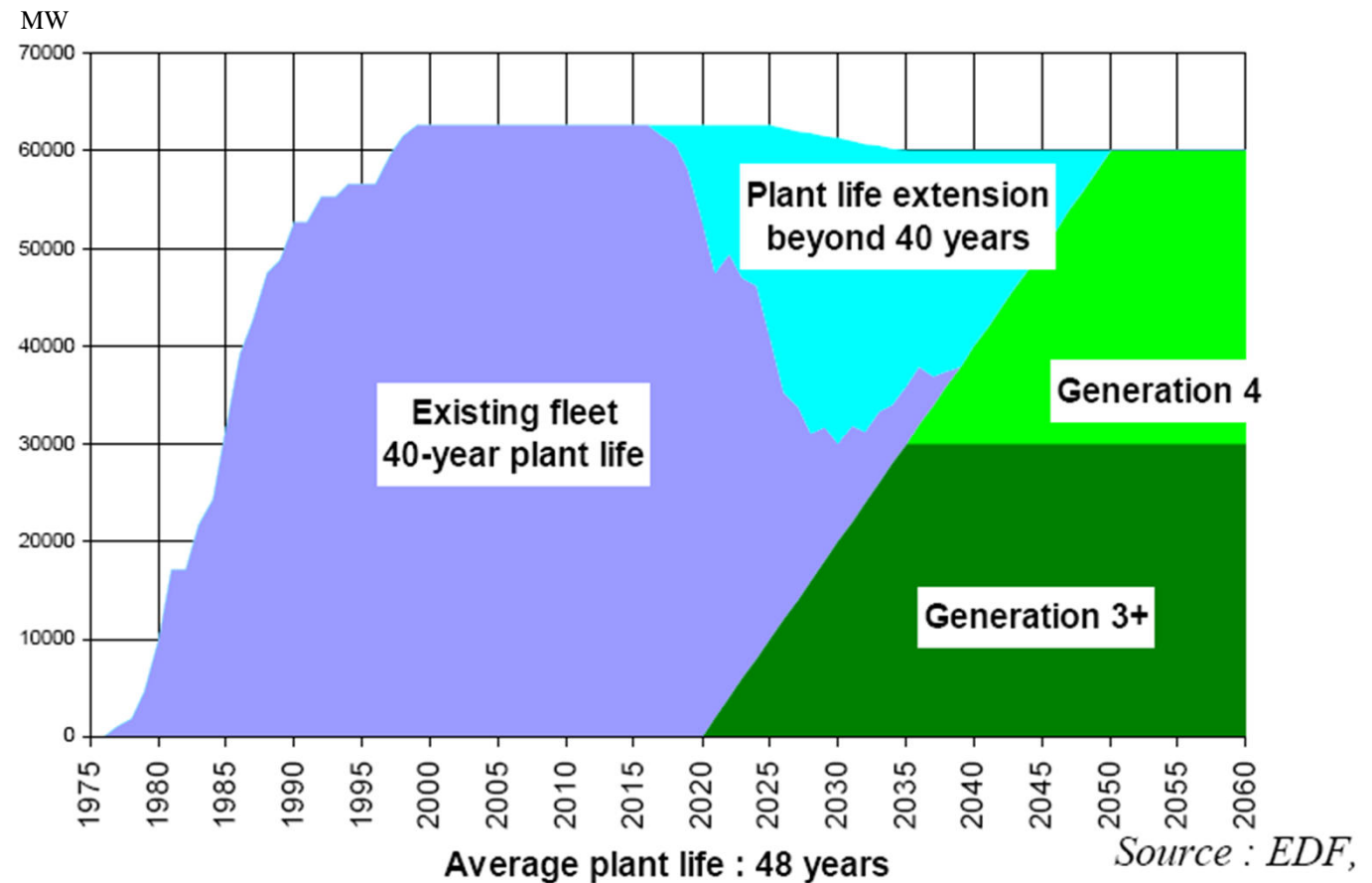
- Expectations for **closed fuel cycle** (with the present electricity generation)
  - Amount of waste can be decreased significantly
  - With the use of transmutation facilities, waste amount can be decreased by an order of magnitude
  - Different waste fractions could be managed separately
  - Problems:
    - Cost reduction
    - Proliferation risks



Effect of fast reactor introduction on the fuel utilization  
Source: GenIV

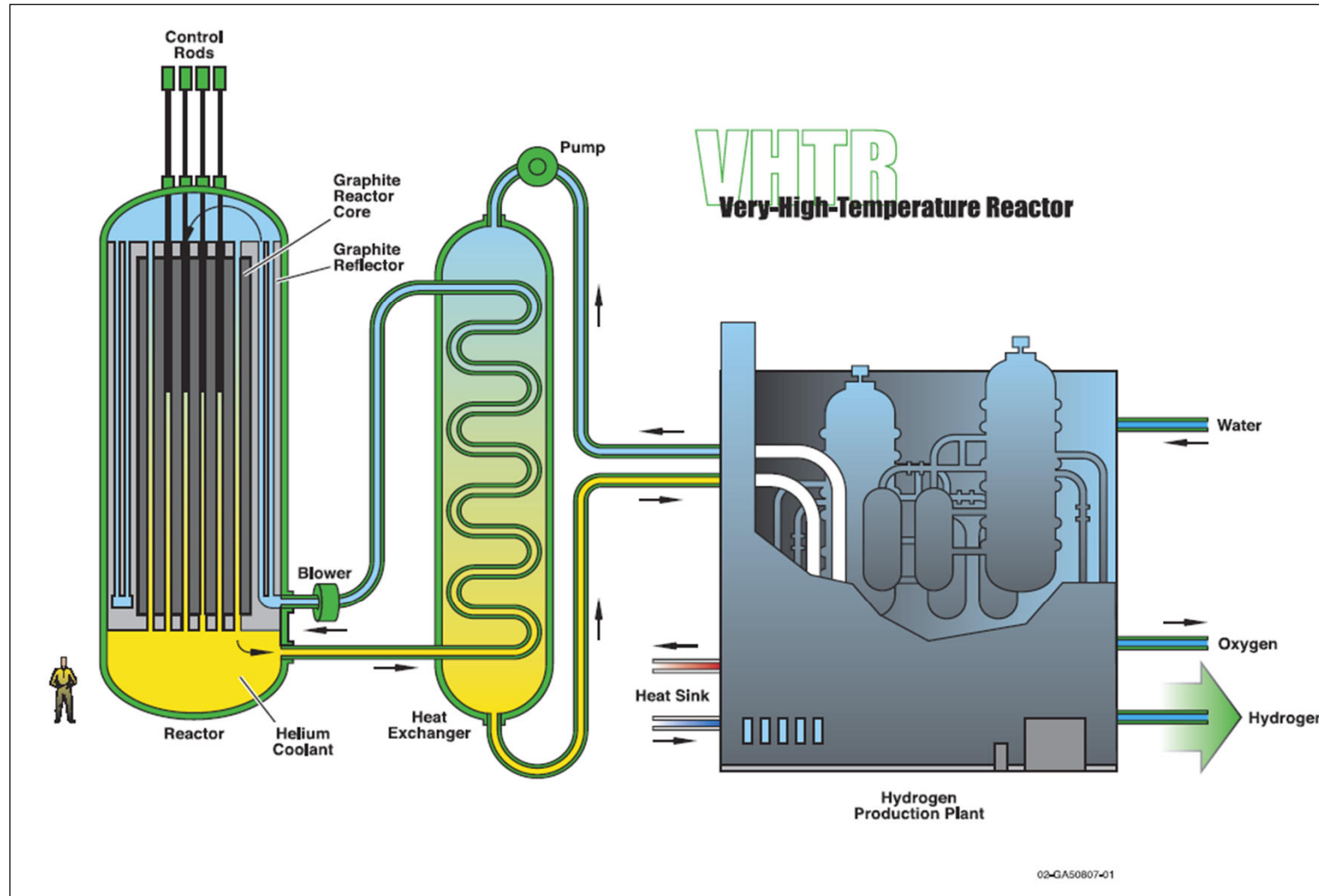
# Transition from Gen III to Gen IV

- Present: operating Generation II reactors with lifetime extension
- Generation III/III+: for replacement of the existing fleet around 2020
- Generation IV: deployment in 2030-2035



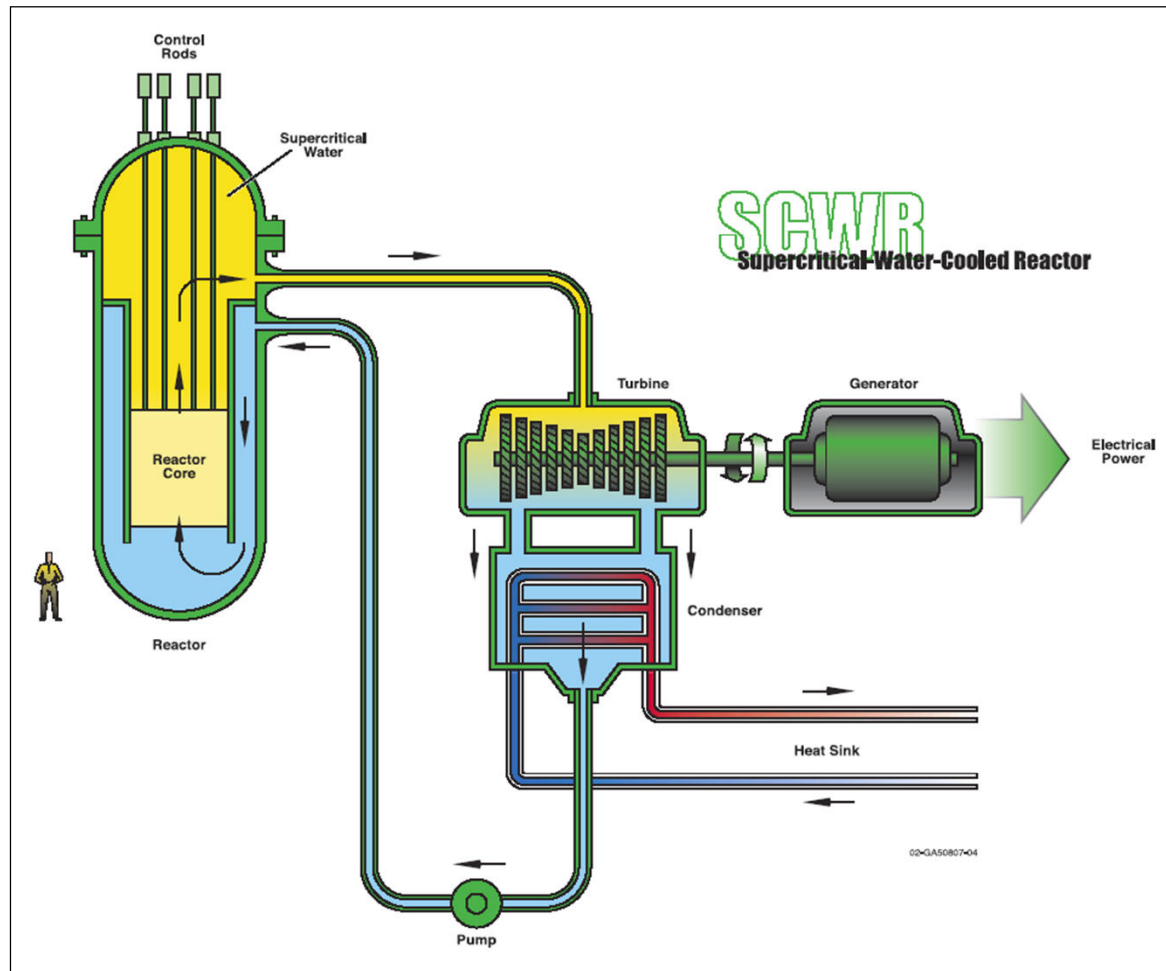
# Generation IV reactors

Source: GenIV



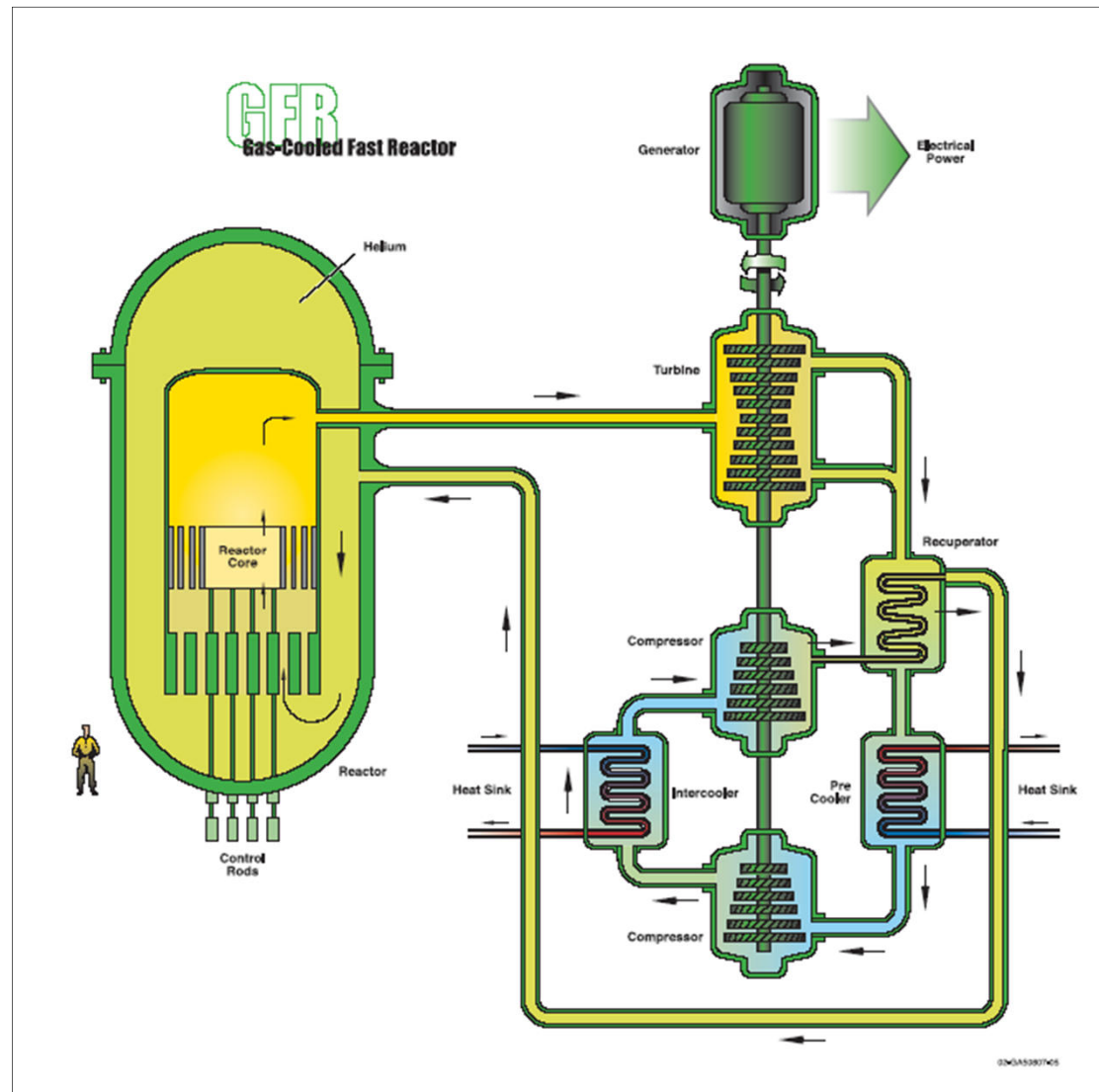
# Generation IV reactors

Source: GenIV



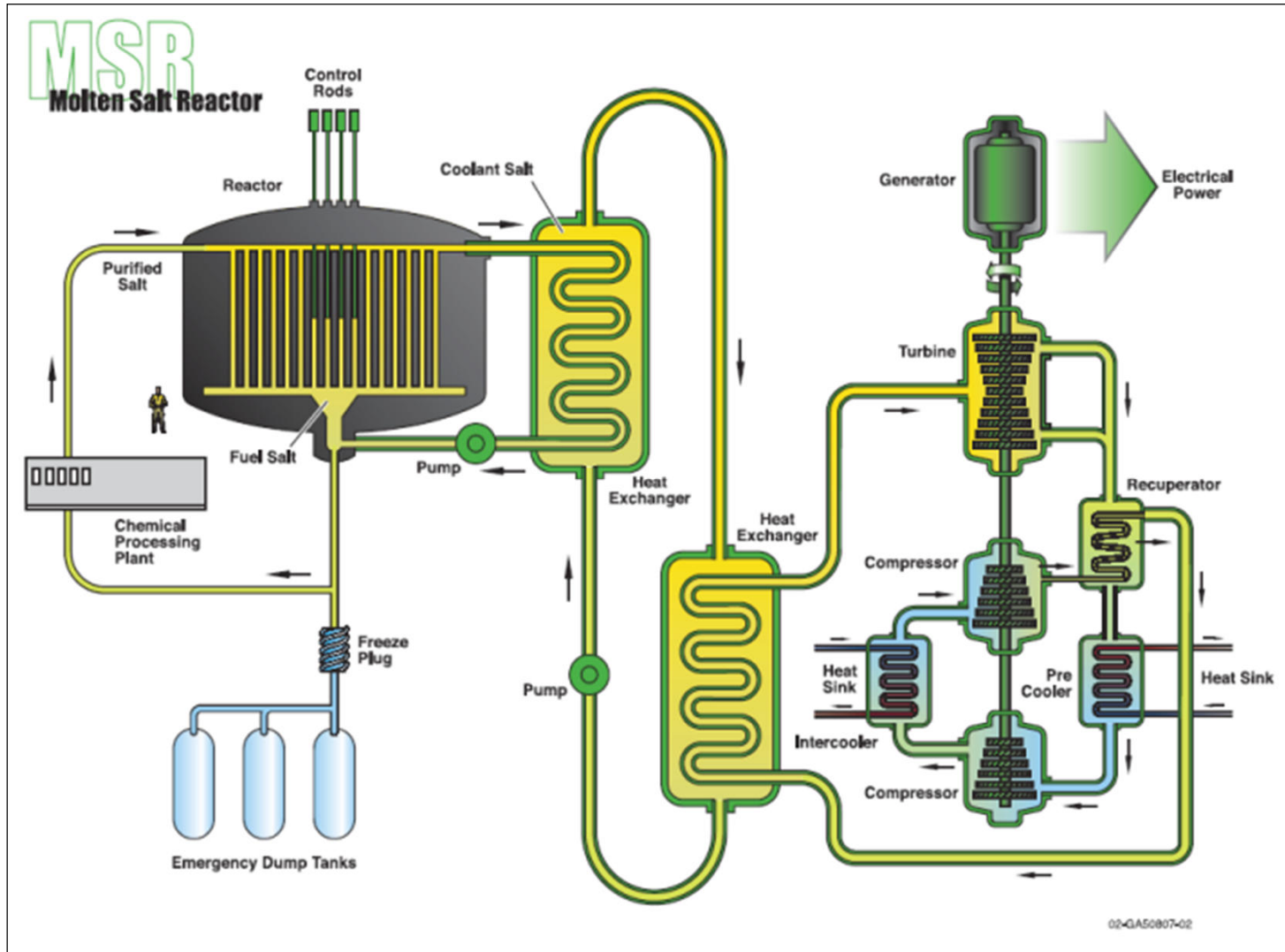
# Generation IV reactors

Source: GenIV



# Generation IV reactors

Source: GenIV





# Generation IV reactors

Source: GenIV

