



# Idaho Cleanup Project

*Progress  
Report  
2007*



Safely delivering the Idaho Cleanup Project

# Progress Report for the Idaho Cleanup Project



Robert C. Iotti

*I would like to congratulate every employee and subcontractor on the Idaho Cleanup Project for an extraordinary 2007. Our continued commitment to doing work safely has enabled us to make real progress in meeting and exceeding our cleanup commitments to the Department of Energy and the people of Idaho. As we continue to demonstrate, when we value safety, performance will follow. Through employee and management involvement, we saw a substantial reduction in injuries in 2007, but we will continue to work toward our goal of zero injuries.*

- *The Idaho Cleanup Project successfully reached Star status – the highest level – under the Department of Energy’s Voluntary Protection Program, which recognizes worksites where workers and management are actively involved in protecting coworkers from injury.*
- *We were the first (and only) site in the Complex to ship remote handled (RH) transuranic waste (TRU) to the Waste Isolation Pilot Plant (WIPP) – completing 98 shipments by year end.*
- *The tank farm team grouted four 15,000-gallon and seven 300,000-gallon underground waste tanks.*
- *D&D demolished 75 buildings, including final demolition of the Hot Shop at Test Area North. This year’s success will allow us to complete the active cleanup mission at Test Area North in 2008. We also completed removal of the Engineering Test Reactor vessel and building at the Reactor Technology Complex.*
- *The Nuclear Materials Disposition team completed the year well ahead of schedule in moving spent nuclear fuel from wet to safer dry storage. They are also nearly 171 percent ahead in disposition of nuclear material items.*
- *We received design approval and construction on the Integrated Waste Treatment Unit, which is well under way at the Idaho Nuclear Technology and Engineering Center.*
- *The Accelerated Retrieval Project team has exhumed more than 10,000 cubic yards of targeted waste.*

*I continue to be impressed with the quality of the Idaho workforce, which has risen to meet so many challenges. I consider myself and my senior management team privileged to lead such a competent, creative workforce with such a strong safety culture.*

*We expect 2008 to be at least as challenging as this year. I’m confident we will keep meeting each new challenge with the same enthusiasm and success as we continue to adapt to a rapidly evolving work environment.*

Robert C. Iotti  
President and Chief Executive Officer  
Idaho Cleanup Project

CH2M-WG Idaho, LLC  
produced this report with  
corporate funds for the  
benefit of its stakeholders.

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# Calendar Year 2007 Goals and Progress

## Idaho Cleanup Project Lifecycle

May 2005

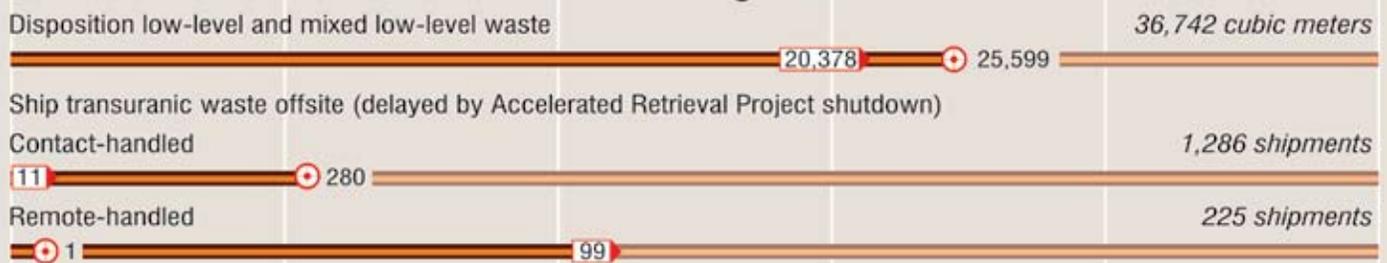
September 2012

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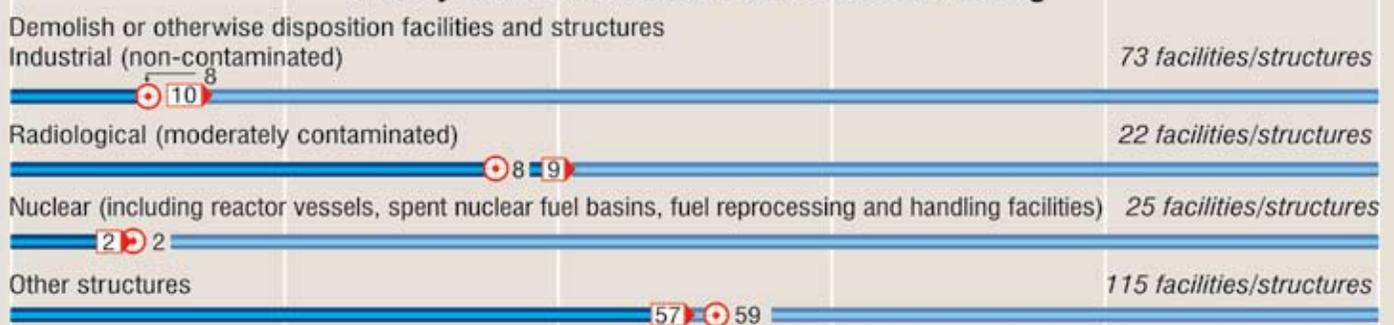
### Idaho Nuclear Technology and Engineering Center



### Waste Management



### Facility Decontamination and Decommissioning



### Environmental Restoration including WAG 7



⊕ Goal through calendar year 2007

▢ Cumulative Progress through December 31, 2007

<sup>†</sup> Designed Comprehensive Environmental Response, Compensation, and Liability Act (CERCLA) sites

# Working Safely

*“Our employees are our most important resource. Protecting them and returning them safely to their families every day is a prerequisite for every job that we undertake.”*

— Brent Rankin



Brent Rankin  
Vice President for  
Environmental, Safety,  
Health and Quality

## A Culture of Safety

A company will make significant improvements in safety only when the workforce is empowered to take action. We were recognized as having an exemplary safety program through achievement of DOE's Voluntary Protection Program (VPP) Star status.

On the Idaho Cleanup Project (ICP), every worker has the right and responsibility to stop work if they believe a job cannot be performed safely, or if there is any question about a procedure or tool. This Stop Work authority is the foundation of the safety culture here, and it's something we will continue to reinforce.

Overall, we saw significantly fewer injuries for workers on the ICP in 2007 than in the previous year, but as always we will continue to work toward our goal of zero injuries. We will continue to focus on the areas where we have seen workers get hurt, as well as on preventive efforts to come up with safer, smarter ways to get our work done.



In 2007 the Idaho Cleanup Project successfully completed major assessments of our safety programs and operations by DOE Headquarters. These assessments recognized the strength of our safety culture and expectations, and also identified areas for continued improvement through the next year and beyond.

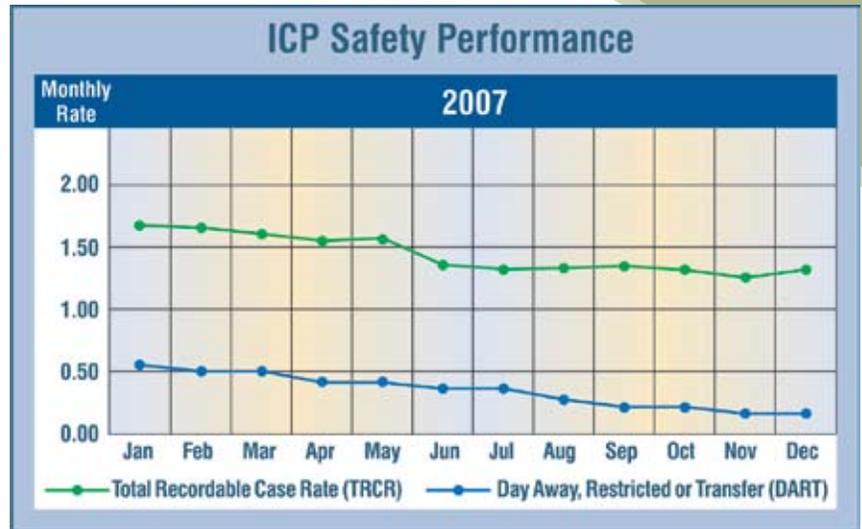


## ICP Became a VPP Star Site

During 2007, the Idaho Cleanup Project was certified as a VPP Star site by the Department of Energy's Office of Health, Safety and Security for its safe work on cleanup activities.

VPP is DOE's tool for promoting excellence in safety through management leadership and the direct involvement of workers. Star status means that the Idaho Cleanup Project is maintaining exemplary safety programs that meet all VPP criteria, including excellent safety systems and processes and employee involvement. It also means that all employees are able to contribute directly to ICP safety and health programs.

The assessors from DOE Headquarters particularly noted the high level of safety awareness, involvement in work preparations, planning, and safe implementation by ICP workers.



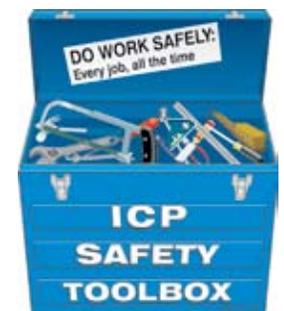
## Audit by DOE's Office of Health, Safety and Security

The assessment by DOE's Office of Health, Safety & Security is an in-depth look at ICP operations, procedures, and safety systems. DOE's assessors found that we have effectively implemented our safety management system, and that expectations for doing work safely have been clearly communicated to, understood and embraced by the workforce.

Among their comments were:

- Workplace monitoring was robust, with good procedures and Health and Safety systems.
- ICP's Environmental Management System is effective and demonstrates good coordination.
- We have provided tools for our workers to provide feedback to help continually improve our safety and procedures.
- The assessors also evaluated the Emergency Management system we share with the Idaho National Laboratory, and found that performance was very strong, including training, drills and exercises; emergency public information; and emergency response.

The challenge for 2008 will be to continue the same focus on improving our ability to safely complete every job we undertake – today, tomorrow, and every day.



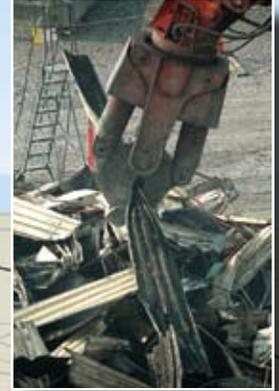
# Work Scope for the Idaho Cleanup Project

The Idaho Cleanup Project involves the safe environmental cleanup of the Idaho National Laboratory site, contaminated with legacy wastes generated from World War II-era conventional weapons testing, government-owned research and defense reactors, spent nuclear fuel reprocessing, laboratory research, and defense missions at other DOE sites.

The project, funded through DOE's Office of Environmental Management,

focuses on reducing risks to workers, the public, and the environment, and protecting the Snake River Plain Aquifer, the sole drinking water source for many Idaho residents.

CH2M-WG Idaho manages the seven-year cleanup effort for DOE. The cleanup focuses on five major geographic areas. In addition, CWI's scope of work includes environmental remediation of several miscellaneous areas on the site, including underground storage tanks, firing ranges, and unexploded ordnance sites.



## Reactor Technology Complex (RTC)

Three major test reactors have operated at the facility—the Materials Test Reactor, the Engineering Test Reactor, and the Advanced Test Reactor (currently operating).

### Scope

- Implement final remedy for two decommissioned reactors
- Remove excess nuclear material
- Close hazardous waste tank systems
- Remediate contaminated environmental sites
- Demolish facilities

## Radioactive Waste Management Complex (RWMC)

Used since the 1950s to manage, store, and dispose of waste contaminated with radioactive elements generated in national defense and energy programs.

### Scope

- Remove targeted waste from the Subsurface Disposal Area
- Implement final remedy for the Subsurface Disposal Area
- Dispose of transuranic waste at offsite facility
- Demolish facilities



## Test Area North (TAN)

Supported numerous research efforts for advancement of the country's nuclear industry, from the development of nuclear-powered jet engines to operation of reactors that simulated the loss of coolant.

### Scope

- Close hazardous waste tank systems
- Remediate contaminated environmental sites
- Demolish facilities



## Idaho Nuclear Technology and Engineering Center (INTEC)

Established in the 1950s to recover usable uranium in spent nuclear fuel from government reactors and to store spent nuclear fuel.

### Scope

- Remove excess nuclear material
- Close radioactive and hazardous waste tanks
- Treat liquid radioactive waste and ship offsite
- Transfer spent nuclear fuel from wet to dry storage
- Remediate spent nuclear fuel basin and treat and dispose of waste
- Remediate contaminated environmental sites
- Demolish facilities



## Power Burst Facility (PBF)

Reactor experiments conducted at the facility helped determine safe operating limits for the commercial nuclear industry.

### Scope

- Implement final remedy for decommissioned reactor
- Close hazardous waste tank system
- Demolish facilities



# Decontamination and Decommissioning



The D&D teams for the Idaho Cleanup Project have made enormous progress in 2007, nearing completion on several highly complex former nuclear facility demolitions as well as many other obsolete or unneeded facilities across the INL Site.

## Reactor Removal

In a major milestone for the project, the Engineering Test Reactor (ETR) was removed from the Reactor Technology Complex. Active from 1957 – 1982, the ETR reactor was used to evaluate fuels, coolant, and modera-

tor characteristics under environments similar to those in many types of power reactors.

The first step was to fracture the reactor's bioshield with explosives. The bioshield, six feet of high-density, steel-reinforced concrete, surrounded by a 3/4-inch steel form, separated the reactor vessel from the surrounding environment. A series of explosions were needed to fracture the bioshield so the reactor vessel could be removed. "The results were exactly what we hoped for," said Mark Slovak, a mechanical engineer on the blast zone re-entry team. "The concrete was rubbleized into manageable pieces and the outer steel form was peeled away exactly the way we wanted."

The next challenge was to remove and transport the 112-ton reactor vessel. The project team designed and constructed a special gantry to lift the vessel nearly four stories and remove it from where it had



been perched within the bioshield. “Our engineering team put in a lot of time to make sure the lift worked according to plan,” said project engineer Kirk Dooley. “One of the challenges was determining the reactor’s weight. We conservatively estimated it to be 272,000 pounds, but once on the gantry, it weighed in at a slim 223,000 pounds.”

All the careful preparations paid off. On September 21, nearly 50 years to the day from the time it became operational, the reactor was lifted above ground. With delicate precision, it came to rest on a multi-axle trailer capable of supporting the vessel’s mass. It was safely transported to the Idaho CERCLA Disposal Facility on the INL site. “Our primary goal from day one was safety,” said Dan Coyne, ETR project director. “We specifically selected methods and controls with the safety of our people in mind.”

## Hot Shop Comes Tumbling Down

Another explosive success was the demolition of the Test Area North Hot Shop facility. The Hot Shop was built in 1954 to support research related to the Aircraft Nuclear Propulsion project that planned to build and fly a nuclear-powered airplane. The aircraft project was eventually cancelled, and the facility was put to many other nuclear safety and accident research uses over the years.

With seven-foot-thick steel reinforced concrete walls, the Hot Shop was built to last. The only way to dismantle it was to literally blow it to bits. Two sets of explosions were necessary—the first to open the gaps in the walls on the sides and around the building’s bay doors to allow placement of additional explosives that would bring the building to the ground in a second blast. The Hot Shop was the last major facility to be demolished at Test Area North.



### Accomplishments

- Demolish 78 facilities and structures, totaling more than 70,000 square feet of footprint reduction
- Removed Engineering Test Reactor vessel and completed reactor building demolition
- Demolished TAN-607 Hot Shop, the last major structure scheduled for demolition at Test Area North

# Environmental Restoration

There are two independent excavation areas at the Radioactive Waste Management Complex where plutonium-contaminated filters, graphite molds, contaminated sludges and oxidized uranium material known as “roaster oxides” are being exhumed, repackaged and shipped for final disposal at the Waste Isolation Pilot Plant (WIPP) in New Mexico. These materials

originated at the Rocky Flats Plant near Denver, Colorado, during nuclear weapons production activities in the 1950s - 60s, and were packaged in barrels and sent to Idaho for buried disposal.

In 2005, the U.S. Department of Energy, U.S. Environmental Protection Agency and state of Idaho agreed to remove these targeted wastes from the eastern portion of Pit 4 and west end of Pit 6.

Crews have been removing targeted waste from the first designated area, Accelerated Retrieval Project -I (ARP-I), within a half-acre area of Pit 4 since early 2005. As of the end of 2007, more than 8,844 cubic yards of material have been exhumed from the pits. Targeted waste, repackaged into more than 3,440 55-gallon drums, is currently being prepared and shipped to WIPP for permanent disposal.

Located approximately in the middle of the



Subsurface Disposal Area at the Radioactive Waste Management Complex, the ARP-I enclosure sits above a portion of Pit 4. After two years of rigorous effort, construction of the second phase of the Idaho Cleanup Project's ARP-II was completed. ARP-II extends past the eastern end of Pit 4 and over part of Pit 6 to access waste targeted for the next phase of the retrieval effort.

The ARP-II officially "went hot" on July 16, 2007. Crews are in the process of exhuming targeted waste from a second retrieval area at the Radioactive Waste Management Complex (RWMC). ARP-III construction has begun over a portion of Pit 6.

The agencies just completed a comprehensive study, called the Remedial Investigation/ Feasibility Study, which lays the foundation for a determination next year on how the remaining waste at the RWMC will be remediated.

In October 2007, more than a decade of studies on buried waste culminated in the release of a proposed plan for review and comment by the public. These comments will be reviewed and responded to by the Agencies when a final Record of Decision is released, scheduled in 2008. This document will detail the final remedy for the entire buried waste area at the Radioactive Waste Management Complex.

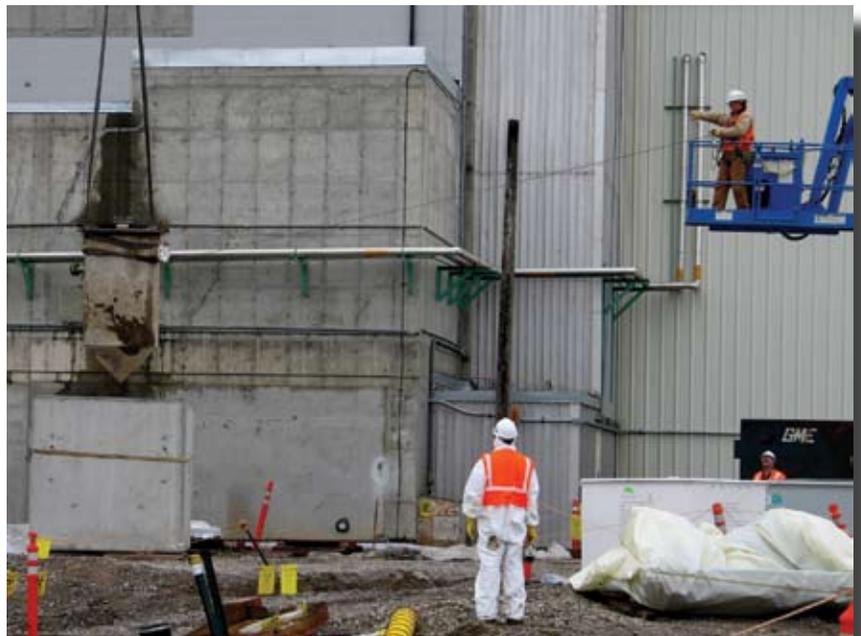
In other Environmental Restoration work, the ICP's team working on closing hazardous waste tanks and systems has closed out 53 of these sites out of a total of 68, well ahead of our planned schedule.

Remediation teams have completed soil cleanup and remediation work on 68 contaminated sites at areas not included within individual facility boundaries or other defined cleanup projects. This work is also ahead of schedule – we are well on our way to completing the 118 miscellaneous sites in the contract.

In another project, the Environmental Restoration team completed the final treatment and disposal of the last of four 'V-tanks,' which has been called one of the most challenging remediation projects in the DOE complex.

## Accomplishments

- Retrieved 10,694 cubic yards of targeted waste from the Subsurface Disposal Area
- Completed installation and testing of the new firewater supply system at the Radioactive Waste Management Complex Subsurface Disposal Area
- Remediated 68 contaminated sites
- Closed 53 hazardous waste tank systems



# Nuclear Material Disposition

Since 2007 began, the Nuclear Materials Disposition (NMD) project has made great progress moving spent fuel from wet to dry storage and also preparing and shipping special nuclear materials to other DOE sites for storage or disposal.

The Spent Fuel Completion team completed the transfer and storage of Pathfinder and



## Accomplishments

- Disposition of 490 nuclear material items
- Transferred 1,801 spent nuclear fuel units from wet storage to safer dry storage
- Prepared to ship unirradiated light-water breeder reactor fuel to Nevada Test Site for disposal

Fermi fuel at the Irradiated Fuel Storage Facility. They also continued the transfer and storage of aluminum plate fuels and unloaded two casks of Japanese research reactor fuel.

The Irradiated Fuel Storage Facility has received wet-to-dry spent fuel transfers from the wet storage basins and received a shipment of domestic research reactor fuel from Texas A&M University in August.

The NMD's Nuclear Materials Completion team is ahead of schedule and made several more shipments in 2007 – some to Oak Ridge Y-12 containing highly enriched uranium and one to Nevada Test Site of excess nuclear material for disposal. Disposition of these items completed the project scope for fiscal 2007 as well as much of the 2008 scope.

They also dispositioned 120 more Engineering Test Reactor elements from the Reactor Technology Complex to Y-12, in addition to transferring the remaining spent nuclear material in CPP-602 to the Savannah River Site. The transfer to the Savannah River Site met the milestone for this material 26 months ahead of schedule.

Approval to terminate safeguards on the unirradiated light water breeder reactor special nuclear material was received, and the refurbishment of the Super Tiger Cask, which will be used to transport this material to the Nevada Test Site for disposal, was completed. The team is working closely with Nevada Test Site and began transfers in January 2008.



# Sodium-Bearing Waste Disposition



## Integrated Waste Treatment Unit

The Integrated Waste Treatment Unit (IWTU) team continues to work on facility construction after DOE gave approval of the project's preliminary design package, cost, and schedule baselines late last year.

In October an air-supported weather enclosure was erected over the construction site so work could continue throughout Idaho's harsh winter. Washington Group International is constructing the 53,000-sq.-ft. building.

Concrete trucks from the site's batch plant began pouring concrete on October 10 for the foundation of the off-gas treatment area, which is adjacent to the processing and packaging cell area of the IWTU. Concrete pours can continue throughout the winter because of winterization of the batch plant and the weather enclosure.

The processing and packaging cell will contain the primary equipment for steam-reforming the remaining liquid waste.

Sodium-bearing waste contains radioactive and hazardous constituents from the decontamination of high-level waste facilities and some spent nuclear fuel reprocessing activities. The treatment process uses a thermal source to heat the waste, turning it into a more stable solid form. Once treated, this waste will be placed in canisters until it is transported to a suitable off-site repository.

Fifteen months of operations will remove and treat the remaining tank waste and will eliminate a potential risk to the Snake River Plain Aquifer.

## Tank Grouting Project Reached Ahead of Schedule

Ensuring the long-term safety of the Snake River Plain aquifer took a major step in 2007. The Idaho Cleanup Project's Tank Farm team grouted 11 of the 15 underground radioactive waste storage tanks at the Idaho Nuclear Technology and Engineering Center.

Initial tank and vault pours on the seven 300,000-gallon tanks began in April and followed the successful grouting of the four 30,000-gallon tanks in March.

This project is a key component of the Idaho Settlement Agreement and is of interest to many Idahoans. Getting this project completed ahead of schedule underpins our commitment to protect the Snake River Plain Aquifer.

The tanks were used in the past to store radioactive liquid waste associated with spent nuclear fuel reprocessing activities. With the successful grouting of the four small tanks and the seven larger tanks, only four 300,000-gallon tanks will remain, three of which contain about 900,000 gallons of liquid waste. One tank, a spare, has never been used.

The remaining liquid waste will be treated in the Integrated Waste Treatment Unit facility, which is currently under construction. The last four 300,000-gallon tanks will be treated and closed after the last tank is emptied and cleaned.



### Accomplishments

- Constructed weather enclosure to enable work through winter on Integrated Waste Treatment Unit construction
  - Completed concrete pour for the Process and Packaging Cells base slab
  - Completed fabrication of the Waste Feed Tank skid as well as forming the Denitration Mineralization Reformer (DMR) top head
- Completed grouting 11 of 15 high-level waste tanks; remaining four to be grouted after treatment of sodium-bearing waste

# Waste Management

## Remote-Handled Transuranic Waste Shipments

In January, Idaho Cleanup Project completed the first-ever shipment of remote-handled transuranic (RH-TRU) waste to the Waste Isolation Pilot Plant (WIPP) near Carlsbad, New Mexico.

TRU waste generally consists of protective clothing, tools, glassware, equipment, soils, and sludge contaminated with plutonium, neptunium, americium, curium, and/or californium. Transuranic waste is divided into two categories, based on its level of radioactivity. RH-TRU emits more radiation than contact-handled transuranic waste and must therefore be both handled and transported in shielded casks. Surface radiation levels of unshielded containers of RH-TRU waste exceed 200 millirems per hour.

The majority of RH-TRU waste at the Idaho

### Accomplishments

- Completed 99 (of 225) shipments of remote-handled transuranic waste to the WIPP
- Disposed of 20,378 m<sup>3</sup> of low-level and mixed low-level waste

National Laboratory site originated at Argonne National Laboratory-East. The waste generated from defense missions was placed in interim storage at the Radioactive Waste Management Complex in the 1970s.

The TRU waste team has been preparing for shipment since May 2005. Preparations required:

- Movement of waste from RWMC to interim storage near processing facilities at the Idaho Nuclear Technology and Engineering Center
- Facility and equipment modifications to handle processing activities
- Physical/chemical/radiological characterization to ensure its acceptability for disposal at WIPP.

By calendar year end, the team had achieved a record six shipments per week, completing 99 of 225 total shipments. The ICP remains the only organization shipping RH-TRU to WIPP. The project will complete its scope well ahead of schedule, in 2008.



# Commitment to Community

As the main contractor for the Idaho Cleanup Project, the employees of CWI work and raise their families in the communities where the company does business. We consider it our responsibility to devote resources to improving the quality of life in our home communities.

CWI believes that when people work together, great things happen. We join forces to help meet community needs, not only through monetary means but also through volunteerism.

Our employees have donated hundreds of hours toward company-sponsored activities and events—benefiting economic development organizations, charities, cultural groups, and educational programs—in addition to the countless hours and money donated to their own favorite causes.

## Public Involvement in Cleanup Decisions

It is vitally important to meet our obligations to involve concerned members of the public in cleanup decisions at the site. As important decisions are being considered by our government agencies, we provide opportunities to review and comment on proposed actions. We have e-mail lists available, and keep our website up to date with notices of open public comment periods. Even when a major decision isn't in the works, you can contact a member of our staff at any time if you have concerns or questions about measures we take to protect the public, our workers, and the environment.

## Economic Development Organizations and Chambers of Commerce

Many CWI employees want to continue their careers in eastern Idaho long after the cleanup is complete. To enhance opportunities for future employment, we recognize the importance of contributing dollars and time to the economic growth and prosperity of the area.

We hold memberships in six local chambers of commerce and serve on boards and committees of economic development organizations like Grow Idaho Falls, Idaho Association of Commerce and Industry, and Yellowstone Business Partnership.

## Charities/Service Organizations United Way

Since 2005, CWI leadership has served in key positions in the United Way. CWI employees contribute heavily to the United Way, donating more than \$300,000 in the past two years.



## Other

CWI employees have devoted many volunteer hours near and far—from building houses for Habitat for Humanity to building fences for The Nature Conservancy. Our support of organizations like the American Red Cross, Big Brothers/Big Sisters of Southeastern Idaho, and the Salvation Army continues to benefit those in need throughout Idaho.

## Cultural Groups

CWI donates time, talent, and dollars to numerous organizations that create and foster a rich cultural community. Our contributions include support of the Idaho Falls Arts Council, ARTI (a local theater group), the Art Museum of Eastern Idaho, the Museum of Idaho, the Idaho Falls Symphony, Shoshone/ Bannock Tribal events, and the Hispanic Youth Symposium.

## Educational Programs

For employees seeking to further their education, CWI offers tuition reimbursement. Our support also includes partnerships with local colleges and universities to strengthen programs for workers interested in enhancing their careers. We promote up-and-coming scientists and engineers through programs like the INL/ICP Engineering Fair and the Idaho Scholastic Tournament.

We are proud of the individuals who generously volunteer their time and energy to making our communities better places to live.



# Small Business Program



**Natalie Packer**  
Small Business  
Program Manager

CWI is making significant headway towards its small business subcontracting goals in support of their contract for the U.S. Department of Energy's Idaho Cleanup Project. Since contract inception in May 2005 through 2007 fiscal year end, CWI has awarded \$363.6 million in total subcontracting dollars. Of that total, \$240.3 million, has been awarded directly to small business.

"Our suppliers are an extension of us," said Natalie Packer, CWI's Small Business Program Manager, "We are very fortunate to have access to such a talented population of small businesses

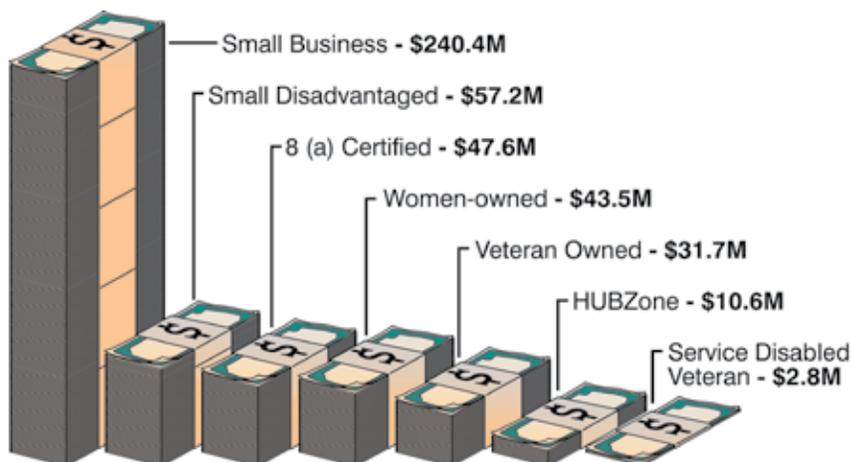
helping us complete our mission."

This accomplishment is noteworthy for CWI because it demonstrates its strong commitment to the program, but equally important, is the evidence that small businesses are completing important work in our community and contributing to a significant economic impact as a team, Packer said.

CWI recognizes the value of establishing relationships with skilled subcontractors who have proven capabilities and who embrace the importance of safety.

CWI proposed very aggressive socioeconomic goals on small business utilization in support of the Idaho Cleanup Project. Not only do these goals represent CWI's pledge to maximize subcontracting opportunities for small business firms, but also conveys a major part of its operations strategy which centers around a strong team of subcontractors to perform significant elements of the baseline.

Although the company is pleased with program results to date, Packer said there's always more to do. She continues to recruit small businesses in each of the socioeconomic goal categories to match qualifications and resources to the next subcontracting opportunity. All small businesses are encouraged to visit the forecast of opportunities posted quarterly on CWI's website: <https://idahocleanupproject.com>.



## Who We Are



CH2M-WG Idaho (CWI) combines the capabilities of CH2M HILL and the Washington Division of URS, leaders in risk reduction and accelerated cleanup of large, complex nuclear facilities.



CH2M HILL is an employee-owned, global project delivery firm headquartered in Denver, Colorado. The company has more than 18,000 employees working in 200 offices worldwide ([www.ch2mhill.com](http://www.ch2mhill.com)).



Washington Group International is now Washington Division of URS Corporation. Headquartered in San Francisco, the new company operates through three divisions: the URS Division, the EG&G Division and the Washington Division. URS Corporation has approximately 55,000 employees in a network of offices in more than 30 countries ([www.urscorp.com](http://www.urscorp.com)).



Premier Technology, CWI's small-business partner based in Pocatello, Idaho, provides specialty design and fabrication services to a wide range of clients and industries in the U.S. and abroad ([www.premiertechology.cc](http://www.premiertechology.cc)).

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