



NEK

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NUCLEAR POWER PLANT KRŠKO

TECHNICAL DIVISION
PRODUCTION DEPARTMENT (TO.PR)

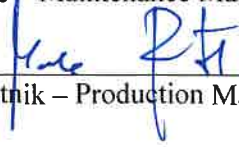


TECHNICAL SPECIFICATION FOR VISUAL EXAMINATION OF BOP HEATERS 3A/B AND 5/6A DURING NEK OUTAGE

(IN 8261887)

Revision 0

CLASSIFICATION: NSR (Non-Safety Related)

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CONTENTS

- 1. Activity**
- 2. Scope of Service**
- 3. Safety Classification**
- 4. Service Type**
- 5. Codes, Standards and Procedures**
- 6. Identification of Equipment**
- 7. Technical Requirements**
- 8. Qualification Requirements**
- 9. Detailed Schedule**
- 10. Contractor Responsibilities**
- 11. NEK Responsibilities**
- 12. Special Requirements**
- 13. QA Requirements**
- 14. Abbreviations and Definitions**
- 15. Attachments**

1. Activity

The activity includes remote visual examination (VT) of internal shell-side structures of secondary side Balance of Plant feedwater heaters:

- CY104HEX-001 (3A),
- CY104HEX-002 (3B),
- CY102HEX-001 (5A),
- CY102HEX-003 (6A),

during Refueling Outage RE27 (April 2027).

The purpose of the inspection is to determine the condition of internal structures of Balance Of Plant (BOP) Heat Exchangers (HEX) stated above. Upon verification of potential degradation mechanisms, the supplier shall analyze and prepare a report regarding the status of internal components. Specific area for inspection shall include, but not be limited to:

- status of support plates,
- inner partition plate welds where applicable (5/6A),
- drain cooler components such as drain cooler shroud and end plate,
- foreign material accumulation and FME check – special attention shall be made in HTR 6A due to fallen battery insert during the outage in October 2025,
- vibration-related damage mechanisms,
- impingement plate welds and erosion,
- shell side erosion,
- and other internal structural degradation or defects.

2. Scope of service

The Contractor shall provide all personnel, equipment, tooling, software, documentation and engineering support necessary to perform remote visual inspection of the shell side of the feedwater heaters.

Areas of interest of internal structures of CY104HEX-001/002 heaters (3A/B) are:

- tube support plates,
- impingement plates,
- tie rods,
- spacer elements,
- internal shell surfaces,
- tube bundle outer rows,
- evidence of vibration,
- evidence of fretting wear,
- deformation of tubes or internals,
- erosion evidence,

- corrosion,
- loose parts & foreign material,
- drain cooler integrity,
- drain cooler shroud & end plate,
- sludge and deposits,
- all other areas of interest that could be identified during the outage.

Documentation of internal structures and components for CY104HEX-001/002 heaters (3A/B) and CY102HEX-001 (5A) and CY102HEX-003 (6A) is available at NEK for review. Mandatory inspection should cover area of:

- partition plate integrity,
- partition plate-to-shell weld, especially on the bottom side of HEX,
- support plates, especially in the 10D - 11D area,
- all accessible tube support plates,
- drain cooler shroud,
- drain cooler end plate,
- impingement plates and flow distribution devices,
- regions corresponding to >40 % TWH ECT indications identified on heater 6A,
- tube-to-support contact regions,
- bottom regions of heater shell,
- sediment accumulation areas,
- foreign material accumulation areas,
- indications of leakage,
- drain cooler integrity,
- drain cooler shroud & end plate,
- evidence of vibration-induced degradation,
- all other areas of interest.

Prior to outage execution, the Contractor shall perform and document a demonstration test of the proposed visual inspection system. The purpose of the demonstration shall be to verify the capability of the proposed inspection method, equipment, software, camera system and personnel to detect and document representative degradation mechanisms expected in feedwater heater internal structures. The demonstration test shall include detection, identification and documentation of simulated defects that are easy to reproduce at the supplier test facility. The supplier shall also:

- 2.1 Test the equipment for VT inspection with emphasis on demonstrating VT tool insertion in the limiting available space – it is encouraged that the potential supplier performs a walkdown of the work area and identifies available entry points of equipment. NEK shall provide all available documentation to support equipment insertion.
- 2.2 Demonstrate the capability of equipment insertion/withdrawal at the start/end of operation without any detrimental effects to HEX internal structures. The test shall also show that no additional foreign material shall be produced due to equipment insertion/withdrawal.

2.3 Demonstrate and document minimum detectable flaw size under representative inspection conditions. The demonstrated capability shall be not less than:

- 1 mm wide crack indication,
- 2 mm diameter pit indication,
- 3 mm local erosion indication,
- 5 mm foreign object.

The contractor shall invite the Purchaser to witness the demonstration test prior to the start of activity at NEK by the end of February 2027 at latest.

2.4 The proposed inspection system shall demonstrate the capability to:

- Detect all implanted target indications,
- correctly classify at least 90% of implanted degradation mechanisms,
- determine location of identified indications within ± 25 mm,
- produce images allowing positive identification of detected indications,
- maintain image quality and resolution throughout the expected inspection distance/range,
- provide a simple FOSAR demonstration with at least one FO item removal if applicable,
- provide sufficient illumination for inspection of all target areas.

The demonstration shall be considered acceptable if:

- 100 % of implanted critical indications are detected,
- no false negative result is recorded for critical indications,
- image quality allows independent review by NEK personnel.

2.5 The supplier shall include a camera calibration test before, during and after the visual inspection and shall include at minimum:

- color reference patches,
- black-white contrast fields,
- line-pair resolution pattern,
- dimensional scale with minimum 1 mm graduations,
- unique identification number.

The calibration target shall be photographed and recorded under the same camera settings used for field inspection.

2.6 All service activities on site shall be completed on schedule (details in item 9).

2.7 Preliminary Report on performed services in the outage shall be submitted by the Contractor in at least (1) original copy and on a USB drive at the final meeting before leaving the plant. The Final Close-out Report in (1) original printed copy and one PDF version (USB stick or electronically) shall be submitted to NEK 30 days after receiving

the comments of the Preliminary Report but **no more than 60 days** after the final / exit meeting.

3. Safety Classification

Visual Examination of BOP Heaters 3A/B And 5/6A During NEK Outage is classified as NON SAFETY RELATED (NSR).

4. Service type

Service shall be performed under the contractor's QA plan/program and working procedures. NEK's coordinator from the Maintenance Department (TO.VZST) will carry out supervision and coordination of work.

5. Codes, Standards and Procedures

- EN 13018 or,
ASME Section V, Article 9 Non-destructive testing - Visual testing - General principles.
- ASNT CP-189 or,
EN ISO 9712 Standard for Qualification and Certification of Nondestructive Testing Personnel.
- ISO 9001 Contractor Quality Management System.
- ISO 14001 Environmental management system.
- ISO 45001 Occupational health and safety at work system.

5.1 Prior to the start of the work the Contractor shall get knowledge on NEK's internal rules for working inside the controlled area and will be obligated to pass the exam. The topics they have to understand are:

- Foreign Material Exclusion – FME program
- Industrial Safety at NEK
- Entrance and movement in the technological area of NEK
- Access of subcontractors to NEK
- Fire protection program
- Protection of adjacent systems, structures, and components

6. Identification of Equipment

All activities covered in this Technical specification will be performed on Balance of Plant heaters: CY104HEX-001 (3A), CY104HEX-002 (3B), CY102HEX-001 (5A) and CY102HEX-003 (6A).

7. Technical Requirements

- 7.1 All services should not produce any foreign material. Qualified equipment should be used for services at NEK.
- 7.2 Inspection shall be performed using remotely operated visual examination equipment with either:
- videoscope or
 - borescope or
 - magnetic crawler,
- or equivalent technology.
- The Contractor shall provide all equipment necessary to obtain inspection coverage of the requested internal structures.
- 7.3 The Contractor shall provide sufficient inspection coverage to evaluate the condition of all structures listed in section 2. Where complete examination is not possible, the Contractor shall:
- identify inaccessible areas,
 - document reasons for limited access,
 - provide estimated percentage of achieved inspection coverage,
 - recommend alternative inspection methods if required.
- 7.4 The inspection shall identify and document:
- general corrosion,
 - localized corrosion,
 - pitting corrosion,
 - erosion,
 - support plate degradation,
 - impingement plate degradation,
 - spacer degradation,
 - drain cooler shroud degradation,
 - drain cooler end plate degradation,
 - weld degradation,
 - vibration damage,
 - fretting wear,
 - deformation,
 - missing components,
 - detached components,
 - loose parts,
 - foreign material,
 - sludge and deposits,
 - leakage traces.

Special attention shall be paid to:

- support plate 10D & 11D area in HTR 6A,
- partition plate weld area between 5A and 6A,
- heater 6A ECT degradation zones,
- shell bottom regions.

- 7.5 Equipment, tools, and auxiliary equipment used during the performance of the scope of this specification shall not have any detrimental effect on the heat exchanger, especially on the integrity of heat exchanger tubes (see item 2.2).
- 7.6 The supplier shall present a reference list for all TVI and FOSAR activities performed in the last 5 years in a table provided below:

Site	Activity performed (TVI, FOSAR)	Month/ year	Contact person at site plant for verification (e-mail and phone number)	Reference evidence (first page of final report, minutes of exit meeting, etc.)

8. Qualification Requirements

The contractor's personnel performing remote visual inspection shall be qualified and certified in accordance with ASNT CP-189 or EN ISO 9712 Standard for Qualification and Certification of Nondestructive Testing Personnel (min. NDE level II) and experienced with FOSAR activities.

Work order/Shift leaders should have a good command of the English language. Key workers must submit evidence of a good command of written and spoken English if English is not their first language. Evidence can be in form of a written statement from the supplier or any other applicable institution.

The contractor shall provide relevant documentation for granting access to NEK for the contractor's personnel at **least 90 days** ahead of the anticipated start of the outage. Personnel qualifications and certificates for job performance should be supplied to the NEK procurement department at least 90 days ahead of the outage start. Before the start of sludge removal activity (typically a day before), the contractor's personnel are required to pass a General Employee Training (GET) at NEK. For security vetting purposes the contractor shall make all arrangements with the purchasing department immediately after the contract is validated.

9. Detailed Schedule

The “Visual examination of BOP Heaters 3A/B and 5/6A” activity shall be performed during the refueling outage from 1st of April 2027 till 7th of May 2027. The time slot for BOP heat exchanger inspection is expected from 4/4/2027 02:00 till 21/4/2027 22:00. The total duration of the planned BOP HEX inspection window HD02 is 428 hrs.

One month before the start of activities the purchaser will confirm the exact planned dates and times of stated activity upon a written request from the supplier. Total duration in hours and time for planned activity is not subject to change by Purchaser. This inquiry must be demanded by the contractor via e-mail or any other written form of request.

The time range for TVI/FOSAR activities defined in this Technical Specification must be met. Any deviation from the planned activity duration must be agreed upon in advance between the contractor and NEK.

For any possible additional outage planned works the detailed schedule on each BOP HEX shall be agreed at least 90 days before the next outage upon a written request from the supplier.

10. Contractor Responsibilities

- 10.1 Preparation for remote visual inspection with FOSAR of NEK BOP HEXs shall be of proper cleanliness before use at NPP Krško. No traces of equipment contamination shall be present if the equipment was previously used at a BWR plant or primary circuit. A report of these preparation activities should be sent to NEK before the equipment arrives on site.
- 10.2 Contractor (Supplier) shall provide to NPP Krško:
 - Personnel with qualifications & performance records as prescribed in Section 8.
 - Time Schedule & Project Organization Chart during the bidding phase.
 - Completion of required scope within available time defined in section 9.
 - Documents shall be handed over to the NPP Krško representative for review and comments.
- 10.3 All contractor's equipment shall be functionally tested before entering the facility at Krško. The test shall show that the equipment can fulfill requirements of 2.1, 2.2, 2.3 and 2.4. Contractor shall submit evidence of such tests to NEK at least **30 days** prior to arrival.
- 10.4 If any problems occur during installation (calibration) or start-up of equipment for remote visual inspection, the qualified contractor's personnel must have an adequate and quick solution (< 30 min) for resolving the problem. Important equipment shall have adequate spare parts inside technological area for fast change in case of problems. All delays or deviations must be immediately reported to NEK support team members.
- 10.5 Prior, during and after TVI, a calibration check of TV tools must be performed according to 2.5 and the insertion position of TV equipment established with NEK-team member and NEK HEX documentation.



- 10.6 With the results of the remote visual inspection, the contractor shall provide a detailed analysis of the component status according to section 2.
- 10.7 The contractor shall provide a statement that the Balance of Plant Heat Exchanger inspection with possible FOSAR has no detrimental effect on the HEX's especially on the integrity of tubes or drain cooler structures and can't produce any foreign objects inside BOP HEX's.
- 10.8 Visual examination of BOP Heaters 3A/B and 5/6A and/or FOSAR activity is to be performed on the secondary side of NEK and shall include listed areas of interest according to paragraph 2. Additionally, the service shall cover:
- transport of the equipment and crew, to and from the site,
 - set-up of the equipment,
 - enter of equipment in the turbine building
 - operation of remote visual inspection equipment,
 - FOSAR activities if applicable,
 - disassembly and packing of the equipment.
- 10.9 The contractor shall have his procedures for performing remote visual inspection (with FOSAR) of BOP HEX's. All work shall be done following the Contractor's Quality Management System program requirements. The contractor's procedures shall be presented to NEK. Procedures shall be provided to NEK at least **60 days** before the start of the outage defined in paragraph 9.
- 10.10 The contractor shall provide all necessary equipment and spare parts for the remote visual inspection/FOSAR activities. Supplier shall have two-fold crucial equipment on site in case of equipment failure. On-shift personnel shall be trained in quick repairs of essential equipment.
- 10.11 The contractor shall prepare and deliver the FOSAR (Foreign Object Search and Retrieval) tool for possible foreign object(s) removal where applicable, and train personnel before on-site arrival. Evidence of said training shall be sent to NEK **60 days** before arrival.
- 10.12 Contractor shall provide requirements for air supply (pressure demands, flow capacity, air quality), electrical power, demi water demands, ... for equipment **at least three months before** the outage starts.
- 10.13 The contractor shall provide a list of equipment by each container before arrival on site and a separate list of the equipment entering HEX's for FME control of items introduced by contractor. The contractor shall provide their own FME supervisor with a LOG IN/LOG OUT list of all equipment that enters the HEX's. The responsibility for an updated LOG IN/LOG OUT list shall rest with the supplier. NEK FME controllers as well as NEK coordinators will check the list periodically according to the prepared FME work permit to minimize FME risks. The final signed LOG IN/LOG OUT will be included in the final report.

- 10.14 The contractor shall promptly report to the NEK coordinator (**within 30 minutes**) any deviation or noncompliance when performing remote visual inspection activities, and/or FOSAR.
- 10.15 The contractor shall present references concerning remote visual inspection, and FOSAR performance at other plants as prescribed in the item 7.
- 10.16 The contractor shall start with potential foreign object retrieval after NEK approval of the retrieval method. Classification and recommendation for foreign object extraction must be done in parallel/on-site during the duration of TVI inspection. FOSAR activities are expected to be completed in the timeframe defined in the item 9.
- 10.17 The contractor personnel performing nondestructive examinations (remote visual inspection) shall be qualified and certified under ASNT CP-189 or EN ISO 9712 Standard for Qualification and Certification of Nondestructive Testing Personnel (min. NDE level II) to meet NEK's requirements and conditions.
- 10.18 The contractor shall obtain any Slovenian labor permit or any other Slovenian authorization such as a security vetting certificate required by Slovenian authorities to allow Contractors personnel to perform the contracted services.
- 10.19 The contractor shall submit to NEK all necessary personnel data for access formalities at **least 90 days** before the arrival of the contractor's personnel onto the NEK site.
- 10.20 The contractor shall submit to NEK all necessary work certificates, equipment certificates, organizational chart, etc. **90 days** before arrival.
- 10.21 The contractor shall submit a detailed schedule of defined operations in the section 9 as a part of an offer. The schedule must not extend the overall time slot for the work planned on SGs as defined in the section 9.
- 10.22 The contractor shall secure a work order leader during all times on-site works are performed inside the TB. Work order personnel must first finish a 2-day course at NEK. The detailed schedule of the course will be coordinated between the supplier and NEK training personnel after the contract is signed. The course is in Slovenian language. This requirement may be waived if otherwise agreed between the contractor and NEK during the procurement process.
- 10.23 All personnel working in the technological area must wear protective eye equipment. The supplier shall provide their eye protective equipment.
- 10.24 The contractor shall bring their electrical cable for connection to the NEK Power cabinet. The cable should be at least 20 m long.

10.25 The supplier shall be able to insert a video inspecting tool into the heat exchanger under these limitations:

- The opening for CY104HEX-001/002 (3A/B) is maximum 104 mm when relief valve 56038/56039 is removed. Additional inspection ports are 2" or 51 mm in diameter. The supplier will be able to check the isometric and heat exchanger's internal drawings upon request.
- The opening for CY102HEX-001 (5A) is limited by the opening when an LCV5007 valve is removed. The width is $2\frac{5}{16}$ " or ~58 mm between flanges. If additional work is needed for equipment insertion such as pipe cutting and subsequent welding, the supplier shall provide the inputs during a walkdown visit. Additional inspection ports are 3" or ~75 mm in diameter. The supplier will be able to check the isometric and heat exchanger's internal drawings upon request.
- The opening for CY102HEX-003 (6A) is limited by the opening when an LCV5014 valve is removed. The width is $2\frac{5}{16}$ " or ~58 mm between flanges. If additional work is needed for equipment insertion such as pipe cutting and subsequent welding, the supplier shall provide the inputs during a walkdown visit. Additional inspection ports are 3" or ~75 mm in diameter. The supplier will be able to check the isometric and heat exchanger's internal drawings upon request.

10.26 Status reporting requirements

- The contractor shall provide brief daily written status reports for the performed work, containing all key information regarding the job. The daily report shall consist of the written status of completed tasks including percent of completeness, problems that have occurred from the last meeting with stated delays, and present a plan for the next day. These reports shall be included in the Preliminary and Final report.
- A Preliminary Report shall be written upon the completion of service and given to NEK at the Exit meeting. Preliminary Report shall include chapters as minimum for NEK review:
 - summary of the work performed,
 - remote visual inspection analysis report based on all requested areas of interest as stated in item 2 along with found degradation mechanisms or possible foreign objects in HEX's with the appropriate classification (type, size, class, ...),
 - status of inspection coverage for each segment of heat exchanger and an assessment of the scope performed,
 - recommendations of mitigation techniques for the future HEX operation.
- As an attachment to the final report a filled-out inspection plan, FME log IN/OUT lists, organization chart, personal qualification/training records, equipment/process performance test reports, equipment lists, a punch list of any obligations not fulfilled, etc. shall be attached.
- Detailed Job Close-out Report shall be prepared and sent to NEK max. 30 days after receiving comments on the Preliminary report from NEK. The report shall include records from the video system on a computerized version (USB stick) and at least a

*.pdf or Word *.docx version of the report shall be available to NEK.

- 10.27 The contractor shall agree with and qualify for General Terms for Implementation of Outage Works and other services in NEK.
- 10.28 All contractor documents shall be in English language.
- 10.29 The contractor shall be prepared to modify the work schedule upon request from NEK due to parallel work on equipment listed in item 1 without additional costs if the overall duration of contractor activities does not change.
- 10.30 The contractor shall not use any clear vinyl or plastic foil inside or outside the Turbine Building (TB) and is obligated to uphold the rules of the FME program.
- 10.31 The contractor must be alert to sensitive NEK equipment installed inside TB especially I&C instrumentation, sensors, snubbers, outage scaffolding, etc....). The contractor's equipment or personnel must not damage any NEK equipment.
- 10.32 The contractor shall use such remote visual inspection tools that are able to maneuver inside the heat exchanger and shall not be damaged easily if it comes in contact with NEK equipment.

11. NEK Responsibilities

- 11.1 Provide overall activity supervision.
- 11.2 Provide overall activity coordination.
This includes:
- communication with NEK departments involved in the service,
 - pipe cutting and welding if needed for TV inspection tool access.
 - coordination between the contractor and planned activities occurring in the same around BOP HEX's inside TB.
- 11.3 Provide Plant's Specific training for contractor personnel including all topics as requested by item 8.
- 11.4 Provide necessary equipment information and documentation needed for service to the contractor:
- Crucial as-built drawings & technical design data of HEX's.
 - Any significant corrective action events.
 - Visual inspection results of the last inspections for comparison analysis if available.
 - Any additional technical details if necessary.
 - NPP Krško operational data with HEX's operating data needed for assessments.
 - Plant layouts, isometric drawings, 3D plant models, etc...*

*Documents, ECT reports & drawings will be available on the NPP Krško site only.

- 11.5 Provide Health & Safety supervision and support for contractor's personnel during the performance of sludge removal and remote visual inspection.
- 11.6 Approve foreign objects retrieval method before the start of retrieval.
- 11.7 Approve closeout LOG-IN/LOG-OUT lists at the end of the inspection and witness the final TVI inspection before TV equipment removal.
- 11.8 Provide an ON-SITE PREE JOB briefing to contractors personnel and provide presentation material, so that a contractor can conduct a presentation additionally if necessary.
- 11.9 Provide an office space for the contractor personnel, with internet and phone connection.

12. Special Requirements

- 12.1 Organizational contact
 - The contractor shall coordinate all technical and schedule matters with the assigned NEK coordinator from the Maintenance department, and all commercial aspects with the assigned NEK coordinator from the Procurement department.
- 12.2 Terms and Conditions
 - All documents, daily sheets, logbooks, reports, etc. shall be written in English.
 - The contractor's supervisor will be familiar with contract contents, commercial and technical agreements and will be involved in bidding procedure discussions.
 - The contractor's supervisor will be present at all meetings with NEK.
- 12.3 Working conditions
 - Planned TVI activities will overlap with some maintenance work on BOP HEX's in TB107. Maintenance personnel from other teams shall be allowed to work during the TVI activities upon prior agreement between all parties concerned.
 - The contractor shall ensure safe working conditions for all other interconnecting workers inside same heat exchanger work area.
 - FME requirement shall be strictly followed.
- 12.4 All video image files shall become NEK property and shall be delivered to NEK in original format.
- 12.4 Any indication potentially affecting structural integrity of HEX's shall be immediately reported to NEK coordinator.

13. QA Requirements

- 13.1 Service shall be performed following the Contractor's Quality Management System which complies with ISO 9001 requirements, and which had been evaluated and accepted by NEK. All activities shall be performed using approved contractor procedures and qualified personnel.
- 13.2 The Contractor shall provide sufficient records and documentation to support the performed inspection activities. As a minimum, the following documentation shall be submitted:
- inspection procedure(s),
 - demonstration test report as required by Section 2,
 - equipment list,
 - personnel qualification records,
 - camera calibration records,
 - inspection coverage assessment,
 - FME LOG-IN / LOG-OUT records,
 - daily reports,
 - preliminary report,
 - final report,
 - list of identified findings and recommendations.
- 13.3 Contractual work will be performed following legal requirements, required standards, and technical regulations in such a manner as to comply with requirements of the environmental management system as per ISO 14001 and occupational health and safety at work system as per ISO 45001.
- 13.4 Contractor shall provide sufficient documents and records to support all the activities as required by this specification. The following, but not limited to, shall be provided:
- Test report including data as required by item 2.1, 2.2, 2.3, 2.4 and 10.3.
 - List of equipment per item 10.13 with supporting data.
 - Include a statement as required by items 8 and 10.7.
 - Presentation to NEK of all documents as required by item 8 in due time.
 - Work instructions/procedures for activities as required by item 10.9.
 - References for requirements as defined by item 7.6 and 10.15.
 - List of instrumentations and relevant valid calibration reports, certificates, and documents as required by item 10.20.
 - NDE personnel qualification records (NDE Level II as minimum).
 - Operational personnel qualification records.
 - Statement not to use clear vinyl or plastic foil inside and outside RB.
- 13.5 NEK shall have the right of access to enter the premises of the contractor to witness demonstration test activities.

- 13.6 All other documents needed to perform the scope of this specification and mentioned under 13.4 shall be made available to NEK at least **60 days** before the start of outage activities (unless otherwise specified in previous chapters) to allow NEK to comment and get the documents properly corrected and be ready before the start of field activities.

14. Abbreviations and Definitions

Bidder	Company bidding on the scope of service
Contractor	Company supplying the service, also; Supplier
DC	Drain Cooler
ECT	Eddy Current Testing
FME	Foreign Material Exclusion
FOSAR	Foreign Object Search and Retrieval
HEX	Heat Exchanger
LTO	Long Term Operation
NEK/NPP Krško	Nuklearna elektrarna Krško
NEK Coordinator	A member of the NEK team in charge of SL, IBL, and TVI of SG's
NSR	Non Safety Related
Purchaser	NEK, the company ordering the service
QA/QC	Quality Assurance/Quality Control
RE27	Outage 2027
TSP	Tube Support Plate
TVI/VT/RVI	Televisual Inspection/Visual Testing/Remote Visual Inspection
TB	Turbine Building
TO.VZST	Technical Division – Mechanical Maintenance department
TWH	Through Wall Hole

15. Attachments

N/A