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(54) **NUCLEAR REACTOR SYSTEM HAVING NATURAL CIRCULATION OF PRIMARY COOLANT**

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(57) **ABSTRACT**

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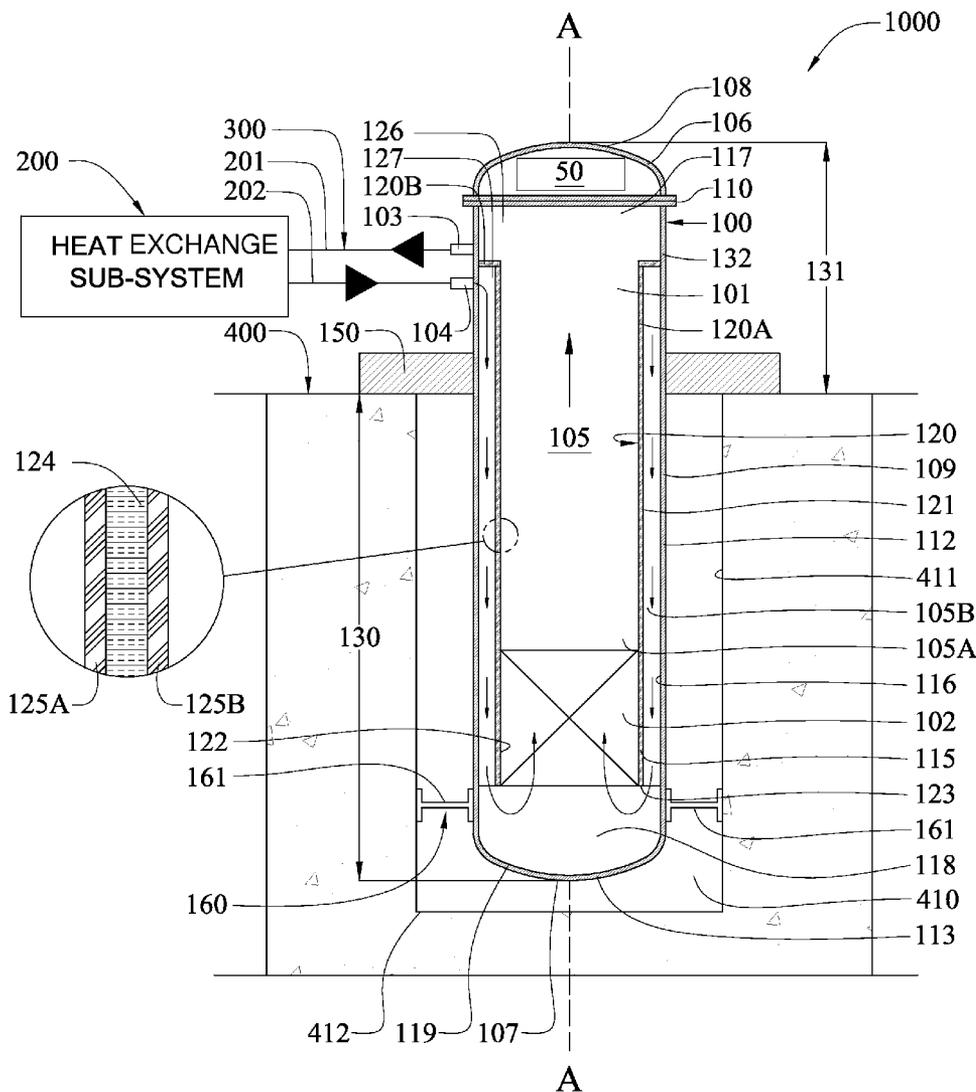
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A nuclear reactor system that, in one embodiment, utilizes natural circulation (i.e., thermosiphon) to circulate a primary coolant in a single-phase through a reactor core and a heat exchange sub-system. The heat exchange sub-system is located outside of the nuclear reactor pressure vessels and, in some embodiments, is designed so as to not cause any substantial pressure drop in the flow of the primary coolant within the heat exchange sub-system that is used to vaporize a secondary coolant. In another embodiment, a nuclear reactor system is disclosed in which the reactor core is located below ground and all penetrations into the reactor pressure vessel are located above ground.



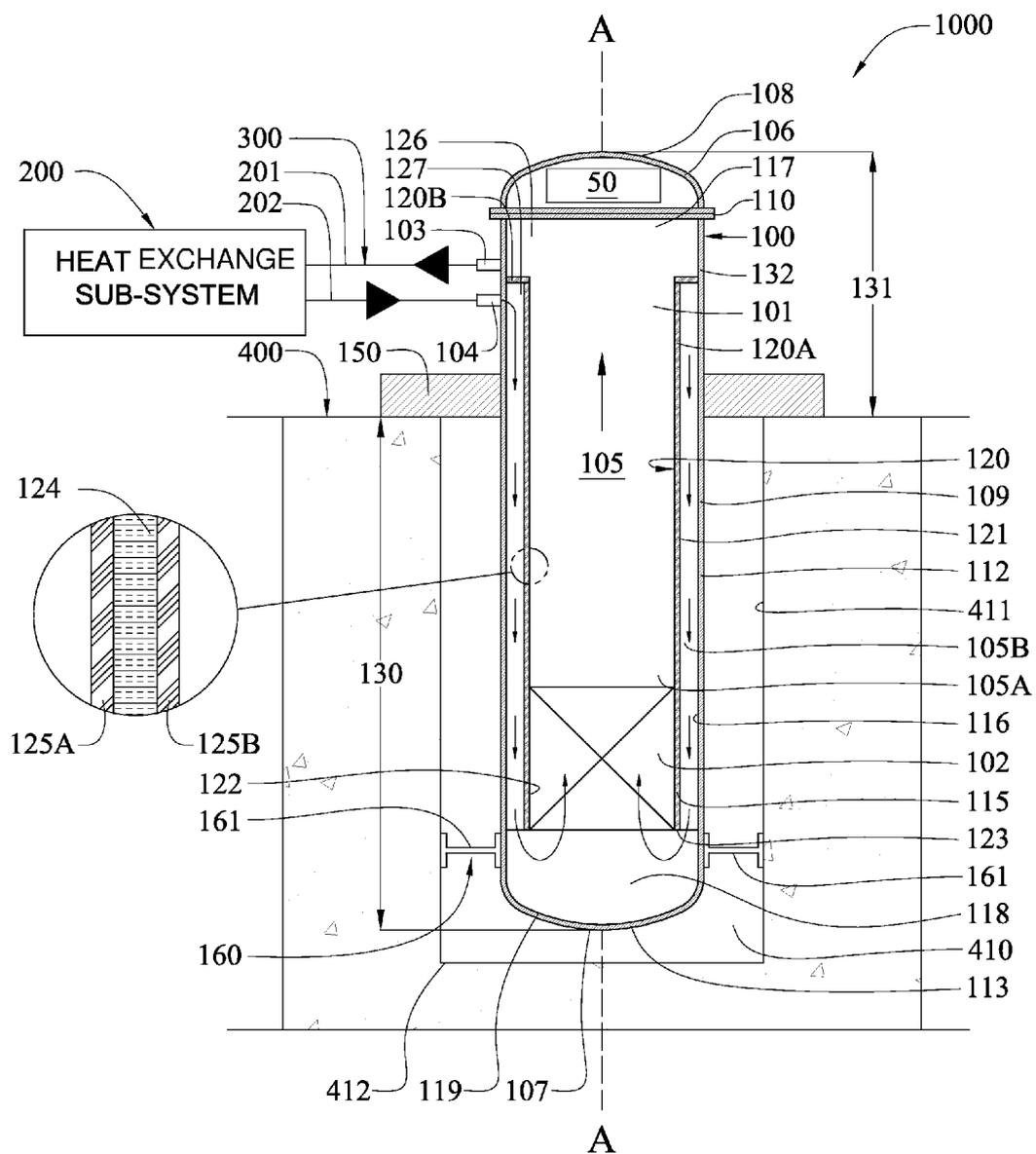


FIGURE 1

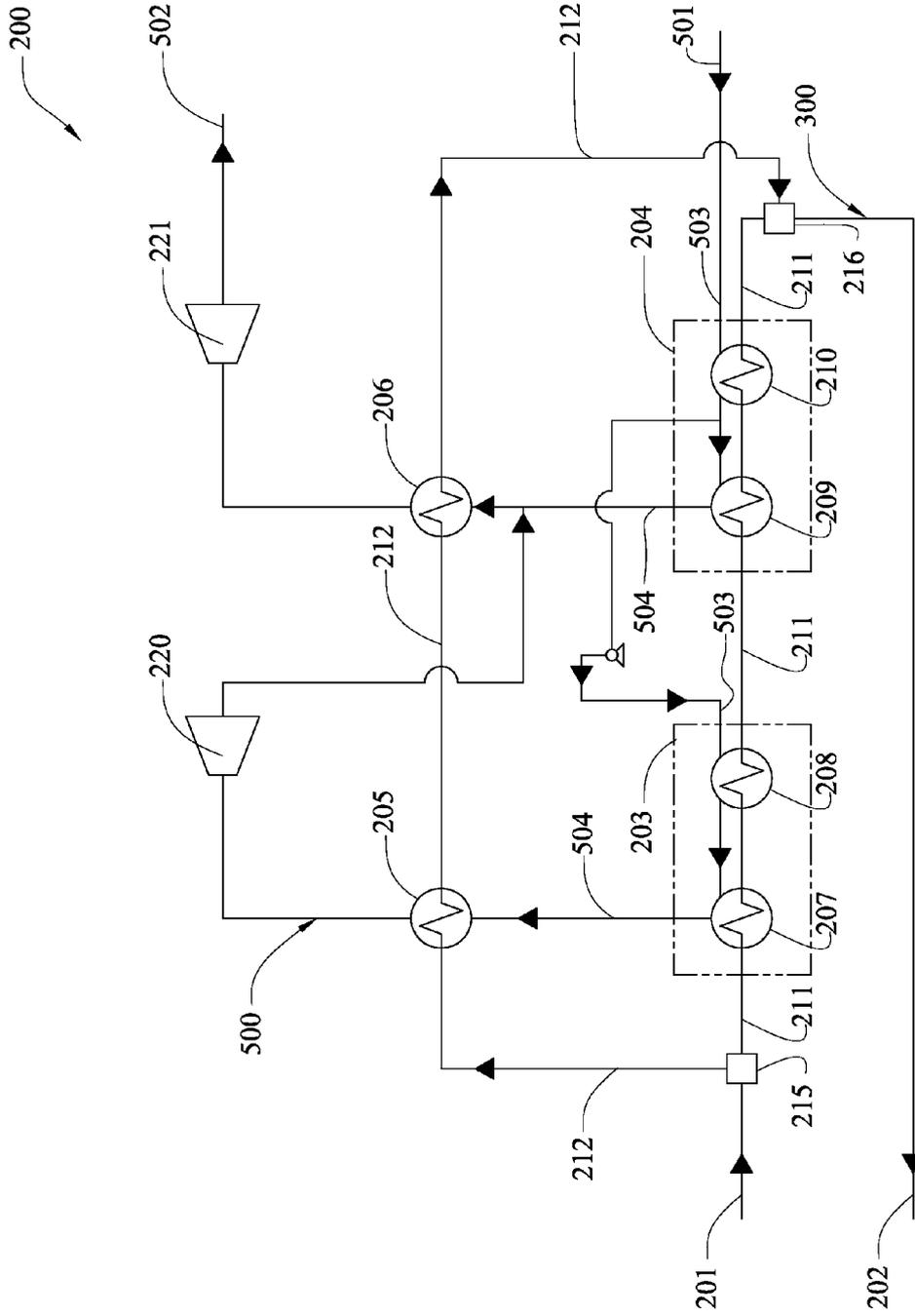


FIGURE 2

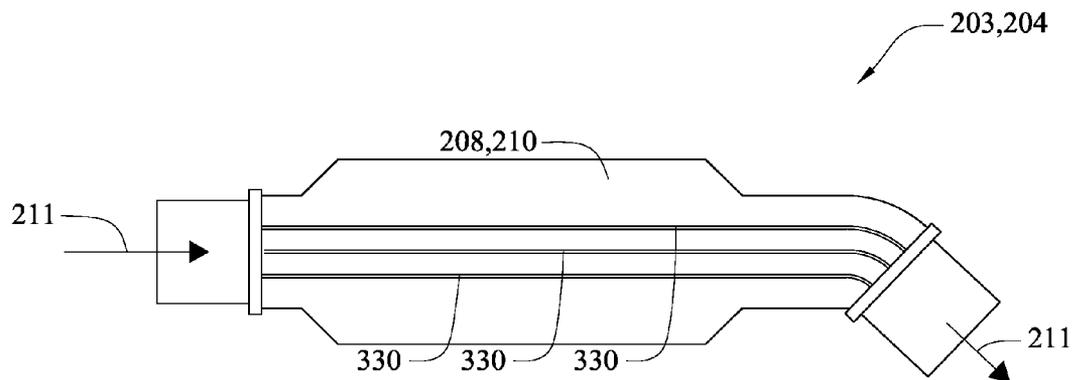


FIGURE 3A

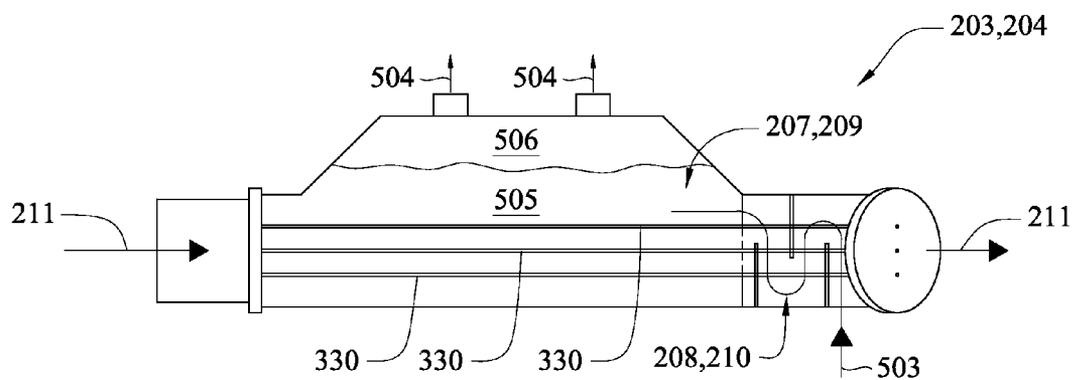


FIGURE 3B

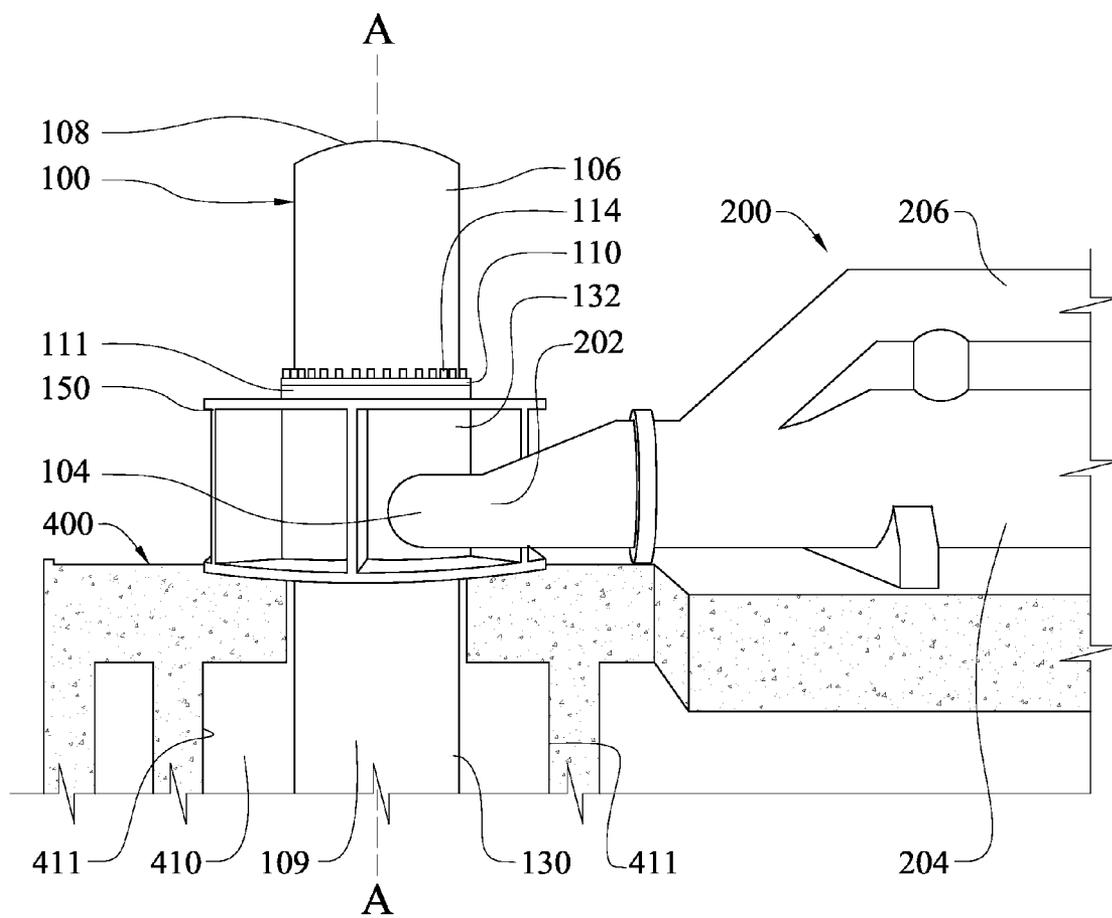


FIGURE 4

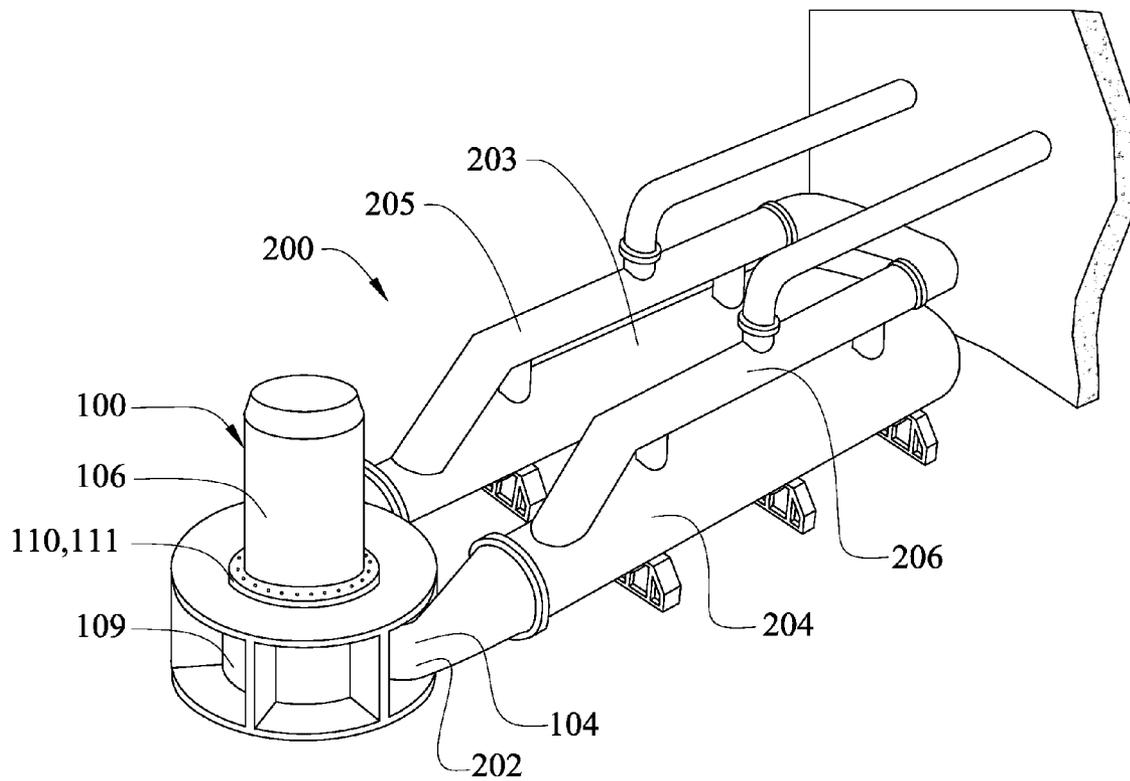


FIGURE 5

**NUCLEAR REACTOR SYSTEM HAVING
NATURAL CIRCULATION OF PRIMARY
COOLANT**

**CROSS-REFERENCE TO RELATED PATENT
APPLICATIONS**

[0001] This application claims the benefit of U.S. Provisional Patent Application No. 61/416,954, filed Nov. 24, 2010, U.S. Provisional Patent Application No. 61/333,551, filed May 11, 2010, and U.S. Provisional Patent Application No. 61/302,069, filed Feb. 5, 2010, the entireties of which are herein incorporated by reference.

FIELD OF THE INVENTION

[0002] The present invention relates generally to nuclear reactor systems, and specifically to nuclear reactor systems that utilize natural circulation of the primary coolant in a single-phase, such as pressurized water reactors (“PWRs”).

BACKGROUND OF THE INVENTION

[0003] Over recent years, a substantial amount of interest has grown in developing commercially viable PWRs that utilize the phenomenon of natural circulation (also known as thermosiphon effect) to circulate the primary coolant to both cool the nuclear reactor and to vaporize a secondary coolant into motive vapor.

[0004] CAREM (Argentina) is a 100 MW(e) PWR reactor design with an integrated self-pressurized primary system through which the primary coolant circulation is achieved by natural circulation. The CAREM design incorporates several passive safety systems. The entire primary system including the core, steam generators, primary coolant and steam dome are contained inside a single pressure vessel. The strong negative temperature coefficient of reactivity enhances the self-controlling features. The reactor is practically self-controlled and need for control rod movement is minimized. In order to keep a strong negative temperature coefficient of reactivity during the whole operational cycle, it is not necessary to utilize soluble boron for burn-up compensation. Reactivity compensation for burn-up is obtained with burnable poisons, i.e. gadolinium oxide dispersed in the uranium di-oxide fuel. Primary coolant enters the core from the lower plenum. After being heated the primary coolant exits the core and flows up through the riser to the upper dome. In the upper part, the primary coolant leaves the riser through lateral windows to the external region, then flows down through modular steam generators, decreasing its enthalpy by giving up heat to the secondary coolant in the steam generator. Finally, the primary coolant exits the internal steam generators and flows down through the down-comer to the lower plenum, closing the circuit. CAREM uses once-through straight tube steam generators. Twelve steam generators are arranged in an annular array inside the pressure vessel above the core. The primary coolant flows through the inside of the tubes, and the secondary coolant flows across the outside of the tubes. A shell and two tube plates form the barrier between primary and secondary coolant flow circuits.

[0005] AST-500 (Russia) is a 500 MW(th) reactor design intended to generate low temperature heat for district heating and hot water supply to cities. AST-500 is a pressurized water reactor with integral layout of the primary components and natural circulation of the primary coolant. Features of the AST-500 reactor include natural circulation of the primary

coolant under reduced working parameters and specific features of the integral reactor, such as a built-in steam-gas pressurizer, in-reactor heat exchangers for emergency heat removal, and an external guard vessel.

[0006] V-500 SKDI *(Russia) is a 500 MW(e) light water integral reactor design with natural circulation of the primary coolant in a vessel with a diameter less than 5 m. The reactor core and the steam generators are contained within the steel pressure vessel (i.e., the reactor pressure vessel). The core has 121 shroudless fuel assemblies having 18 control rod clusters. Thirty six fuel assemblies have burnable poison rods. The hot primary coolant moves from the core through the riser and upper shroud windows into the steam generators located in the downcomer. The coolant flows due to the difference in coolant densities in the downcomer and riser. The pressurizer is connected by two pipelines, to the reactor pressure vessel and the water clean up system.

[0007] The NHR-200 (China) is a design for providing heat for district heating, industrial processes and seawater desalination. The reactor power is 200 MW(th). The reactor core is located at the bottom of the reactor pressure vessel (RPV). The system pressure is maintained by N2 and steam. The reactor vessel is cylindrical. The RPV is 4.8 m in diameter, 14 m in height, and 197 tons in weight. The guard vessel consists of a cylindrical portion with a diameter of 5 m and an upper cone portion with maximum 7 m in diameter. The guard vessel is 15.1 m in height and 233 tons in weight. The core is cooled by natural circulation in the range from full power operation to residual heat removal. There is a long riser on the core outlet to enhance the natural circulation capacity. The height of the riser is about 6 m. Even in case of interruption of natural circulation in the primary circuit due to a LOCA the residual heat of the core can be transmitted by steam condensed at the uncovered tube surface of the primary heat exchanger.

[0008] While the aforementioned PWRs utilize natural circulation of the primary coolant to both cool the reactor core and heat the secondary coolant, all of these natural circulation PWRs suffer from the drawback that the heat exchange equipment is integrated with and located within the reactor pressure vessel. Such an arrangement not only makes the heat exchange equipment difficult to repair and/or service but also subjects the equipment to corrosive conditions. Furthermore, locating the heat exchange equipment within the reactor pressure vessel results in increased complexity and a potential increase in the number of penetrations into the reactor pressure vessel. However, prior to the present invention, the location of the heat exchange equipment within the reactor pressure vessel was likely deemed necessary to achieve the natural circulation of the primary coolant in the PWR cycle.

[0009] A drawback of other PWRs that exist in the art is the fact that the reactor pressure vessels have penetrations at both the top portion of the reactor pressure vessel and at the bottom portion of the reactor pressure vessel. Still another drawback of existing PWRs is the fact that a substantial length of piping and a large number of joints are used carry the primary coolant from the reactor pressure vessel to the heat exchange equipment, thereby increasing the danger of failure due to a pipe break scenario.

BRIEF SUMMARY OF THE INVENTION

[0010] These, and other drawbacks, are remedied by the present invention. A nuclear reactor system is presented herein that, in one embodiment, utilizes natural circulation

(i.e., thermosiphon) to circulate a primary coolant in a single-phase through a reactor core and a heat exchange sub-system, wherein the heat exchange sub-system is located outside of the nuclear reactor pressure vessel. In some embodiments, the heat exchange sub-system is designed so as to not cause any substantial pressure drop in the flow of the primary coolant within the heat exchange sub-system that is used to vaporize a secondary coolant. In another embodiment, a nuclear reactor system is disclosed in which the reactor core is located below ground and all penetrations into the reactor pressure vessel are located above ground. In certain embodiment, the inventive nuclear reactor system is a PWR system.

[0011] In one embodiment, the invention can be a natural circulation nuclear reactor system comprising: a reactor pressure vessel having an internal cavity; a reactor core comprising nuclear fuel disposed within the internal cavity at a bottom portion of the reactor pressure vessel; a heat exchange sub-system located outside of the reactor pressure vessel; a closed-loop primary coolant circuit that flows a primary coolant through the reactor pressure vessel to cool the reactor core and through the heat exchange sub-system to transfer heat to a secondary coolant; and wherein operation of the reactor core causes natural circulation of the primary coolant through the closed-loop primary coolant circuit in a single phase.

[0012] In another embodiment, the invention can be a nuclear reactor system comprising: an elongated reactor pressure vessel having an internal cavity containing a primary coolant, the reactor pressure vessel extending along a substantially vertical axis, a major portion of the axial length of the reactor pressure vessel located below a ground level; a reactor core comprising nuclear fuel disposed within the internal cavity at a bottom portion of the reactor pressure vessel reactor and below the ground level; the reactor pressure vessel comprising a primary coolant outlet port located above the ground level; the reactor pressure vessel comprising a primary coolant inlet port located above the ground level; a heat exchange sub-system located outside of the reactor pressure vessel and above the ground level, an incoming hot leg of the heat exchange system fluidly coupled to the primary coolant outlet port and an outgoing cold leg of the heat exchange system fluidly coupled to the primary coolant inlet port; and wherein the major portion of the reactor pressure vessel is free of penetrations.

[0013] In yet another embodiment, the invention can be a nuclear reactor system comprising: an elongated reactor pressure vessel having an internal cavity containing a primary coolant, the reactor pressure vessel extending along a substantially vertical axis; a reactor core comprising nuclear fuel disposed within the internal cavity at a bottom portion of the reactor pressure vessel reactor; a partition dividing the internal cavity of the reactor pressure vessel into a primary coolant riser passageway and a primary coolant downcomer passageway, the reactor core disposed within the primary coolant riser passageway; the reactor pressure vessel comprising a primary coolant outlet port in fluid communication with a top portion of the primary coolant riser passageway; the reactor pressure vessel comprising a primary coolant inlet port in fluid communication with a top portion of the primary downcomer riser passageway; at least one steam generator located outside of the reactor pressure vessel, an incoming hot leg of the steam generator fluidly coupled to the primary coolant outlet port and an outgoing cold leg of the steam generator fluidly coupled to the primary coolant inlet port; and wherein the steam generator does not cause any substantial pressure

drop in a flow of the primary coolant through the steam generator resulting from an increase in elevation.

[0014] Further areas of applicability of the present invention will become apparent from the detailed description provided hereinafter. It should be understood that the detailed description and specific examples, while indicating the preferred embodiment of the invention, are intended for purposes of illustration only and are not intended to limit the scope of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

[0015] The present invention will become more fully understood from the detailed description and the accompanying drawings, wherein:

[0016] FIG. 1 is a schematic of a natural circulation nuclear reactor system according to one embodiment of the present invention.

[0017] FIG. 2 is a schematic of an embodiment of a heat exchange sub-system that can be used in the natural circulation reactor system of FIG. 1.

[0018] FIG. 3A is a schematic top view of a single-pass horizontal steam generator in accordance with an embodiment of the present invention.

[0019] FIG. 3B is a schematic side view of the single-pass horizontal steam generator of FIG. 3A.

[0020] FIG. 4 is a side view of a portion of the natural circulation nuclear reactor system of FIG. 1 according to one structural embodiment:

[0021] FIG. 5 is an elevated isometric view of a portion of the natural circulation nuclear reactor system of FIG. 1 according to one structural embodiment.

DETAILED DESCRIPTION OF THE DRAWINGS

[0022] The following description of the preferred embodiment(s) is merely exemplary in nature and is in no way intended to limit the invention, its application, or uses.

[0023] Prior to discussing FIGS. 1-5 in detail, an overview of one specific embodiment of the inventive natural circulation reactor system, and its operation, will be set forth. Those skilled in the art will appreciate that the overview is directed to one very specific embodiment and that the details thereof are not limiting of the present invention in all embodiments. Furthermore, those skilled in the art will appreciate how the overview applies to the subsequent detailed discussion of FIGS. 1-5.

I. Overview of one Potential Commercial Embodiment

[0024] The inventive nuclear reactor system, in one potential commercial embodiment, is a 145 MWe nuclear reactor designed to provide an economical and safe source of clean energy from nuclear fission. Strengths of the inventive nuclear reactor system include its inherent safety and simplicity of operation. The operational simplicity of the inventive nuclear reactor system and the modest outlay required to establish and commission it will make it possible to deliver the fruits of pollution-free nuclear energy to the vast mass of humanity around the globe that does not presently have access to a reliable source of power or to a robust electrical energy delivery system. Competitive with large nuclear reactors on a per-megawatt basis, the inventive nuclear reactor system is tailored to add generation capacity to the installed base incrementally with incremental capital outlays. Due to its inherent operational simplicity, the inventive nuclear reac-

tor system requires a minimal cadre of trained personnel to run the plant. Multiple units of the inventive nuclear reactor system can be clustered at one location or geographically dispersed without a significant increase in the per-megawatt construction cost. Geographical dispersal and underground configuration serve as natural antidotes to post-9/11 concerns. The modest power output of the inventive nuclear reactor system makes it a viable candidate source of reliable electrical energy or for providing heating steam to a city or process steam as a cogeneration plant serving an industrial plant.

[0025] As a passive small modular reactor of the PWR genre with safety, ease of maintenance and superb security, the inventive nuclear reactor system is ideally suited to serve as a reliable power source to strategic national assets of any country. Design features of the inventive nuclear reactor system that speak to its inherent safety and reliability are:

[0026] 1. Reactor Core Deep Underground

[0027] The reactor core resides deep underground in a thick-walled reactor pressure vessel (RPV) made of an ASME Code material that has decades of proven efficacy in maintaining reactor integrity in large PWR and BWR reactors. All surfaces wetted by the reactor coolant are made of stainless steel or Inconel, which eliminates a major source of crud accumulation in the reactor vessel.

[0028] 2. Natural Circulation of the Reactor Coolant

[0029] The inventive nuclear reactor system does not rely on any active components, such as a reactor coolant pump, for circulating the primary coolant through the closed-loop primary coolant circuit, which includes flow through the reactor core and the heat exchange sub-system. Instead, the flow of the primary coolant through the reactor pressure vessel, the horizontal steam generators, and other miscellaneous equipment occurs by the pressure head created by density differences in the flowing water in the hot and cold segments of the closed-loop primary coolant circuit. The reliability of gravity as a motive force underpins inherent safety of the inventive nuclear reactor system. The movement of the primary coolant requires no pumps, valves, or moving machinery of any kind, in certain embodiments.

[0030] 3. No Reliance on Off-Site Power

[0031] Offsite power is not essential for shutting down the inventive nuclear reactor system. The rejection of reactor residual heat during the shutdown also occurs by natural circulation. Thus, the need for an emergency shutdown power supply at the site—a major concern for nuclear plants—is eliminated.

[0032] 4. Assurance of a Large Inventory of Water Around and Over the Reactor Core

[0033] The reactor pressure vessel of the inventive nuclear reactor system has no penetrations in its below-ground portion, which can be the bottom 100 feet, which means that the reactor core will remain submerged in a large inventory of water. All penetrations in the reactor pressure vessel are located in the above-ground portion, or top portion, of the reactor pressure vessel and are small in size. The absence of large piping in the closed-circuit primary coolant circuit precludes the potential of a “large break” LOCA event.

[0034] 5. All Critical Components Readily Accessible

[0035] Both the heat exchange sub-system, which includes the steam generators, and the control rod drive system are located outside the reactor pressure vessel at a level that facilitates easy access, making their preventive maintenance and repair a conveniently executed activity. Each of the steam

generators is a horizontal pressure vessel with built-in design features to conveniently access and plug tubes.

[0036] 6. Demineralized Water

[0037] The primary coolant (which can also be referred to as the reactor coolant) is demineralised water, which promotes criticality safety because of its strong negative reactivity gradient with rise in temperature. Elimination of boric acid also simplifies the nuclear steam supply system (NSSS) by eliminating the systems and equipment needed to maintain and control boron levels in the primary coolant. Pure water and corrosion resistant primary coolant loop help minimize crud buildup in the reactor pressure vessel.

[0038] 7. Modularity

[0039] One can build only one of the inventive nuclear reactor systems at a site, or a large number thereof. Clustering a number of inventive nuclear reactor systems at one site will reduce the overall O&M costs.

[0040] 8. Long Operating Cycle

[0041] The inventive nuclear reactor system will operate for approximately 3.5 years before requiring refueling.

[0042] 9. Short Construction Life Cycle

[0043] Virtually all components of the inventive nuclear reactor system are shop fabricated. Site work is limited to reinforced concrete construction and a limited amount of welding to assemble the shop-built equipment and parts. As a result, it is possible to complete the construction of one of the inventive nuclear reactor systems in 24 months from the first shovel in the ground.

[0044] 10. Efficient Steam Cycle

[0045] A pair of two horizontal steam generators are arranged in series and integrally welded to the reactor pressure vessel. The efficiency of the power cycle of the inventive nuclear reactor system, and its compactness, is further enhanced by superheaters that are integrally welded to the horizontal steam generators. The superheaters, one attached to each steam generator, increases cycle efficiency and also protect both the high pressure and low pressure turbines from the deleterious effect of moist steam.

[0046] 11. Integral Pressurizer

[0047] The design of the reactor pressure vessel incorporates an integral pressurizer that occupies the upper reaches of the reactor pressure vessel. The pressurizer serves to control the pressure in the reactor vessel.

[0048] 12. Suitable for Water-Challenged Sites

[0049] The inventive nuclear reactor system can be installed at sites with limited water availability, such as creeks and small rivers that are inadequate for large reactors. The inventive nuclear reactor system can be operated equally well in a water-challenged region by using air-cooled condenser technology to reject the plant’s waste heat. Using air in lieu of water, of course, results in a moderate increase in the plant’s cost.

[0050] 12. System Parameters in the Safe and Proven Range

[0051] The operating pressure and temperature within the reactor pressure vessel is in the proven range for PWRs. Lower core power density than that used in large PWRs for improved thermal-hydraulic control (please see table below) and an improved margin to departure-from-nucleate boiling in the reactor core.

Exemplary System Parameters	Data
Number of fuel assemblies in the core	32
Nominal thermal power, MWt	446
Nominal recirculation rate, MLb per hour	5.46
Reactor water outlet temperature, deg. F.	580
Reactor water inlet temperature, deg. F.	333
Reactor pressure, pounds per sq. inch	2,250
Water in the RV cavity, gallons	30.00

[0052] 13. Minimized Piping Runs and Minimum Use of Active Components to Enhance Reliability and Cost Competitiveness

[0053] The amount of piping in the close-loop primary coolant circuit and the secondary coolant circuit in the inventive nuclear reactor system is the least of any nuclear plant design on the market, as is the number of pumps and valves.

[0054] 14. In-Service Inspection

[0055] All weld seams in the primary system including those in the reactor pressure vessel wall are available at all times for inspection. In particular, the weld seams in the reactor pressure vessel can be inspected by operating a manipulator equipped in-service inspection device in the reactor well during power generation. Thus, inventive nuclear reactor system exceeds the in-service inspection capability expected of nuclear plants under ASME Code Section XI.

[0056] 15. Earthquake Hardened Design

[0057] Virtually all major equipment in the inventive nuclear reactor system are either underground or horizontally mounted to withstand strong seismic motions. This includes the reactor pressure vessel, the fuel pool, the reactor water storage tank (all underground) and the horizontal steam generators, the horizontal superheaters, and the horizontal kettle reboiler that are floor mounted.

[0058] 16. Aircraft Impact Proof Containment

[0059] The containment structure of the inventive nuclear react system is designed to withstand the impact of a crashing fighter plane or a commercial liner without sustaining a thru-wall breach.

II. Detail

[0060] Referring now to FIG. 1, a natural circulation nuclear reactor system 1000 (hereinafter the “reactor system 1000”) is illustrated according to one embodiment of the present invention. The reactor system 1000 generally comprises a reactor pressure vessel 100 and a heat exchange sub-system 200. The reactor pressure vessel 100 contains a primary coolant 101 that is used to cool the reactor core 102 and to heat a secondary coolant within the heat exchange sub-system 200. The reactor pressure vessel 100 is fluidly coupled to an incoming hot leg 201 of the heat exchange sub-system 200 via a primary coolant outlet port 103. Similarly, the reactor pressure vessel 100 is also fluidly coupled to an outgoing cool leg 202 of the heat exchange sub-system 200 via a primary coolant inlet port 104. As a result, a closed-loop primary coolant circuit 300 is formed through which the primary coolant 101 flows in a single-phase. As discussed in greater detail below, the flow of the primary coolant 101 through the closed-loop primary coolant circuit is a natural circulation flow induced by the heat given off by the normal operation of the reactor core 102.

[0061] In certain embodiments, the internal cavity 105 of the reactor pressure vessel 100 is maintained under sufficient pressure to maintain the primary coolant 101 in a liquid-phase despite the high temperature within the reactor pressure vessel 100. In the exemplified embodiment, a pressure control sub-system 50 (commonly referred to in the art as a pressurizer) is located within a top region of the reactor pressure vessel 100 and is configured to control the pressure of the internal cavity 105 of the reactor pressure vessel 100. The pressure control sub-system 50 is integral with the removable head 106 of the reactor pressure vessel 100 to prevent line break concerns and to provide a more compact reactor system 1000. Pressurizers are well known in the art and any standard pressurizer could be used as the pressure control sub-system 50. In one embodiment, the internal cavity 105 of the reactor pressure vessel 100 is maintained at a pressure in a range of 2000 psia to 2500 psia. In one more specific embodiment, the internal cavity 105 of the reactor pressure vessel 100 is maintained at a pressure between 2200 psia to 2300 psia. Of course, the exact pressure maintained in the internal cavity 105 of the reactor pressure vessel 100 is not to be limiting of the invention unless specifically claimed.

[0062] The reactor pressure vessel 100 is an elongated tubular pressure vessel formed by a thick wall made of an acceptable ASME material, such as stainless steel. The reactor pressure vessel 100 extends from a bottom end 107 to a top end 108 along a substantially vertical axis A-A, thereby defining an axial length of the reactor pressure vessel 100. In one embodiment, the reactor pressure vessel 100 has an axial length of over 100 feet to facilitate an adequate level of turbulence in the recirculating primary coolant 101 from the natural circulation (also referred to as thermosiphon action in the art). In certain other embodiments, the reactor pressure vessel 100 has an axial length in a range between 100 feet to 150 feet. Of course, the invention is not so limited in certain alternate embodiments.

[0063] The reactor pressure vessel 100 generally comprises a domed head 106 and a body 109. The domed head 106 is detachably coupled to a top end of the body 109 so as to be removable therefrom for refueling and maintenance. The domed head 106 can be coupled to the body 109 through the use of any suitable fastener, including bolts, clamps, or the like. In the exemplified embodiment, the body 109 comprises an upper flange 110 and the domed head 106 comprises a lower flange 111 that provided mating structures through which bolts 114 (FIG. 4) extend to couple the domed head 106 to the body 109. When the domed head 106 is coupled to the body 109, a hermetic seal is formed therebetween via the use of a gasket or other suitably contoured interface.

[0064] The body 109 of the reactor pressure vessel 100 comprises an upstanding tubular wall 112 and a domed bottom 113 that hermetically seals the bottom end 107 of the reactor pressure vessel 100. The tubular wall 112 has a circular transverse cross-sectional profile in the illustrated embodiment but can take on other shapes as desired. In the exemplified embodiment, the domed bottom 113 is integral and unitary with respect to the tubular wall 112. Of course, in other embodiments, the domed bottom 113 may be a separate structure that is secured to the tubular wall 112 via a welding or other hermetic connection technique, such as the flanged technique described above for the domed head 106 and the body 109. Integral and unitary construct of the domed bottom 113 and the body 109 is, however, preferable in certain

embodiments as it eliminates seams and/or interfaces that could present rupture potential.

[0065] The reactor pressure vessel 100 forms an internal cavity 105 in which a reactor core 102 is housed. The reactor core 102 comprises nuclear fuel, in the form of fuel assemblies, as is known in the art. The details of the structure of the reactor core 102 are not limiting of the present invention in and the reactor system 1000 can utilize any type of reactor core or nuclear fuel. The reactor core 102 is positioned in a bottom portion 115 of the reactor pressure vessel 100. In one embodiment, the reactor core 102 has a core thermal power of 400 MWt to 600 MWt during the operation thereof.

[0066] In one embodiment, the reactor core 102 is comprised of vertically arrayed fuel assemblies. The spacing between the fuel assemblies is governed by the design objective of keeping the reactivity (neutron multiplication factor) at 1.0 at all locations in the reactor pressure vessel 100. The criticality control in the axial direction is provided by the built-in neutron poison in the fuel rods (called IFBAs by Westinghouse) and possibly by control rods.

[0067] A partition 120 is provided within the internal cavity 105 of the reactor pressure vessel 100 that divides the internal cavity into a primary coolant riser passageway 105A and a primary coolant downcomer passageway 105B. Both the passageways 105A, 105B are axially extending vertical passageways that form part of the closed-loop primary coolant circuit 300.

[0068] In the exemplified embodiment, the partition 120 comprises an upstanding tubular wall portion 120A and a transverse wall portion 120B. The tubular wall portion 120A is an annular tube that is mounted within the internal cavity 105 of the reactor pressure vessel 100 so as to be concentrically arranged with respect to the upstanding wall 112 of the reactor pressure vessel 100. As a result, the primary coolant downcomer passageway 105B is an annular passageway that circumferentially surrounds the primary coolant riser passageway 105A. The primary coolant downcomer passageway 105B is formed between an outer surface 121 of the upstanding tubular wall portion 120A of the partition 120 and the inner surface 116 of the upstanding wall 112 of the reactor pressure vessel 100. The primary coolant riser passageway 105B is formed by the inner surface 122 of the upstanding tubular wall portion 120A of the partition 120.

[0069] The transverse wall portion 120B is annular ring-like plate that is connected to a top end of the of the upstanding tubular wall portion 120A of the partition 120 at one end and to the upstanding wall 112 of the reactor pressure vessel 100 on the other end. The transverse wall portion 120B acts a separator element that prohibits cross-flow of the primary coolant 101 between the primary coolant riser passageway 105A and the primary coolant downcomer passageway 105B within the top portion 117 of the reactor pressure vessel 100. In essence, the transverse wall portion 120B forms a roof of the primary coolant downcomer passageway 105B that prevents the heated primary coolant 101 that exits the reactor pressure vessel 100 via the primary coolant outlet port 103 from mixing with the cooled primary coolant 101 that enters the reactor pressure vessel 100 via the primary coolant inlet port 104, and vice-versa. Cross-flow of the primary coolant 101 between the primary coolant riser passageway 105A and the primary coolant downcomer passageway 105B is prohibited by the upstanding tubular wall portion 120A of the partition 120.

[0070] In addition to physically separating the flow of the heated and cooled primary coolant 101 within the primary coolant downcomer and riser passageways 105A, 105B as discussed above, the partition 120 also thermally insulates the cooled primary coolant 101 within the primary coolant downcomer passageway 105B from the heated primary coolant 101 within the primary coolant riser passageway 105A. Stated simply, one does not want heat to transfer freely through the partition 120. Thus, it is preferred that the partition 120 be an insulating partition in the sense that its effective coefficient of thermal conductivity (measured radially from the primary coolant riser passageway 105A to the primary coolant downcomer passageway 105B) is less than the coefficient of thermal conductivity of the primary coolant 101.

[0071] Making the effective coefficient of thermal conductivity of the partition 120 less than the coefficient of thermal conductivity of the primary coolant 101 ensures that the primary coolant 101 in the primary coolant downcomer passageway 105B remains cooler than the primary coolant 101 in the primary riser passageway 105A, thereby maximizing the natural circulation rate of the primary coolant 101 through the closed-loop primary coolant circuit 300. In a very simple construction, this can be achieved by creating the partition 120 out of a single solid material that has a low coefficient of thermal conductivity. However, it must be considered that the material should neither degrade nor deform under the operating temperatures and pressures of the reactor pressure vessel 100. In such an embodiment, the effective coefficient of thermal conductivity is simply the coefficient of thermal conductivity of the single solid material.

[0072] In the exemplified embodiment, the low coefficient of thermal conductivity of the partition 120 is achieved by making the partition 120 as a multi-layer construction. As exemplified, the partition 120 comprises an insulating layer 124 that is sandwiched between two outer layers 125A, 125B. In one embodiment, the insulating layer 124 is a refractory material while the outer layers 125A, 125B are stainless steel or another corrosion resistant material. In certain embodiments, the insulating layer 124 is full encased in the outer layers 125A, 125B.

[0073] The internal cavity 115 of the reactor pressure vessel 100 also comprises a plenum 118 at the bottom portion 115 of the reactor pressure vessel 100 that allows cross-flow of the primary coolant 101 from the primary coolant downcomer passageway 105B to the primary coolant riser passageway 105A. In the exemplified embodiment, the plenum 118 is created by the fact that the bottom end 123 of the upstanding tubular wall portion 120A of the partition 120 is spaced from the inner surface 119 of the domed bottom 113, thereby creating an open passageway. In alternate embodiments, the partition 120 may extend all the way to the inner surface 119 of the domed bottom 113. In such embodiments, the plenum 118 will be formed by providing a plurality of apertures/openings in the partition 120 so as to allow the desired cross-flow.

[0074] The internal cavity 105 further comprises a plenum 126 at the top portion 117 of the reactor pressure vessel 100. The plenum 126 allows the heated primary coolant 101 that is rising within the primary coolant riser passageway 105A to gather in the top portion 117 of the reactor pressure vessel 100 and then flow transversely outward from the vertical axis A-A and through the primary coolant outlet port 103.

[0075] The reactor core 102 is located within the primary coolant riser passageway 105A above the bottom plenum

118. During operation of the reactor core **102**, thermal energy produced by the reactor core **102** is transferred into the primary coolant **101** in the primary coolant riser passageway **105A** adjacent the reactor core **102**, thereby becoming heated. This heated primary reactor coolant **101** rises upward within the primary coolant riser passageway **105A** due to its decreased density. This heated primary coolant **101** gather in the top plenum **126** and exits the reactor pressure vessel **100** via the primary coolant outlet port **103** where it enters the heat exchange sub-system **200** as the incoming hot leg **201**. In one embodiment, the heated primary coolant **101** entering the hot leg **201** of the heat exchanger has a temperature of at least 570° F., and in another embodiment a temperature in a range of 570° F. to 620° F.

[0076] This heated primary coolant **101** passes through the heat exchange sub-system **200** where its thermal energy is transferred to a secondary coolant (described below in greater detail with respect to FIG. 2), thereby becoming cooled and exiting the heat exchange sub-system **200** via the cold leg **202**. When exiting the cold leg **202** of the heat exchange sub-system, this cooled primary coolant **101** has a temperature in a range of 300° F. to 400° F. in one embodiment. In another embodiment, the heat exchange sub-system **200** is designed so that the temperature differential between the heated primary coolant in the hot leg **201** and the cooled primary coolant in the cold leg is at least 220° F.

[0077] The cooled primary coolant **101** exiting the cold leg of the heat exchange sub-system **200** then enters the reactor pressure vessel **100** via the primary coolant inlet port **104**, thereby flowing into a top portion **127** of the primary coolant downcomer passageway **105B**. Once inside the primary coolant downcomer passageway **105B**, the cooled primary coolant **101** (which has a greater density than the heated primary coolant **101** in the primary coolant riser passageway **105A**) flows downward through the primary coolant downcomer passageway **105B** into the bottom plenum **118** where it is drawn back up into the primary coolant riser passageway **105A** and heated again by the reactor core **102**, thereby completing a cycle through the closed-loop primary circuit **300**.

[0078] As discussed above, operation of the reactor core **102** causes natural circulation of the primary coolant **101** through the closed-circuit primary coolant circuit **300** by creating a riser water column within the primary coolant riser passageway **105A** and a downcomer water column within the primary coolant downcomer passageway **105B**. In one embodiment, the riser water column and the downcomer water column have a vertical height in a range of 80 ft. to 150 ft., and more preferably from 80 ft. to 120 ft. The vigorosity of the natural circulation (or termosiphon flow) is determined by the height of the two water columns (fixed by the reactor design), and the difference between the bulk temperature of the two water columns (in water the SES and the downcomer space). For example, water at 2200 psia and 580° F. has density of 44.6 lb/cubic feet. This density increases to 60.5 lb/cubic feet if the temperature reduces to 250° F. The hot and cold water columns 60 feet high will generate a pressure head of 6.6 psi which is available to drive natural circulation of the primary coolant **101** through the closed-loop primary coolant circuit **300**. A 90 feet high column will generate 50% greater head (i.e., 9.9 psi).

[0079] As a result of the natural circulation of the primary coolant **101** achieved by the water columns and gravity, the reactor system **1000** is free of active equipment, such as

pumps or fans, for forcing circulation of the primary coolant through the closed-loop primary coolant circuit.

[0080] In the embodiment illustrated in FIG. 1, the primary coolant outlet port **103** is at a slightly lower elevation (1-3 ft.) than the primary coolant inlet port **104**. However, in other embodiments, the primary coolant outlet port **103** and the primary coolant inlet port **104** will be at substantially the same elevation (see FIGS. 4 and 5). When the primary coolant outlet port **103** and the primary coolant inlet port **104** are at substantially the same elevation the partition **120** will be appropriately designed. Furthermore, as used herein, the term port includes mere apertures or openings.

[0081] In one embodiment, the primary coolant **101** is a liquid that has a negative reactivity coefficient. Thus, the chain reaction in the reactor core **102** would stop automatically if the heat rejection path to the heat exchange sub-system **200** is lost in a hypothetical scenario. Thus, the reactor system **1000** is inherently safe. In one specific embodiment, the primary coolant **101** is demineralized water. All systems and controls used to maintain boron concentration in the reactor vessel in a typical PWR are eliminated from the reactor system **1000**. Moreover, the use of demineralized water as the primary coolant **101** and the existence of the corrosion resistant surfaces of the reactor pressure vessel **100** help maintain crud buildup to a minimum. The reactivity control in the reactor core **102** is maintained by a set of control elements (burnable poisons) that are suspended vertically and occupy strategic locations in and around the fuel assemblies to homogenize and control the neutron flux.

[0082] Referring now to FIGS. 1, 4 and 5 concurrently, it can be seen that a major portion **130** of the axial length of the reactor pressure vessel **100** located below a ground level **400** while a minor portion **131** of the axial length of the reactor pressure vessel **100** extends above the ground level **400**. As such, the reactor core **102** is located deep below the ground level **400** while the heat exchange sub-system **200** is located above the ground level **400**. In one embodiment, the heat exchange sub-system **200** is at an elevation that is 80 ft. to 150 ft., and preferably 80 ft. to 120 ft., greater than the elevation of the reactor core **102**.

[0083] The minor portion **131** of the reactor pressure vessel **100** includes a top portion **132** of the body **109** and the domed head **106**. The primary coolant outlet port **103** and the primary coolant inlet port **104** are located on the minor portion **131** of the reactor pressure vessel **100** that is above the ground level **400**. More specifically, the primary coolant outlet port **103** and the primary coolant inlet port **104** are located on the top portion **132** of the body **109** of the reactor pressure vessel **100** that is above the ground level **400**.

[0084] The major portion **130** includes a majority of the body **109** and the domed bottom **113**. In certain embodiment, the major portion **130** of the reactor pressure vessel **130** is at least 75% of the axial length of the reactor pressure vessel **100**. In other embodiments, the major portion **130** of the reactor pressure vessel **130** is between 60% to 95% of the axial length of the reactor pressure vessel **100**. In another embodiment, the major portion **130** of the reactor pressure vessel **130** is between 75% to 95% of the axial length of the reactor pressure vessel **100**.

[0085] The reactor pressure vessel **100** comprises a reactor flange **150**. The top portion **132** of the body **109** of the reactor pressure vessel **100** is welded to the reactor flange **150**, which is a massive upper forging. The reactor flange **150** also provides the location for the primary coolant inlet port **104** and

the primary coolant outlet port **103** (FIGS. **4** and **5**), and the connections to the heat exchange sub-system **200** (and for the engineered safety systems to deal with various postulated accident scenarios). This reactor flange **150** contains vertical welded lugs to support the weight of the reactor pressure vessel **100** in the reactor well **410** in a vertically oriented cantilevered manner (FIG. **1**). As a result, the reactor pressure vessel **100** is spaced from the wall surfaces **411** and floor surface **412** of the reactor well **410**, thereby allowing the reactor pressure vessel **100** to radially and axially expand as the reactor core **102** heats up during operation and causes thermal expansion of the reactor pressure vessel **100**.

[**0086**] Furthermore, the major portion **130** of the reactor pressure vessel **100** is free of penetrations. In other words, the major portion **130** of the reactor pressure vessel **100** comprises no apertures, holes, opening or other penetrations that are either open or to which pipes or other conduits are attached. All penetrations (such as the primary coolant inlet and outlet ports **103**, **104**) in the reactor pressure vessel **100** are located in the above-ground minor portion **131**, and more specifically in the top portion **132** of the body **109** of the reactor pressure vessel **100**. In one embodiment, it is further preferred that the major portion **130** be a unitary construct with no connections, joints, or welds.

[**0087**] The bottom portion **115** of the reactor pressure vessel **100** is laterally restrained by a lateral seismic restraint system **160** that spans the space between the body **109** of the reactor pressure vessel **100** and the wall surfaces **411** of the reactor well **410** to withstand seismic events. The seismic restraint system **160**, which comprises a plurality of resiliently compressible struts **161**, allows for free axial and diametral thermal expansion of the reactor vessel. The bottom of the reactor well **410** contains engineered features to flood it with water to provide defense-in-depth against a (hypothetical, non-mechanistic) accident that produces a rapid rise in the enthalpy of the reactor's contents. Because the reactor system **1000** is designed to prevent loss of the primary coolant **101** by leaks or breaks and the reactor well **410** can be flooded at will, burn-through of the reactor pressure vessel **100** by molten fuel (corium) can be ruled out as a credible postulate. This inherently safe aspect simplifies the design and analysis of the reactor system **1000**.

[**0088**] Referring now to FIGS. **2** and **4-5** concurrently, an embodiment of the heat exchange sub-system **200** is illustrated. While a specific embodiment of the heat exchange sub-system **200** will be described herein, it is to be understood that, in alternate embodiments, one or more of components can be omitted as desired. For example, in certain embodiments, one or both of the horizontal superheaters **205**, **206** may be omitted. In certain other embodiments, one of the horizontal steam generators **203**, **204** may be omitted and/or combined into the other one of the horizontal steam generators **203,204**. Moreover, additional equipment may be incorporated as necessary so long as the natural circulation of the primary coolant **101** through the closed-loop primary coolant circuit **300** is not prohibited through the introduction of substantial head loss.

[**0089**] As mentioned above, the heat exchange subsystem **200** comprises an incoming hot leg **201** that introduces heated primary coolant into the portion of the closed-loop primary coolant circuit **300** that passes through the heat exchange sub-system **200** and an outgoing cold leg **202** that removes cooled primary coolant from the portion of the closed-loop primary coolant circuit **300** that passes through the heat

exchange sub-system **200**. In order to minimize (and in some embodiments eliminate) pressure loss in the closed-loop primary coolant circuit **300** caused by an increase in the elevation of the primary coolant flow, the steam generators **203**, **204** and the superheaters **205**, **206** are all of the horizontal genre (i.e., the tubes which carry the primary coolant extend substantially horizontal through the shell-side fluid) and are in horizontal alignment with each other where possible.

[**0090**] Within the heat exchange sub-system **200**, the primary coolant flow of the closed-loop primary coolant circuit **300** is divided into two paths **211**, **212** at a flow divider **210**. The flow divider **210** can be a three-way valve, a three-way mass flow controller, or a simple Y plumbing joint. The first path **211**, which carries the majority of the primary coolant flow, travels through the first horizontal steam generator **203** and then through the second horizontal steam generator **204**. Meanwhile, the second path **212**, which carries a minority of the primary coolant flow, travels through the first horizontal superheater **205** and then through the second horizontal superheater **206**. After passing through the first and second horizontal steam generators **203**, **204** and the first and second horizontal superheaters **205**, **206**, the first and second paths **211**, **212** converge in a flow converger **216**, which combines the primary coolant flows of the first and second paths **211**, **212** and directs the combined flow to the outgoing cold leg **202**. As with the flow divider **210**, the flow converger **216** may be a three-way valve, a three-way mass flow controller, or a simple Y plumbing joint.

[**0091**] In one embodiment, 10% to 15% of the incoming primary coolant flow that enters the heat exchange sub-system **200** via the hot leg **201** is directed into the second path **212** while the remaining 85% to 90% of the incoming primary coolant is directed into the first path **211**. In one specific example, the incoming primary coolant that enters the heat exchange sub-system **200** via the hot leg **201** has a flow rate of 5 to 7 million lbs./hr. In this example, 0.6 to 1 million lbs./hr. of the primary coolant is directed into the second path **212** while the remainder of the primary coolant flow is directed into the first path **211**.

[**0092**] The first and second horizontal steam generators **203**, **204** are operably coupled in series to one another along the first path **211** of the closed-loop primary coolant circuit **300**. Both of the horizontal steam generators **203**, **204** are horizontally disposed shell-and-tube heat exchangers. The first horizontal steam generator **203** is a high pressure steam generator while the second horizontal steam generator **204** is a low pressure steam generator (in comparison to the high pressure steam generator). The high first steam generator **203** is located upstream of the second horizontal steam generator **204** along the closed-loop primary coolant circuit **300**. Similarly, the first and second horizontal superheaters **205**, **206** are operably coupled in series to one another along the second path **212** of the closed-loop primary coolant circuit **300**. The first horizontal superheater **205** is a high pressure superheater while the second horizontal superheater **206** is a low pressure superheater (in comparison to the high pressure superheater). The high first steam superheater **205** is located upstream of the second horizontal superheater **206** along the closed-loop primary coolant circuit **300**. Furthermore, the first and second superheaters **205**, **206** are located in parallel to the first and second horizontal steam generators **203**, **204** along the closed-loop primary coolant circuit **300**.

[**0093**] Furthermore, the first and second horizontal steam generators **203**, **204** are interconnected by a return header so

that the hot primary coolant entering the first horizontal steam generator **203** heats the secondary coolant to make steam for the high-pressure turbine **220** and then proceeds to the second horizontal steam generator **204** with minimal pressure loss to make steam for the low-pressure turbine **221**.

[0094] The flow of the primary coolant in the first path **211** is used to convert a secondary coolant flowing through the shell-side of the first and second horizontal steam generators **203, 204** from liquid-phase to gas-phase through the transfer of heat from the primary coolant to the secondary coolant within the first and second horizontal steam generators **203, 204**. Because the flow of the primary coolant through the first and horizontal second steam generators **203, 204** is substantially horizontal in nature, the flow of the primary coolant through the first path **211** does not cause any substantial pressure drop in the closed-loop primary coolant circuit **300** resulting from an increase in elevation. Moreover, because of the horizontal alignment of the first and second horizontal steam generators **203, 204** with each other and the primary coolant outlet and inlet ports **103, 104** of the reactor pressure vessel **100** (FIG. 5), the primary coolant flow that travels along the first path **211** from the primary coolant outlet port **103** of the reactor pressure vessel **100** to the primary coolant inlet port **104** of the reactor pressure vessel **100** does not cause any substantial pressure drop in the closed-loop primary coolant circuit **300** resulting from an increase in elevation. While the achievement of substantial zero pressure drop in the closed-loop primary coolant circuit **300** resulting from an increase in elevation is exemplified in terms of a horizontal flow, it is possible that such substantial zero pressure drop can be achieved by a decline in elevation as the primary coolant flows downstream in the closed-loop primary coolant circuit **300**.

[0095] The flow of the primary coolant in the second path **212** is used to superheat the vapor-phase of the secondary coolant exiting the first and second horizontal steam generators **203, 204** via the first and second horizontal superheaters **205, 206** respectively, thereby further drying the vapor-phase of the secondary coolant. The use of the horizontal superheaters enhance the thermodynamic efficiency of the turbine cycle, carried out on the high pressure turbine **220** and the low pressure turbine **221**.

[0096] The first and second horizontal superheaters **205, 206** are horizontally disposed shell-and-tube heat exchanger positioned directly above (and in series) with the first and second steam generators **203, 204** (FIG. 5). However, due to the slight increase in the elevation of the superheaters **205, 206** resulting from their location above the first and second horizontal steam generators **203, 204**, the flow of the primary coolant in the second path **212** does cause some pressure drop in the closed-loop primary coolant circuit **300** resulting from an increase in elevation. However, because only a small amount (10% to 15%) of the total primary coolant that flows through the heat exchange subsystem **200** is directed into the second path **212** and through the horizontal superheaters **205, 206**, the pressure drop does not significantly affect the desired natural circulation. Moreover, the increase in elevation is negligible when compared to the height of the flow driving water columns. In such an embodiment, at least 85% of the flow of the primary coolant through the heat exchange subsystem **200** is still entirely horizontal from the primary coolant outlet **103** to the primary coolant inlet **104** and does not cause any substantial pressure drop in the closed-loop primary coolant circuit **300** due to increase in elevation. Further,

in certain alternate embodiments, the horizontal superheaters **205, 206** could be eliminated and/or repositioned to be in horizontal alignment with the horizontal steam generators **203, 204**.

[0097] As shown in FIG. 5, the first and second horizontal steam generators **203, 204** are coupled directly to the each other and to the reactor pressure vessel **100**. More specifically, the inlet of the first horizontal steam generator **203** is coupled directly to the primary coolant outlet port **103** of the reactor pressure vessel **100** while the outlet of the first horizontal steam generator **203** is coupled directly to the inlet of the second horizontal steam generator **204**. The outlet of the second horizontal steam generator **204**, is in turn, coupled directly to the primary coolant inlet port **104** of the reactor pressure vessel **100**. The first and second horizontal steam generators **203, 204** are arranged so as to extend substantially parallel to one another, thereby collectively forming a generally U-shaped structure. Thus, the first path **211** also takes on a generally U-shape. In certain embodiments, the first and second horizontal steam generators **203, 204** are integrally welded to the reactor vessel **100** and to each other.

[0098] Referring now to FIGS. 2 and 3A-B, each of the first and second horizontal steam generators **203, 204** comprise a preheating zone **208, 210** and a boiling zone **207, 209**. Both of the first and second horizontal steam generators **203, 204** are of the single-pass type in which the primary coolant flow of the first path **211** is the tube-side fluid. Each of the single-pass tubes **330** extend substantially horizontally through the preheating zones **208, 210** and the boiling zones **207, 209**. The secondary coolant circuit has a main feedwater intake **501** and a return to condenser exit **502** into and out of the heat exchange sub-system **200** respectively.

[0099] The secondary coolant, which is in the liquid-phase **505**, enters each of the first and second horizontal steam generators **203, 204** along line **503**. The incoming liquid phase **505** of the secondary coolant is preheated within the preheater zones **208, 210** of the first and second horizontal steam generators **203, 204**. The secondary coolant in liquid-phase **505** flows through a tortuous path as shell-side fluid in the preheater zones **208, 210** and then enters the boiling zones **207, 209**, where it is further heated by the primary coolant flow passing through the tubes **330**. In the boiling zones **207, 209**, the liquid-phase secondary coolant **505** vaporizes and exits the first and second horizontal steam generators **203, 204** as high pressure and low pressure steam **504** that is respectively supplied to the high and low pressure turbines **220, 221**.

[0100] The shells of the horizontal steam generators **203, 204** and the horizontal superheaters **205, 206** provide additional barriers against potential large-break LOCAs, as do the turning plenum and the eccentric flanges that join the steam generators **203, 204** to the reactor pressure vessel **100**, as shown in FIGS. 4 and 5. All systems connected to the reactor vessel **100** use a similar approach to ensure that there is no potential for a large-break LOCA that could rapidly drain the water from the reactor vessel **100** and uncover the reactor core **102**. As long as the reactor core **102** is covered under all potential conditions of operation and hypothetical accident, the release of radioactive material to the public is minimal.

[0101] As explained in the foregoing, the reactor system **1000** is an intrinsically safe reactor which, in the event of a problem external to the reactor containment building or within containment, is designed to automatically shut down in a safe mode with natural circulation cooling. Nevertheless,

to instill maximum confidence, a number of redundant safety systems can be engineered to protect public health and safety under hypothetical accident scenarios that are unknown or unknowable, i.e., cannot be mechanistically postulated. In the case of an abnormal condition when the normal heat transport path through the steam generators are not available, then the pressure in the reactor vessel 100 will begin to increase. In such a case rupture discs will breach allowing the reactor coolant to flow into a kettle reboiler located overhead. The kettle will have a large inventory of water that will serve to extract the heat from the reactor coolant until the system shuts down. Diverse systems perform duplicate or overlapping functions using different physical principles and equipment to ensure that a common-mode failure is impossible.

[0102] As used throughout, ranges are used as shorthand for describing each and every value that is within the range. Any value within the range can be selected as the terminus of the range. In addition, all references cited herein are hereby incorporated by referenced in their entireties. In the event of a conflict in a definition in the present disclosure and that of a cited reference, the present disclosure controls.

[0103] While the invention has been described with respect to specific examples including presently preferred modes of carrying out the invention, those skilled in the art will appreciate that there are numerous variations and permutations of the above described systems and techniques. It is to be understood that other embodiments may be utilized and structural and functional modifications may be made without departing from the scope of the present invention. Thus, the spirit and scope of the invention should be construed broadly as set forth in the appended claims.

1. A natural circulation nuclear reactor system comprising:
 - a reactor pressure vessel having an internal cavity;
 - a reactor core comprising nuclear fuel disposed within the internal cavity at a bottom portion of the reactor pressure vessel;
 - a heat exchange sub-system located outside of the reactor pressure vessel;
 - a closed-loop primary coolant circuit that flows a primary coolant through the reactor pressure vessel to cool the reactor core and through the heat exchange sub-system to transfer heat to a secondary coolant; and
 - wherein operation of the reactor core causes natural circulation of the primary coolant through the closed-loop primary coolant circuit in a single phase.
2. The natural circulation nuclear reactor system according to claim 1 further comprising:
 - a partition dividing the internal cavity of the reactor pressure vessel into a primary coolant riser passageway and a primary coolant downcomer passageway, the reactor core disposed within the primary coolant riser passageway, wherein operation of the reactor core causes the primary coolant to rise within the primary coolant riser passageway;
 - the reactor pressure vessel comprising a primary coolant outlet port located at a top portion of the reactor pressure vessel in fluid communication with the primary coolant riser passageway;
 - the reactor pressure vessel comprising a primary coolant inlet port located at a top portion of the reactor pressure vessel in fluid communication with the primary coolant downcomer passageway; and

a plenum at the bottom portion of the reactor vessel that allows cross-flow of the primary coolant from the primary coolant downcomer passageway to the primary coolant riser passageway.

3. (canceled)

4. The natural circulation nuclear reactor system according to claim 2 wherein the partition has an effective coefficient of thermal conductivity measured from the primary coolant riser passageway to the primary coolant downcomer passageway that is less than an effective coefficient of thermal conductivity of the primary coolant.

5. The natural circulation nuclear reactor system according to claim 2 wherein the partition is a tubular structure having an inner surface and an outer surface, the inner surface of the tubular structure forming the primary coolant riser passageway, and the primary coolant downcomer passageway being formed between the outer surface of tubular structure and the inner surface of the reactor pressure vessel, the primary coolant downcomer passageway being an annular passageway that circumferentially surrounds the primary coolant riser passageway.

6.-8. (canceled)

9. The natural circulation nuclear reactor system according to claim 1 wherein the reactor pressure vessel extends along a substantially vertical axis, a major portion of the axial length of the reactor pressure vessel located below a ground level, and the reactor core located below the ground level and the heat exchange sub-system located above the ground level.

10. The natural circulation nuclear reactor system according to claim 9 further comprising:

a partition dividing the internal cavity of the reactor pressure vessel into a primary coolant riser passageway and a primary coolant downcomer passageway, the reactor core disposed within the primary coolant riser passageway;

the reactor pressure vessel comprising a primary coolant outlet port located at a top portion of the reactor pressure vessel above the ground level and in fluid communication with the primary coolant riser passageway, the primary coolant outlet port fluidly coupled to the heat exchange sub-system to form an incoming hot leg of primary coolant of the heat exchange sub-system; and

the reactor pressure vessel comprising a primary coolant inlet port located at the top portion of the reactor pressure vessel above the ground level and in fluid communication with the primary coolant downcomer passageway, the primary coolant inlet port fluidly coupled to the heat exchange sub-system to form an outgoing cool leg of primary coolant of the heat exchange sub-system.

11. The natural circulation nuclear reactor system according to claim 10 wherein the primary coolant has a first high temperature in the incoming hot leg and a second low temperature in the outgoing cool leg, the first high temperature being at least 220° F. greater than the second low temperature.

12.-14. (canceled)

15. The natural circulation nuclear reactor system according to claim 9 wherein the reactor pressure vessel comprises a flange portion that supports the major portion of the reactor pressure vessel below the ground level in a vertically-oriented cantilevered manner within a reactor well.

16.-19. (canceled)

20. The natural circulation nuclear reactor system according to claim 1 wherein the heat exchange sub-system comprises a first horizontal steam generator and a second hori-

zontal steam generator operably coupled in series with one another other along the closed-loop primary coolant circuit, the first and second steam generators converting the secondary coolant from liquid-phase to gas-phase via the heat transferred from the primary coolant.

21. The natural circulation nuclear reactor system according to claim **20** wherein the first horizontal steam generator is a high pressure steam generator and the second horizontal steam generator is a low pressure steam generator, the high pressure steam generator being upstream of the low pressure steam generator along the closed-loop primary coolant circuit.

22. (canceled)

23. The natural circulation nuclear reactor system according to claim **20** wherein the first and second horizontal steam generators are single-pass heat exchangers, the primary coolant being a tube-side fluid in both the first and second horizontal steam generators, and wherein the first and second horizontal steam generators do not cause any substantial pressure drop in the closed-loop primary coolant circuit due to increase in elevation.

24. (canceled)

25. The natural circulation nuclear reactor system according to claim **20** wherein an inlet of the first horizontal steam generator is coupled directly to a primary coolant outlet port of the reactor pressure vessel, an outlet of the first horizontal steam generator is coupled directly to an inlet of the second horizontal steam generator, and an outlet of the second horizontal steam generator is coupled directly to a primary coolant inlet port of the reactor pressure vessel.

26. (canceled)

27. The natural circulation nuclear reactor system according to claim **25** wherein the first and second horizontal steam generators are integrally welded to the reactor vessel.

28. The natural circulation nuclear reactor system according to claim **20** wherein the heat exchange sub-system comprises a first superheater configured to heat the vapor-phase of the secondary coolant exiting the first steam generator and a second superheater configured to heat the vapor-phase of the secondary coolant exiting the second steam generator, wherein the first and second superheaters are operably coupled to one another in series along the closed-loop primary coolant circuit and in parallel to the first and second steam generators along the closed-loop primary coolant circuit.

29. The natural circulation nuclear reactor system according to claim **28** wherein between 10% to 15% of the flow of the primary coolant through the heat exchange sub-system is directed through the first and second superheaters, the remainder of the flow of the primary coolant through the heat exchange sub-system being directed through the first and second steam generators.

30. (canceled)

31. The natural circulation nuclear reactor system according to claim **1** wherein operation of the reactor core causes natural circulation of the primary coolant by creating a riser water column and a downcomer water column within the internal cavity of the reactor pressure vessel, the riser water column and the downcomer water column having a vertical height in a range of 80 ft. to 120 ft.

32. The natural circulation nuclear reactor system according to claim **1** wherein the primary coolant has a negative reactivity coefficient.

33. (canceled)

34. (canceled)

35. The natural circulation nuclear reactor system according to claim **1** wherein the internal cavity of the reactor pressure vessel is maintained at a pressure in a range of 2000 psia to 2500 psia.

36. (canceled)

37. The natural circulation nuclear reactor system according to claim **1** wherein the heat exchange sub-system is at an elevation that is 80 ft. to 120 ft. greater than an elevation of the reactor core.

38. (canceled)

39. A nuclear reactor system comprising:

an elongated reactor pressure vessel having an internal cavity containing a primary coolant, the reactor pressure vessel extending along a substantially vertical axis, a major portion of the axial length of the reactor pressure vessel located below a ground level;

a reactor core comprising nuclear fuel disposed within the internal cavity at a bottom portion of the reactor pressure vessel reactor and below the ground level;

the reactor pressure vessel comprising a primary coolant outlet port located above the ground level;

the reactor pressure vessel comprising a primary coolant inlet port located above the ground level;

a heat exchange sub-system located outside of the reactor pressure vessel and above the ground level, an incoming hot leg of the heat exchange system fluidly coupled to the primary coolant outlet port and an outgoing cold leg of the heat exchange system fluidly coupled to the primary coolant inlet port; and

wherein the major portion of the reactor pressure vessel is free of penetrations.

40. The nuclear reactor system according to claim **39** further comprising:

a partition dividing the internal cavity of the reactor pressure vessel into a primary coolant riser passageway and a primary coolant downcomer passageway, the reactor core disposed within the primary coolant riser passageway;

the primary coolant outlet port in fluid communication with a top portion of the primary coolant riser passageway ; and

the primary coolant inlet port in fluid communication with a top portion of the primary coolant downcomer passageway.

41. The nuclear reactor system according to claim **40** wherein the partition has an effective coefficient of thermal conductivity measured from the primary coolant riser passageway to the primary coolant downcomer passageway that is less than an effective coefficient of thermal conductivity of the primary coolant.

42. The nuclear reactor system according to claim **40** wherein the primary coolant has a first high temperature in the incoming hot leg and a second low temperature in the outgoing cool leg, the first high temperature being at least 220° F. greater than the second low temperature.

43. The nuclear reactor system according to claim **39** wherein the major portion of the reactor pressure vessel is at least 75% of the axial length of the reactor pressure vessel.

44. (canceled)

45. (canceled)

46. The nuclear reactor system according to claim **39** wherein the heat exchange sub-system and the internal cavity of the reactor pressure vessel collectively form a closed-loop

primary coolant circuit that flows the primary coolant through the reactor pressure vessel to cool the reactor core and through the heat exchange sub-system to transfer heat to a secondary coolant, wherein operation of the reactor core causes natural circulation of the primary coolant through the closed-loop primary coolant circuit in a single phase, and wherein the secondary coolant is converted from liquid-phase to gas-phase within the heat exchange sub-system by the heat transferred from the primary coolant.

47. (canceled)

48. The nuclear reactor system according to claim 46 wherein the heat exchange sub-system comprises a first horizontal steam generator and a second horizontal steam generator operably coupled in series with one another other along the closed-loop primary coolant circuit, the first and second steam generators converting the secondary coolant from liquid-phase to gas-phase via the heat transferred from the primary coolant.

49. The nuclear reactor system according to claim 48 wherein the first and second horizontal steam generators are single-pass heat exchangers, the primary coolant being a tube-side fluid in both the first and second horizontal steam generators, and wherein the first and second horizontal steam generators do not cause any substantial pressure drop in the closed-loop primary coolant circuit due to increase in elevation.

50. The nuclear reactor system according to claim 48 wherein an inlet of the first horizontal steam generator is coupled directly to the primary coolant outlet port of the reactor pressure vessel, an outlet of the first horizontal steam generator is coupled directly to an inlet of the second horizontal steam generator, and an outlet of the second horizontal steam generator is coupled directly to the primary coolant inlet port of the reactor pressure vessel.

51. (canceled)

52. (canceled)

53. The nuclear reactor system according to claim 46 wherein the primary coolant has a negative reactivity coefficient.

54. A nuclear reactor system comprising:

an elongated reactor pressure vessel having an internal cavity containing a primary coolant, the reactor pressure vessel extending along a substantially vertical axis;
a reactor core comprising nuclear fuel disposed within the internal cavity at a bottom portion of the reactor pressure vessel reactor;

a partition dividing the internal cavity of the reactor pressure vessel into a primary coolant riser passageway and a primary coolant downcomer passageway, the reactor core disposed within the primary coolant riser passageway;

the reactor pressure vessel comprising a primary coolant outlet port in fluid communication with a top portion of the primary coolant riser passageway;

the reactor pressure vessel comprising a primary coolant inlet port in fluid communication with a top portion of the primary downcomer riser passageway;

at least one steam generator located outside of the reactor pressure vessel, an incoming hot leg of the steam generator fluidly coupled to the primary coolant outlet port and an outgoing cold leg of the steam generator fluidly coupled to the primary coolant inlet port; and

wherein the steam generator does not cause any substantial pressure drop in a flow of the primary coolant through the steam generator resulting from an increase in elevation.

55. (canceled)

56. (canceled)

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