

**SSME FMEA/CIL
REDUNDANCY SCREEN**

Component Group: Igniters and Sensors
 CIL Item: J220-02
 Component: HPFTP Discharge Pressure Transducers (F4.1), HPOTP Discharge Pressure Transducers (O6.1)
 Part Number: RE2233/RES7001
 Failure Mode: Leakage Into sensor housing.

Prepared: M. Oliver
 Approved: T. Nguyen
 Approval Date: 3/30/99
 Change #: 4
 Directive #: CCB D ME3-01-4994
 Page: 1 of 1

Phase	Failure / Effect Description	Criticality Hazard Reference
SMC 4.1	Leakage results in housing failure. Overpressurization of aft compartment. Loss of vehicle. Redundancy Screens: SINGLE POINT FAILURE N/A	1 ME-D3S,A,M,C, ME-C3S,A,M,C

SSME EA/CIL
DESIGN

Component Group: Igniters and Sensors
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Page: 1 of 1

Design / Document Reference

FAILURE CAUSE: A: Parent material or weld failure in pressure-containing cavity.

THE DIAPHRAGM AND A PORTION OF THE ISOLATOR ASSEMBLY ARE MANUFACTURED FROM A-286. STRENGTH, DUCTILITY, ELASTIC MODULUS, RESISTANCE TO CORROSION, AND RESISTANCE TO HYDROGEN ENVIRONMENT EFFECTS ARE THE PRIMARY REASONS FOR SELECTING A-286 (1). THE REMAINDER OF THE ISOLATOR ASSEMBLY, PRESSURE CAVITY, AND EXTERNAL CASE ARE MANUFACTURED FROM 304L CRES. THIS MATERIAL WAS SELECTED FOR ITS STRENGTH, WELDABILITY, CORROSION RESISTANCE, AND RESISTANCE TO STRESS CORROSION CRACKING (1). THE DESIGN CRITERIA FOR THE PRESSURE REFERENCE CAVITY REQUIRES THE UNIT BE CAPABLE OF WITHSTANDING 1.5 TIMES THE FULL SCALE PRESSURE, WITHOUT COMPONENT DAMAGE. (2) DESIGN REQUIRES BURST PRESSURE TO BE 3 TIMES FULL SCALE PRESSURE, TO A MAXIMUM VALUE OF 20,000 LBS. (2).

THE SENSORS ARE A VENDOR ITEM. DRAWING SPECIFICATIONS AND MANUFACTURING PROCESSES ARE CONTROLLED BY ROCKETDYNE (2). WELD CONTROLS INCLUDE WELD PREPARATION, CLEANLINESS, OPERATOR CERTIFICATION, AND WELD PARAMETERS (2). ALL SENSOR DESIGNS ARE SUBJECTED TO A CRITICAL DESIGN REVIEW. ANY DESIGN CHANGES ARE RE-REVIEWED (2). THE SENSORS HAVE COMPLETED DESIGN VERIFICATION TESTING (3), INCLUDING VIBRATION TESTING (4). THE MINIMUM FACTORS OF SAFETY MEET CEI REQUIREMENTS (5). THE SENSORS WERE ANALYZED FOR HIGH CYCLE FATIGUE AND LOW CYCLE FATIGUE LIFE AND MEET CEI REQUIREMENTS (6) WITH EXCEPTION TO THOSE SENSORS CONTROLLED BY MAJOR WAIVER. PRESSURE SENSORS INSTALLED AT SEVEN ENGINE LOCATIONS (PBP/LPOTP/HPFTP/HPFTP COOLANT LINER/HPOTP SS CAVITY AND HPOTP POGO PRECHARGE) ARE HIGH CYCLE FATIGUE LIFE LIMITED BY MAJOR WAIVER (7). ONLY EATON PRESSURE SENSORS ARE TO BE USED IN REDLINE PERFORMANCE AND ENGINE READY PARAMETERS. TABLE J220 LISTS ALL THE FMEA/CIL WELDS AND IDENTIFIES THOSE WELDS IN WHICH THE CRITICAL INITIAL FLAW SIZE IS NOT DETECTABLE, AND THOSE WELDS IN WHICH THE ROOT SIDE IS NOT ACCESSIBLE FOR INSPECTION. THESE WELDS HAVE BEEN ASSESSED AND DETERMINED TO HAVE IMPROVED ULTIMATE AND YIELD STRENGTHS, ENDURANCE LIMITS AND FRACTURE TOUGHNESS OVER THOSE WELDS LIST IN THE WELD ASSESSMENT (8). SENSORS FROM ENGINE 2010 WERE RE-SUBJECTED TO ACCEPTANCE TESTING. ALL SENSORS MET ACCEPTANCE CRITERIA FOR THIS FAILURE MODE.

(1) RSS-8582; (2) RC7001; (3) DVS-SSME-203, RSS-8660; (4) RSS-203-13, RSS-203-14; (5) RSS-8546, CP320R0003B; (6) RL00532, CP320R0003B; (7) DAR 2147; (8) VRS-0550

**SSME FMEA/CIL
INSPECTION AND TEST**

Component Group: Igniters and Sensors
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Page: 1 of 1

Failure Causes	Significant Characteristics	Inspection(s) / Test(s)	Document Reference
A	SINGLE PICKUP, DUAL OUTPUT, PRESSURE TRANSDUCER		RE2233 / RES7001
	MATERIAL INTEGRITY	MATERIAL INTEGRITY IS VERIFIED PER SPECIFICATION REQUIREMENTS.	
	WELD INTEGRITY	ALL WELDS ARE INSPECTED TO DRAWING AND SPECIFICATION REQUIREMENTS PER WELD CLASS. INSPECTIONS INCLUDE: VISUAL, DIMENSIONAL, PENETRANT, RADIOGRAPHIC, ULTRASONIC, AND FILLER MATERIAL, AS APPLICABLE.	RC7001
	ASSEMBLY INTEGRITY	TRANSDUCERS ARE PROOF PRESSURE TESTED PER SPECIFICATION REQUIREMENTS. VACUUM CASE IS LEAK CHECKED TO VERIFY SEAL PER SPECIFICATION REQUIREMENTS. AFTER THE CASE IS WELDED, HELIUM LEAK TESTS ARE PERFORMED TO VERIFY HERMETIC SEAL.	
	HOT FIRE ACCEPTANCE TESTING (GREEN RUN)	ALL VENDOR INSPECTION AND TEST CRITERIA IS UNDER ROCKETDYNE APPROVAL AND CONTROL. SENSOR OPERATION IS VERIFIED THROUGH HOT FIRE ACCEPTANCE TESTING.	RL00401
	DATA REVIEW	ALL CONTROLLER DATA FROM THE PREVIOUS FLIGHT OR HOT FIRE IS REVIEWED. ANY ANOMALOUS CONDITION NOTED REQUIRES FURTHER TESTING OR HARDWARE REPLACEMENT PRIOR TO THE NEXT FLIGHT.	MSFC PLN 1229
	PRE-FLIGHT CHECKOUT	SENSORS ARE VISUALLY INSPECTED. SENSOR OPERATION IS VERIFIED EVERY MISSION FLOW BY SUCCESSFUL COMPLETION OF THE CONTROLLER SENSOR ELECTRICAL CHECKOUT. (LAST TEST)	OMRSD V418UJ.030 OMRSD V41AQC.010 OMRSD SC0FA0 213

Failure History: Comprehensive failure history data is maintained in the Problem Reporting database (PRAMS/PRACA). Reference: NASA letter SA21788/309 and Rocketdyne letter 88RC09761.

Operational Use: Not Applicable.

1-61

FIELD CONFIGURATION VARIANCES FROM CIL RATIONALE

Component Group: Igniters and Sensors
 Item Name: HPFTP Discharge Pressure Transducers (F4.1), HPOTP Discharge Pressure Transducers (O8.1)
 Item Number: J220
 Part Number: RE2233/RES7001

Prepared: M. Oliver
 Approved: T. Nguyen
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 Directive #: CCBO ME3-01-4994

Page: 1 of 1

Base Line Rationale	Variance	Change Rationale	Variant Dash Number
J220 - These welds have been assessed and determined to have improved ultimate and yield strengths, endurance limits and fracture toughness over those welds listed in the weld assessment (VRS-0650).	Welds were assessed as acceptable for flight by risk assessment (RSS-8756)	New design eliminates one weld and increases overall component strength. USE AS IS RATIONALE: Welded assemblies meet all CEI requirements (RSS-8756).	RES7001-214,234 RE2233-051
J220 - New design improves producibility, inspectability and reliability of the transducer. New design reduces the risk of the introduction of conductive contamination.	An internal vacuum case is used for zero pressure reference point.	New design eliminates internal vacuum case and reduces potential for conductive contamination. USE AS IS rationale: Functionality of zero pressure reference is maintained.	RES7001-214, -234 RE2233-051

SSME FMEA/CIL
WELD JOINTS

Component Group: Igniters and Sensors
 CIL Item: J220
 Component: HPFTP Discharge Pressure Transducers (F4.1), HPOTP Discharge Pressure Transducers (O6.1)
 Part Number: RE2233/RES7001

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 Page: 1 of 1

Component	Basic Part Number	Weld Number	Weld Type	Class	Root Side Not Access	Critical Initial Flaw Size Not Detectable		Comments
						HCF	LCF	
PRESSURE TRANSDUCER	RE2233/RES7001							
PRESSURE TRANSDUCER	JKR1900	CCC-1	EBW	II	X	X	X	
PRESSURE TRANSDUCER	JLD1900	CCC-2	EBW	II	X	X	X	
PRESSURE TRANSDUCER	JVA1900	CCC-5	EBW	II	X			