

**SSME FMEA/CIL**  
**REDUNDANCY SCREEN**

Component Group: Ducts and Lines  
CIL Item: K541-01  
Part Number: R0019431  
Component: HPFTP Bearing Purge Line  
FMEA Item: K541  
Failure Mode: Fails to contain hydrogen.

Prepared: D. Early  
Approved: T. Nguyen  
Approval Date: 7/25/00  
Change #: 1  
Directive #: CCBD ME3-01-5638  
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Phase	Failure / Effect Description	Criticality Hazard Reference
SMC 4.1	Hydrogen leakage into aft compartment. Overpressurization of aft compartment. Loss of vehicle.  Redundancy Screens: SINGLE POINT FAILURE: N/A	1 ME-A1A, ME-D3S,A,M,C

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**SSME EA/CIL  
DESIGN**

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Design / Document Reference

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**FAILURE CAUSE:** A: Parent material failure or weld failure of line.  
B: Parent material failure of plate.

THE LINE ASSEMBLY (1) AND PLATE (2) ARE MANUFACTURED UTILIZING INCONEL 625 TUBE AND BAR. INCONEL 625 WAS SELECTED FOR ITS WELDABILITY, FORMABILITY, RESISTANCE TO STRESS CORROSION CRACKING, AND CORROSION RESISTANCE (3). INCONEL 625 IS NOT SIGNIFICANTLY EFFECTED BY HYDROGEN IN THIS ENVIRONMENT (3). INCONEL 625 POSSESSES THE REQUIRED STRENGTH WITHOUT REQUIRING HEAT TREAT. A STIFFENER IS INCORPORATED ACROSS THE PLATE TO PREVENT FLANGE DISTORTION UNDER PRESSURE. THE STIFFENER INCORPORATES RADII TO PREVENT STRESS RISERS. FLANGE AND ADAPTER SECTIONS INCORPORATE RADIUS JOINTS TO REDUCE STRESS CONCENTRATIONS. OFFSET LIMIT REQUIREMENTS ARE ESTABLISHED TO REDUCE STRESS CONCENTRATIONS AND IMPROVE WELD GEOMETRY. TUBING STOCK IS DRAWN TO MAINTAIN SURFACE REGULARITY. INSTALLATION IS CONTROLLED FOR ANGULARITY AND OFFSET PER SPECIFICATION REQUIREMENTS (4). MINIMUM FACTORS OF SAFETY FOR THE LINE MEET CEI REQUIREMENTS (5). HIGH AND LOW CYCLE FATIGUE LIFE MEET CEI REQUIREMENTS (6). THE LINE ASSEMBLY HAS COMPLETED PRESSURE CYCLING AND ULTIMATE PRESSURE DVS TESTING (7). THE PLATE WAS DVS TESTED DURING ENGINE DVS TESTING (8). THE LINE ASSEMBLY PARENT MATERIAL WAS CLEARED FOR FRACTURE MECHANICS/NDE FLAW GROWTH, SINCE THEY ARE NOT FRACTURE CRITICAL PARTS (9). TABLE K541 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 AS ACCEPTABLE FOR FLIGHT BY RISK ASSESSMENT (10).

(1) R0019431; (2) R0011086; (3) RSS-8582; (4) RA1102-006; (5) RSS-8546, CP320R0003B; (6) RL00532, CP320R0003B; (7) RSS-511-31, RSS-511-45; (8) DVS-SSME-101; (9) NASA TASK 117; (10) RSS-8756

**SSME FMEA/CIL**  
**INSPECTION AND TEST**

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Failure Causes	Significant Characteristics	Inspection(s) / Test(s)	Document Reference
A, B	LINE		R0019431
	FLANGE		RS007159
	ADAPTER		R0011250
	FLANGE		R0011251
	PLATE		R0011086
	MATERIAL INTEGRITY	MATERIAL INTEGRITY IS VERIFIED PER DRAWING REQUIREMENTS.	R0019431 RS007159 R0011250 R0011251 R0011086
		DETAILS ARE PENETRANT INSPECTED PER DRAWING AND SPECIFICATION REQUIREMENTS.	R0019431 RS007159 R0011250 R0011251 RB0170-213 RA0115-116
	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.	RL10011 RA0607-094 RA0115-116 RA0115-006 RA1115-001 RA0115-127
	ASSEMBLY INTEGRITY	THE ASSEMBLY IS PROOF PRESSURE TESTED PER DRAWING REQUIREMENTS. THE PLATE STIFFENER RADII ARE INSPECTED PER DRAWING REQUIREMENTS.	R0019431 R0011086
	FLIGHT FLOW TESTING	THE EXTERNAL SURFACE IS VISUALLY INSPECTED PRIOR TO EACH LAUNCH. THE PLATE AND SEAL ARE LEAK CHECKED EACH FLIGHT. A HELIUM SIGNATURE LEAK TEST IS PERFORMED PRIOR TO EACH LAUNCH. (LAST TEST)	OMRSD V41BU0.030 OMRSD V41GEN.565 OMRSD S00000.950

Failure History: Comprehensive failure history data is maintained in the Problem Reporting database (PRAMS/PRACA)  
 Reference: NASA letter SA21/88/308 and Rocketdyne letter 88RC09761.

Operational Use: Not Applicable.

**SSME EA/CIL  
WELD JOINTS**

Component Group: Ducts and Lines  
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Component	Basic Part Number	Weld Number	Weld Type	Class	Root Side Not Access	Critical Initial Flaw Size Not Detectable		Comments
						HCF	LCF	
LINE	R0019431	1,2	GTAW	I	X	X	X	
LINE	R0019431	3,4	GTAW	I	X	X	X	