

SSM 1EA/CIL
REDUNDANCY SCREEN

Component Group: Block 1 Ducts and Lines
CIL Item: K618-01
Part Number: RS007118
Component: HPOTP Turbine Primary Seal Drain Manifold (ATD Configured Engine)
FMEA Item: K618
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. Aft compartment overpressurization. Possible fire or detonation. Loss of vehicle. Redundancy Screens: SINGLE POINT FAILURE: N/A | 1 ME-F3DS,A,M,C |

SSME FMEA/CIL
DESIGN

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Design / Document Reference

FAILURE CAUSE: A: Parent material failure or weld failure.

THE MANIFOLD ASSEMBLY (1) IS FABRICATED USING INCONEL 625 TUBE AND BAR. INCONEL 625 WAS SELECTED FOR ITS WELDABILITY, FORMABILITY, RESISTANCE TO STRESS CORROSION CRACKING, AND CORROSION RESISTANCE (2). INCONEL 625 POSSESSES THE REQUIRED STRENGTH WITHOUT REQUIRING HEAT TREAT. INCONEL 625 IS NOT SIGNIFICANTLY EFFECTED BY HYDROGEN IN THIS ENVIRONMENT (2). FLANGE 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 (3). MINIMUM FACTORS OF SAFETY FOR THE MANIFOLD MEET CEI REQUIREMENTS (4). HIGH AND LOW CYCLE FATIGUE LIFE MEET CEI REQUIREMENTS (5). THE MANIFOLD ASSEMBLY HAS COMPLETED PRESSURE CYCLING AND ULTIMATE PRESSURE DVS TESTING (6). THE MANIFOLD ASSEMBLY PARENT MATERIAL WAS CLEARED FOR FRACTURE MECHANICS/NDE FLAW GROWTH, SINCE THEY ARE NOT FRACTURE CRITICAL PARTS (7). TABLE K618 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 (8).

(1) RS007118; (2) RSS-8582; (3) RA1102-006; (4) RSS-8546, CP320R0003B; (5) RL00532, CP320R0003B; (6) SSME-81-1046; (7) NASA TASK 117; (8) RSS-8756

**SSME F~~IT~~ /CIL
INSPECTION AND TEST**

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| Failure Causes | Significant Characteristics | Inspection(s) / Test(s) | Document Reference |
|---------------------|---|--|---|
| A | LINE | | RS007118 |
| | FLANGE | | RS007136 |
| | FLANGE | | RS007387 |
| | MATERIAL INTEGRITY | MATERIAL INTEGRITY IS VERIFIED PER DRAWING REQUIREMENTS. | RS007118 RS007136 RS007387 |
| | | DETAILS ARE PENETRANT INSPECTED PER SPECIFICATION REQUIREMENTS. | 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. | RS007118 | |
| FLIGHT FLOW TESTING | THE EXTERNAL SURFACE IS VISUALLY INSPECTED PRIOR TO EACH LAUNCH. A HELIUM SIGNATURE LEAK TEST IS PERFORMED PRIOR TO EACH LAUNCH. (LAST TEST) | OMRSD V41BU0.030 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 FMEA/CIL
WELD JOINTS

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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 | RS007118 | 5,8 | GTAW | I | X | X | | |