

**SSMF 1EA/CIL
REDUNDANCY SCREEN**

Component Group: Block 1 Ducts and Lines
 CIL Item: K611-01
 Part Number: R0018051
 Component: FPB ASI Oxidizer Supply Line (Phase II+)
 FMEA Item: K611
 Failure Mode: Fails to contain GN2/oxidizer.

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
P 4.1	Loss of GN2 purge to FPB ASI oxidizer supply line would reduce the purge flow below acceptable limits for inerting propellant leakage at ICD limits. Potential open air fire. Loss of vehicle. Redundancy Screens: SINGLE POINT FAILURE: N/A	1 ME-FA1P
SMC 4.1	External leakage of the ASI oxidizer supply line will release LOX into the aft compartment that will mix with fuel-rich hot gas backflow from the ruptured ASI line resulting in a fire, overpressurization of aft compartment. Loss of vehicle. Redundancy Screens: SINGLE POINT FAILURE: N/A	1 ME-FC3S, ME-FC3A,C, ME-FC3M

SSME FMEA/CIL
DESIGN

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Design / Document Reference

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

THE LINE ASSEMBLY (1) IS MANUFACTURED UTILIZING 321 CRES TUBE AND INCONEL 625. 321 CRES TUBING WAS SELECTED BECAUSE OF ITS STRENGTH, FABRICABILITY, GENERAL CORROSION RESISTANCE, AND STRESS CORROSION RESISTANCE (2). 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. ALL MATERIALS USED IN THE LINE FABRICATION ARE LOX COMPATIBLE (2). FLANGE, TEE, AND MOUNT 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 LINE MEET CEI REQUIREMENTS (4). HIGH AND LOW CYCLE FATIGUE LIFE MEET CEI REQUIREMENTS (5). THE LINE ASSEMBLY HAS COMPLETED CERTIFICATION TESTING BY ANALYSIS, SIMILARITY AND HOT FIRE TESTING (6). THE LINE ASSEMBLY PARENT MATERIALS WERE CLEARED FOR FRACTURE MECHANICS/NDE FLAW GROWTH, SINCE THEY ARE NOT FRACTURE CRITICAL PARTS (7). TABLE K611 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 (8).

(1) R0018051; (2) RSS-8582; (3) RL00530; (4) CP320R0003B; (5) RL00532, CP320R0003B; (6) VRS-0487; (7) NASA TASK 117; (8) RSS-8756

**SSME F₁ A/CIL
INSPECTION AND TEST**

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Failure Causes	Significant Characteristics	Inspection(s) / Test(s)	Document Reference	
A	LINE		R0018051	
	TEE		RS009530	
	ORIFICE		RS009038	
	MOUNT		R0019162	
	MATERIAL INTEGRITY	MATERIAL INTEGRITY IS VERIFIED PER DRAWING REQUIREMENTS.		R0018051 RS009530 RS009038 R0019162
	WELD INTEGRITY	THE DETAILS ARE PENETRANT INSPECTED PER SPECIFICATION REQUIREMENTS. ALL WELDS ARE INSPECTED TO DRAWING AND SPECIFICATION REQUIREMENTS PER WELD CLASS. INSPECTIONS INCLUDE: VISUAL, DIMENSIONAL, PENETRANT, RADIOGRAPHIC, ULTRASONIC, AND FILLER MATERIAL, AS APPLICABLE.		RA0115-116 RL10011 RA0607-094 RA0115-116 RA0115-006 RA1115-001 RA0115-127
ASSEMBLY INTEGRITY	THE ASSEMBLY IS PROOF PRESSURE TESTED PER DRAWING REQUIREMENTS.		R0018051	
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	R0018051	1-3	GTAW	I	X	X		
LINE	R0018051	4	GTAW	I	X	X		
LINE	R0018051	5	GTAW	I	X	X		