

SSME FMEA/CIL
REDUNDANCY SCREEN

Component Group: Ducts and Lines
 CIL Item: N500-01
 Part Number: RS010439
 Component: POGO Recirculation Line
 FMEA Item: K213, K214, N500
 Failure Mode: Fails to contain 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
PSMCD 4.1	Oxidizer leakage into aft compartment. Overpressurization of aft compartment. Loss of vehicle. Redundancy Screens: SINGLE POINT FAILURE: N/A	1 ME-C3P,D, ME-C3S, ME-C3M, ME-C3A,C

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DESIGN

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Design / Document Reference

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

THE LINE ASSEMBLY (1) IS MANUFACTURED UTILIZING INCONEL 625. 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 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 FOR THE LINE MEET CEI REQUIREMENTS (5). THE LINE ASSEMBLY HAS COMPLETED PRESSURE CYCLE AND ULTIMATE PRESSURE DVS TESTING (6). THE LINE ASSEMBLY PARENT MATERIAL WAS CLEARED FOR FRACTURE MECHANICS/NDE FLAW GROWTH, SINCE THEY ARE NOT FRACTURE CRITICAL PARTS (7). TABLE N500 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) RS010439; (2) RSS-8582; (3) RA1102-006; (4) RSS-8546, CP320R0003B; (5) RL00532, CP320R0003B; (6) SSME-81-1054; (7) NASA TASK 117; (8) RSS-8756

**SSME FMEA/CIL
INSPECTION AND TEST**

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Failure Causes	Significant Characteristics	Inspection(s) / Test(s)	Document Reference
A	LINE FLANGE		RS010439 RS010440
	MATERIAL INTEGRITY	MATERIAL INTEGRITY IS VERIFIED PER DRAWING REQUIREMENTS.	RS010439 RS010440
	HEAT TREAT	HEAT TREAT IS VERIFIED PER SPECIFICATION REQUIREMENTS.	RA0611-020
	SURFACE FINISH	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.	RS010439
	HOT-FIRE ACCEPTANCE TESTING (GREEN RUN)	ASSEMBLY STRUCTURAL INTEGRITY IS VERIFIED THROUGH HOT-FIRE ACCEPTANCE TESTING.	RL00461
	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	RS010439	1,2	GTAW	I	X	X		
