

PPPL ENGINEERING CHANGE NOTICE (ECN) ECN # 5115

COGNIZANT INDIVIDUAL: Paul Goranson	
ECN TITLE: NCSX VVSA Flange Seal Weld	
ASSOCIATED ECP: None	
CC/WP/Job: 9450-1***-1203	AREA OR PROJECT: NCSX

LIMITATION OF SCOPE - NOTE: A Work Planning Form is NOT required if the total change to be accomplished (ENG-032):

- Is not large or complex or does not represent a new installation into a usable space
- Does not have a significant ES&H impact
- Does not involve tritium or other radioactive contaminated or activated equipment
- Does not impact multiple projects, systems, or groups

OR does not change the scope or intent of the original design.

Responsible Line Manager CONCURRENCE: _____
 (Signature indicates that no Work Planning form is required.)

If non-concurrence or associated with a work planning form, enter the WP Number:

DRAWING(S) AFFECTED NUMBER:	NEW Revision	TITLE
SE120-004	See RLM Comment	Vacuum Vessel – Leak – Inspection & Leak Check Assembly

<p>DESCRIPTION OF CHANGE: (State Drawing No., Zone/Group, or List Attachments):</p> <p>Authorized to apply fillet welds (approximately 1/8” fillets x 1/2” to 1.0” long) to the opposite side of the groove weld (exterior side) to provide added rigidity critical to assisting in distortion control. Also authorized to vary from the 1.015” flatness requirement (zone D2) and to maintain 0.050” flatness if opposing sides fillets are applied</p>
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REASON FOR CHANGE:

PPPL to confirmed that 100% penetration is the requirement. MTM noted that it would be difficult, if not impossible, to do this using the currently required welding. MTM suggested using fillet welds to provide added rigidity control to assist in distortion control. MTM also noted difficulty in maintaining the flatness requirement and suggested a relaxation in the this requirement.

RFD-12-016 authorized this deviation.

ENGINEERING CHANGE PROPOSAL: N/A

DATE: 4/17/2006

COGNIZANT INDIVIDUAL MAKING THE CHANGE:

RESONSIBLE LINE MANAGER:

RLM Comments: This ECN will NOT be immediately incorporated. Rather a stamp will be placed on this drawing as Rev 2-c to SE120-004 to indicate that this ECN is outstanding.

NOTE: This is the third ECN against this drawing – the next ECN will require a formal revision per ENG-010.

From: Griffith, Mike [<mailto:mgriffith@majortool.com>]
Sent: Wednesday, April 05, 2006 11:51 AM
To: NKHFlowen@aol.com; royjratc-aol-com-offsite
Cc: Bowling, Kevin
Subject: Request for Lifting holes in Poloidal Break Shims

In order to assist in the intermediate and final assembly of the poloidal break shims in the remaining C's and in all of the A and B shims, we are requesting the addition of a 3/8-16 hole in both ends of the shim to be used for lifting. The drawing below is a C shim showing the approximate location of the holes. Please review and forward this request to PPPL. Thanks.

