

PPPL ENGINEERING CHANGE NOTICE (ECN) ECN # 5109

COGNIZANT INDIVIDUAL: Paul Goranson
ECN TITLE: VVSA Leak Check Tube/Block 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
SE120-005	See RLM Comment	Vacuum Vessel Port Extension Weldment
SE122-006	See RLM Comment	
SE-122-007	See RLM Comment	

DESCRIPTION OF CHANGE: (State Drawing No., Zone/Group, or List Attachments)

It is permissible to replace the weld with a braze joint using a silver free braze material (Nicrobraze).

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REASON FOR CHANGE:

The vendor was unable to make the 1/32" fillet weld between the leak check tube and the leak check block called out in this drawing. MTM requested that consideration be given to replacing the joint with silver solder one.

RFD-12-004 approved this request with the proviso that the braze joint use a silver free material (Microbraze).

ENGINEERING CHANGE PROPOSAL: N/A

DATE: 4/17/2006

COGNIZANT INDIVIDUAL MAKING THE CHANGE:

RESPONSIBLE LINE MANAGER:

RLM Comments: This ECN will NOT be immediately incorporated. Rather a stamp will be placed on these drawings as Rev 0-a to indicate that this ECN is outstanding.

Request for Deviation

MCWF Type C

Number: MTM-RFD-C-PORTS

RFD Description:

During a joint meeting at MTM 4 thru 6-Jan-06, the port surface geometry location was discussed. MTM forwarded the geometry as currently programmed via IGES surfaces. The proposed change to the CAD model is to allow MTM to machine the port openings at common angles that require less time for setups.

Initiator: Kevin Bowling

Organization: Major Tool and Machine, Inc.

List of Impacted Documents:

Database and drawing for SE141-116 Type C castings.

Cost Impact: None

Schedule Impact: Helps to eliminate extra setups for different approach angles.

Quality Impact: None

Initiator Signature: Kevin Bowling **Date:** 16-FEB-06

Kevin Bowling
5-July-2005



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