NCSX RFD Part I	**Number: 12-016**	**RFD Description: NCSX VVSA Flange Seal Weld**
Initiator: Doug McCorkle	**Organization: Major Tool and Machine**	
List of Impacted Documents: ***(Specification, MIT/QA Plan, SOW, drawing, etc.)*** **NCSX-CSPEC-121-02-06; SE120-004 sheet 3, zone B8.**		
Cost Impact: ***(If none, so state) NONE***		
Schedule Impact: ***(If none, so state: NONE***		
Quality Impact: ***(If none, so state): NONE***		
State Requirement Deviation is Requested For***: (Specification, MIT/QA Plan, SOW, drawing, etc.)*** **Specfication and impacted drawings. Seal to flange weld by current design requirements is a straight but weld (assuming 100% penetration since no effective throat is specified).**		
Full Description of the Deviation Requested: ***(Use continuation pages, e-mails, letter, sketches, etc. as needed and include amplifying information as appropriate to support deviation request.)*** **Request PPPL to confirm 100% penetration is the requirement or provide a minimum effective throat to maintain. MTM will prep the seal strip accordingly (straight but weld joint preparation will not ensure full penetration under current circumstances).** **Request authorization 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.** **Request relief from the 0.015" flatness requirement (zone D2). MTM believes it is possible to maintain approximately 0.050" flatness if opposing side fillets are applied. Welding the seals in place according to the drawing is expected to result in a partial penetration weld (approximately 30-40%) and 0.080 – 0.100" welding distortion to the seal.**		
Attachments: N/A		
Initiator Signature: Doug McCorkle Date: 14Feb2006		

NCSX RFD Part II	**Number: 12-016**	**RFD Description: NCSX VVSA Flange Seal Weld**
RLM: Brad Nelson	**Organization: ORNL**	

Impact on Interfaces with Other WBS Elements/Items: ***(If none, so state): NONE***

RLM Recommendation:

☒ **Approve** ☐ **Do Not Approve**

Additional remarks:

Weld mod is acceptable. VVSA is the first article to be fabricated.

Does this Change Impact Material Already Procured or Parts/Assemblies Already Assembled/Manufactured using this Material: ☐ **Yes** ☒ **No**

If "Yes", what is the recommended disposition of this material/part/assembly?

RLM Signature: _____

Project Disposition:

☐ **Approved. No ECP required.**

☒ **Approved. ECP – 044 already assigned and will be processed.**

Bob Simmons

Digitally signed by Bob Simmons
DN: CN = Bob Simmons, C = US
Reason: I have reviewed this document
Date: 2006.04.04 14:52:02 -04'00'

NCSX Systems Engineering Support Manager

☐ **Not Approved. Reason(s) for disapproval:**