

<i>NCSX RFD</i> <i>Part I</i>	<b>Number:</b> <b>RFD-12-017</b>	<b>RFD Description:</b> <b>Port Attachment Weld Deviation Request</b>
<b>Initiator:</b> Doug McCorkle		<b>Organization:</b> Major Tool & Machine, Inc.
<b>List of Impacted Documents:</b> ( <i>Specification, MIT/QA Plan, SOW, drawing, etc.</i> ) NCSX-CSPEC-121-02-06; SE120-004;		
<b>Cost Impact:</b> ( <i>If none, so state</i> ) None		
<b>Schedule Impact:</b> ( <i>If none, so state</i> ) None		
<b>Quality Impact:</b> ( <i>If none, so state</i> ) : Quality improvement.		
<b>State Requirement Deviation is Requested For:</b> ( <i>Specification, MIT/QA Plan, SOW, drawing, etc.</i> ): Ref: Drawing SE120-004, Sht 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, & 19. The drawing weld symbol for joining the port extension to the vessel.		
<p><b>Full Description of the Deviation Requested:</b> (<i>Use continuation pages, e-mails, letter, sketches, etc. as needed and include amplifying information as appropriate to support deviation request.</i>)</p> <p><b>Deviation Requested:</b>  All round ports: Current design requires the tube to be butted to the exterior surface of the vessel wall, prepped to the outside of the tube, and welded 100% with no backing weld or interior weld, with a continuous fillet around the exterior. Request approval for cutting the hole in the vessel to the o.d. size of the tube and welding full penetration from the vessel interior (ground flush) with a continuous fillet weld around the tube exterior. In order to achieve this, the hole in the vessel is cut to the o.d. size of the tube and the vessel wall is prepped. The majority of the joint is filled from the interior, and the exterior is back ground and filled in for 100% penetration. A 3/16" continuous fillet is applied to the exterior of the joint for strength and to properly blend the two surfaces together.</p> <p>Ports 4, 12, NB: Current design offers two welding options. MTM chose the optional method. Request approval to weld the exterior fillet as a continuous fillet opposed to the specified intermittent weld.</p> <p>Clevis bosses: Request adding a 3/16 fillet to the exterior side of the joint.</p> <p><b>Justification:</b> Quality improvement / better welding distortion control.</p>		
<b>Attachments:</b> None		
<b>Initiator Signature:</b> <u>Doug McCorkle</u> <b>Date:</b> <u>20Mar2006</u>		

<i>NCSX RFD</i> <i>Part III</i>	<b>Number:</b> <b>RFD-12-017</b>	<b>RFD Description:</b> <b>Port Attachment Weld Deviation Request</b>
<b>RLM:</b> <b>Brad Nelson</b>	<b>Organization:</b> <b>ORNL</b>	
<b>Impact on Interfaces with Other WBS Elements/Items: (If none, so state)</b> <i>None</i>		
<p><b>RLM Recommendation:</b></p> <p><input checked="" type="checkbox"/> <b>Approve</b>   <input type="checkbox"/> <b>Do Not Approve</b></p> <p><b>Additional remarks:</b></p> <p><b>ECN-5082 will incorporate this change.</b></p> <p><b>Does this Change Impact Material Already Procured or Parts/Assemblies Already Assembled/Manufactured using this Material: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No</b></p> <p><b>If “Yes”, what is the recommended disposition of this material/part/assembly? Use “as is”. Will impact other two segments also.</b></p>		
<b>RLM Signature:</b> _____		
<p><b>Project Disposition:</b></p> <p><input type="checkbox"/> <b>Approved. No ECP required.</b></p> <p><input checked="" type="checkbox"/> <b>Approved. ECP-044 assigned and will be processed.</b></p> <p>_____</p> <p><b>NCSX Systems Engineering Support Manager</b></p> <p><input type="checkbox"/> <b>Not Approved. Reason(s) for disapproval:</b></p>		