NCSX RFD Part I	**Number:** NCSX-RFD-12-006	**RFD Description:** NCSX Vessel Port Manufacture

Initiator: Doug McCorkle	**Organization:** Major Tool and Machine

List of Impacted Documents: ***(Specification, MIT/QA Plan, SOW, drawing, etc.)***
NCSX-CSPEC-121-02

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.)*
NCSX-CSPEC-121-02

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.)***

Sch 40 pipe is short supply (See deviation request NCSX-RFD-12-005).

Request deviation to manufacture the 2.5" and 3.5" Pipe from 0.25" plate – will roll and weld plate. Follow ASTM B705 as a guideline during production. The material certification will be ASTM B443

Attachments:
NONE

Initiator Signature: Doug McCorkle **Date:** May 25, 2005

NCSX RFD Part II	**Number:** NCSX-RFD-12-006	**RFD Description:** NCSX Vessel Port Manufacture
RLM: Brad Nelson	**Organization: ORNL**	

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

RLM Recommended Disposition:

☒ **Approve** ☐ **Do Not Approve (If recommendation is to approve, ECP will be assigned)**

Additional remarks:

Cognizant Engineer Comments: Need to confirm whether there is also shortage of 2.5" Sch10 ASTM 625 (one trade name is Inconel) piping. If necessary to fabricate this piping, the 3/16" ASTM 625 plate is more appropriate for the 2.5" Sch10 pipe (RFD NCSX-12-002R1 previously authorized substitution of Sch10 pipe for Sch40 pipe for the 2.5 inch pipe).

? Signature Not Verified Paul Goranson

Digitally signed by Paul Goranson
DN: cn=Paul Goranson, c=US
Date: 2005.05.27 11:04:11 -04'00'

RLM Comments: PTR has confirmed with MTM that the 2.5" Sch10 pipe is in house, but since this material is also in scarce supply, this deviation is a "just in case" scenario. Based on that, this RFD is approved subject to the following stipulations:

(1) Use of ASTM 625 ¼" plate is authorized to manufacture the 3.5" Sch40 pipe
(2) Use of ASTM 625 3/16" plate is authorized to manufacture any additional 2.5" Sch10 pipe as needed.

RLM Signature: ? Signature Not Verified Brad Nelson

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, o=ORNL, ou=Fusion Energy Division, c=US
Date: 2005.05.27 11:08:45 -04'00'

Project Disposition: (Include ECP Number): ECP-032