

THE REQUIREMENTS CONTAINED HEREIN APPLY TO THE SELLER'S AND THEIR SUB-TIER SUPPLIER PROCEDURES USED IN FULFILLING THE REQUIREMENTS OF THIS PURCHASE ORDER.

A. PROCEDURE APPROVAL

1. ALL PRODUCTION AND REPAIR WELDING (INCLUDING CASTING REPAIR) AND BRAZING WHEN INVOKED BY THIS PURCHASE ORDER OR SUB-TIER DOCUMENTS (I.E. FABRICATION/MATERIAL SPECIFICATIONS, DRAWINGS, ETC.), MUST BE PERFORMED IN ACCORDANCE WITH WRITTEN PROCEDURES APPROVED BY THE BUYER PRIOR TO PERFORMANCE OF WELDING OR BRAZING AND SHOULD BE SUBMITTED FOR APPROVAL WITHIN THIRTY (30) DAYS OF SELLER'S RECEIPT OF ORDER. IN ADDITION, EVIDENCE OF PERSONNEL QUALIFICATIONS SHALL BE AVAILABLE UPON REQUEST WHEN SUCH QUALIFICATION IS A REQUIREMENT.

NOTE

PERMISSION TO PERFORM REPAIR WELDING FOR OTHER THAN MINOR AND NOMINAL REPAIRS AS DEFINED BY THE FABRICATION SPECIFICATION MUST BE AUTHORIZED BY THE BUYER PRIOR TO PERFORMING SUCH REPAIRS.

PROCEDURES SHALL BE PROVIDED TO THE BUYER VIA A PROPERLY COMPLETED VENDOR PROCEDURE APPROVAL REQUEST (VPAR, EB FORM 84-01-2974).

PERMISSION TO PERFORM REPAIR WELDING (WHEN REQUIRED) SHALL BE REQUESTED VIA A PROPERLY COMPLETED VENDOR INFORMATION REQUEST (VIR, EB FORM 84-01-2205). SELLER SHALL SEND THESE DOCUMENTS TO THE PURCHASER'S BUYER DESIGNATED ON THE PURCHASE ORDER.

2. INSTRUCTIONS FOR THE PREPARATION OF WELDING PROCEDURE QUALIFICATION RECORDS (PQR'S) AND WELDING PROCEDURE SPECIFICATIONS (WPS'S)

THAT WILL BE SUBMITTED TO ELECTRIC BOAT CORPORATION VIA A VPAR CAN BE FOUND IN THE FOLLOWING AREA:

ELECTRIC BOAT HOME PAGE/WWW.GDEB.COM/
SUPPLIERS/SECTION 4.0 PURCHASE ORDER INFORMATION/
SECTION 4.3A "VPAR WELD PROCEDURE INSTRUCTION
BROCHURE (REV.3, 03/14/03 PDF) "

THESE INSTRUCTIONS OFFER A GUIDE TO PREPARING AND PRESENTING THE QUALIFICATION AND WELDING PROCEDURE INFORMATION SUCH THAT IT WILL CONFORM TO THE REQUIREMENTS OF S9074-AQ-GIB-010/248 (TECH. PUB. 248) TABLE V.

B. SELLER'S AND SELLER'S SUBCONTRACTOR PREVIOUSLY APPROVED PROCEDURES

1. WELDING/BRAZING PROCEDURES ARE TYPICALLY APPROVED FOR EITHER GENERAL USE WITHOUT RESTRICTION OR FOR NON-CRITICAL APPLICATIONS ONLY.
2. ALL REVISIONS TO WELDING/BRAZING PROCEDURES WHICH REQUIRE QUALIFICATION OR REQUALIFICATION AS SPECIFIED BY PARAGRAPHS 4.7 AND 4.8 OF PPD-802-6335695 (MIL-STD-248D) OR BY PARAGRAPH 6.3.3 OF NAVSEA 250-1500-1 MUST BE SUBMITTED ON A VPAR.
3. ALL PROCEDURES WHICH HAVE BEEN REVISED BUT DO NOT REQUIRE REQUALIFICATION AS SPECIFIED IN PARAGRAPHS 4.7 AND 4.8 OF PPD-802-6335695 (MIL-STD-248D) OR BY NAVSEA 250-1500-1, SHALL BE SUBMITTED FOR INFORMATION USING A VPAR PRIOR TO START OF MANUFACTURE BUT NOT MORE THAN THIRTY (30) DAYS AFTER RECEIPT OF ORDER. THE SUBMITTAL SHALL CLEARLY DESCRIBE THE FULL EXTENT OF ALL CHANGES.
4. PROCEDURES PREVIOUSLY APPROVED FOR NON-CRITICAL APPLICATIONS AS DEFINED BY SECTION 4 OF PPD-802-6335694 (MIL-STD-1689) AND/OR PARAGRAPH 4.2.1.1 OF

MIL-STD-278F IN WHICH APPLICATIONS ARE NOT SPECIFICALLY LISTED IN THE WELDING PROCEDURES BY THE BUYER'S PART NUMBER OR BY VENDOR DRAWING AND PART NUMBER SHALL BE RESUBMITTED USING A VPAR WITH THE APPLICATION(S) CLEARLY IDENTIFIED.

5. EXCEPT FOR NON-CRITICAL PROCEDURES DESCRIBED IN 4. ABOVE PROCEDURES WHICH HAVE PREVIOUSLY RECEIVED THE BUYER'S WRITTEN APPROVAL, NEED NOT BE RESUBMITTED FOR APPROVAL OR INFORMATION ON THIS PURCHASE ORDER PROVIDED THAT THE PROCEDURE, INCLUDING REVISION, IS THE SAME AS THAT PREVIOUSLY APPROVED.

WHEN PREVIOUSLY APPROVED PROCEDURES AS DESCRIBED IN 5. ABOVE ARE TO BE USED, SELLER SHALL ATTACH A PHOTOCOPY OF THE BUYERS VPAR THAT APPROVED THE PROCEDURE TO THE PACKING SLIP AND THE WELDING RECORDS, WHEN REQUIRED TO BE SUBMITTED.

7. THE ABOVE REQUIREMENTS DO NOT RELIEVE THE SELLER OF HIS RESPONSIBILITY TO COMPLY WITH THE SPECIFICATION REQUIREMENTS OF THE PURCHASE ORDER. ANY DEVIATIONS FROM OR WAIVERS TO THE PURCHASE ORDER REQUIREMENTS MUST BE CLEARLY IDENTIFIED AS SUCH BY THE SELLER AND MUST BE APPROVED IN WRITING BY THE BUYER.

C SELLER'S AND SELLER'S SUBCONTRACTOR PROCEDURES PREVIOUSLY APPROVED BY OTHER ORGANIZATIONS.

1. WELDING/BRAZING PROCEDURES TO BE USED ON THIS CONTRACT THAT HAVE NOT BEEN PREVIOUSLY APPROVED BY OTHER ORGANIZATIONS STILL MUST BE SUBMITTED TO THE BUYER FOR APPROVAL ON AN ELECTRIC BOAT VPAR, AS APPLICABLE TO THE PURCHASE ORDER.

2. TO EXPEDITE APPROVAL, PROCEDURES

MUST BE SUBMITTED WITH THE
SUPPORTING QUALIFICATION DATA AND
COPIES OF ALL APPROVAL
DOCUMENTATION.

D. REPAIR OF BASE MATERIALS

WELD REPAIR OF BASE MATERIALS SHALL
BE CONDUCTED IN ACCORDANCE WITH
EB-4186 REVISION D. REPAIR WELDING
IN EXCESS OF THAT ALLOWED BY THE BASE
MATERIAL SPECIFICATION IS NOT PER-
MITTED WITHOUT PRIOR APPROVAL BY
THE BUYER ON A VENDOR INFORMATION
REQUEST (VIR).

E. FABRICATION STANDARD SUBSTITUTIONS

WHERE REFERENCE IS MADE TO THE
FOLLOWING SPECIFICATIONS OR PPDS IN
THIS PURCHASE ORDER OR IN REFERENCED
DOCUMENTS (I.E. PURCHASE SPECIFICATIONS,
DRAWINGS), THE LISTED SUBSTITUTIONS (OR
ALTERNATE SUBSTITUTION AT SUPPLIER
OPTION) SHALL BE USED.

SPECIFICATION:

MIL-STD-248

SUBSTITUTION:

EB-4187 REV A

ALTERNATE SUBSTITUTION:

S9074-AQ-GIB-010/248 (1 AUGUST 1995)

SPECIFICATION:

PPD 802-6335695

SUBSTITUTION:

EB-4187 REV A

ALTERNATE SUBSTITUTION:

S9074-AQ-GIB-010/248 (1 AUGUST 1995)

SPECIFICATION:

MIL-STD-278

SUBSTITUTION:

EB-4188 REV A

ALTERNATE SUBSTITUTION:

A9074-AR-GIB-010/278 (1 AUGUST 1995)

SPECIFICATION:
MIL-STD-1681
SUBSTITUTION:
PPD 802-6335689 (26 JUNE 1989)
ALTERNATE SUBSTITUTION:
T9074-AD-GIB-010/1688 (1 MAY 1997)

SPECIFICATION:
PPD 802-6335689
SUBSTITUTION:
PPD 802-6335689 (26 JUNE 1989)
ALTERNATE SUBSTITUTION:
T9074-AD-GIB-010/1688 (1 MAY 1997)

SPECIFICATION:
MIL-STD-1688
SUBSTITUTION:
EB-4189 REV A
ALTERNATE SUBSTITUTION:
T9074-AD-GIB-010/1688 (1 MAY 1997)

SPECIFICATION:
PPD 802-6335720
SUBSTITUTION:
EB-4189 REV A
ALTERNATE SUBSTITUTION:
T9074-AD-GIB-010/1688 (1 MAY 1997)

SPECIFICATION:
MIL-STD-1689
SUBSTITUTION:
EB-4191 REV A
ALTERNATE SUBSTITUTION:
T9074-AD-GIB-010/1688 (1 MAY 1997)

SPECIFICATION:
PPD 802-6335694
SUBSTITUTION:
EB-4191 REV A
ALTERNATE SUBSTITUTION:
T9074-AD-GIB-010/1688 (1 MAY 1997)

SPECIFICATION:
MIL-STD-1628
SUBSTITUTION:

PPD 802-6335707 (30 APRIL 1987)
ALTERNATE SUBSTITUTION:
PPD 802-6337550 (5 FEBRUARY 1998)

SPECIFICATION:
PPD 802-6335707
SUBSTITUTION:
PPD 802-6335707 (30 APRIL 1987)
ALTERNATE SUBSTITUTION:
PPD 802-6337550 (5 FEBRUARY 1998)

THE SPECIFICATION USED SHALL BE CLEARLY NOTED ON REQUIRED DOCUMENTATION (E.G., PROCEDURES, RECORDS, CERTIFICATIONS).

WHEN THE SUPPLIER ELECTS TO USE THE ALTERNATE SUBSTITUTION, THE SUPPLIER MUST COMPLY WITH THE EFFECTIVE REVISIONS OF ALL REFERENCED DOCUMENTS THEREIN UNLESS OTHERWISE SPECIFIED. IN ADDITION, NEW PROCEDURES, OR PROCEDURES WHICH ARE REVISED TO REFERENCE THE ALTERNATE SUBSTITUTION, SHALL BE SUBMITTED FOR APPROVAL IN ACCORDANCE WITH THE REQUIREMENTS OF THIS STANDARD CLAUSE. HOWEVER, REVISIONS TO VENDOR DRAWINGS TO REFLECT USE OF THE ALTERNATE SUBSTITUTION ARE NOT MANDATORY.

WELDING, FABRICATION, AND INSPECTION REQUIREMENTS OF ELECTRIC BOAT PREPARED AND NAVSEA APPROVED COMPONENT SPECIFICATIONS TAKE PRECEDENCE OVER THE ABOVE

F. WELDER WORKMANSHIP TRAINING

WELDER WORKMANSHIP TRAINING SHALL BE IN ACCORDANCE WITH EB-4186 REV. D.

NOTE

MATERIAL PROVIDED TO UNAPPROVED PROCEDURES OR INCORRECT PROCEDURE REVISIONS ARE SUBJECT TO REJECTION.

FOR PURCHASE ORDERS THAT ORIGINATE FROM NORTHROP GRUMMAN NEWPORT NEWS SHIPBUILDING, 4101 WASHINGTON AVE, NEWPORT NEWS, VA. 23607, YOU ARE REQUESTED TO FORWARD ALL UNAPPROVED SOFTWARE DELIVERABLES IDENTIFIED HEREIN AS FOLLOWS:

PURCHASE ORDERS WHOSE LINE ITEM "MATERIAL GROUP" IS IDENTIFIED AS CM-I, CM-III, CM(-), CM-A OR CM-FAC:

DEPARTMENT E89, BLDG 600/1
ATTN: SOFTWARE COORDINATOR

PURCHASE ORDERS WHOSE LINE ITEM "MATERIAL GROUP" IS IDENTIFIED OTHER THAN CITED ABOVE:

DEPARTMENT E45(VCS), BLDG 600/2
ATTN" SOFTWARE COORDINATOR

SOFTWARE DELIVERABLES PREVIOUSLY APPROVED SHALL BE PROVIDED AS PART OF THE HARDWARE DELIVERABLES.