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

A. SPECIFICATION SUBSTITUTION

1. WHEREVER REFERENCE IS MADE TO THE FOLLOWING GROUP A SPECIFICATIONS OR PPDS IN THIS PURCHASE ORDER OR IN REFERENCED DOCUMENTS (I.E. PURCHASE SPECIFICATIONS, DRAWINGS), THE CORRESPONDING ALTERNATE SUBSTITUTION SHALL BE USED, EXCEPT THAT SUPPLIERS FOR WELDING OTHER THAN TITANIUM, WHO HAVE OBTAINED PRIOR EB OR NORTHROP GRUMMAN SHIPBUILDING - NEWPORT NEWS OPERATIONS APPROVAL OF NON-DESTRUCTIVE TEST PROCEDURES OR WELD PROCEDURE QUALIFICATION TEST RECORDS FOR USE WITH THE SPECIFICATION SUBSTITUTIONS, MAY CONTINUE TO USE THE SPECIFICATION SUBSTITUTION. FOR SUPPLIERS WELDING TITANIUM, ONLY SUPPLIERS WITH TITANIUM WELD PROCEDURES THAT HAD THE WELD PROCEDURE QUALIFICATION TEST RECORDS APPROVED IN ACCORDANCE WITH THE SPECIFICATION SUBSTITUTION PRIOR TO 1 OCTOBER 1997 AND HAVE PERFORMED TITANIUM FABRICATION PRIOR TO 1 OCTOBER 1997 MAY CONTINUE TO USE THE SPECIFICATION SUBSTITUTION. ALL OTHER SUPPLIERS WELDING TITANIUM MUST USE THE ALTERNATE SUBSTITUTION UNLESS OTHERWISE SPECIFICALLY APPROVED TO CONTINUE TO USE THE SPECIFICATION SUBSTITUTION.

GROUP A
MIL-STD-248
SUBSTITUTION
EB-4187 REV A
ALTERNATE SUBSTITUTION
S9074-AQ-GIB-010/248 (1 AUGUST 1995)

GROUP A
PPD 802-6335695
SUBSTITUTION
EB-4187 REV A
ALTERNATE SUBSTITUTION
S9074-AQ-GIB-010/248 (1 AUGUST 1995)

GROUP A
MIL-STD-278
SUBSTITUTION
EB-4188 REV A
ALTERNATE SUBSTITUTION
S9074-AR-GIB-010/278 (1 AUGUST 1995)

GROUP A

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

GROUP A
PPD 802-6335689
SUBSTITUTION
PPD 802-6335689 (26 JANUARY 1989)
ALTERNATE SUBSTITUTION
T9074-AD-GIB-010/1688 (1 MAY 1997)

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

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

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

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

GROUP A
MIL-STD-1628
SUBSTITUTION
PPD 802-6335707 (30 APRIL 1987)
ALTERNATE SUBSTITUTION
PPD 802-6337550 (5 FEBRUARY 1998)

GROUP A
PPD 802-6335707

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SUBSTITUTION

PPD 802-6335707 (30 APRIL 1987)

ALTERNATE SUBSTITUTION

PPD 802-6337550 (5 FEBRUARY 1998)

THE REQUIREMENTS IN THIS SECTION SHALL APPLY EXCEPT WHERE NAVSEA-APPROVED EQUIPMENT SPECIFICATIONS STATE OTHERWISE, IN WHICH CASE, THE REQUIREMENTS OF THE NAVSEA-APPROVED EQUIPMENT SPECIFICATIONS SHALL TAKE PRECEDENCE.

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

WHEN THE SUPPLIER ELECTS TO USE THE ALTERNATE SUBSTITUTION, THE SUPPLIER MUST USE THE ALTERNATE SUBSTITUTION FOR 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.

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

B. USE OF UNLISTED BASE MATERIALS

1. ALL BASE METALS (SPECIFICATION AND CLASS OR GRADE) THAT ARE NOT LISTED IN MIL-STD-248/MIL-STD-278 MUST HAVE APPROVAL TO BE USED AS AN S-NUMBERED MATERIAL IN ACCORDANCE WITH MIL-STD-248/MIL-STD-278, TABLE I FOOTNOTE 1.
2. IF THE SUPPLIER DOES NOT HAVE AN APPROVAL REFERENCE (APPROVAL LETTER NUMBER), THE SUPPLIER MUST REQUEST APPROVAL VIA A VIR. THE VIR MUST PROVIDE THE MATERIAL SPECIFICATION, TYPE, CONDITION, AND APPLICATION WHERE THIS MATERIAL IS BEING USED.

NOTE: APPROVAL TO CLASSIFY A MATERIAL TO AN S-GROUP DOES NOT CONSTITUTE APPROVAL TO USE THAT MATERIAL FOR A PARTICULAR APPLICATION OR TO AUTHORIZE SUBSTITUTION OF A MATERIAL ON A DRAWING.

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C. PREPARATION OF WELDING PROCEDURES

1. INSTRUCTIONS FOR THE PREPARATION OF WELDING PROCEDURE QUALIFICATION RECORDS AND WELDING PROCEDURES THAT WILL BE SUBMITTED TO ELECTRIC BOAT CORPORATION VIA A VPAR CAN BE FOUND BY FOLLOWING THE INSTRUCTIONS BELOW:

GO TO THE WEB SITE [HTTP://WWW.GDEB.COM/SUPPLIERS](http://www.gdeb.com/suppliers), CLICK ON PURCHASE ORDER INFO, THEN CLICK ON SECTION 4.3A "VPAR WELD PROCEDURE INSTRUCTION BROCHURE".

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 TABLE V.

2. IN ADDITION, ELECTRIC BOAT HAS PREPARED FORMS FOR WELDING PROCEDURES IN EXCEL SPREADSHEET FORMAT. THESE CAN BE USED TO DEVELOP APPROVABLE DOCUMENTATION AND MAY BE OBTAINED THROUGH THE WEB SITE [HTTP://WWW.GDEB.COM/ SUPPLIERS](http://www.gdeb.com/suppliers), CLICK ON PURCHASE ORDER INFO, THEN CLICK ON SECTION 4.3B "WELD PROCEDURE TEMPLATE".

D. PROCEDURE APPROVAL

1. ALL PRODUCTION AND REPAIR WELDING (INCLUDING BASE METAL REPAIR) AND BRAZING WHEN REQUIRED 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.
2. PROCEDURES SHALL BE PROVIDED TO THE BUYER VIA A PROPERLY COMPLETED VENDOR PROCEDURE APPROVAL REQUEST (VPAR, EB FORM 84-01-2974). EACH WELD PROCEDURE (INCLUDING SUPPORTING QUALIFICATION DATA, TEST REPORTS AND PREVIOUS APPROVAL INFORMATION) MUST BE SUBMITTED ON A SEPARATE VPAR.

MATERIAL WELDED OR BRAZED WITH UNAPPROVED PROCEDURES OR UNAPPROVED OR INCORRECT PROCEDURE REVISIONS IS SUBJECT TO REJECTION.

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- E. 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 OR MINOR STRUCTURE APPLICATIONS ONLY.
 2. ALL REVISIONS TO WELDING OR BRAZING PROCEDURES WHICH REQUIRE QUALIFICATION OR REQUALIFICATION AS SPECIFIED BY PARAGRAPHS 4.7 AND 4.8 OF MIL-STD-248, BY PARAGRAPH 6.3.3 OF NAVSEA 250-1500-1 OR PARAGRAPH 4.2.8.1 OF NAVSEA 0900-LP-001-7000 MUST BE SUBMITTED FOR APPROVAL ON A VPAR. THE BUYER MUST BE NOTIFIED OF THE INTENT TO SUBMIT VPARS FOR WELD PROCEDURES UNDERGOING QUALIFICATION TESTING WITHIN THIRTY (30) DAYS AFTER RECEIPT OF ORDER.
 3. ALL PROCEDURES WHICH HAVE BEEN REVISED BUT DO NOT REQUIRE REQUALIFICATION AS SPECIFIED IN PARAGRAPHS 4.7 AND 4.8 OF MIL-STD-248, BY PARAGRAPH 6.3.3 OF NAVSEA 250-1500-1 OR PARAGRAPH 4.2.8.1 OF NAVSEA 0900-LP-001-7000 SHALL BE SUBMITTED FOR APPROVAL 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 4.2 OF MIL-STD-1689 AND/OR PARAGRAPH 4.2.1.1 OF MIL-STD-278 OR DEFINED AS MINOR STRUCTURE IN PARAGRAPH 3.33.3.1 OF NAVSEA T9074-AD-GIB-010/1688 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 PROCEDURES DESCRIBED IN E.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.
 6. WHEN PREVIOUSLY APPROVED PROCEDURES AS DESCRIBED IN E.5. ABOVE ARE TO BE USED, THE SELLER SHALL ATTACH A PHOTOCOPY OF THE BUYER'S VPAR THAT APPROVED THE PROCEDURE TO BOTH THE PACKING SLIP AND THE WELD

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RECORDS (WHEN WELD RECORDS ARE 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.

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

1. WELDING/BRAZING PROCEDURES TO BE USED ON THIS CONTRACT THAT HAVE BEEN PREVIOUSLY APPROVED BY OTHER ORGANIZATIONS STILL MUST BE SUBMITTED TO THE BUYER FOR APPROVAL ON AN ELECTRIC BOAT VPAR.
2. TO EXPEDITE APPROVAL, PROCEDURES MUST BE SUBMITTED WITH THE SUPPORTING QUALIFICATION DATA AND COPIES OF ALL APPROVAL DOCUMENTATION FROM OTHER ORGANIZATIONS.

G. REPAIR OF BASE MATERIALS

1. WHEN REQUIRED BY EB-4186, PERMISSION TO PERFORM REPAIR WELDING SHALL BE REQUESTED VIA A PROPERLY COMPLETED VENDOR INFORMATION REQUEST SUBMITTED BY THE SELLER EITHER ELECTRONICALLY USING THE APPROVED SPARS VES (VIRTUAL ENTERPRISE SERVER) OR IN PAPER FORMAT (VIR, EB FORM 84-01-2205). SELLER SHALL SEND THESE DOCUMENTS TO THE PURCHASER'S BUYER DESIGNATED ON THE PURCHASE ORDER.
2. WELD REPAIR OF BASE MATERIALS SHALL BE CONDUCTED IN ACCORDANCE WITH EB-4186.

NOTE

PERMISSION TO PERFORM REPAIR WELDING SHALL BE OBTAINED AS SPECIFIED IN EB-4186, PARAGRAPH 4.1.1.2. WHEN REQUIRED BY EB-4186, REPAIR WELDING MUST BE AUTHORIZED BY THE BUYER PRIOR TO PERFORMING SUCH REPAIRS.

H. WELDER WORKMANSHIP TRAINING

1. WELDER WORKMANSHIP TRAINING SHALL BE IN ACCORDANCE WITH EB-4186. IF REQUESTED, THE BUYER CAN PROVIDE ADDITIONAL DOCUMENTATION TO THE SELLER TO SUPPORT THIS TRAINING. THIS REQUIREMENT IS NOT MANDATORY FOR

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FABRICATORS THAT HAVE WELDER WORKMANSHIP PROCEDURES THAT ARE PREVIOUSLY APPROVED BY NAVSEA OR A NAVSEA AUTHORIZED REPRESENTATIVE.

I. NORTHROP GRUMMAN SHIPBUILDING - NEWPORT NEWS OPERATIONS SUBMITTALS

1. FOR PURCHASE ORDERS THAT ORIGINATE FROM NORTHROP GRUMMAN SHIPBUILDING - NEWPORT NEWS OPERATIONS, 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

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