

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 & 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) OR NNS EQUIVALENT. SELLER SHALL SEND THESE DOCUMENTS TO THE BUYER DESIGNATED ON THE PURCHASE ORDER.

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 PUBLICATION 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 & 4.8 OF PPD-802-6335695 (MIL-STD-248D) OR BY PUBLICATION 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 PARAGRAPH 4.3 OF PPD 803-6335694 (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 PURCHASER'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 5. ABOVE ARE TO BE USED, SELLER SHALL COMPLETE THE ATTACHED FORM 84-00-5423 (CERTIFICATION OF PREVIOUSLY APPROVED PROCEDURE), FOR EACH PROCEDURE OR PROVIDE CERTIFICATION ON A SIMILAR SELLER'S FORMAT CONTAINING ALL OF THE INFORMATION REQUIRED BY FORM 84-00-5423, THE ORIGINAL AND ONE COPY OF THE SELLER'S CERTIFICATION MUST BE SENT TO THE BUYER DESIGNATED ON THE ORDER NO LATER THAN THIRTY (30) DAYS FOLLOWING THE SELLER'S RECEIPT OF THE ORDER, & IN ALL INSTANCES PRIOR TO THE START OF THE SELLER'S MANUFACTURE UNDER THIS ORDER, WHICHEVER IS FIRST.

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 PURCHASER.

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 PERMITTED WITHOUT PRIOR APPROVAL BY THE BUYER ON A VENDOR INFORMATION REQUEST (VIR).

D. 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 SUBSTITUTION (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
ALTERNATE SUBSTITUTION:
T9074-AD-GIB-010/1688 (1 MAY 1997)
(26 JUNE 1989)

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

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

ALTERNATE SUBSTITUTION:

PPD 802-6337550 (5 FEBRUARY 1998)
(30 APRIL 1987)

SPECIFICATION:

PPD 802-6335707

SUBSTITUTION:

PPD 802-6335707

ALTERNATE SUBSTITUTION:

PPD 802-6337550 (5 FEBRUARY 1998)
(30 APRIL 1987)

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.

E. WELDER WORKMANSHIP TRAINING

WELDER WORKMANSHIP TRAINING SHALL BE IAW
EB-4186 REV. D

NOTE

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