

TEST REPORTS FOR PERFORMANCE OF VISUAL INSPECTION (VT) OF STRUCTURAL AND/OR COMPLETED WELDS.

1 COPY OF TEST REPORTS SHOWING THE RESULTS OF VISUAL INSPECTION IS REQUIRED TO ACCOMPANY EACH SHIPMENT OF THE TESTED MATERIALS. THE REPORTS AND/OR OTHER VERIFICATION OF CONFORMANCE DOCUMENTS SHALL RECORD:

- A. THE NDT METHOD/S USED.
- B. DESCRIPTION OR UNIQUE IDENTIFICATION OF THE ITEM INSPECTED.
- C. PROCEDURE IDENTIFICATION.
- D. THE PERFORMING ACTIVITY, WHETHER IT BE THE SELLER, A SUB-TIER SUPPLIER OR A TEST LAB.
- E. QUANTITY INSPECTED.
- F. ACCEPTANCE STANDARD USED.
- G. QUANTITY ACCEPTED/REJECTED.
- H. DATE OF INITIAL INSPECTION AND INSPECTOR IDENTIFICATION.
- I. SIGNATURE OF THE INSPECTOR.

2. IN ADDITION, THE SELLER SHALL ATTACH A COPY OF THE BUYERS VPAR THAT APPROVED THE PROCEDURE TO THE TEST REPORT.

3. TEST REPORTS AND/OR OTHER VERIFICATION OF CONFORMANCE DOCUMENTS SHALL BE SIGNED AND DATED BY THE SELLER'S AUTHORIZED REPRESENTATIVE.

RECORDS SHALL IDENTIFY UNIT, APPLICABLE DRAWINGS, WELD IDENTIFICATION OF THE FABRICATION COMPLETED (DRAWING, ASSEMBLY, PIECE MARK) AND TYPE OF NDT INSPECTION PERFORMED. AUTHORIZED SIGNATURE SHALL REPRESENT CERTIFICATION OF ONLY THAT PORTION OF THE STRUCTURE INSPECTED AT THAT TIME.

TEST REPORTS SHALL BE ATTACHED TO THE PACKING LIST. WHERE MORE THAN ONE CONTAINER OR PACKAGE IS INCLUDED IN THE SHIPMENT, THE TEST REPORTS SHALL BE ATTACHED SECURELY TO OR PLACED IN ONE CONTAINER OR PACKAGE AND CLEARLY IDENTIFIED ON THE OUTSIDE.

SPECIAL ALLOWANCES FOR MIL-STD-278 REVISION F, CLASS M, P AND A WELDMENTS.

WHERE MIL-STD-278, REVISION F REQUIRES ROOT LAYER VT INSPECTION FOR CLASS M, P OR A WELDMENTS, THE SELLER MAY USE PRODUCTION WELDERS TO PERFORM VISUAL INSPECTIONS OF THE ROOT LAYERS IN ACCORDANCE WITH MIL-STD-278, REVISION F, PROVIDED THAT THE WELDERS HAVE PASSED REQUISITE TRAINING IN WORKMANSHIP AND DETAILED VISUAL INSPECTION REQUIREMENTS OF ALL FABRICATION DOCUMENTS TO WHICH WELDING IS PERFORMED AND DEMONSTRATE THEIR PROFICIENCY BY SUCCESSFULLY PASSING AN APPROPRIATE OPERATIONAL EXAMINATION AT THE TIME OF WELDING QUALIFICATION, AS REQUIRED BY MIL-STD-248, REVISION D, AND MAINTAIN QUALIFICATION BY SUCCESSFULLY PASSING VISUAL INSPECTION OPERATIONAL TESTING ONCE EVERY THREE YEARS. IN ADDITION TO THE ABOVE DEMONSTRATIONS, ALL PERSONNEL PERFORMING PRODUCTION NDT ARE REQUIRED TO PERFORM THE ACTUAL TEST FOR WHICH THEY ARE CERTIFIED AT LEAST ONCE EVERY SIX MONTHS.

ADDITIONALLY, WHERE MIL-STD-278, REVISION F ALLOWS VT AT 5X MAGNIFICATION TO BE SUBSTITUTED FOR REQUIRED MT/PT ROOT LAYER INSPECTIONS FOR VARIOUS CLASS WELDMENTS, THE SELLER MAY USE PRODUCTION WELDERS TO PERFORM VISUAL INSPECTIONS OF THE ROOT LAYERS IN ACCORDANCE WITH MIL-STD-278, REVISION F, PROVIDED THAT THE WELDERS HAVE PASSED REQUISITE TRAINING IN WORKMANSHIP AND DETAILED VISUAL INSPECTION REQUIREMENTS OF ALL FABRICATION DOCUMENTS TO WHICH WELDING IS PERFORMED AND DEMONSTRATE THEIR PROFICIENCY BY SUCCESSFULLY PASSING AN APPROPRIATE OPERATIONAL EXAMINATION AT THE TIME OF WELDING QUALIFICATION, AS REQUIRED BY MIL-STD-248, REVISION D, AND MAINTAIN QUALIFICATION BY SUCCESSFULLY PASSING VISUAL INSPECTION OPERATIONAL TESTING ONCE EVERY THREE YEARS.

IN ADDITION TO THE ABOVE DEMONSTRATIONS, ALL PERSONNEL PERFORMING PRODUCTION NDT ARE REQUIRED TO PERFORM THE ACTUAL TESTS FOR WHICH THEY ARE CERTIFIED AT LEAST EVERY SIX

MONTHS.

AS AN ALTERNATE MEANS FOR PROVIDING RECORDS FOR PRESSURE VESSEL CLASS A-4 OR MACHINERY CLASS M-2 WELDS IN ACCORDANCE WITH MIL-STD-278, REVISION F, THE SELLER MAY PROVIDE CERTIFICATION THAT ALL VISUAL INSPECTIONS OF ROOT LAYERS AND FINAL WELDS HAVE BEEN SUCCESSFULLY PERFORMED FOR COMPLETED SUBASSEMBLIES (E.G. MAIN CONDENSER HOTWELL). COLLECTIVELY, THESE CERTIFICATIONS SHALL COVER ALL PRESSURE VESSEL CLASS A-4 OR MACHINERY CLASS M-2 WELDS FOR THE ENTIRE COMPONENT.