

Coded Note Number: **LI072**

Revision: **C001**

Date: **June 27, 2012**

Title: **WELD PROCEDURE IAW MIL-STD-1689 FOR APPROVAL**

PROCEDURE SUBMITTAL:

Prior to performing any fabrication welding to MIL-STD-1689, fabrication weld procedure(s) and procedure qualification test report(s) shall be submitted in accordance with Appendix K for approval within 30 days after receipt of this purchase order.

The request for approval shall include:

Current purchase order/item number(s),

NN Material Number(s),

This coded note number,

The procedure number/revision,

The procedure qualification record number(s), evidence of prior Navy approval (if available).

In the event the scheduled date for submittal cannot be met, the supplier shall provide a complete list of all documents and revisions to be used in advance of submittal.

Full compliance to this submittal requirement is expected.

It is highly recommended for development of any new welding procedure(s) or reformatting/revising of existing procedure(s) required for the manufacture of the items listed herein be performed using NavWeld software. A license for NavWeld has been secured for NNS suppliers. To gain access to NavWeld contact Troy Paskell at paskell@weldqc.com or (614) 487-7207. A temporary password will be provided as well as training on how to use NavWeld. Reformatted or revised existing welding procedures must include a copy of the original PQR along with the welding procedure submittal.

PRIOR APPROVED PROCEDURE(S):

If prior approval for welding to MIL-STD-1689 has been obtained from NNS but the procedure number and revision **is not listed** on this purchase order, re-submittal of the procedure is not required. A request for extension of the previous approval shall be submitted and shall include the information detailed above.

NO SUBMITTAL REQUIRED:

If prior approval for welding to MIL-STD-1689 has been obtained from NNS and the procedure number and revision **is listed** on this purchase order, with the exception of procedures used to weld repair castings, no additional submittal is required to satisfy this requirement.

The above requirements do not relieve the seller of his responsibility to comply with the specification requirements of the purchase order.

All casting weld repair requests and approval of the procedure(s) and applicable procedure qualification test report(s) shall be by Vendor Information Request (VIR) in accordance with Appendix "A".

RT FILM SUBMITTAL FOR PROCEDURE QUALIFICATION:

Welding Procedure Qualification Records (PQRs) in accordance with MIL-STD-248D or NAVSEA S9074-AQ-GIB-010/248 for which radiography (RT) inspection is required and which have not been previously approved shall require submittal of the RT film and RT data for review and approval as defined in Appendix K, Section VI.

WELDER WORKMANSHIP TRAINING PROGRAM:

Supplier must have a Welder Workmanship Training Program as described in Appendix K, Section V.

Documents/extensions shall be submitted as follows:

SPARS (Shipbuilding Partners and Suppliers) enabled suppliers are required to submit through <https://spars.huntingtoningalls.com/ngcspars/Auth>

All other suppliers shall submit via:

e-mail pmo@hii-nns.com

or

Newport News Shipbuilding

4101 Washington Ave.

Newport News, VA 23607

ATTN: E45 Software Coordinator

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