

Coded Note Number: LI072

Revision: C005

Date: August 19, 2020

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

This requirement may be satisfied by one of the following methods.

### 1. PROCEDURE SUBMITTAL:

Prior to performing any fabrication welding to MIL-STD-1689, submit fabrication weld procedure(s) and procedure qualification test report(s) in accordance with Appendix K for approval within 30 days after receipt of this purchase order. Include clearly marked on the submittal:

- a. This current purchase order/item number(s),
- b. NN Material Number(s),
- c. This coded note number,
- d. The procedure number/revision,
- e. 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](mailto: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.

### 2. NOTIFICATION OF (UNLISTED) APPROVED/PENDING APPROVAL PROCEDURE(S):

If previous approval for welding to MIL-STD-1689 has been obtained from NNS OR the procedure has been submitted and is pending approval from NNS but the procedure number and revision is not listed on this purchase order/item, re-submittal of the procedure is not required. Submit notification of the previous OR pending approval, including 1.a through e. above and the PO and item number of the previous submittal. For previously approved procedure, also include the previous approval letter number/identification.

### 3. USE OF (LISTED) APPROVED PROCEDURE(S):

If the weld procedure to MIL-STD-1689 used is listed on this purchase order/item, with the exception of procedures used to weld repair castings, this requirement is satisfied, the supplier is authorized to perform work and no submittal is required.

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>

or mail to:

Newport News Shipbuilding  
4101 Washington Ave.  
Newport News, VA 23607  
ATTN: E68 Software Coordinator  
BLDG. 902-2

Click the following link for assistance meeting the requirements of this coded note:

[http://supplier.huntingtoningalls.com/sourcing/doc\\_submittal\\_checklists.html](http://supplier.huntingtoningalls.com/sourcing/doc_submittal_checklists.html)

<b>Revision History Table</b>		
<b>Rev</b>	<b>Description</b>	<b>Revision Date</b>
C005	Revised: Mailing address- changed E45 to E68.	08-07-2020
C004	Deleted: E-mail address submittal option.	06-06-2016

**This revision history is provided for convenience and does not alleviate the supplier's responsibility with understanding and complying with the full coded note.**