

Coded Note Number: **LI114**

Revision: **C003**

Date: **June 27, 2012**

Title: **INTEGRALLY REINFORCED WELD BRANCH CALCULATIONS AND DRAWINGS FOR APPROVAL**

CALCULATIONS AND DRAWINGS SUBMITTAL:

These forgings/fittings shall have sufficient integral reinforcement, including attachment weld, to assure that the strength of the pipe to which the fittings are attached is not reduced.

Calculations used in determining this and drawings showing all pertinent dimensions and weld details are to be furnished for approval within 30 days after receipt of this purchase order.

Calculations shall be similar to those for ASME B31.1 with an internal corrosion allowance of 0.050 inches deducted for the run and fitting wall thickness. Unless otherwise specified in this order all fittings shall be chamfered on the inlet bore to reduce turbulence in the branch.

The request for approval shall include:

Current purchase order/item number(s),

NN Material Number(s),

This coded note number,

The procedure number/revision.

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.

PRIOR APPROVED CALCULATIONS AND DRAWINGS:

If prior approval has been obtained from NNS but the calculations and drawings

ARE NOT LISTED on this purchase order, re-submittal of the calculations and drawings are not required. A request for extension may be submitted and should include the information detailed above.

NO SUBMITTAL REQUIRED:

If prior approval has been obtained from NNS and the calculations and drawings and current revisions **ARE LISTED** on this purchase order, no additional submittal is required to satisfy this requirement. In this instance the supplier is authorized to perform work.

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

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 to pmo@hii-nns.com

or

Newport News Shipbuilding

4101 Washington Ave.

Newport News, VA 23607

Attn: E45 Software Coordinator

Bldg. 600-1