

Coded Note Number: **N3170**

Revision: **C004**

Date: **December 19, 2012**

Title: **NDT (UT, MT, ET, VT, PT) INSPECTION PROCEDURE SUBMITTAL**

QUANTITY: ONE (1) COPY

Forward deliverables here in to:

NEWPORT NEWS SHIPBUILDING
4101 Washington Avenue
Newport News, VA 23607
ATTN: E45 SOFTWARE COORDINATOR
BLDG. **902-2**

As required by Appendix K, applicable Ultrasonic (UT), Magnetic Particle (MT), Eddy Current (ET), Visual Testing (VT), and/or Liquid Penetrant (PT) inspection procedures used for "acceptance inspection" shall be submitted to NNS for approval within 30 days of receipt of this order (for level i assemblies, this requirement applies only to those parts identified as pressure boundary parts in NNS purchase order Appendix P plus any additional parts specifically identified as level I in the purchase order item description and inspection of any welds to these pressure boundary parts). Visual Testing (VT), as it pertains to this coded note, is limited to the inspection of completed fabrication weld joints.

A copy of the navy approval letter(s) for such procedures shall be included (if available).

Notes:

1. If the applicable UT/MT/ET/VT/PT procedures have been previously approved by NNS, submittal and approval of NN Form 4790 will fulfill this requirement.
2. The term "acceptance inspection" used above is intended to mean the final UT/MT/VT/PT inspection performed on the part in accordance with the invoked drawings, specifications, fabrication document, and purchase order requirements. It does not include in-process inspections performed for reasons other than final acceptance. For assemblies and manufactured parts, it also does not include inspections performed on raw materials used to manufacture the assembly/part.
3. It is the supplier's responsibility to adequately control any sub-tier non-destructive testing performed. In addition to the above submittal requirements, NNS reserves the right to request copies of any or all NDT procedures used by the supplier or sub-tier suppliers at any time.
4. For repair welding, submittal of NDT procedures (and applicable qualification test

reports) shall be by Vendor Information Request (VIR) in accordance with NNS purchase order Appendix "A".

Submittal of NDT procedures must include the following information on the form 4790 or submittal letter.

1. The specific application for which inspection is required (i.e. welds, castings, casting repairs, forgings, wrought material or fasteners).
2. The documents invoked by the drawing for technique requirements and acceptance requirements to accomplish the inspection.

All NDT procedures written to the requirements of Appendix K and submitted to the buyer for approval shall contain the following information.

1. The minimum requirements as specified in each method section of the standard.
1. Detailed acceptance criteria as required by the purchase order, applicable specifications, and drawings. The acceptance criteria should be detailed enough to be self standing (i.e., not just referring to the paragraph, but rather citing the wording as often as practical). Acceptance criteria may be contained in separate attachments, addenda, or supplements to the base procedure. General reference to the applicable acceptance specification will not be accepted, except where reference to acceptance standard, section and class stand-alone and can be easily applied by an inspector.
1. A statement that the contractor's or any subcontractor's NDT personnel are certified in accordance with SNT-TC-1A as modified by Appendix K. The NDT contractor's or any subcontractor's NDT personnel certification procedure should be referenced in the NDT procedure.
1. A certification statement signed by the level iii examiner, as required by Appendix K.
1. The signature of the level III examiner approving the procedure. The name of the person approving the NDT procedure shall be identified in the procedure as a level III examiner.

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

[NAV03 – Nondestructive Testing](#)