

Coded Note Number: **N3430**

Revision: **C002**

Date: **July 18, 2018**

Title: **VISUAL INSPECTION (VT) PROCEDURE REQUIREMENTS FOR WELDED NNS CUNI B16.9 FITTINGS (TY-W AND TY-WX)**

All welds, including those in the welded tubular products (MIL-T-16420 TY-II) used to make this Purchase Order (PO) item, require Visual Inspection (VT) inspection in accordance with NAVSEA Technical Publication T9074-AS-GIB-010/271.

1. Written procedure requirements. The Supplier or subcontractor shall use written VT procedure(s) approved by the Level III Examiner. The procedure(s) shall meet the requirements of the applicable specification and the requirements herein.
 - 1.1. The Supplier or subcontractor shall maintain the VT procedure(s). Procedure(s) shall be available to NNS upon request.
2. Procedure content requirements. The VT procedure shall contain:
 - a) The minimum requirements as specified in NAVSEA Technical Publication T9074-AS-GIB-010/271.
 - b) Detailed acceptance criteria as required by the PO, 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.
 - c) A statement that the Supplier's or any subcontractor's NDT personnel are certified in accordance with SNT-TC-1A as modified by NAVSEA Technical Publication T9074-AS-GIB-010/271. The NDT Supplier's or any subcontractor's NDT personnel certification procedure should be referenced in the NDT procedure.
 - d) A certification statement signed by the Level III Examiner, as required by paragraph 1.7.1 of NAVSEA Technical Publication T9074-AS-GIB-010/271.
 - e) 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.

2.1. The NNS supplier website contains a VT procedure checklist to aid suppliers in developing an approved VT procedure in accordance with NAVSEA Technical Publication T9074-AS-GIB-010/271:

http://supplier.huntingtoningalls.com/sourcing/docs/Document_Submittal_Checklists/NDT/Supplier_VTPrcdChecklist_TP278-TP271CompletedWelds-RootLayer-5X_FORM.docx

Revision History Table		
Rev	Description	Revision Date
C001	Initial Issue	6/22/2018
C002	Changed to correct formatting issues. <u>Removed:</u> 1. Footer removed from each page.	7/18/2018

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