

Coded Note Number: **N3440**

Revision: **C004**

Date: **July 15, 2020**

Title: **RADIOGRAPHIC TEST (RT) PROCEDURE REQUIREMENTS FOR NNS CUNI B16.9 TY-WX AND MSS SP-119 FITTINGS**

All welds including those in the welded tubular products (MIL-T-16420 TY-II) used to make this Purchase Order (PO) item, longitudinal weld(s), and where present, the circumferential weld, require 100% radiograph inspection in accordance with NAVSEA Technical Publication T9074-AS-GIB-010/271.

1. Written procedure requirements. The Supplier and/or subcontractor shall use written Radiographic Test (RT) procedure(s) approved by the Level III Examiner. Procedure(s) shall meet the requirements of NAVSEA Technical Publication T9074-AS-GIB-010/271, the applicable specification, and the requirements herein.

1.1. The Supplier and/or subcontractor shall maintain the RT procedure(s). Procedure(s) shall be available to NNS upon request.

2. Procedure content requirements. The RT 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 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 an RT procedure checklist to aid Suppliers in developing an approved RT procedure in accordance with NAVSEA Technical Publication T9074-AS-GIB-010/271:

http://supplier.huntingtoningalls.com/sourcing/docs/Document_Submittal_Checklists/NDT/Supplier_RT_Checklist.docx

Revision History Table		
Rev	Description	Revision Date
C001	Initial Issue	6/22/2018
C002	Changed to add date to Coded Note and correct formatting issues. <u>Removed:</u> 1. Footer removed from each page.	7/18/2018
C003	<u>Removed:</u> Return(s) (blank line(s)) following revision history note after table removed to allow SAP ZIPM functionality.	8/17/18
C004	Revised title to accommodate use on MSS SP-119 belled end fittings.	7/15/2020

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