

Coded Note Number N3450

Revision: **C001**

Date: **September 12, 2018**

Title: **NDT (VT, RT) IAW NAVSEA TECH PUB 271 FOR WELDED CRES NNS B16.9MOD FITTINGS**

1. When Non-Destructive Test (NDT) inspection is required for this Purchase Order (PO) item as identified in Section 2 and 3 of this coded note, NDT inspection shall be performed in accordance with NAVSEA Technical Publication T9074-AS-GIB-010/271 by qualified personnel using the Class 2 acceptance criteria in MIL-STD-2035, in lieu of the ASME Boiler and Pressure Vessel Code.
2. NDT Requirements When No Filler Metal Is Used
 - 2.1. ASTM-A403 CL-W NNS B16.9MOD fittings:
Single longitudinal seam welds made by the pipe or fitting Manufacturer, without the use of filler metal, do not require NDT inspection (e.g. Fittings formed from filler metal free welded pipe).
 - 2.2. ASTM-A403 CL-WX NNS B16.9MOD fittings:
Welds made by the pipe or fitting Manufacturer, without the use of filler metal do not require Visual Inspection (VT). Radiographic Test (RT) of the welds is required (e.g. Fittings formed from filler metal free welded pipe).
 - 2.2.1. The fitting Manufacturer / Supplier shall perform RT on the entire length of all weld(s) using an approved written procedure.
3. NDT Requirements When Filler Metal Is Used
 - 3.1. All pipe welds made by the pipe or fitting Manufacturer with the addition of filler metal require VT and RT inspection throughout the entire length of the weld(s). Ultrasonic Test (UT) inspection of these welds is not acceptable.
 - 3.1.1. The fitting Manufacturer / Supplier shall perform VT and RT on the entire length of all weld(s) using an approved written procedure.
4. Written procedure requirements VT and RT procedures require approval by a Level III Examiner. The procedures shall meet the requirements of NAVSEA Technical Publication T9074-AS-GIB-010/271 and the requirements herein.
 - 4.1. The Supplier shall maintain the procedures used for this PO item. Procedures shall be available to NNS upon request.

5. Procedure content requirements VT and RT procedures 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 fitting Manufacturer's, Supplier's, or subcontractor's NDT personnel are certified in accordance with SNT-TC-1A as modified by NAVSEA Technical Publication T9074-AS-GIB-010/271. The fitting Manufacturer's, Supplier's, or 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.

5.1. The NNS Supplier website contains VT and RT procedure checklists to aid Suppliers in developing procedure(s) in accordance with NAVSEA Technical Publication T9074-AS-GIB-010/271:

VT Procedure Checklist

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

RT Procedure Checklist

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

Revision History Table		
Rev	Description	Revision Date
C001	Initial Issue	09/12/2018

