

Coded Note Number: **N3460**

Revision: **C002**

Date: **November 30, 2018**

Title: **RADIOGRAPHIC TEST (RT) RECORDS FOR WELDED CRES AND ALLOY 625 NNS B16.9MOD FITTINGS**

When Radiographic Test (RT) inspection of fitting welds is required by the Purchase Order (PO), the Supplier shall send RT records to Newport News Shipbuilding (NNS) for approval prior to material shipment, unless authorized by NNS.

1. General Radiography Requirements. The requirements for radiographic inspection in NAVSEA Technical Publication T9074-AS-GIB-010/271 are supplemented by the following:
 - 1.1. Radiography of more than one fitting per film is prohibited.
 - 1.2. The following identification shall appear on each radiograph, as a result of exposure of the film:
 - a) RT serial number or code for the particular component.
 - b) Film location markers.
 - 1.3. Date of exposure shall appear on each radiograph, either by exposure or by punching.
 - 1.4. Identification of the organization making the radiograph shall appear on the reports accompanying the radiograph submittal.
 - 1.5. Radiography of a repaired weld area shall be in accordance with the same technique used for original radiography. Radiographs shall be identified with the same serial number or code used for original radiographs followed by the letter R and a numeral 1, 2, etc., to indicate the number of times the weld area involved has been repaired.
2. RT records. The Supplier shall submit the following RT records for this Purchase Order (PO) item to NNS for approval upon completion of radiographic inspection:
 - a) All radiographs, original and of any weld repairs.
 - b) A set-up sketch showing the basic parameters used to radiograph the weld(s) (source placement, film placement, back filter placement, penetrometer and shim location, location marker placement, lead letter "B" location).
 - c) Radiographic inspection reports signed by the radiographic inspector.

2.1. The Supplier shall identify the PO number and PO item number on the outer wrapping for all shipments of radiographs and radiograph inspection reports. The following identifying information for each set of radiographs shall be included in the shipment:

- a) Description (name) of fitting
- b) PO number, PO item number, and material number (Newport News Part Number (NNPN))
- c) Drawing number(s), which show welded joints requiring RT
- d) Radiograph identification number

2.2. The Supplier shall submit Radiographs in a waterproof envelope or container.

3. Submittal Directions. All RT records shall be submitted to NNS by mail:

Newport News Shipbuilding (NNS)
 4101 Washington Ave
 Newport News, VA 23607-2770
 ATTN: RT Interpretation Section
 Dept. O37 Bldg. 167/1

Revision History Table		
Rev	Description	Revision Date
C001	Initial Issue	09/12/2018
C002	<u>Revised:</u> 1. Coded Note Title was "RADIOGRAPHIC TEST (RT) RECORDS FOR WELDED (CL-W AND CL-WX) CRES NNS B16.9MOD FITTINGS" Reason: To allow Coded Note to be used on welded Alloy 625 NNS B16.9MOD fittings as well as welded CRES fittings.	11/30/2018

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