

Coded Note Number: **W1380**

Revision: **C001**

Date: **October 29, 2014**

Title: **BUTT WELD FITTINGS REQUIREMENTS**

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

Change from Revision C001.

Bolded font indicates changed/added content.

[Text deleted] inserted in the document indicates the removal of content.

Unless otherwise specified, Butt welded fittings shall meet the requirements of [Text deleted] ASME B16.9 [Text deleted]. [Text deleted] The basis for the qualification of each fitting design shall be maintained and available to [Text deleted] NNS for inspection [Text deleted]. When proof testing is used as a basis for qualification, then the documentation shall include the following:

- (A) Burst test results for each size and type prototype fitting tested to comply with **[Text deleted] ASME B16.9 [Text deleted]**, including a complete history of the material and strength characteristics of the prototype fitting.
- (B) Dimensional history of the prototype fitting including a design sketch which shows location of all pertinent dimensions, i.e., crotch thickness, weld end thickness, etc.
- (C) Production drawings which show all pertinent dimensions taken from the prototype fittings and against which the production fittings are checked in accordance with **[Text deleted] ASME B16.9 [Text deleted]**.

This requirement applies to ASME B16.28 fittings when invoked on purchase order.