

Coded Note Number: W1450  
Revision: C007  
Date: December 21, 2020  
Title: INTEGRALLY REINFORCED WELD BRANCHES

This requirement may be satisfied by one of the following methods.

1. CALCULATIONS AND DRAWINGS SUBMITTAL:

These forgings/fittings shall have sufficient integral reinforcement, including attachment weld, to assure that the strength of the pipe to which the fittings are attached is not reduced. Submit all new calculations used in determining this and drawings showing all pertinent dimensions and weld details and/or any listed reports if revised subsequent to the last approval are to be furnished for approval within 30 days after receipt of this purchase order. Calculations shall be similar to those for ASME B31.1 with an internal corrosion allowance of 0.050 inches deducted for the run and fitting wall thickness. Unless otherwise specified in this order all fittings shall be chamfered on the inlet bore to reduce turbulence in the branch.

Include clearly marked on the submittal:

- a. This current purchase order/item number(s),
- b. NN Material Number(s),
- c. This coded note number,
- d. The calculation and drawing number/revision.

In the event the scheduled date for submittal cannot be met, the supplier shall provide a complete list of all documents and revisions to be used in advance of submittal. Full compliance to this submittal requirement is expected.

2. NOTIFICATION OF (UNLISTED) APPROVED/PENDING APPROVAL CALCULATIONS AND DRAWINGS:

If previous approval has been obtained from NNS OR the calculations and drawings have been submitted and are pending approval from NNS but the calculations and drawings number and revision is not listed on this purchase order/item, re-submittal of the calculations and drawings is not required. Submit notification of the previous OR pending approval, including 1.a. through d. above and the PO and item number of the previous submittal. For previously approved calculations and drawings, also include the previous approval letter number/identification..

3. USE OF (LISTED) APPROVED CALCULATIONS AND DRAWINGS:

If the calculations and drawing revision used is listed on this purchase order/item, this requirement is satisfied, the supplier is authorized to perform work and no submittal is required.

The above requirements do not relieve the seller of his responsibility to comply with the specification requirements of the purchase order.

Documents/extensions shall be submitted as follows:

SPARS (Shipbuilding Partners and Suppliers) enabled suppliers are required to submit through <https://spars.huntingtoningalls.com/ngcspars/Auth>

All other suppliers shall submit via:

mail to:

Newport News Shipbuilding

4101 Washington Ave.

Newport News, VA 23607

Attn: E68 Software Coordinator

Bldg. 902-2

<b>Revision History Table</b>		
<b>Rev</b>	<b>Description</b>	<b>Revision Date</b>
C007	Revised: Mailing address- changed E45 to E68.	12-21-2020

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