

Coded Note Number: **W3020**

Revision: **C002**

Date: **September 3, 2017**

Title: **SSN688CL STEEL PLATE REPAIR WELDS**

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

**Change from Revision C001 – Editorial change to reformat to current standard.**

**Bolded font indicates changed/added content.**

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

Where plates require weld repair, the repairs may be made by the vendor subject to the following:

Military specification MIL-S-16216 (revision as specified in ordering data) para.

3.6.1, delete and substitute:

3.6.1 Weld Repair of Mill Defects. Mill defects may be repair welded by the manufacturer or referred to the consignee for acceptance and subsequent repair welding by the consignee. Areas of the plate found to have less than the minimum specified thickness may have the thickness restored by welding the depressed area. Welding of such areas is subject to the following limitations:

- A. The total area to be repaired shall not exceed one percent of the surface of one side of the plate.
- B. The depth of any area to be repaired shall not exceed one-half the minimum plate thickness specified or one-half inch, whichever is less. The depth of the area to be repaired shall be minimum of one-sixteenth inch.
- C. Areas within two inches of each other which require weld repair shall be combined to form a single repair.
- D. All of the areas to be welded shall be ground sufficiently to assure that the welds are made on clean, sound metal.
- E. After preparation for repair and prior to welding, all of the depressed areas shall be magnetic particle inspected in accordance with MIL-STD-271, and shown to be free of linear discontinuities.
- F. Weld repairs shall be in accordance with MIL-STD-1688 or the applicable fabrication document. Procedures and personnel shall be qualified in accordance with MIL-STD-248.

- G. if mill defects are repair welded followed by heat treatment, such weld repairs shall be made using an acceptable heat-treatable electrode.
- H. The final repaired surface shall be ground smooth and shall be essentially flush with the adjacent surface and free of undercut in excess of .020 inch. No point of the finished weld surface shall be below the adjacent plate surface.
- I. Plates or segments of plates containing surface weld repairs shall be magnetic particle inspected after final grinding (or subsequent heat treatment, if applicable) in accordance with MIL-STD-271. All welds and adjacent heat affected zone surfaces shall be free of relevant linear indications longer than 1/8 inch in accordance with NAVSEA 0900-LP-003-8000.
- J. All repaired areas shall be marked. Marking methods shall be such that they will not be removed prior to performing all inspections as required by this document.
- K. Notations of such repaired areas shall be made on the plate inspection form as part of the records.
- L. Newport News Shipbuilding shall be notified with a referral letter prior to shipment of the plate.
- M. The requirements contained herein apply to each level of the supply chain and must be flowed down to the producer of castings and/or the producer of weldments of any type.