

Coded Note Number: **W3030**

Revision: **C004**

Date: **May 5, 2020**

Title: **NO WELDING/BRAZING WITHOUT AUTHORIZATION**

## 1.0. Fabrication

- 1.1. No welding/brazing fabrication of any kind is authorized without written approval from NNS.
- 1.2. Requests to fabricate via welding/brazing are to be submitted to NNS for approval via a Vendor Information Request (VIR). VIR shall include the applicable welding/brazing procedure and procedure qualification records/reports (PQR). Purchase Order (PO) Appendix K applies.

## 2.0. Weld Repair

- 2.1. Base Metal. Minor weld repair of base metal, as defined in NAVSEA Technical Publication S9074-AR-GIB-010/278, is authorized provided all the following conditions are met:
  - 2.1.1. An NNS approved weld repair procedure in accordance with the applicable fabrication specification as modified by PO Appendix K is used.
  - 2.1.2. The weld repair is specifically permitted by the weld repair procedure, fabrication specification, equipment/material specification, or approved drawing.
  - 2.1.3. Weld repair is not otherwise restricted within the PO.
- 2.2. Castings. Minor and nominal weld repair of castings, as defined in NAVSEA Technical Publication S9074-AR-GIB-010/278, is authorized provided the the following conditions are met:
  - 2.2.1. An NNS approved weld repair procedure in accordance with the applicable fabrication specification as modified by PO Appendix K is used.
  - 2.2.2. The weld repair is specifically permitted by the weld repair procedure, fabrication specification, equipment/material specification, or approved drawing.
  - 2.2.3. Weld repair is not otherwise restricted within the PO.
  - 2.2.4. For nominal repairs, the casting identification number, welding procedure number or title, welder identification, and name of the

authorized representative are recorded and documentation retained as required in NAVSEA Technical Publication S9074-AR-GIB-010/278.

2.3. Weld repair procedures and PQRs are to be submitted to NNS for approval via a VIR, as necessary. PO Appendix K applies.

2.4. When base metal or casting weld repair has been determined necessary, yet the fabrication specification, equipment/material specification, or approved drawing doesn't cover weld repair or doesn't specifically permit weld repair, a VIR must be submitted to NNS for approval. PO Appendix K applies.

Revision History Table		
Rev	Description	Revision Date
C004	<p><u>Added:</u></p> <ol style="list-style-type: none"> <li>1. Verbiage clarifying requirements regarding NNS authorization to perform minor repair on base metal and minor and nominal repair of castings.</li> </ol> <p><u>REVISED:</u></p> <ol style="list-style-type: none"> <li>2. The title was revised to include brazing.</li> <li>3. Coded Note re-written / reorganized.</li> <li>4. Verbiage providing authorization to perform weld repair on base metal or castings using NNS approved procedures, "except where specifically restricted" verbiage changed to "where specifically permitted".</li> </ol> <p><u>REMOVED:</u></p> <ol style="list-style-type: none"> <li>5. Removed "the government" as a procedure approval agent.</li> <li>6. Removed sentence regarding "Level I" material requiring NDT procedures be submitted for NNS approval when subject to weld repair.</li> <li>7. Removed sentence regarding all requirements contained herein apply to each level of the supply chain.</li> </ol> <p>REASONS: (1) To differentiate between weld repair of base metal and castings. Weld repair on base metal not defined as minor is not authorized and requires submittal of a VIR for NNS approval. Special repair, as defined in NAVSEA Tech Pub 278, of castings is not authorized and requires submittal of VIR for NNS approval. (2) Brazing is discussed in the note but was not included in the title; (3) To simplify/clarify requirements, organize to clearly differentiate fabrication welding and base metal weld repair. (4) The "except where specifically restricted" verbiage could be misconstrued to authorize weld repair when NNS does not intend to (e.g. specification, drawing or purchase order does not address weld repair, neither restricting it or permitting it) (5) weld repair procedures approved by the government would not include any NNS Appendix K modifications to the associated fabrication specification and may not align with the document revision(s)</p>	05/06/2020

required by NNS Appendix K. (6) Coded Note is about fabrication welding and base metal weld repair, NDT procedure requirement is out of place. (7) Requirement is conveyed to vendors in Coded Note E1010, and is not limited to welding requirements.

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