

W4020
Revision Level C000
Revision Date April 22, 2005
BRAZING & WELDING PROCEDURE APPROVAL

W4020-20050422

QUANTITY: SEE APPENDIX K

FORWARD DELIVERABLES HERE IN TO:
NORTHROP GRUMMAN NEWPORT NEWS
4101 WASHINGTON AVENUE
NEWPORT NEWS, VA 23607
ATTN: E45 SOFTWARE COORDINATOR
BLDG. 635-6

PRIOR TO PERFORMING ANY FABRICATION WELDING/ SILVER BRAZING, THE FABRICATION WELDING/ BRAZING PROCEDURE, PROCEDURE QUALIFICATION TEST REPORT(S) AND, IF AVAILABLE, EVIDENCE OF PRIOR NAVY APPROVAL SHALL BE SUBMITTED IN ACCORDANCE WITH APPENDIX "K".

THE PERFORMANCE OF WELD REPAIRS USING PROCEDURES PREVIOUSLY QUALIFIED AND APPROVED BY THE GOVERNMENT OR NNS FOR THE BASE MATERIAL OR CASTING IS AUTHORIZED EXCEPT WHERE SPECIFICALLY RESTRICTED BY THE WELD REPAIR PROCEDURE FABRICATION SPECIFICATION (IE. NAVSEA S9074-AR-GIB-010/278, PROJECT PECULIAR DOCUMENT (PPD) 802-6337597, NAVSEA T9074-AD-GIB-010/1688, ETC) OR EQUIPMENT/MATERIAL SPECIFICATION, APPROVED DRAWING, OR ELSEWHERE IN THIS ORDER. PROCEDURES FOR VT/UT/MT/PT INSPECTION NOT PREVIOUSLY APPROVED BY THE GOVERNMENT OR NNS MUST BE SUBMITTED FOR APPROVAL FOR REPAIR OF "LEVEL I" (CONTROLLED MATERIAL) PARTS.

NOTE:(1) IF THE APPLICABLE WELDING/BRAZING PROCEDURES INCLUDING CURRENT REVISIONS HAVE BEEN PREVIOUSLY APPROVED BY NNS, SUBMITTAL AND APPROVAL OF FORM 4790 WILL FULFILL THIS REQUIREMENT.

(2) SUBMITTAL OF REPAIR REQUESTS AND APPROVAL OF THE PROCEDURE(S)AND APPLICABLE PROCEDURE QUALIFICATION TEST REPORT(S) SHALL BE BY VENDOR INFORMATION REQUEST (VIR) IN ACCORDANCE WITH APPENDIX "A".

(3) WHERE A CONTINUOUS WELD JOINT DESIGN IS USED (IE, DOUBLE FILLET WELD, BUTT WELD ETC.) THE ENDS OF ALL CONTINUOUS WELDS ARE REQUIRED TO BE WRAPPED.

(4) APPENDIX K MODIFIED MIL-STD-278 FOR SSN 688 CLASS SUBMARINES TO REQUIRE VENDORS QUALITY CONTROL SYSTEM TO INCLUDE PREPARING AND MAINTAINING WRITTEN WELD RECORDS FOR EACH WELD JOINT IDENTIFIED AS A-F, A-1, A-2, A-LT, P1, P-LT, AND T-1 CLASS WELDS. THESE WELD JOINT RECORDS SHALL BE MADE AVAILABLE TO NNS UPON REQUEST AS PART OF THE CONTRACTUAL REQUIREMENTS.

NOTE (4) ABOVE IS APPLICABLE ONLY WHEN APPENDIX K-600 IS INVOKED IN THE LIST OF APPENDICES OF THIS PURCHASE ORDER.