

W4020  
Revision Level C004  
Revision Date February 13, 2012  
BRAZING & WELDING PROCEDURE APPROVAL

W4020 WELDING & BRAZING PROCEDURE APPROVAL

QUANTITY: SEE APPENDIX K

FORWARD DELIVERABLES HERE IN TO:  
NEWPORT NEWS SHIPBUILDING  
4101 WASHINGTON AVENUE  
NEWPORT NEWS, VA 23607  
ATTN: E45 SOFTWARE COORDINATOR  
BLDG. **600-1**

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" AND APPROVED BY NGSB-NN PRIOR TO USE IN MANUFACTURING.

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 PECUILIAR 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) 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.