

Coded Note Number: **W4030**

Revision: **C004**

Date: **February 04, 2020**

Title: **NNS APPROVED WELD PROCEDURE IAW NAVSEA S9074-AR-GIB-010/278  
REQUIRED FOR CUNI PIPE FITTINGS**

1. A Newport News Shipbuilding (NNS) approved weld procedure in accordance with NAVSEA Technical Publication S9074-AR-GIB-010/278 and Procedure Qualification Record (PQR) in accordance with NAVSEA Technical Publication S9074-AQ-GIB-010/248 are required for this Purchase Order (PO) item, including any welded tubular products used to make this item.

If the Supplier has a subcontractor performing any welding to manufacture the fitting or MIL-T-16420 TY-II welded CUNI tube starting material, the subcontractor's production welding procedure(s) and supporting PQR are required to be submitted to NNS for approval. The submittal shall clearly state the company that will use the procedure(s), and the applicable NNS PO number and PO item number.

No production welding shall be performed until the Supplier obtains NNS approval for the weld procedure(s) intended to be used to fabricate this PO item, including those for the MIL-T-16420 TY-II welded CUNI tube starting material, when applicable. Weld procedures require individual approvals for each NNS material number.

The requirement to have an NNS approved weld procedure including the associated PQR may be satisfied through one of the following methods:

1.1. Use of an Approved Procedure.

- 1.1.1. When one or more weld procedures are listed as specifications for the PO item number, the use of one of the listed weld procedures is acceptable. Welding in accordance with a listed procedure number and revision is authorized, and no submittal is required.

1.2. Use of Unlisted Approved Procedure(s) / Procedure(s) Pending Approval.

- 1.2.1. The use of a weld procedure listed for the PO item number is not mandatory. If previous approval for welding to NAVSEA Technical Publication S9074-AR-GIB-010/278 has been obtained from NNS for the NNS material number or the procedure has been submitted and is pending approval from NNS but the procedure number and revision is not listed on this PO item, re-submittal of the procedure is not required. However, authorization to weld is withheld until a notification is submitted and approved.

1.2.2. The Supplier shall submit notification of the previous approval or pending approval to NNS for approval using the submittal directions in Section 3. Notification shall include the PO and item number of the previous submittal, the weld procedure number and revision, and as applicable, the previous approval letter number or identification.

Note: Upon NNS approval, NNS will update the NNPN to reflect the weld procedure number and revision so the procedure will be listed as a specification on future POs involving that NNPN.

1.3. Submittal of a New Procedure for Approval. If the Supplier or subcontractor does not have an NNS approved weld procedure, the Supplier shall submit a proposed procedure qualification plan, including a description of the qualification, to NNS for review within 30 days after receipt of this PO using the submittal directions in Section 3.

1.3.1. After the Supplier receives feedback on their proposed procedure qualification plan from NNS, the Supplier shall submit the new weld procedure and PQR to NNS for approval using the submittal directions in Section 3.

1.3.1.1. The following information shall be clearly identified on the submittal:

- a) PO Number and PO item number(s)
- b) Material Number(s)
- c) This coded note number
- d) Fabrication standard and revision
- e) The applicable material fitting specification
- f) Weld procedure number and revision
- g) Weld procedure qualification record number
- h) Evidence of prior Navy approval (if available)

1.3.2. NavWeld software is the preferred method for developing, reformatting, or revising welding procedures required for the manufacture of the items listed in the PO. A license for NavWeld is available for NNS Suppliers, and access can be granted by contacting Troy Paskell at [paskell@weldqc.com](mailto:paskell@weldqc.com) or 614-956-1153. See the NNS Supplier website for further information.

1.3.3. Reformatted or revised existing welding procedures shall include a copy of the original PQR along with the welding procedure submittal.

Note: Upon NNS approval, NNS will update the NNPN to reflect the weld procedure number and revision so the procedure will be listed as a

specification on future POs involving that NNPN.

2. Radiographic Inspection (RT) Film Submittal for Procedure Qualification. Welding PQRs in accordance with NAVSEA Technical Publication S9074-AQ-GIB-010/248 for which radiographic inspection (RT) is required, and which have not been previously approved by NNS, require RT record submittal to NNS for approval.

2.1. The supplier shall submit the following RT records to NNS for approval:

- a) the associated radiograph(s),
- b) set-up sketch(es), and
- c) radiographic inspection report(s) for review and approval.

2.1.1. The following information shall be identified on the submittal:

- a) The statement: "RT film and data for Welding Procedure Qualification."
- b) PQR Number \_\_\_\_\_
- c) Welding Procedure Number \_\_\_\_\_.
- d) The statement: "Visual Inspection (VT) was conducted and the weld found to be satisfactory."
- e) The RT performance standard and acceptance criteria for NAVSEA Technical Publication S9074-AQ-GIB-010/248 Qualifications as listed below:
  - Performance standard: NAVSEA Technical Publication T9074-AS-GIB-010/271
  - Acceptance standard: MIL-STD-2035A, Class I
- f) Joint type i.e. butt, single bevel, double bevel, backing bar, etc.
- g) Base material type
- h) Filler material type
- i) Joint thickness
- j) Joint form plate/pipe

2.2. The RT records shall be submitted for approval by mail:

Newport News Shipbuilding (NNS)  
4101 Washington Ave.  
Newport News, VA 23607-2770  
Attn: RT Interpretation Section  
Dept. O37 Bldg. 167/1

2.3. A copy of the RT records approval from NNS shall be included with the PQR when it is submitted for approval.

3. Submittal Directions. The Supplier shall submit procedures, PQRs, or notification as required, through SPARS (Shipbuilding Partners and Suppliers) <https://spars.huntingtoningalls.com/ngcspars/Auth>

or mail to:

Newport News Shipbuilding (NNS)  
 4101 Washington Ave.  
 Newport News, VA 23607  
 Attn: E68 Software Coordinator, Bldg. 902-2

Prior to submittal, Suppliers are encouraged to use the weld procedure checklist on the NNS Supplier website.

4. Welder Workmanship Training (WWT) Program: The Supplier and/or subcontractor shall fully implement a welder workmanship and visual inspection training (WWT) program as required by NAVSEA Technical Publication S9074-AQ-GIB-010/248 Section 5.2.3.1. Every two years, a NDT Level III Examiner shall re-certify in writing that the program is adequate. Copies of these certificates shall be retained by the Supplier and be available for audit.

NNS strongly suggests the Supplier and/or subcontractor complete WWT available from NavNDT. See the NNS Supplier website for a copy of “NNS WWT-PIPING/PRESSURE VESSEL/MACHINERY WELDER WORKMANSHIP TRAINING FOR NON-VIRGINIA CLASS CONTRACTORS AND/OR SUBCONTRACTORS” and information on NavNDT.

Revision History Table		
Rev	Description	Revision Date
C001	Initial Issue	7/18/2018
C002/003	<u>Removed</u> : Return(s) (blank line(s)) following revision history note after table removed to allow SAP ZIPM functionality.	8/17/18
C004	<u>Revised</u> : 1. Coded Note Title did read “NNS APPROVED WELD PROCEDURE IAW NAVSEA S9074-AR-GIB-010/278 REQUIRED FOR NNS CUNI B16.9 FITTINGS” REASON: Revised Title to make it applicable to pipe fitting NNPNs other than NNS B16.9MOD fittings (e.g. MSS-SP-119 BE Fittings).  2. Changed department from O52 to E68 in Section 3. Submittal Directions.	02/04/2020

REASON: The appropriate software coordinator is now in E68.
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**This revision history is provided for convenience and does not alleviate the supplier's responsibility with understanding and complying with the full coded note.**