

WR002-19970314

NNS NOTE WR002 Effective date 19970314

"FORGING REPAIRS:

WHERE DAMAGE OCCURS TO WELDMENT OR BASE MATERIAL DURING FABRICATION, THE DAMAGED AREA MAY BE REPAIR WELDED PROVIDED THE REPAIR WELD AND ADJACENT METAL IS INSPECTED BY THE SAME METHOD AS REQUIRED FOR THE CLASS OF WELDING. WELD REPAIRS NOT IN EXCESS OF THOSE DEFINED FOR 'MINOR CASTING REPAIRS' CAN BE MADE ON THE WROUGHT MATERIAL AT THE DISCRETION OF THE FABRICATOR PROVIDED ALL REQUIREMENTS OF MIL-STD-278 REVISION C ARE MET.

OTHER REPAIRS SHALL REQUIRE SPECIFIC APPROVAL BY THE AUTHORIZED AGENT EXCEPT THAT NO APPROVAL SHALL BE REQUIRED FOR REPAIRS MADE WITH AN APPROVED STANDARD REPAIR WELD PROCEDURE INCLUDING WELDING PARAMETERS, INSPECTION REQUIREMENTS, RECORDS, ETC. MEETING ALL THE REQUIREMENTS OF MIL-STD-278 AND MIL-STD-00248B.

WHERE RADIOGRAPHIC INSPECTION (RT) IS A REQUIREMENT OF THE CLASS OF WELDING, MAGNETIC PARTICLE (MT) OR LIQUID PENETRANT INSPECTION (PT) MAY BE USED IN LIEU OF RT WHERE THE FINISHED WELD THICKNESS DOES NOT EXCEED 3/8 INCH OR HALF THE THICKNESS OF THE BASE METAL, WHICHEVER IS LESS. IN ADDITION WHERE RT WOULD NORMALLY BE REQUIRED FOR THE CLASS OF WELDING INVOLVED AND THE REPAIR FALLS WITHIN A FLUID BOUNDARY AREA (I.E. MISDRILLED FLANGE BOLT HOLES, ETC.) CASE BASIS APPROVAL TO DELETE RT MAY BE OBTAINED FROM THE AUTHORIZED AGENT.

EXCEPT FOR ARC STRIKES AND REMOVAL SITES OF WELD ATTACHMENTS, ALL REPAIRS ON CLASSES P-1, P-LT, A-1, A-2, A-F AND A-LT COMPONENTS SHALL BE DOCUMENTED AND RECORDS MAINTAINED AVAILABLE TO THE AUTHORIZED AGENT FOR REVIEW. THESE REPAIR RECORDS SHALL INCLUDE THE FOLLOWING:

- NAME AND IDENTIFICATION OF COMPONENT
- DESCRIPTION OF DEFECTS REPAIRED (LOCATION, LENGTH, WIDTH AND DEPT OF EXCAVATION)

- BASE MATERIAL; WELDING
- WELDING FILLER METAL
- POST HEAT TREATMENT (WHERE APPLICABLE)
- FINAL INSPECTION RESULTS."