

WR004-20050909

BASE METAL REPAIRS:

SURFACE DEFECTS AND DAMAGED BASE MATERIAL 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 NAVSEA TECHNICAL PUBLICATION S9074-AR-GIB-010/278 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 NAVSEA TECHNICAL PUBLICATION S9074-AR-GIB-010/278 AND NAVSEA TECHNICAL PUBLICATION S9074-AQ-GIB-010/248.

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 DESIGN 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 NONFLUID BOUNDARY AREA (I.E. MISDRILLED FLANGE BOLT HOLES, ETC.) CASE BASIS APPROVAL TO DELETE RT MAY BE OBTAINED FROM THE AUTHORIZED REPRESENTATIVE.

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 AND MADE 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 DEPTH OF EXCAVATION)
- BASE MATERIAL
- WELDING FILLER METAL
- POST HEAT TREATMENT (WHERE APPLICABLE)
- FINAL INSPECTION RESULTS