

Coded Note Number: **LI061**

Revision: **C012**

Date: **October 9, 2026**

Title: **WELD PROCEDURE IAW NAVSEA S9074-AR-GIB-010/278 FOR APPROVAL**

<u>Section</u>	<u>Title</u>
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2	Welding Procedure Approval
3	New PQR RT Film Submittal
4	Welder Workmanship Training (WWT) Program
5	Weld Repair of Base Metal and Castings
6	Submittal Directions

1. Welding Procedure Requirements

A Newport News Shipbuilding (NNS) approved welding procedure in accordance with NAVSEA Technical Publication S9074-AR-GIB-010/278 and Procedure Qualification Record/Report (PQR) in accordance with NAVSEA Technical Publication S9074-AQ-GIB-010/248 are required for this Purchase Order (PO) item.

- 1.1. Use the effective revisions of NAVSEA Technical Publications S9074-AR-GIB-010/278 and S9074-AQ-GIB-010/248 identified in and modified by Appendix-K.
- 1.2. If the Supplier has a subcontractor performing any welding to manufacture this PO item, the subcontractor's production welding procedure(s) and supporting PQR(s) are required to be submitted to NNS for approval. The submittal shall clearly state the company that will use the procedure(s), the applicable PO item number and NNS material number/Newport News Part Number. Note: Weld procedures require individual approvals for each NNS material number/Newport News Part Number (NNPN).
- 1.3. No Production Welding shall be performed until the Supplier obtains NNS approval for the welding procedure(s) intended to be used to fabricate this PO item and NNS material number/Newport News Part Number (NNPN).

2. Welding Procedure Approval

The requirement to have an NNS approved welding procedure, including the associated PQR(s), may be satisfied through one of the following methods:

2.1. Submittal of a New Procedure for Approval.

If the Supplier or their subcontractor does not have an NNS approved welding

procedure, the Supplier shall submit the new welding procedure and supporting PQR(s) to NNS for approval within 30 days after receipt of the purchase order using the submittal directions in Section 6. Unapproved PQR(s) also require NNS approval of the RT records in accordance with Section 3. A copy of the RT records approval from NNS shall be included with the PQR when it is submitted for approval.

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

- a) PO Number and PO item number(s)
- b) Material Number(s)/NNPN(s)
- c) This coded note number (LI061)
- d) Fabrication standard and revision
- e) Welding procedure number and revision
- f) PQR number
- g) Evidence of prior Navy approval (if available)

2.1.2. 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 at no cost, and access can be granted by contacting Troy Paskell at paskell@weldqc.com or 614-956-1153. See the NNS Supplier website for further information:
<https://hii.com/suppliers/newport-news-suppliers/nns-supplier-technical-references-guides/#docsub>.

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

2.1.4. Where to Obtain Documents:

2.1.4.1. Forms:

<https://hii.com/suppliers/newport-news-suppliers/nns-supplier-purchase-order-reference-documents-forms/>

2.1.4.2. Government Documents:

- a) Standardization Document Order Desk Bldg. 4, Sec. D
700 Robbins Ave
Philadelphia, PA 19111-5094
- b) ACCURIS
Denver, CO
<https://accuristech.com/>
- c) LogiQuest
Terabase Corporation
Danvers, MA

<https://www.logiquest.com/>

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

2.2. Use of an Approved Procedure.

- 2.2.1. When one or more welding procedures are listed as specifications for the PO item number, the use of one of the listed welding procedures is acceptable. Welding in accordance with a listed procedure number and revision is authorized, and no submittal is required, with the exception of casting weld repairs.
- 2.2.2. Section 5 identifies when casting repairs, require additional approval and shall be submitted with the NNS approved welding procedure(s) via Vendor Information Request (VIR).

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

- 2.3.1. The use of a welding 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/NNPN 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.
- 2.3.2. The Supplier shall submit notification of the previous approval or pending approval to NNS for approval using the submittal directions in Section 6. Notification shall include the PO and item number of the previous submittal, the welding 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.

2.3.3. Procedure(s) approved by EB and BPMI:

If the supplier has a weld procedure and revision that's received approval by EB or BPMI without application limitation or restriction(s) and it's suitable for the purchase order (PO) application, NNS re-approval of the weld procedure is not needed. The supplier shall submit a certification statement that the weld procedure has been reviewed and is suitable for the PO application, 2.1.1.a through 2.1.1.g above and the PO item number

of the previous submittal, along with a copy of the weld procedure/revision approvals from EB or BPML and a copy of the supporting PQR(s). This certification statement shall read "We certify that the previously approved weld procedure has been reviewed and determined to be suitable for use on the purchase order/item it's being submitted for." This statement can be included in the body of the submittal form ('Non-VCS Form' for SPARS submittals and Form 9883 for Non SPARS submittals). Upon submittal of this certification statement and approvals, the supplier may commence welding work. NNS reserves the right to review the EB/BPML approved weld procedure against the application being welded on this PO to verify the certification statement is technically accurate.

Failure to submit the above information for NNS consideration will result in NNS reviewing the weld procedure and supporting procedure qualifications for approval.

3. New PQR RT Film Submittal. 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, require RT record submittal to NNS for approval **prior to performing destructive testing**.

3.1. The Supplier shall submit the following RT records to NNS for approval:

- a) The associated radiograph(s)
- b) Set-up sketch(es)
- c) Radiographic inspection report(s) for review and approval

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

- d) The statement: "RT film and data for Welding Procedure Qualification."
- e) PQR Number _____
- f) Welding Procedure Number _____
- g) The statement: "Visual Inspection (VT) was conducted and the weld found to be satisfactory."
- h) 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
- k) Return address and contact information for returning the submittal
- l) Applicable NNS purchase order/line item

m)Applicable NNP/ NNS Material Number

3.3. 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.
E37 Bldg. 167-1

3.4. Upon receipt of NNS approval of the RT film, the required destructive testing may be performed according to NAVSEA Technical Publication S9074-AQ-GIB-010/248, paragraph 4.5.2. A copy of the RT records approval from NNS shall be included with the PQR when it is submitted for approval.

4. Welder Workmanship Training (WWT) Program

4.1. All welders and welding operators shall be formally trained in accordance with NAVSEA Technical Publication S9074-AQ-GIB-010/248, paragraphs 5.2.3 and 5.6.8.

4.2. The Supplier and/or subcontractor must fully implement a welder workmanship training program as required by NAVSEA Technical Publication S9074-AQ-GIB-010/248, paragraph 5.2.3.1. This document requires a formal welder workmanship training program to be administered and audited by a Level III NDT examiner.

4.3. The Supplier and/or subcontractor must develop and obtain required approval(s), detailed in section 4.4, and fully implement welder workmanship procedure(s) documenting this training program in accordance with NAVSEA Technical Publication S9074-AQ-GIB-010/248, paragraph 5.2.3.1.a PRIOR to starting production welding on the items Newport News Shipbuilding is buying. The Supplier and/or subcontractor will be required to have an NDT Level III Examiner certify in writing that the approved welder workmanship procedure(s) and program has been successfully implemented (including test requirements).

4.4. The Supplier and/or their subcontractor may choose to develop and obtain required approval(s) of its welder workmanship procedure(s) by one of the following methods:

- Develop procedure(s) using the standard NNS format or NavNDT, requiring only NDT Level III approval.

- Develop procedure(s) using the standard EB format, requiring only NDT Level III approval.
 - Develop procedure(s) using another format, requiring VT Level III approval and submittal to NNS for Government approval.
- 4.4.1 WWT Procedures (Standard Format) - Develop procedure(s) utilizing the NavNDT or NNS standard welder workmanship procedures (minimum requirements) from one of the following locations:
- <http://navndt.com/>
 - <https://www.hii.com/documents/supplier-welding-and-brazing-checklist>:
 - Newport News Shipbuilding Procedure WWT-Piping/Pressure Vessel/Machinery For Non-VIRGINIA Class Contractors and/or Subcontractors
 - Newport News Shipbuilding Procedure WWT-STRUCTURE For Non-VIRGINIA Class Contractors and/or Subcontractors

The procedure(s) shall be approved by the Supplier's and/or their subcontractor's NDT Level III Examiner and do NOT require further submittal to Newport News Shipbuilding for Government approval. Newport News Shipbuilding has developed and obtained required Government approvals of these standard welder workmanship procedures. Separate procedures were developed for NAVSEA Technical Publication S9074-AR-GIB-010/278 and Project Peculiar Document 802-7094539 applications for utilization by the Newport News Shipbuilding Supplier and/or their subcontractors. The Supplier and/or their subcontractor may choose to utilize one or both of the approved procedures and shall tailor (customize) them to meet its specific welding applications.

- 4.4.2 WWT Procedures (Requiring Government Approval) If the standard format is not used, develop procedure(s), obtain required NDT Level III Examiner's approval and submit the procedure(s) to Newport News Shipbuilding for Government approval.

- 4.5. Every two years, an 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.

5. Weld Repair of Base Metal and Castings

- 5.1. Base Metal. Minor weld repair of base metal, as defined in NAVSEA Technical Publication S9074-AR-GIB-010/278, is authorized provided all the following conditions are met:

- 5.1.1. An NNS approved weld repair procedure in accordance with the applicable fabrication specification is used.

5.1.2. The weld repair is specifically permitted by the weld repair procedure, fabrication specification, equipment/material specification, or approved drawing.

5.1.3. Weld repair is not otherwise restricted within the PO.

5.2. Minor and Nominal Casting Repairs

Minor and nominal weld repair of castings, as defined in NAVSEA Technical Publication S9074-AR-GIB-010/278, is authorized provided the following conditions are met:

5.2.1. An NNS approved weld repair procedure in accordance with the applicable fabrication specification is used.

5.2.2. The weld repair is specifically permitted by the welding procedure, fabrication specification, equipment/material specification, or approved drawing.

5.2.3. Weld repair is not otherwise restricted within the PO.

5.2.4. For nominal repairs, the casting identification number, welding procedure number or title, welder identification, and name of the authorized representative are recorded and documentation retained as required in NAVSEA Technical Publication S9074-AR-GIB-010/278.

5.3. Special Casting Repairs

Special weld repair of castings, as defined in NAVSEA Technical Publication S9074-AR-GIB-010/278, require submittal to NNS for review and approval (includes Navy approval).

5.4. Submitting Weld Repair Requests for Approval

5.4.1. Submit a VIR to NNS for approval when base metal or casting weld repair has been determined necessary, yet the fabrication specification, equipment/material specification, or approved drawing does not cover weld repair or does not specifically permit weld repair. The supplier shall receive approval prior to the start of weld repair.

5.4.2. Requests for casting weld repairs shall include a "Casting Weld Repair Request" form NN 9135, located at:
<https://www.hii.com/suppliers/newport-news-suppliers/nns-supplier-purchase-order-reference-documents-forms>.

5.4.3. The request must identify the NNS approved welding procedure and revision to be used for the repair. If the identified welding procedure is not already approved by NNS, it shall be submitted for approval per Section 2 prior to requesting to use it for a repair.

6. Submission requirements to (LI061) shall be submitted as follows:

1. SPARS (Shipbuilding Partners and Suppliers) enabled suppliers are required to submit procedures, PQRs, or notification through the following link:
<https://spars.huntingtoningalls.com/ngcspars/Auth>. Suppliers are to select form type 'Non-VCS Form' for submittal entries.
2. All other suppliers or when a SPARS submittal is not allowed (i.e. Classified or Sensitive But Unclassified (SBU) NOFORN and NNPI data) shall submit Form 9883 via mail to:

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

Submissions received by other means may be rejected

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

The following website provides additional documents for assistance meeting the requirements of this coded note:

<https://supplier.huntingtoningalls.com/sourcing/submittal-checklists/>

Revision History Table		
Rev	Description	Revision Date
C010	Revised: Mailing address- changed E45 to E68.	08-07-2020

C011	<u>ADDED:</u> 2. Requirement for submittal of a Vendor Information Request (VIR) for NNS Approval prior to any base metal weld repair. 3. Detailed RT record submittal requirements. 4. Revision History Table. REASON: (1) Identified omission in current technical ordering data packages (2) clarification (3) Change to new iDS format. <u>REVISED:</u> 4. Re-organized wording, clarified requirements, made editorial changes. REASON: (4) Changes made to simplify and add clarification and consistency where necessary. <u>REMOVED:</u> 5. The previous method for showing revisions (revision control paragraph at the beginning of PPN, [text deleted] and bold text. Reason: (5) Change to new iDS format.	02/02/2021
C012	<u>ADDED:</u> 5. Clarification about the use of Appendix K. 6. Detailed WWT instructions moved from Appendix K. <u>REASON:</u> Appendix K is being revised to move administrative process information to coded notes. 3. Procedure approvals from EB and BPML guidelines. <u>REVISED:</u> 4. Re-organized wording, clarified requirements to match current processes, made editorial changes. <u>REASON:</u> Changes made to simplify and add clarification and consistency where necessary. 5. Submission Requirements	10/9/26

This revision history is provided for convenience and does not alleviate the supplier's responsibility with understanding and complying with the full coded note.