

QUALITY ALERT – WELDING AND NON-DESTRUCTIVE TESTING REQUIREMENTS

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BACKGROUND

NNS has found that many suppliers continue to misunderstand, and fail to meet, welding and non-destructive test (NDT) requirements which are specified in most of the purchase orders which have welded parts or possible weld repair requirements. These failures are mostly related to misunderstanding or misinterpretation of the requirements dictated by NAVSEA Technical Publications S9074-AQ-GIB-010/248, S9074-AS-GIB-010/271 and S9074-AR-GIB-010/278, commonly referred to as the Tech Pubs. Too often they result in costly delays, intensive technical analysis involving the Navy, NNS, and the involved suppliers, and in some cases repair/ rework by either NNS or the Supplier.



ACTION

NNS is updating our welding coded notes and Appendix K which will invoke changes to the welding and NDT requirements of future purchase orders. These changes are driven by concerns our customer, the US Navy, has risen regarding the many non-conformances reported by NNS in the recent past. NNS Engineering is taking a proactive approach in assisting our 1st tier, and as necessary our 2nd tier welded product suppliers to ensure purchase order requirements compliance in an effort to prevent future inspection findings, audit findings or quality failures. To reduce your future risk of non-compliance, please review the content of this alert and contact us with any questions or concerns.

AREAS OF ALERT FOCUS/CONCERN

Weld Procedure Submittal Using NavWeld – NavWeld is a secure, internet-based application and database provided by WeldQC, Inc., which assists in developing welding procedures that meet the requirements of various U.S Navy specifications. NavWeld is available to NNS suppliers at no cost. We encourage suppliers to submit any and all new weld procedures developed using NavWeld software. Suppliers using the software experience as much as a 60% improvement in first-time approval. Benefits also include consistent procedure formatting and a sufficient method of maintaining all welders' qualifications.

WeldQC (<http://www.weldqc.com/>) offers training and technical support. To gain access, contact Troy Paskell by email at PASKELL@WELDQC.COM or phone at (614) 487-7207. A temporary password and user training will be provided. (*Reference Coded Note*)



Welder Workmanship Training (WWT) Program – If our purchase order requires compliance to the Tech Pubs discussed above; you, and your sub-tiers as applicable, **MUST** have a Welder Workmanship Training (WWT) program as specified in Tech Pub 248 section 5.2.3. Certification of the WWT procedure can **ONLY** be provided by a Tech Pub 271 certified Level III NDT examiner. The procedure must also be approved by NNS or EB. Many suppliers have failed audits and inspections as a result of misunderstanding these requirements. If you are unsure if you meet these requirements, you are encouraged to use the self-assessment questionnaire available at ([NAV22](#) & [NAV03](#)). These are actual copies of the audit questionnaires used by NNS when performing weld and NDT audits. In particular you should refer to Section VII of NAV22 and paragraph 3 (Personnel Qualification) of NAV03. Submit any questions regarding these Audit Guidelines to weldquestions@hii-nns.com if you need further assistance. Self-identified issues **will not** affect your quality score.

NNS Supplier Quality engineers will include these requirements in audit criteria and may contact the supplier at or shortly after purchase order award to assess 1.) awareness of the WWT requirement; 2.) confirmation of the program existence; and 3.) the examiner's certification credentials. (*Reference Appendix K*)

CONTACT INFORMATION

Please contact weldquestions@hii-nns.com with any questions or concerns related to any of these issues. Thank you.