**USAGE NOTE:**

**Choose YES or NO. An “R” added beside the checkbox identifies information that is required to be included in procedure. Make sure this information gets added to the procedure prior to submittal for approval.**

Company:

Procedure:

Revision:

**(Checklist Not To Be Used For Titanium Welds)**

|  |  |  |  |
| --- | --- | --- | --- |
| **“MINIMUM” (SHALL) ATTRIBUTES REQUIRED**  **(PER NAVSEA APPROVED NNS WWT TEMPLATE IN APPENDIX K)** | | | |
| **Has the subject information been included in the procedure?** | | **SUBJECT** | **NNS WWT TEMPLATE**  **Para.** |
| **YES** | **NO** |
| R |  | Supplier has incorporated and customized its WWT procedure to meet the minimum requirements of the NAVSEA approved NNS WWT template(s) based on the Supplier’s application. | 1.0 and 2.B |
| R |  | Supplier’s WWT procedure is approved by a fully certified TP271 NDT Level III Examiner. | 1.0 |
| R |  | WWT training and examination are conducted initially and at least once every three (3) years thereafter. | 2.D |
| R |  | Examination grade shall be at least 75 percent. | 2.E |
| R |  | Record of the examination for each welder and welding operator shall include: Name, fabrication/acceptance standards covered, date of test and certifying signature of test administrator. | 2.F |
| R |  | Successful completion of this WWT program. | 2.G |
| R |  | Periodic audit of at least once in every two (2) years shall be performed of the Supplier’s WWT training program by the designated NDT Level III Examiner. | 2.H |
| R |  | Welding of or to HY/HSLA materials shall meet the NNS’ WWT-Structure template. | 2.I |
| **WORKMANSHIP AND VISUAL INSPECTION TOPICS**  **(Includes Subparagraphs)** | | | |
| **YES** | **NO** |  | |
| R |  | Visual Inspection Zone | 3.A |
| R |  | Visual Inspection Attributes | 3.B |
| R |  | Weld Completeness | 3.C |
| R |  | Weld Marking | 3.D |
| R |  | Material Identification | 3.E |
| R |  | Cleaning | 3.F |
| R |  | Joint Configuration | 3.G |
| R |  | Thermal Cut Surfaces | 3.H. |
| R |  | Surface Preparation | 3.I |
| R |  | Joint Fit-Up | 3.J |
| R |  | Peening | 3.K |
| R |  | Repairs | 3.L |
| R |  | Preheat and Interpass Temperature | 3.M |
| R |  | Seal Welds | 3.N |
| R |  | Purging | 3.O |