



**Newport News Shipbuilding**  
A Division of Huntington Ingalls Industries

# **Approved Suppliers: Foundries Approved to Produce 70/30 Copper Nickel (CuNi) Castings**

Please Note:

If the casting is also a BW/SW fitting, Seller shall ensure the BW/SW fitting manufacturer is also on the approved BW/SW fittings supplier list.

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## Copper Nickel (CuNi) 70/30 Casting Supplier Requirements

When providing CuNi 70/30 castings or CuNi 70/30 castings in an assembly, Seller shall utilize only the suppliers listed on the Buyer's (Huntington Ingalls Newport News Shipbuilding or Electric Boat Corporation) approved CuNi 70/30 casting supplier list. The approved list for Electric Boat Corporation may be accessed using the hyperlink provided at the bottom of the page.

If utilizing a CuNi 70/30 casting supplier other than one currently on the approved CuNi 70/30 supplier list, a VIR must be submitted to the Buyer requesting approval of the selected CuNi 70/30 casting supplier. An evaluation will be performed and the VIR will be answered.

In addition to, or in conjunction with, testing required elsewhere in the purchase order, the Seller shall invoke the following requirements on orders for CuNi 70/30 castings from a foundry approved by the Buyer:

- a) For each heat, the foundry shall analyze and have available a chemical composition test report from an "A" (beginning of pour) and "B" (end of furnace charge pour) chemistry test coupon. Test reports and chemistry coupons shall be identified as "A" and "B" in addition to the heat number traceability.
- b) Mechanical test bars are to be poured no sooner than 50% through the furnace charge pour.
- c) The foundry or supplier shall maintain the "A" and "B" chemistry coupons and the mechanical test specimens, and their respective test results, as objective quality evidence, subject to audit and further analysis by the Buyer.
  - i. Retention shall be a minimum of seven (7) years.
  - ii. Notify Buyer for disposition prior to disposal of records and specimens.
- d) Buyer's products may be poured in the same heat; however, the heat shall be unique to the Buyer (No other customer's product shall be included in the heat.)
- e) Chemistry and mechanical test report submittal shall be in accordance with the requirements contained elsewhere in this purchase order. Unless otherwise specified elsewhere in the purchase order, the "B" coupon chemistry test results shall be submitted.

The following hyperlink provides Electric Boat Corporation's list of Foundries Approved to Produce 70/30 Copper Nickel Fitting Castings (SC10-133). [http://www.gdeb.com/suppliers/10\\_quality/doc\\_44/](http://www.gdeb.com/suppliers/10_quality/doc_44/)

# Approved Suppliers: Foundries Approved to Produce 70/30 Copper Nickel Castings



Supplier	Supplier #	Location	Telephone
Badger Alloys	<b>ST0002</b>	Milwaukee, Wisconsin 53208	(414) 258-8200
Bridesburg Foundry Company	<b>ST0006</b>	Whitehall, PA 18052	(610) 266-0900
<b>Federal Bronze Casting Industries, Inc</b>	<b>27514A</b>	Newark, NJ <b>07105</b>	(973) 589-7575
Johnson Brass & Machine Foundry, dba <b>Johnson Centrifugal Technology</b> (Centrifugal Castings only)	<b>108913</b>	Saukville, WI 53080	(262) 377-9440
<b>Deleted - Lee Brass Foundry LLC</b>			
Metal Dynamics Corp	<b>ST0023</b>	Tulsa, OK 74106	(918) 582-0124
Metaltek International, <b>Wisconsin Centrifugal Division</b>	<b>87195B</b>	Waukesha, WI 53188-3898	<b>(262) 544-7824</b>
Stainless Foundry and Engineering Inc. <b>For Surface Ship Use Only, Not Approved for Any Submarine Contracts</b>	<b>ST0036</b>	Milwaukee, Wisconsin 53209	(414) 462-7400
West Philadelphia Bronze Corporation	<b>109951</b>	Chester, PA 19013	(610) 874-1454
Western Bronze Inc. <b>For Surface Ship Use Only, Not Approved for Any Submarine Contracts</b>	<b>84655A</b>	West Springfield, MA 01089	(413) 737-1319
Wollaston Alloys, Inc. - <b>CPP Boston</b>	<b>86558A</b>	Braintree, MA 02184	<b>(781) 848-3333</b>
<b>Table Revision - 07-18-2019 - Changes Boldfaced</b>			

Seller's use of an approved manufacturer does not relieve the Seller of its responsibility to ensure that all technical, service, and Purchase Order requirements are met.

The following hyperlink provides Electric Boat Corporation's list of Foundries Approved to Produce 70/30 Copper Nickel Fitting Castings (SC10-133). [http://www.gdeb.com/suppliers/10\\_quality/doc\\_44/](http://www.gdeb.com/suppliers/10_quality/doc_44/)