Thin Line Towed Array Handling System – Shipsets 3 - 7
Contract # 1000073561 (March 2024)
Subcontract Flowdowns

Any questions, please contact Subcontract Manager, Susan Caromano (susan.caromano@lmco.com) or Subcontract Program Manager, Ken Peter (kenneth.j.peter@lmco.com).

These Subcontract Flowdowns listed below are **in addition to** the CorpDocs terms and conditions contained in your purchase order for this program.

A. INCORPORATION OF FAR AND DFARS CLAUSES

The FAR and DFARS clauses referenced below are incorporated herein by reference, with the same force and effect as if they were given in full text, and are applicable, including any notes following the clause citation, to this Contract. If the date or substance of any of the clauses listed below is different from the date or substance of the clause actually incorporated in the Prime Contract referenced by number herein, the date or substance of the clause incorporated by said Prime Contract shall apply instead. The Contracts Disputes Act shall have no application to this Contract, and nothing in this Contract grants SELLER a direct claim or cause of action against the U.S. Government. Any reference to a "Disputes" clause shall mean the "Disputes" clause of this Contract. SELLER shall include in each lower-tier subcontract the appropriate flow down clauses as required by the FAR and FAR Supplement clauses included in this Contract.

B. GOVERNMENT SUBCONTRACT

(a) This Contract is entered into by the parties in support of a U.S. Government contract.
(b) As used in the FAR and DFARS clauses referenced below and otherwise in this Contract:
1. "Commercial Item" means a commercial item as defined in FAR 2.101.
2. "Commercially available off-the-shelf (COTS) item" means a COTS item as defined in FAR 2.101
3. "Contract" means this contract.
4. "Contracting Officer" shall mean the Lockheed Martin Procurement Representative.
5. "Contractor" and "Offeror" means the SELLER, which is the party identified on the face of the Contract with whom Lockheed Martin is contracting, acting as the immediate subcontractor to LOCKHEED MARTIN.
6. "Prime Contract" means the contract between LOCKHEED MARTIN and the U.S. Government or between LOCKHEED MARTIN and its higher-tier contractor who has a contract with the U.S. Government.
7. "Subcontract" means any contract placed by SELLER or lower-tier subcontractors under this Contract.

Additional FAR/DFARS applicable to this contract:

TYPE	CLAUSE NO.	Date	Title	Modification
DFARS	252.225-7025	Dec 2009	Restriction on Acquisition of Forgings.	Applies if the Work contains forging items described by the clause.
DFARS	252.227-7013 ALT II	Mar 2011	Alternate II - Rights in Technical Data--Noncommercial Items.	
DFARS	252.227-7015 ALT I	Dec 2011	Alternate I - Technical Data-Commercial Items.	
DFARS	252.229-7006	Dec 2011	Value Added Tax Exclusion (United Kingdom)	Applies if Seller is a United Kingdom firm. "This contract" means "the prime contract."
DFARS	252.243-7002	Dec 2012	Requests for Equitable Adjustment.	"Government" means "Lockheed Martin."

General Dynamics Electric Boat Contract Clauses:

Clause No.	Date	Title	Mandatory Text
5252.227-9113	Apr-15	GOVERNMENT-INDUSTRY DATA EXCHANGE PROGRAM	5. NAVSEA 5252.227-9113, GOVERNMENT-INDUSTRY DATA EXCHANGE PROGRAM (Apr 2015) (MODIFIED) (Applies if this Purchase Order exceeds $500,000.) a. The Subcontractor shall participate in the appropriate interchange of the Government-Industry Data Exchange Program (GIDEP) in accordance with GIDEP PUBLICATION 1 dated April 2008. Data entered is retained by the program and provided to qualified participants. Compliance with this requirement shall not relieve Subcontractor from complying with any other requirements of this Purchase Order. b. DELETED as not applicable. c. GIDEP materials, software and information are available without charge from: GIDEP Operations Center, P.O. Box 8000, Corona, California 92878-8000 (951) 898-3207 (Ph.) (951) 898-3250 (Fax) Internet: http://www.gidep.org.
9	May-93	ASSIGNMENT AND USE OF NATIONAL STOCK NUMBERS (NAVSEA)	9. ASSIGNMENT AND USE OF NATIONAL STOCK NUMBERS (NAVSEA) (May 1993) Modified a. To the extent that National Stock Numbers (NSNs) or preliminary NSNs are assigned by the Government for the identification of parts, pieces, items, subassemblies or assemblies to be furnished under this Purchase Order, the SELLER shall use such NSNs or preliminary NSNs in the preparation of provisioning lists, package labels, packing lists, shipping containers and shipping documents as required by applicable specifications, standards, or data item descriptions of this Purchase Order or as required by orders for spare and repair parts. When NSNs or preliminary NSNs are required to be assigned, SELLER shall request them in writing. The BUYER's cognizant Government Contract Administration Office shall be responsible for providing the SELLER such NSNs or preliminary NSNs which may be assigned and which are not already in the possession of the SELLER.
12		HEALTH AND SAFETY	12. HEALTH AND SAFETY The Contractor shall take all reasonable precautions in the performance of the work under this contract to protect the health and safety of employees and of members of the public and to minimize danger from all hazards to life and property. The Contractor shall comply with all health, safety, and fire protection regulations and requirements (including reporting requirements) of the Government. In the event the Contractor fails to comply with such regulations or requirements of the Government, the BUYER may, without prejudice to any other legal or contractual rights of the BUYER, issue an order stopping all or any part of the work being performed under this contract; thereafter an order for resumption of work will be issued upon the determination by the BUYER that the deficiency has been corrected. The Contractor shall make no claims for an extension of the delivery date or for damages or any other compensation by reason of or in connection with such work stoppage, unless the contractor can demonstrate that he was in compliance with such regulations or requirements of the Government.
15		DATA RIGHTS AND ACCESS	15. DATA RIGHTS AND ACCESS Notwithstanding any other provisions in this subcontract, the Parties agree that all Technical Data and Computer Software (including designs, consisting of design disclosure data products, drawings, specifications, notes, other works and tactical software) that are developed in the performance of this sub contract with Government funds (Technical Design Data and Tactical Software) may be used by the United States Government for Government purpose, either domestically or abroad.
19		SPECIAL PROGRAM CERTIFICATIONS	19. SPECIAL PROGRAM CERTIFICATIONS SELLER agrees to complete and submit in writing to the BUYER, on a timely basis, requested certifications deemed necessary and required by the BUYER. These certifications include but are not limited to: 1. Supplier Registration Form; 2. Certification and Representation Regarding Foreign Ownership, Control or Influence (FOCI Cert) form; and 3. Supplier Quality Questionnaire (when requested). 4.The FOCI Cert form and any attachments shall be updated and re-submitted to BUYER every twelve (12) months. Additional certifications may be required. SELLER agrees to notify BUYER, in writing, of changes to previously submitted certifications (such as change in ownership, place of performance, etc.) and agrees to complete new certifications as requested by BUYER.

* Exception: EB Standard Clauses listed below are not applicable to Commercial Off the Shelf (COTS) or MIL-SPEC procurements.
Please contact your Procurement Representative -or- the Subcontracts Team (listed at the top of this document) with any questions on applicability.

General Dynamics Electric Boat Standard Clauses can be found at: https://www.gdeb.com/suppliers/stdcls/
Standard Clause text description for the clauses below applicable to this contract are included in this document.

EB Standard Clauses	Rev	Title
10-110	15	MODS to QQ-N-286
60-11E	3	Effective Revisions of Specifications
60-33	2	Special Requirements for NiCu, NiCuAl
60-67	26	NonDestructive Test Procedure Approval
60-77	22	Welding and Brazing Procedure Approval
60-86	4	Contracting Vendor NonDestructive Services
76-22L	1	NDT IAW COMPONENT DRAWING AND/OR SPECIFICATION
76-24	8	Reqmts for Radiography-Castings
76-57	6	Origin of Test Reports for Chemical Mechanical Properties
76-95	3	Radiographic Film Retention by Electric Boat Corporation
76-9HD	6	TORQUE REQUIREMENTS TEST
78-1A	4	SPCL Tooling & SPCL Test Equipment
EB3900	5	Modifications to MIL-STD-271 and T9074-AS-GIB-010/271

GENERAL DYNAMICS
Electric Boat

Purchase Order Standard Clauses

New Search

Number 10-110

Revision 15

Title MODS TO QQ-N-286

Clause

STANDARD CLAUSE: 10-110
REVISION: 15
TITLE: MODS TO QQ-N-286
CLAUSE: ELECTRIC BOAT CORPORATION PURCHASING STANDARD CLAUSE 10-110

IF ANY NICUAL (K-MONEL) MATERIAL IS UTILIZED IN THIS ORDER, IT MUST BE IN ACCORDANCE WITH ONE OF THE FOLLOWING MODIFICATIONS:
A). QQ-N-286 REVISION F, DATED 29 NOVEMEBER 1990, AND HAVE BEEN PRODUCED ONLY BY SPECIAL METALS CORPORATION (FORMERLY INCO ALLOYS INTERNATIONAL/HUNTINGTON ALLOYS INC) WITH A PRODUCTION (POUR) DATE LATER THAN DECEMBER 21, 1976.
FIRST ARTICLE TESTING PER PARAGRAPH 3.1 OF QQ-N-286 REVISION F IS REQUIRED FOR ALL HEATS PRODUCED AFTER FEBRUARY 19, 2001. SPECIAL METALS CORPORATION WAS EXEMPT FROM FIRST ARTICLE TESTING FOR ALL HEATS PRODUCED PRIOR TO FEBRUARY 19, 2001.
TEST REPORTS FOR EACH HEAT AND LOT OF MATERIAL FURNISHED SHOWING ACTUAL RESULTS OF CHEMICAL ANALYSIS, MECHANICAL PROPERTY TESTING AND FIRST ARTICLE TESTING* REQUIRED BY THE SPECIFICATION SHALL BE FURNISHED FOR LEVEL 1 MATERIAL AND MADE AVAILABLE UPON REQUEST FOR LEVEL N MATERIAL. TEST REPORTS SHALL BE ANNOTATED BY THE SUPPLIER WITH THE BUYERS PURCHASE ORDER NUMBER, ITEM NUMBER, MATERIAL SPECIFICATION/REVISION (INCLUDING FORM AND CONDITION) AND SHALL INDICATE THE SAME HEAT AND LOT NUMBER, OR TRACEABILITY NUMBER THAT IS MARKED ON THE MATERIAL SUPPLIED FOR LEVEL 1 APPLICATIONS ONLY.
*IF REQUIRED BASED UPON PRODUCTION DATE
B). QQ-N-286 REVISION G WITH THE FOLLOWING MODIFICATIONS:
REVISE PARAGRAPH 4.2.2.2 OF QQ-N-286G AS FOLLOWS;
4.2.2.2 SLOW STRAIN RATE TENSILE TESTS. THREE SPECIMENS SHALL BE PREPARED AND TESTED PER LOT. SPECIMENS SHALL BE TAKEN AFTER THE FINAL HEAT TREATMENT. WHEN MATERIAL IS SHIPPED IN THE ANNEALED CONDITION, SPECIMENS MAY BE TAKEN AFTER FINAL ANNEAL AND SHALL BE HEAT TREATED IN ACCORDANCE WITH 4.3.6.1.
4.2.2.2.1 BAR, ROD AND FORGINGS. SLOW STRAIN RATE TENSILE TEST SPECIMENS SHALL BE TAKEN FROM ONE END OF A BAR, OR FORGING AT THE QUARTER DIAMETER (HALF RADIUS) AND IN THE LONGITUDINAL DIRECTION. BARS, RODS OR FORGINGS TOO SMALL TO HAVE A SLOW STRAIN RATE TEST SPECIMEN TAKEN FROM THE QUARTER DIAMETER THAT ARE TAKEN FROM A LOT (SEE 4.2.1.3) THAT DOES NOT HAVE ANY LARGER SIZES SHALL HAVE THE SPECIMENS TAKEN FROM THE CENTER AND IN THE LONGITUDINAL DIRECTION. BARS, RODS OR FORGINGS TOO SMALL TO HAVE A SLOW STRAIN RATE TEST SPECIMEN TAKEN FROM THE CENTER THAT ARE TAKEN FROM A LOT (SEE 4.2.1.3) THAT DOES NOT HAVE ANY LARGER SIZES SHALL BE TAKEN FROM THE HEAT AT THE LATEST INTERMEDIATE ROLLING OR FORGING STEP THAT A SLOW STRAIN RATE TEST SPECIMEN CAN BE TAKEN FROM THE MID-RADIUS AND HEAT TREATED USING THE SAME HEAT TREATMENT PROCEDURES USED ON THE PRODUCTION HEAT.
4.2.2.2.2 WIRE. SLOW STRAIN RATE TENSILE TEST SPECIMENS SHALL BE TAKEN FROM THE HEAT AT THE LATEST INTERMEDIATE ROLLING OR FORGING STEP THAT A SLOW STRAIN RATE TEST SPECIMEN CAN BE TAKEN FROM THE MID-RADIUS AND HEAT TREATED USING THE SAME HEAT TREATMENT IN ACCORDANCE WITH

4.3.6.1.
4.2.2.2.3 SHEET AND PLATE. SLOW STRAIN RATE TENSILE TEST SPECIMENS SHALL BE TAKEN FROM ONE END OF A PLATE AT THE QUARTER THICKNESS AND IN THE LONGITUDINAL DIRECTION. PLATE TOO SMALL TO HAVE A SLOW STRAIN RATE TEST SPECIMEN TAKEN FROM THE QUARTER THICKNESS MAY HAVE THE SPECIMENS TAKEN FROM THE CENTER AND IN THE LONGITUDINAL DIRECTION. SHEET AND PLATE TOO SMALL TO HAVE A SLOW STRAIN RATE TEST SPECIMEN TAKEN FROM THE CENTER MAY HAVE THE SPECIMENS TAKEN AT THE LATEST INTERMEDIATE ROLLING STEP THAT A SLOW STRAIN RATE TEST SPECIMEN CAN BE TAKEN FROM THE QUARTER THICKNESS.
REVISE PARAGRAPH 4.3.6.4.4 OF QQ-N-286G AS FOLLOWS:
4.3.6.4.4 TEST LABORATORY: SLOW STRAIN TENSILE TESTING SHALL BE PERFORMED BY A NAVSEA APPROVED TEST LABORATORY. THE FOLLOWING IS A LISTING OF THE CURRENTLY APPROVED TEST LABORATORIES, ANY OF WHICH MAY BE USED AT THE VENDORS DISCRETION.
HUNTINGTON ALLOYS, A SPECIAL METALS COMPANY
ATTN: FRANK VELTRY
3200 RIVERSIDE DRIVE
HUNTINGTON, WV 25705

METALLURGICAL CONSULTANTS, INC.
ATTN: W.M. BUEHLER
4820 CAROLINE
P.O. BOX 88046
HOUSTON, TX 77288-0046

NAVAL SURFACE WARFARE CENTER, CARDEROCK DIV.
ATTN: CHARLES ROE
CODE 614
9500 MACARTHUR BLVD.
WEST BETHESDA, MD 20817-5700

ATI ALLVAC-ALLEGHENY TECHNOLOGIES INC.
ATTN: DR. W.D. CAO
2020 ASHCRAFT AVE.
MONROE, NC 28110

MANNESMANN ROHRENWERKE
MANNESMANN FORSCHUNGSINSTITUT (MFI)
ATTN: DR. WEISS
POSTFACH 251160
47251 DUISBURG
GERMANY

WESTMORELAND MECHANICAL TESTING & RESEARCH, INC.
OLD ROUTE 30, WESTMORELAND DRIVE
P.O. BOX 388 WESTMORELAND DRIVE
YOUNGSTOWN, PA 15696-0388

REVISE PARAGRAPH 6.2 AS FOLLOWS:
S) THE LABORATORY CONDUCTING THE SLOW STRAIN RATE TENSILE TESTING SHALL BE ONE APPROVED BY NAVSEA (SEE 4.3.6.4.4).
NOTE: FIRST ARTICLE TESTING INVOKED ELSEWHERE IN THIS PURCHASE ORDER DOES NOT APPLY TO MATERIAL PRODUCED IN ACCORDANCE WITH REVISION G OF QQ-N-286.
TEST REPORTS FOR EACH HEAT AND LOT OF MATERIAL FURNISHED SHOWING ACTUAL RESULTS OF CHEMICAL ANALYSIS, MECHANICAL PROPERTY TESTING AND SLOW STRAIN RATE TENSILE TESTS REQUIRED BY THE SPECIFICATION SHALL BE FURNISHED FOR LEVEL 1 MATERIAL AND MADE AVAILABLE UPON REQUEST FOR LEVEL N MATERIAL. TEST REPORTS SHALL BE ANNOTATED BY THE SUPPLIER WITH THE BUYERS PURCHASE ORDER NUMBER, ITEM NUMBER, MATERIAL SPECIFICATION/REVISION (INCLUDING FORM AND CONDITION) AND SHALL INDICATE THE SAME HEAT AND LOT NUMBER, OR TRACEABILITY NUMBER THAT IS

MARKED ON THE MATERIAL SUPPLIED FOR LEVEL 1 APPLICATIONS ONLY.
FIGURE 4: DELETE CAPTION AND REPLACE WITH "TEMPLATE FOR SLOW STRAIN RATE FRACTURE TEST EVALUATION. CONCENTRIC CIRCLES 2.5000", 1.5625", AND 0.6250" IN DIAMETER IN A 3.5" BY 4.5" FRAME."

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General Supplier Questions and Comments: suppliers@gdeb.com

GENERAL DYNAMICS
Electric Boat

Purchase Order Standard Clauses

New Search

Number 60-11E

Revision 3

Title EFFECTIVE REVISIONS OF SPECIFICATIONS

Clause

THE EFFECTIVE REVISIONS OF INVOKED SPECIFICATIONS SHALL BE DETERMINED AS FOLLOWS:
A) WHEN A SPECIFICATION REVISION IS CITED IN THE PURCHASE ORDER, ONLY THAT REVISION IS APPROVED FOR USE. HOWEVER, WHERE THE SUPPLIER HAS A NEED TO USE AN ALTERNATE REVISION, THAT REVISION MAY BE USED WITHOUT FURTHER APPROVAL WHEN IT IS WITHIN THE RANGE OF REVISIONS LISTED FOR THE SAME SPECIFICATION AND DESIGNATED WITH A INTERCHANGEABILITY CODE OF AN"*" (ASTERISK)".

WHERE THE SPECIFICATION REVISION IS NOT WITHIN THE RANGE OF REVISIONS LISTED FOR THE SAME SPECIFICATION AS DESCRIBED ABOVE, A VIR REQUESTING AUTHORIZATION TO USE THE ALTERNATE REVISION IS REQUIRED

B) WHEN A REVISION IS NOT CITED IN THE PURCHASE ORDER, ANY REVISION LISTED IN EB2P756-OR MAY BE USED.

C) WHEN A SPECIFICATION IS NOT CITED IN EITHER THE PURCHASE ORDER OR EB2P756-OR, ANY ISSUED REVISION MAY BE USED.

EB2P756-OR IS LOCATED AT WWW.GDEB.COM UNDER THE SUPPLIERS TAB AND PURCHASE ORDER INFO LINK.

(NOTE: WHEN EB2P756-OR, THE ORP SPECIFICATION EFFECTIVITY INDEX, IS REFERRED TO ABOVE, THE SELLER MAY USE ANY VERSION WHICH HAS BEEN PROVIDED BY THE BUYER, NOT TO BE DATED ANY EARLIER THAN 6 MONTHS PRIOR TO THE DATE OF THE APPLICABLE PURCHASE ORDER.)

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GENERAL DYNAMICS
Electric Boat

Purchase Order Standard Clauses

New Search

Number 60-33

Revision 2

Title SPECIAL REQUIREMENTS FOR NiCu, NiCuAl AND CuNi ALLOY PARTS

Clause

The sulfur content of the gas and oil fuels used in firing furnaces for forging, extruding, or other hot working processes and for heat treatment of NiCu (NO4400), NiCuAl (NO5500), CuNi (C70600 and C71500), and other nickel or nickel base alloys shall be limited as follows:

1. Gas: 30 Grains per 100 cu. ft. maximum
2. Oil: 0.5% by weight maximum

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GENERAL DYNAMICS
Electric Boat

Purchase Order Standard Clauses

New Search

Number 60-67
Revision 26
Title NONDESTRUCTIVE TEST PROCEDURE APPRVL
Clause NONDESTRUCTIVE TEST AND ALLOY IDENTIFICATION PROCEDURE APPROVAL

THE REQUIREMENTS CONTAINED HEREIN SHALL APPLY TO THE SELLERS AND ANY SUB-TIER SUPPLIERS NONDESTRUCTIVE TEST NDT PROCEDURES USED IN FULFILLING THE REQUIREMENTS OF THIS PURCHASE ORDER. THIS STANDARD CLAUSE IS ALSO APPLICABLE TO ALLOY IDENTIFICATION PROCEDURES.

A. GENERAL REQUIREMENTS FOR NDT PROCEDURES

1. ALL RADIOGRAPHY, MAGNETIC PARTICLE, LIQUID PENETRANT, ULTRASONIC, EDDY CURRENT, AND VISUAL TESTING MUST BE PERFORMED IN ACCORDANCE WITH WRITTEN PROCEDURES APPROVED BY THE BUYER.

VISUAL TESTING, AS IT PERTAINS TO THIS STANDARD CLAUSE, IS ONLY APPLICABLE TO THE INSPECTION OF COMPLETED FABRICATION WELDMENTS.

2. ALL PROCEDURES SHALL BE UNIQUELY IDENTIFIED BY A PROCEDURE NUMBER, WITH A REVISION AND DATE.

3. PROCEDURES SHOULD BE SUBMITTED FOR BUYER APPROVAL WITHIN THIRTY (30) DAYS OF THE SELLERS RECEIPT OF THE ORDER. PROCEDURES THAT WILL BE USED DURING THE MANUFACTURE OF THE PURCHASED ITEM/S SHALL BE APPROVED PRIOR TO THE PERFORMANCE OF ANY SUCH INSPECTIONS. NDT PROCEDURES THAT WERE PREVIOUSLY USED TO INSPECT AND CERTIFY BASE MATERIAL PROCURED FROM A SUB-TIER SOURCE SHALL BE SUBMITTED FOR APPROVAL PRIOR TO ANY USAGE OF THAT MATERIAL.

4. ALL PROCEDURE CHANGES OR REVISIONS SHALL BE RESUBMITTED TO THE BUYER FOR WRITTEN APPROVAL PRIOR TO THE PERFORMANCE OF ANY TESTING. MATERIAL INSPECTED IN ACCORDANCE WITH UNAPPROVED CHANGES OR REVISIONS SHALL BE SUBJECT TO REJECTION.

B. NDT PERFORMANCE SPECIFICATIONS

1. WHERE REFERENCE IS MADE TO THE FOLLOWING PERFORMANCE SPECIFICATIONS, THE EFFECTIVE ISSUES SHALL BE AS FOLLOWS
MIL-STD-271 SHALL BE NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271, REVISION F MAY ONLY BE USED AS PERMITTED IN PARAGRAPH B.2 BELOW.
NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271 SHALL BE DATED 30 APRIL 1997 WITH NOTICE 1 DATED 16 FEBRUARY 1999 AND AS MODIFIED BY EB SPEC 3900.
NAVSEA 0900-LP-003-8000, NAVSEA 0900-LP-003-9000, AND NAVSEA 0900-LP-006-3010 SHALL BE MIL-STD-2035.
MIL-STD-2035 SHALL BE REVISION A.

NAVSEA 250-1500-1 SHALL BE REVISION 17.
MIL-STD-2132 SHALL BE REVISION D.
NSTR-99 SHALL BE REVISION 4.

IF AN ELECTRIC BOAT COMPONENT SPECIFICATION NAVSEA APPROVED INVOKES SPECIFICATION REVISIONS THAT CONFLICT WITH THE ABOVE, THE COMPONENT SPECIFICATION SHALL TAKE PRECEDENCE.

2. THE USE OF PROCEDURES PREVIOUSLY APPROVED TO THE REQUIREMENTS OF MIL-STD-271, REVISION F IS STILL PERMITTED, PROVIDED THE GUIDELINES OF SECTION I ARE MET. HOWEVER, ANY SUBMITTAL OF NEW OR REVISED PROCEDURES SHALL COMPLY WITH NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271 EVEN IF MIL-STD-271 IS INVOKED.
C. VENDOR PROCEDURE APPROVAL REQUEST, VPAR.

1. ALL SELLER AND SUB-TIER SUPPLIER NDT PROCEDURES SHALL BE FORWARDED TO THE BUYER VIA A PROPERLY COMPLETED VENDOR PROCEDURE APPROVAL REQUEST VPAR, EB FORM 84-01-2974. EACH PROCEDURE SHALL BE SUBMITTED SEPARATELY. THE SELLER SHALL SEND THE VPAR AND A COPY OF THE PROCEDURE TO THE BUYER DESIGNATED ON THIS PURHCASE ORDER. THE VPAR SHALL BE DISPOSITIONED BY THE BUYERS DESIGNATED REPRESENTATIVE AND SHALL SERVE AS THE SELLERS PROCESS APPROVAL, WHEN APPROVED.

2. TO EXPEDITE PROCEDURE APPROVAL, THE SELLER SHOULD ASSURE THAT THE VPAR FORM IS COMPLETED PROPERLY AND ALL PERTINENT INFORMATION IS INCLUDED. PARTICULAR ATTENTION SHOULD BE APPLIED TO THE FOLLOWING SECTIONS

A. BLOCK 10. THIS BLOCK IS INTENDED TO IDENTIFY THE APPLICABLE DRAWING. WITHOUT THIS INFORMATION, THE BUYER CANNOT VERIFY THE APPLICATION FOR WHICH THE VPAR IS BEING SUBMITTED. IF THE SAME TECHNIQUE WILL BE APPLIED TO NUMEROUS DRAWINGS, VARIOUS SHOULD BE ENTERED IN THIS BLOCK AND AN EXPLANATION ENTERED IN BLOCK 13. IF DRAWINGS ARE NOT APPLICABLE TO THIS ORDER, N/A SHOULD BE ENTERED.

B. BLOCK 11. THIS BLOCK IS INTENDED TO IDENTIFY THE PIECE MARK ON THE DRAWING IDENTIFIED IN BLOCK 10 FOR WHICH THE PROCEDURE APPROVAL IS BEING REQUESTED. IF A PIECE MARK IS NOT APPLICABLE, ENTER N/A. WHERE THE PURCHASE ORDER REFERENCES A BUYERS PART NUMBER FOR RAW MATERIAL, THAT NUMBER SHOULD BE ENTERED.

C. BLOCK 12. THIS BLOCK SHOULD REFERENCE THE PERFORMANCE SPECIFICATION AND ACCEPTANCE SPECIFICATION FOR WHICH THE PROCEDURE APPROVAL IS BEING REQUESTED.
FOR EXAMPLE, T9074-AS-GIB-010/271 AND MIL-T-16420K(1), OR MIL-STD-2132DAND MIL-F-23509F(1), ETC.

D. BLOCK 13. THIS BLOCK IS INTENDED TO PROVIDE INFORMATION TO THE BUYER PERTAINING TO THE SPECIFIC PROCEDURE FOR WHICH APPROVAL IS BEING REQUESTED, E.G., PROCEDURE NUMBER, REVISION, DATE, AND ANY ATTACHMENTS/ADDENDA/SUPPLEMENTS, ETC.
THIS BLOCK SHOULD ALSO STATE THE APPLICATIONS FOR WHICH APPROVAL IS BEING REQUESTED AND THE APPLICABLE ACCEPTANCE CRITERIA E.G., PT OF NAVSEA TECHNICAL PUBLICATION S9074-AR-GIB-010/278, P-1 WELDS WITH ACCEPTANCE TO MIL-STD-2035A, SECTION 7.2, CLASS 1.
IF CLARIFICATION TO BLOCKS 10 AND 11 IS REQUIRED, THIS BLOCK SHOULD BE UTILIZED E.G., PIPING DETAILS ARE BEING FABRICATED TO VARIOUS DRAWINGS AND VARIOUS PIECE MARKS. ALL WELDING IS IN ACCORDANCE WITH NAVSEA TECHNICAL PUBLICATION S9074-AR-GIB-010/278, CLASS P-1.

IF PROCEDURE APPROVAL IS BEING REQUESTED FOR MORE THAN ONE APPLICATION, EACH APPLICATION AND ACCEPTANCE SPECIFICIATION SHOULD BE CLEARLY STATED E.G., PT OF NICUAL FASTENERS AND WELD REPAIRS TO CUNI CASTINGS.

3. WHEN RADIOGRAPHY IS REQUIRED, THE SELLER IS RESPONSIBLE FOR THE REVIEW AND APPROVAL OF ALL PRODUCTION RADIOGRAPHS. IN ADDITION, THE SELLER SHALL FORWARD TO THE BUYER ALL PRODUCTION RADIOGRAPHS VIA A PROPERLY COMPLETED VPAR. THE BUYER MUST APPROVE ALL RADIOGRAPHS, INCLUDING ALL REPAIR CYCLES, PRIOR TO SHIPMENT OF HARDWARE UNLESS THE REQUIREMENT IS SPECIFICALLY WAIVED IN WRITING BY THE BUYER.

D. GENERAL REQUIREMENTS FOR PROCEDURE APPROVAL

1. THE BUYER REVIEWS SELLER AND SUB-TIER SUPPLIER NDT PROCEDURES TO ASSURE COMPLIANCE WITH APPLICABLE PERFORMANCE DOCUMENTS AND ACCEPTANCE CRITERIA SPECIFICATIONS. IN GENERAL, ANY PORTION OF A PERFORMANCE DOCUMENT OR ACCEPTANCE SPECIFICATION THAT CONTAINS THE WORD SHALL MUST BE INCLUDED IN THE VENDOR PROCEDURE.

2. ALL NDT PROCEDURES SHALL BE SIGNED FOR BY THE PERFORMING ACTIVITYS COGNIZANT LEVEL III TEST EXAMINER DENOTING APPROVAL.

3. ALL NDT PROCEDURES, WITH THE EXCEPTION OF RADIOGRAPHY, MUST CONTAIN DETAILED ACCEPTANCE CRITERIA AS REQUIRED BY THIS PURCHASE ORDER AND APPLICABLE SPECIFICATIONS AND DRAWINGS. ACCEPTANCE CRITERIA MAY BE CONTAINED IN SEPARATE ATTACHMENTS/ADDENDA/SUPPLEMENTS TO THE BASE PERFORMANCE PROCEDURE. ACCEPTANCE CRITERIA SHALL BE DETAILED ENOUGH TO BE SELF-STANDING, E.G., NOT JUST REFERRING TO THE PARAGRAPH BUT RATHER CITING THE WORDING, AS OFTEN AS IS PRACTICAL. NOTED EXCEPTIONS ARE
SAE J122/123.
FF-S-86

E. ADDITIONAL REQUIREMENTS FOR NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271 PROCEDURES

1. WHENEVER NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271 IS INVOKED, THE FOLLOWING MUST BE INCLUDED IN ALL NDT PROCEDURES
A STATEMENT IS REQUIRED THAT THE PROCEDURE IS IN ACCORDANCE WITH THE REQUIREMENTS OF NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271 TO MEET THE REQUIREMENT OF PARAGRAPH 1.7.1.
A STATEMENT IS REQUIRED THAT PERSONNEL CERTIFICATIONS MUST BE IN ACCORDANCE WITH SNT-TC-1A, AS A MINIMUM REQUIREMENT, EXCEPT AS MODIFIED BY SECTION 1 OF NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271 TO MEET THE REQUIREMENT OF PARAGRAPH 1.6.
A STATEMENT IS REQUIRED THAT ACCEPTANCE INSPECTIONS SHALL BE PERFORMED ON AN ITEM IN THE FINAL SURFACE AND HEAT-TREATED CONDITION, UNLESS OTHERWISE SPECIFIED, TO MEET THE REQUIREMENT OF PARAGRAPH 1.4. HOWEVER, IT IS ALSO RECOGNIZED THAT UT INSPECTION IS TYPICALLY PERFORMED WHEN THE PART HAS A SIMPLE GEOMETRY I.E. PRIOR TO FINAL MACHINING PER PARAGRAPH 6.3.

2. WHENEVER NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271 IS INVOKED, THE MINIMUM PROCEDURAL ELEMENTS ARE CONTAINED IN EACH NDT SECTION RT - PARAGRAPH 3.3.2, MT - PARAGRAPH 4.3.1.2, PT - PARAGRAPH 5.4.2, UT - PARAGRAPH 6.5.2, ET - PARAGRAPH 7.3.2, PARAGRAPH VT - 8.3, RESPECTIVELY. ADDITIONALLY, THE FOLLOWING INFORMATION MUST ALSO BE CONTAINED IN ALL NDT PROCEDURES

MAGNETIC PARTICLE TESTING
LIGHTING REQUIREMENTS.
FINAL CLEANING.

LIQUID PENETRANT TESTING
MATERIAL TO BE TESTED; E.G., WELDS, WELD REPAIRS, CASTINGS, ETC.
SURFACE PREPARATION.
LIGHTING REQUIREMENTS.
ALL PENETRANTS, EMULSIFIERS, REMOVERS, AND DEVELOPERS SHALL BE INCLUDED ON THE QUALIFIED PRODUCTS LIST OF THE LATEST REVISION OF AMS 2644.

ULTRASONIC TESTING
THE INSTRUMENT MODEL/S ALLOWED FOR THE INSPECTION.
EQUIPMENT QUALIFICATION METHOD OR REFERENCE TO A QUALIFICATION PROCEDURE.
DESCRIPTION OF THE REFERENCE CALIBRATION STANDARD.

VISUAL TESTING
TYPE OF WELDS OR SURFACES TO BE INSPECTED.
NOTE UNLESS OTHERWISE STATED IN THE ORDERING DATA OR DOCUMENT/S INVOKED, THIS REQUIREMENT CAN BE SATISFIED BY SIMPLY OFFERING AN OPENING STATEMENT TO THE EFFECT THAT THIS PROCEDURE SPECIFIES THE REQUIREMENTS FOR PERFORMING THE VISUAL INSPECTION OF COMPLETED FABRICATION WELDMENTS IN ACCORDANCE WITH ENTER APPLICABLE SPECIFICATION.

F. ELECTRIC BOAT APPROVAL

1. PROVIDED THE METHODOLOGY AND ACCEPTANCE CRITERIA CONTAINED IN AN NDT PROCEDURE ARE ACCEPTABLE, THE BUYERS APPROVAL WILL BE GRANTED FOR THE SPECIFIC APPLICATION/S REQUESTED BY THE SELLER. FOR EXAMPLE, IF A PENETRANT PROCEDURE IS SUBMITTED FOR THE INSPECTION OF MIL-S-1222H NICU BOLTS, THE BUYERS EVALUATION SHOULD STATE THIS PROCEDURE HAS BEEN REVIEWED AND APPROVED FOR THE PENETRANT TESTING LIST THE TYPE AND METHOD OF MIL-S-1222H FASTENERS IN ACCORDANCE WITH NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271 WITH ACCEPTANCE TO SAE J123C. IF THE VENDOR PROCEDURE ALSO CONTAINS ACCEPTANCE CRITERIA FOR OTHER APPLICATIONS SUCH AS FORGINGS OR CASTINGS, BUT APPROVAL IS NOT REQUESTED IN BLOCK 13 OF THE VPAR AND NOT REQUIRED BY THIS PURCHASE ORDER, PROCEDURE APPROVAL FOR THOSE OTHER APPLICATIONS WILL NOT BE GRANTED. THE SELLER MUST THEN RESUBMIT THIS PROCEDURE TO OBTAIN BUYER APPROVAL PRIOR TO USAGE ON ANY OTHER APPLICATIONS.

2. IN SELECTED INSTANCES, THE BUYER MAY APPROVE A PROCEDURE WITH COMMENTS. IN SUCH INSTANCES, THE PERFORMING ACTIVITYS INSPECTION PERSONNEL MUST BE MADE AWARE OF THESE COMMENTS AND ALL TESTING SHALL BE PERFORMED TO INSTRUCTIONS INCORPORATING THESE COMMENTS. IN ADDITION, THE SELLER OR SUB-TIER SUPPLIER MUST INCORPORATE THEM AND RESUBMIT A REVISED PROCEDURE FOR BUYER APPROVAL PRIOR TO FUTURE USE.

G. ALLOY IDENTIFICATION PROCEDURE REVIEW

1. ALL PROCEDURES SHALL BE UNIQUELY IDENTIFIED BY A PROCEDURE NUMBER, WITH A REVISION AND DATE.

2. THE ALLOY IDENTITY PROCEDURE SUBMITTED FOR APPROVAL SHALL CONTAIN THE FOLLOWING AS A MINIMUM

A. SCOPE - THE PROCEDURE SHALL INCLUDE A LIST OF ALL THE GENERIC MATERIALS MANUFACTURED OR USED IN THE SELLERS OR SUPPLIERS SHOP AND THE TESTING INSTRUMENT/S USED TO SEPARATE EACH.

B. EQUIPMENT DESCRIPTION - THE PROCEDURE SHALL STATE THE TESTING INSTRUMENT BRAND NAME, MODEL NUMBER AND PRINCIPLE OF OPERATION.

C. EQUIPMENT SETUP - THE PROCEDURE SHALL LIST THE STEPS NECESSARY FOR EQUIPMENT SETUP AND PREPARATION FOR USE.

D. INSTRUMENT CHECK OR CALIBRATION - THE PROCEDURE SHALL PROVIDE MEANS FOR DETERMINING THAT THE TESTING INSTRUMENT IS FUNCTIONING PROPERLY. IF A CALIBRATION STANDARD OF KNOWN VALUE IS USED, AN ACCEPTANCE CRITERIA FOR PROPER CALIBRATION SHALL ALSO BE GIVEN, AND SHALL AS A MINIMUM BE PRIOR TO AND AT THE CONCLUSION OF TESTING, AND AFTER ANY CHANGE IN OPERATOR, EQUIPMENT OR PERIODS OF INACTIVITY. APPROPRIATE DOCUMENTATION OF THE CALIBRATION STANDARD COMPOSITION SHALL BE MAINTAINED ON FILE BY THE SUPPLIER.

E. TESTING OF MATERIAL - THE PROCEDURE SHALL INCLUDE DETAILS OF TESTING TECHNIQUE INCLUDING INSTRUMENT SETTINGS, POSITIONING OF INSTRUMENT PROBES AND PRECAUTIONS CONCERNING CONDITION OF MATERIAL TO BE TESTED SUCH AS FREE FROM OIL, GREASE, OXIDE, SCALE AND FILM AS APPROPRIATE.

F. ACCEPTANCE CRITERIA - THE PROCEDURE SHALL PROVIDE ACCEPTANCE CRITERIA FOR EACH OF THE GENERIC MATERIALS MANUFACTURED OR USED IN THE SUPPLIERS SHOP.

G. OVERLAP - THE PROCEDURE SHALL ADDRESS THE QUESTION OF OVERLAP OF READINGS AMONG DIFFERENT GENERIC MATERIALS. IT SHALL CONTAIN ADEQUATE INSTRUCTIONS ON SUPPLEMENTAL TESTS USE OF MAGNET, SPECTROGRAPHIC ANALYSIS, ETC., TO DISTINGUISH BETWEEN SUCH MATERIALS AND TO PROVIDE POSITIVE IDENTIFICATION WHEN OVERLAP OCCURS.

3. GENERIC MATERIALS SHALL INCLUDE BUT ARE NOT LIMITED TO THOSE LISTED BELOW. OTHER MATERIALS ENCOUNTERED IN WORK WHICH ARE NOT LISTED HERE ALSO REQUIRE THE GENERIC IDENTITY CHECK.

NICUAL-CHROMIUM-IRON BASE ALLOYS INCONELS AND HASTELLOYS
K-MONEL
COPPER-NICUAL ALLOYS CUPRO-NICKELS
NICKEL-COPPER ALLOYS MONELS
AUSTENITIC STAINLESS STEELS AISI 300 SERIES
MARTENSITIC & FERRITIC STAINLESS STEELS AISI 400 SERIES & 17-4 PH CLASS
CARBON AND ALLOY STEELS
TITANIUM ALLOYS
COBALT BASE ALLOYS STELLITES
NICKEL-CHROMIUM-BORON ALLOYS COLMONOYS
COPPER
BRONZE
NICKEL-ALUMINUM BRONZE
BRASS
SILVER BRAZING MATERIAL

4. MATERIAL NOT MEETING THE ACCEPTANCE CRITERIA IN THE APPROVED ALLOY IDENTITY TESTING PROCEDURE SHALL BE REJECTED.

H. RESUBMITTAL OF SELLER AND SUB-TIER SUPPLIER PROCEDURES

1. THE SELLER OR SUB-TIER SUPPLIER MAY BE REQUIRED TO RESUBMIT PROCEDURES DUE TO DISAPPROVAL, CHANGES IN APPLICATION OR ACCEPTANCE CRITERIA, OR PERIODIC MODIFICATIONS TO PERFORMANCE AND ACCEPTANCE SPECIFICATIONS. RESUBMITTALS SHALL BE TIMELY AND IN ALL CASES, BUYERS APPROVAL OF THE RESUBMITTED PROCEDURE IS REQUIRED PRIOR TO USE. IN SUCH INSTANCES, THE SELLER SHOULD AGAIN UTILIZE A VPAR TO EXPLAIN WHY THE PROCEDURE IS BEING RESUBMITTED, LETTER NUMBER AND DATE OF PREVIOUS SUBMITTAL AND IDENTIFICATION OF HOW THE PROCEDURE HAS BEEN MODIFIED, IF AT ALL. THIS INFORMATION WILL ASSIST IN THE EVALUATION OF THE PROCEDURE AND EXPEDITE APPROVAL.

2. RADIOGRAPHIC PROCEDURES REVISED TO DENOTE WHEN X-RAY MACHINE TUBES ARE CHANGED AND THE NEW FOCAL SPOT IS EQUAL TO OR LESS THAN THE ORIGINAL OR FOR NEW ISOTOPE SOURCES WHERE THE PHYSICAL SIZE IS EQUAL TO OR LESS THAN THAT OF THE LARGEST SOURCE, OF SAME TYPE, ORIGINALLY QUALIFIED DO NOT REQUIRE RESUBMITTAL FOR APPROVAL.

I. PROCEDURES PREVIOUSLY APPROVED

1. FOR SELLERS THAT RECEIVE MULTIPLE OR REPETITIVE ORDERS THAT APPLY TO SIMILAR ITEMS, IT IS NOT ALWAYS NECESSARY TO SUBMIT A VPAR FOR EVERY APPLICATION. PREVIOUSLY APPROVED PROCEDURES MAY BE USED PROVIDED THE FOLLOWING CONDITIONS ARE SATISFIED

A. THE PROCEDURE, INCLUDING REVISION, AND ANY ASSOCIATED ATTACHMENTS/ADDENDA/SUPPLEMENTS, IS THE SAME AS WAS PREVIOUSLY APPROVED BY THE BUYER.

B. THE PROCEDURE COVERS THE SAME TYPE OF PROCESS, PROCESS SPECIFICATION REVISION, MATERIAL SPECIFICATION REVISION, APPLICATION AND ACCEPTANCE CRITERIA. IN ADDITION, THE CONFIGURATION MUST BE THE SAME, I.E., THE PROPOSED NDT METHOD CAN TECHNICALLY BE APPLIED WITH QUALITY RESULTS AS DETERMINED BY THE PERFORMING ACTIVITYS COGNIZANT LEVEL III TEST EXAMINER WITH RESPECT TO SIZE AND SHAPE.

2. NDT PROCEDURES PREVIOUSLY APPROVED TO THE REQUIREMENTS OF MIL-STD-271, REVISION F MAY CONTINUE TO BE USED PROVIDED ALL THE REQUIREMENTS SET FORTH ABOVE ARE FOLLOWED.

3. WHERE THE SELLER ELECTS TO USE PROCEDURES PREVIOUSLY APPROVED, A COPY OF THE BUYERS PREVIOUSLY APPROVED ELECTRIC BOAT VPAR OR EQUIVALENT NEWPORT NEWS SHIPBUILDING VPAR AND APPLICABLE NEWPORT NEWS SHIPBUILDING APPROVAL LETTER MEETING ALL THESE CONDITIONS SHALL BE FURNISHED WITH THE SHIPMENT.

IF THE NAME AND/OR ADDRESS OF THE PERFORMING ACTIVITY LISTED ON THE CERTIFICATION OF ACCOMPLISHMENT IS DIFFERENT THAN THE NAME OF THE ACTIVITY LISTED ON THE APPLICABLE PROCEDURE FOR THE PREVIOUSLY APPROVED VPAR, THE SUPPLIER SHALL PROVIDE OQE THAT:
I. THIS CHANGE IS ADMINISTRATIVE IN NATURE,
II. THIS IS NOT CONSIDERED TO BE A TRANSFER OF PROCEDURES AS GOVERNED BY TECH PUB 271, PARAGRAPH 1.7.4, AND
III. THE PERFORMING ACTIVITY IS OPERATING UNDER THE SAME QUALITY ASSURANCE MANAGEMENT AND USING THE SAME QUALITY ASSURANCE PLAN AS WAS APPLICABLE TO THE ACTIVITY LISTED ON THE APPLICABLE PROCEDURE FOR THE PREVIOUSLY APPROVED VPAR, AS REQUIRED BY TECH PUB 271, PARAGRAPH 1.5.3.

4. PROCEDURES PREVIOUSLY APPROVED BY EITHER ELECTRIC BOAT OR NEWPORT NEWS SHIPBUILDING ARE ACCEPTED BY BOTH SHIPBUILDERS FOR VIRGINIA CLASS PROCUREMENTS ONLY.

J. TEST REPORTS FOR PERFORMANCE OF NDT

1. WHEN SPECIFIED, REPORTS SHOWING THE RESULTS OF EACH TEST PERFORMED WITHIN THE SPECIFIED NONDESTRUCTIVE TEST METHOD ARE REQUIRED. GUIDELINES FOR PROPER TEST REPORT REQUIREMENTS ARE AS DETAILED IN APPLICABLE SPECIFICATIONS. WHERE GUIDANCE IS NOT PROVIDED, THE SELLER SHALL RECORD THE BELOW LISTED INFORMATION, AS A MINIMUM.

A. THE NDT METHOD/S USED.
B. DESCRIPTION OR UNIQUE IDENTIFICATION OF THE ITEM INSPECTED.
C. PROCEDURE INDENTIFICATION.
D. THE PERFORMING ACTIVITY, WHETHER IT BE THE SELLER, A SUB-TIER SUPPLIER OR A TEST LAB.
E. QUANTITY INSPECTED.
F. ACCEPTANCE STANDARD USED.
G. QUANTITY ACCEPTED/REJECTED.
H. DATE OF INITIAL INSPECTION AND INSPECTOR IDENTIFICATION.

2. IN ADDITION, THE SELLER SHALL ATTACH A COPY OF THE BUYERS VPAR THAT APPROVED THE PROCEDURE TO THE TEST REPORT.

3. TEST REPORTS AND/OR OTHER VERIFICATION OF CONFORMANCE DOCUMENTS SHALL BE SIGNED AND DATED BY THE SELLERS AUTHORIZED REPRESENTATIVE.

4. EVIDENCE OF ALL TESTS AND INSPECTIONS PERFORMED, AS REQUIRED BY THIS PURCHASE ORDER OR SPECIFICATION, MUST BE MAINTAINED BY THE SELLER. HOWEVER, RECORDS REQUIRED TO BE SUBMITTED BY THIS PURCHASE ORDER OR SPECIFICATION SHALL BE FORWARDED WITH EACH SHIPMENT.
TEST REPORTS SHALL BE ATTACHED TO THE PACKING LIST. WHERE MORE THAN ONE CONTAINER OR PACKAGE IS INCLUDED IN THE SHIPMENT, THE TEST REPORTS SHALL BE ATTACHED SECURELY TO OR PLACED IN ONE CONTAINER OR PACKAGE AND CLEARLY IDENTIFIED ON THE OUTSIDE.

FOR PURCHASE ORDERS THAT ORIGINATE FROM NEWPORT NEWS SHIPBUILDING, REFER TO STANDARD CLAUSE 38-4 FOR SUBMITTAL OF ALL UNAPPROVED PURCHASE ORDER SOFTWARE DELIVERABLES.

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GENERAL DYNAMICS
Electric Boat

Purchase Order Standard Clauses

New Search

Number 60-77

Revision 22

Title WELDING AND BRAZING PROCEDURE APPROVAL

Clause

NUMBER: 60-77
TITLE: WELDING AND BRAZING PROCEDURE APPROVAL
SCOPE: REQUIREMENTS FOR MILITARY AND COMMERCIAL WELDING AND BRAZING
ACRONYMS:
ACN (ADVANCE CHANGE NOTICE)
BPS (BRAZING PROCEDURE SPECIFICATION OR BRAZING PROCEDURE)
NDT (NON-DESTRUCTIVE TESTING)
PQR (PROCEDURE QUALIFICATION RECORD)
RT (RADIOGRAPHIC TEST)
SPARS VES (SHIPBUILDING PARTNERS AND SUPPLIERS VIRTUAL ENTERPRISE SERVER)
VIR (VENDOR INFORMATION REQUEST)
VPAR (VENDOR PROCEDURE APPROVAL REQUEST)
VT (VISUAL TEST)
WPQ (WELDER PERFORMANCE QUALIFICATION RECORDS)
WPS (WELDING PROCEDURE SPECIFICATION OR WELD PROCEDURE)

CLAUSE: THE REQUIREMENTS CONTAINED HEREIN APPLY TO PROCEDURES USED IN FULFILLING THE REQUIREMENTS OF THIS PURCHASE ORDER. THE REQUIREMENTS ARE APPLICABLE TO BOTH SUPPLIERS AND THEIR SUBCONTRACTOR(S).

EFFECTIVITY: THIS STANDARD CLAUSE REVISION IS APPLICABLE TO PURCHASE ORDERS INITIATED FROM 05/31/2019 FORWARD. ANY PURCHASE ORDERS DATED PRIOR TO 05/31/2019 MAY UTILIZE REVISION 20 OF THIS STANDARD CLAUSE.

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SECTION XV - COMPLIANCE REQUIREMENT STATEMENT

I) GENERAL REQUIREMENTS:

A) WRITTEN PROCEDURES SHALL BE APPROVED BY THE BUYER PRIOR TO PERFORMANCE OF WELDING OR BRAZING AND SHALL BE SUBMITTED FOR APPROVAL WITHIN THIRTY (30) DAYS OF SUPPLIER'S RECEIPT OF A PURCHASE ORDER. THE PRIME SUPPLIER WILL BE RESPONSIBLE FOR SUBMITTING FOR APPROVAL THEIR SUBCONTRACTOR?S WRITTEN PROCEDURES AND ONCE APPROVED BY EB, THE APPROVAL DOCUMENT SHALL BE FLOWED DOWN TO THE SUBCONTRACTOR.

B) FOR CASES WHERE THE SUPPLIER IS NOT ABLE TO SUBMIT PROCEDURES WITHIN THE THIRTY DAY REQUIREMENT, THE SUPPLIER IS REQUIRED TO NOTIFY THE BUYER AND PROVIDE A SCHEDULE FOR WHEN THE PROCEDURES WILL BE SUBMITTED FOR APPROVAL.

C) FOR PURCHASE ORDERS THAT ORIGINATE FROM HUNTINGTON INGALLS INDUSTRIES NEWPORT NEWS SHIPBUILDING (HII-NNS) SEE SECTION XI OF THIS STANDARD CLAUSE.

D) **WARNING ** MATERIAL WELDED OR BRAZED WITH UNAPPROVED PROCEDURES OR UNAPPROVED PROCEDURE REVISIONS IS SUBJECT TO REJECTION AT THE SUPPLIERS EXPENSE. SUPPLIERS MUST WORK TO THE MOST RECENT APPROVED REVISION OF THEIR PROCEDURE LISTED IN THE CORRECTIVE ACTION BLOCK FOR ELECTRONIC VPARS OR BLOCK 13 OF THE PAPER VERSION. EACH VPAR APPROVAL FOR A NEW PROCEDURE REVISION SUPERSEDES THE PREVIOUS REVISION APPROVAL.

E) ** WARNING** PROCEDURES SHALL BE SUBMITTED TO THE BUYER ELECTRONICALLY THROUGH THE SPARS VPAR SYSTEM OR A PROPERLY COMPLETED VENDOR PROCEDURE APPROVAL REQUEST (VPAR), (EB FORM 84-01-2974) WHEN REQUIRED BY SECTION I.G. SUBMITTAL SHALL INCLUDE AT A MINIMUM ITEMS IN SECTION I.K BELOW.

F) COMMERCIAL WELDING AND BRAZING:

1) WHEN THIS STANDARD CLAUSE IS INVOKED ON APPLICATIONS PERMITTING COMMERCIAL WELDING AND BRAZING, WPS AND BPS SHALL BE SUBMITTED ON A VPAR IN ACCORDANCE WITH THE REQUIREMENTS OF THIS CLAUSE.

G) WPS OR BPS AND SUPPORTING PQR(S) SHALL BE SUBMITTED WHEN ANY OF THE FOLLOWING APPLIES:

1) IT IS A NEW PROCEDURE OR A PROCEDURE WHICH HAS NOT BEEN PREVIOUSLY APPROVED.
2) IT IS A PREVIOUSLY APPROVED PROCEDURE THAT IS REVISED. SUBMITTAL IS REQUIRED FOR ADMINISTRATIVE ONLY REVISION.
3) IT IS A PROCEDURE PREVIOUSLY APPROVED SPECIFICALLY FOR A SINGLE PURCHASE ORDER OR SINGLE APPLICATION, AS DEFINED IN THE CORRECTIVE ACTION BLOCK FOR ELECTRONIC VPARS (OR BLOCK 13 OF THE PAPER VPAR), THAT WILL BE USED ON A DIFFERENT PURCHASE ORDER OR APPLICATION.
4) IF THE PROCEDURE APPROVAL IS ONLY FOR A DRAWING NUMBER, IF A REVISION IS MADE TO THAT DRAWING AFFECTING THE WELDING OR BRAZING ON THAT DRAWING.
5) FOR EB-PURCHASED MATERIAL, IT IS A PROCEDURE PREVIOUSLY APPROVED BY AN ORGANIZATION OTHER THAN EB BUT NOT BY EB. FOR NNS-PURCHASED

MATERIAL, IT IS A PROCEDURE APPROVED BY AN ORGANIZATION OTHER THAN NNS BUT NOT BY NNS.

I. TO EXPEDITE APPROVAL, THE SUBMITTAL SHALL CONTAIN THE SUPPORTING QUALIFICATION DATA AND COPIES OF ALL APPROVAL DOCUMENTATION FROM OTHER ORGANIZATIONS. FOR EXAMPLE: A NAVSEA LETTER OF APPROVAL, AN AUTHORIZED REPRESENTATIVE LETTER OF APPROVAL, NNS FORM 9014.

H) PROCEDURES ARE NOT REQUIRED TO BE SUBMITTED FOR THE FOLLOWING CASES:

1) PROCEDURES WHICH HAVE PREVIOUSLY RECEIVED THE BUYER'S WRITTEN APPROVAL ON A VPAR NEED NOT BE RESUBMITTED PROVIDED THAT THE PROCEDURE, INCLUDING REVISION AND DATE, IS THE SAME AS THAT LISTED ON THE PREVIOUSLY APPROVED VPAR AND THE APPROVAL IS NOT FOR SPECIFIC APPLICATIONS AS LISTED IN SECTION II.B
2) WHEN SPECIFICALLY EXEMPTED BY NAVSEA APPROVED SPECIFICATIONS, DRAWINGS; AS ALLOWED BY FABRICATION DOCUMENTS; OR AS OTHERWISE APPROVED BY EB.

I) FOR HARDWARE INVOLVING WELDING/BRAZING, WHERE THE WPS/BPS REQUIRES APPROVAL, THE SUPPLIER SHALL ATTACH A PHOTOCOPY OF THE APPROVED VPAR FOR EACH WPS/BPS USED TO THE FOLLOWING:

1) THE PACKING SLIP
2) THE WELD OR BRAZE RECORDS, WHEN RECORDS ARE REQUIRED

J) ONLY ONE WELDING/BRAZING PROCEDURE (INCLUDING SUPPORTING QUALIFICATION DATA, TEST REPORTS AND PREVIOUS APPROVAL INFORMATION) PER VPAR SHALL BE SUBMITTED. RECORDS FOR MORE THAN ONE SUPPORTING QUALIFICATION TEST MAY BE SUBMITTED WITH A VPAR, AS NECESSARY, IN SUPPORT OF A SINGLE WELDING/BRAZING PROCEDURE.

K) VPAR DETAIL REQUIREMENTS: VPAR SUBMITTAL FOR INITIAL PQR/WPS/BPS APPROVAL SHALL INCLUDE THE FOLLOWING DOCUMENTS (SEE SECTIONS V, VI AND VII FOR DETAILED REQUIREMENTS FOR WPS, BPS AND PQR).

1) WPS OR BPS
2) SUPPORTING PQR(S). FOR PQRS WHICH HAVE NOT BEEN PREVIOUSLY APPROVED, ALSO INCLUDE:

I. SUPPORTING TEST LAB REPORTS
II. MATERIAL CERTIFICATIONS FOR DUAL-CERTIFIED FILLER MATERIAL
III. APPROVED RT VPAR (SEE SECTION VI.D.4), FOR QUALIFICATIONS REQUIRING RT.

3) NAVSEA OR NAVSEA AUTHORIZED REPRESENTATIVE APPROVAL DOCUMENTATION FOR PREVIOUSLY APPROVED PQR(S), WHEN APPLICABLE.

L) IN CASES WHERE WELDING OR BRAZING PROCEDURES CONSIST OF A MAIN OR GENERAL PROCEDURE AND A SUPPLEMENTAL TECHNIQUE SHEET, AND ESSENTIAL WELDING/BRAZING PROCEDURE ELEMENTS ARE CONTAINED IN BOTH DOCUMENTS, BOTH DOCUMENTS SHALL BE SUBMITTED. NOTE THAT IN SOME CASES, A WELDING OR BRAZING PROCEDURE IS CALLED A SCHEDULE; SCHEDULES SHALL BE SUBMITTED FOR REVIEW AND APPROVAL AS WELL. GENERAL PROCEDURES WRITTEN TO BOTH MILITARY AND COMMERCIAL SPECIFICATIONS WILL NOT BE ACCEPTED.

II) VPAR APPROVAL LIMITATIONS:

A) WPS OR BPS WRITTEN IN ACCORDANCE WITH NAVSEA TECHNICAL PUBLICATIONS (I.E. NAVSEA T9074-AD-GIB-010/1688 OR S9074-AR-GIB-010/278) OR MILITARY STANDARDS (I.E. MIL-STD-278) ARE TYPICALLY APPROVED FOR GENERAL USE WITHOUT RESTRICTION.

B) APPROVAL OF WPS OR BPS FOR NON-CRITICAL APPLICATIONS (AS DEFINED BY PARAGRAPH 4.2 OF SEAWOLF PPD 802-6335694 AND/OR PARAGRAPH 4.2.1.1 OF MIL-STD-278 OR NAVSEA S9074-AR-GIB-010/278), MINOR STRUCTURE (AS DEFINED IN PARAGRAPH 3.33.3.1 OF NAVSEA T9074-AD-GIB-010/1688) OR TO COMMERCIAL OR OTHER SPECIFICATIONS, IS LIMITED TO ONE OF THE FOLLOWING:

1) A SINGLE PURCHASE ORDER.
2) SINGLE APPLICATION. SINGLE APPLICATION APPROVAL IS BASED ON DRAWING NUMBER AND PART NUMBER.

C) LIMITED APPROVAL MAY ALSO BE DUE TO NAVSEA APPROVAL OF SPECIAL WELD PROCEDURES WHERE SPECIFIC APPLICATION APPROVAL IS REQUIRED BY MIL-STD-278 / NAVSEA S9074-AR-GIB-010/278, PARAGRAPH 6.2.

D) EACH VPAR APPROVAL IS ISSUED FOR A SPECIFIC SINGLE WPS OR BPS REVISION AND DATE.

1) SUPPLIERS SHALL WORK TO THE MOST RECENT APPROVED REVISION OF THEIR PROCEDURE LISTED IN THE CORRECTIVE ACTION BLOCK FOR ELECTRONIC VPARS (OR BLOCK 13 OF THE PAPER VPAR) ONCE APPROVAL IS GRANTED.
2) EACH NEW VPAR APPROVAL FOR A NEW PROCEDURE REVISION SUPERSEDES THE PREVIOUS REVISION APPROVAL.

I. THE USE OF EARLIER REVISIONS OF A PROCEDURE IS PROHIBITED UNLESS USE IS SPECIFICALLY APPROVED. REQUESTS TO DO SO SHALL BE SUBMITTED ON A VIR.
II. THE VIR SUBMITTAL SHALL IDENTIFY WHAT APPLICATION THE EARLIER REVISION OF THE PROCEDURE WILL BE USED ON.
III. THE VIR SHALL PROVIDE JUSTIFICATION FOR USING THAT REVISION OF THE PROCEDURE.

3) IF A VPAR APPROVAL IS RESCINDED, USE OF A PREVIOUSLY APPROVED REVISION OF THE PROCEDURE IS NOT AUTHORIZED.

III) FABRICATION AND QUALIFICATION DOCUMENT APPLICABILITY:

A) WELDING AND BRAZING SHALL BE PERFORMED IN ACCORDANCE WITH ELECTRIC BOAT SPECIFICATION 5341 (EB-5341).

B) THE EFFECTIVE DOCUMENT AND REVISION, INCLUDING MODIFICATIONS THERTO, OF WELDING AND BRAZING SPECIFICATIONS AND STANDARDS SHALL BE AS SPECIFIED BY EB-5341.

C) THE APPLICABLE FABRICATION AND QUALIFICATION SPECIFICATION AND REVISION LEVEL SHALL BE EXPLICITLY LISTED IN FULL ON THE REQUIRED DOCUMENTATION (WELDING OR BRAZING PROCEDURES, PROCEDURE QUALIFICATION RECORDS, AND CERTIFICATIONS) E.G. WRITING "NAVSEA S9074-AQ-GIB-010/248" AS "248" IS NOT ACCEPTABLE.

IV) USE OF UNLISTED BASE OR FILLER MATERIALS:

A) WELDING OR BRAZING OF UNLISTED BASE MATERIALS OR WITH UNLISTED FILLER MATERIAL/ELECTRODE IS PROHIBITED EXCEPT AS SPECIFIED BELOW:

1) WELDING: ALL BASE METALS (SPECIFICATION, TYPE AND CLASS OR GRADE) THAT ARE NOT LISTED S-GROUP NUMBERS IN NAVSEA S9074-AQ-GIB-010/248 TABLE I OR NAVSEA S9074-AR-GIB-010/278 TABLE I MUST HAVE NAVSEA OR NAVSEA AUTHORIZED REPRESENTATIVE APPROVAL PRIOR TO WELDING.
2) BRAZING: ALL BASE METALS (SPECIFICATION, TYPE AND CLASS OR GRADE) THAT ARE NOT LISTED P-GROUP NUMBERS IN NAVSEA 0900-LP-001-7000 TABLE 4-4 OR NAVSEA S9074-AQ-GIB-010/248 TABLE XIII MUST HAVE NAVSEA OR NAVSEA AUTHORIZED REPRESENTATIVE APPROVAL PRIOR TO BRAZING.
3) FILLER MATERIAL/ELECTRODE SPECIFICATION AND TYPE: ALL FILLER MATERIALS/ELECTRODES THAT ARE NOT LISTED A-/F-GROUP NUMBERS IN NAVSEA S9074-AR-GIB-010/278 TABLE II, NAVSEA T9074-AD-GIB-010/1688 TABLES 10-1, 10-2, 10-3, 10-4, NAVSEA S9074-AQ-GIB-010/248 TABLE II OR TABLE XIV, OR NAVSEA 0900-LP-001-7000 TABLE 4-2 MUST HAVE NAVSEA OR NAVSEA AUTHORIZED REPRESENTATIVE APPROVAL PRIOR TO WELDING OR BRAZING.

B) IF THE SUPPLIER DOES NOT HAVE AN APPROVAL FOR A BASE OR FILLER MATERIAL/ELECTRODE, THE SUPPLIER MUST REQUEST APPROVAL VIA A VIR. THE VIR MUST PROVIDE THE MATERIAL SPECIFICATION, TYPE, CONDITION, AND APPLICATION WHERE THE MATERIAL IS BEING USED.

C) IN ADDITION, IF A LISTED MATERIAL SPECIFICATION IS FOUND TO BE OBSOLETE AND POINTS TO A REPLACEMENT SPECIFICATION, THE REPLACEMENT SPECIFICATION SHALL NOT BE USED UNLESS THAT MATERIAL SPECIFICATION IS APPROVED AS AN S-/P-/A-/F-GROUP MATERIAL.

D) THE NAVWELD SOFTWARE, DISCUSSED IN SECTION VIII, CONTAINS A LISTING OF MATERIALS APPROVED TO BE LISTED, BY GROUP NUMBERS.

NOTE: APPROVAL TO CLASSIFY A MATERIAL TO AN S-, P-, A-, OR F-GROUP DOES NOT CONSTITUTE APPROVAL TO USE THAT MATERIAL FOR A PARTICULAR APPLICATION OR TO AUTHORIZE SUBSTITUTION OF A MATERIAL ON A DRAWING.

V) PREPARATION OF WELDING OR BRAZING PROCEDURES:

A) WPS, BPS AND SUPPORTING PQRS SHALL BE WRITTEN IN ACCORDANCE WITH THE APPLICABLE NAVSEA TECHNICAL PUBLICATION OR APPLICABLE COMMERCIAL REQUIREMENTS AND REQUIREMENTS IN THIS PURCHASE ORDER.

B) VPAR WELD PROCEDURE INSTRUCTION BROCHURE OFFERS GUIDANCE FOR PREPARATION AND CAN BE FOUND BY GOING TO THE EB WEB SITE HTTP://WWW.GDEB.COM. THESE INSTRUCTIONS OFFER A GUIDE TO PREPARING AND PRESENTING THE QUALIFICATION AND WELDING PROCEDURE INFORMATION SUCH THAT IT WILL CONFORM TO THE REQUIREMENTS OF SPECIFICATIONS LISTED IN EB-5341. IN ADDITION, USE OF NAVWELD (SEE SECTION VIII) WILL GREATLY AID SUPPLIERS IN PREPARING AND PRESENTING QUALIFICATION AND WELDING PROCEDURE INFORMATION.

C) WPS, BPS AND PQR SHALL BE WRITTEN USING ONE OF THE FOLLOWING FORMATS:

1) PREFERRED: NAVWELD SOFTWARE. IT IS RECOMMENDED THAT BOTH NEW SUPPLIERS AND, FOR STANDARDIZATION PURPOSES, EXISTING SUPPLIERS USE THE NAVWELD SYSTEM IN PREPARING PROCEDURES AND QUALIFICATION DATA. ADDITIONAL INFORMATION IS PRESENTED IN SECTION VIII.

2) SUPPLIER?S OWN EXISTING FORMAT.

VI) WPS, BPS AND PQR REQUIREMENTS:

A) THE FOLLOWING SECTION PROVIDES CLARIFICATION OF SPECIFICATION REQUIREMENTS AS WELL AS ADDITIONAL REQUIREMENTS INVOKED BY THE BUYER.

B) ALL NEW WELDING PROCEDURES SHALL BE LIMITED TO ONE FABRICATION SPECIFICATION. WELDING PROCEDURES WRITTEN AND QUALIFIED TO MULTIPLE SPECIFICATIONS WILL NOT BE ACCEPTED. THE EXCEPTION TO THIS IS WHEN NAVSEA S9074-AR-GIB-010/278 AND NAVSEA T9074-AD-GIB-010/1688 PROCEDURES HAVE BEEN QUALIFIED TO NAVSEA S9074-AQ-GIB-010/248.

C) PROCEDURES WRITTEN TO BOTH MILITARY AND COMMERCIAL SPECIFICATIONS WILL NOT BE ACCEPTED.

D) SPECIFIC REQUIREMENTS FOR NEW PQRS:

1) EACH PQR (TEST ASSEMBLY AND WRITTEN DOCUMENTS) SHALL BE IDENTIFIED BY A UNIQUE PQR NUMBER. WHERE MULTIPLE TEST ASSEMBLIES ARE PERFORMED, THEY SHALL BE UNIQUELY IDENTIFIED.

I. THE UNIQUE PQR NUMBER SHALL BE DIFFERENT FROM THE WELDING OR BRAZING PROCEDURE NUMBER OR ANOTHER PQR NUMBER, E.G. WPS-123 AND PQR-123 WOULD BE ACCEPTABLE.
II. THE UNIQUE PQR NUMBER SHALL APPEAR ON ALL QUALIFICATION SUPPORTING DOCUMENTS, INCLUDING TEST LAB REPORTS.
III. THE UNIQUE PQR NUMBER REQUIREMENT APPLIES TO BOTH MILITARY AND COMMERCIAL WELDING AND BRAZING.
IV. REPLACEMENT PQR FOR A FAILED PQR SHALL HAVE ITS OWN UNIQUE NUMBER.

2) THE UNIQUE PQR NUMBER(S) SHALL BE LISTED ON THE WPS OR BPS WHICH IT SUPPORTS.
3) BOTH THE PQR AND THE TEST LAB REPORTS SHALL IDENTIFY THE FOLLOWING AS APPLICABLE OR BE SUBJECT TO REJECTION:

I. THE NDT PERFORMANCE STANDARD AND REVISION (E.G. NAVSEA T9074-AS-GIB-010/271, ACN 1)
II. NDT ACCEPTANCE STANDARD AND REVISION (E.G. MIL-STD-2035, REVISION A, CLASS 1)
III. DESTRUCTIVE TEST PERFORMANCE STANDARD AND REVISION (E.G. AWS B4.0, 2007)
IV. DESTRUCTIVE TEST ACCEPTANCE CRITERIA (STANDARD, PARAGRAPH, AND SUBPARAGRAPH IF APPLICABLE) (E.G. MACROS IN ACCORDANCE WITH (IAW) NAVSEA S9074-AQ-GIB-010/248, PARAGRAPH 4.5.2.6.B)
V. BEND TESTS SHALL REPORT BEND ANGLE, THICKNESS, AND BEND RADIUS, AS A MINIMUM OF INFORMATION
VI. ALL CHANGES TO LAB REPORTS SHALL BE ACCOMPLISHED BY THE COGNIZANT LAB, WITHOUT EXCEPTIONS.

4) RADIOGRAPHY (RT) OF PQRS FOR WPS IN ACCORDANCE WITH NAVSEA TECHNICAL PUBLICATIONS OR MILITARY STANDARDS, FOR WHICH RT INSPECTION OF TEST ASSEMBLY FINAL WELD IS REQUIRED AND WHERE THE PQR HAS NOT BEEN PREVIOUSLY APPROVED, SHALL REQUIRE SUBMITTAL OF THE RT FILM AND RT DATA FOR REVIEW AND APPROVAL ON A VPAR SEPARATE FROM THE WELDING PROCEDURE VPAR IN ACCORDANCE WITH THE FOLLOWING:

I. THE RT VPAR SHALL BE APPROVED PRIOR TO SUBMITTAL OF THE WPS VPAR.

II. PQR TEST ASSEMBLIES TO BE QUALIFIED WITH POST WELD HEAT TREATMENT (PWHT) SHALL RECEIVE PWHT AFTER WELDING AND PRIOR TO FINAL RT INSPECTION, WHEN THE PWHT INVOLVES QUENCHING IN A LIQUID MEDIUM.
III. VISUAL INSPECTION (VT) SHALL BE CONDUCTED AND FOUND SATISFACTORY BEFORE PERFORMING FINAL RT OF THE TEST ASSEMBLY.
IV. THE RT FILM WITH ASSOCIATED SET-UP (TECHNIQUE) AND READER?S SHEET SHALL BE SUBMITTED ON THE VPAR.
V. THE RT VPAR SHALL CONTAIN THE FOLLOWING ITEMS IN THE VPAR DESCRIPTION OF DOCUMENT BLOCK FOR ELECTRONIC VPARS (OR BLOCK 13 FOR THE PAPER VPAR) OR BE SUBJECT TO REJECTION:

A. THE STATEMENT: "RT FILM AND DATA FOR WELDING PROCEDURE QUALIFICATION"
B. PQR NUMBER
C. WELDING PROCEDURE NUMBER
D. THE STATEMENT: "VISUAL INSPECTION (VT) WAS CONDUCTED AND THE WELD FOUND TO BE SATISFACTORY."
E. RT PROCEDURE IDENTIFIED BY: PERFORMING ACTIVITY, NUMBER, REVISION, AND DATE (AND ANY ADDENDA)
F. JOINT TYPE I.E. BUTT, SINGLE BEVEL, DOUBLE BEVEL, BACKING BAR, ETC.
G. STATEMENT IF BACKING BAR WAS REMOVED OR LEFT ON DURING SHOOTING
H. BASE MATERIAL TYPE
I. FILLER MATERIAL TYPE
J. JOINT THICKNESS
K. JOINT FORM (PLATE/ PIPE)
L. IF THE TEST ASSEMBLY RECEIVED PWHT, THE RT VPAR SHALL IDENTIFY IF PWHT WAS PERFORMED BEFORE OR AFTER RT.

VI. THE RT PERFORMANCE STANDARD AND ACCEPTANCE CRITERIA SHALL BE LISTED IN THE CORRECTIVE ACTION BLOCK FOR ELECTRONIC VPARS (OR BLOCK 13 OF THE PAPER VPAR) PER A. OR B. BELOW:

A. FOR NAVSEA TECHNICAL PUBLICATION QUALIFICATIONS THE RT PERFORMANCE STANDARD SHALL BE NAVSEA T9074-AS-GIB-010/271; ACCEPTANCE TO MIL-STD-2035A CLASS I.
B. FOR MIL-STD AND PPD QUALIFICATIONS THE PERFORMANCE STANDARD SHALL BE NAVSEA T9074-AS-GIB-010/271 OR MIL-STD-271F; ACCEPTANCE TO MIL-STD-2035A CLASS I.

VII. THE RT FILM AND ASSOCIATED DATA SHOULD BE SUBMITTED FOR REVIEW AND APPROVAL PRIOR TO SECTIONING THE QUALIFICATION TEST ASSEMBLY FOR DESTRUCTIVE TESTING. DOING SO MAY AVOID HAVING TO WELD ADDITIONAL TEST ASSEMBLIES SHOULD THE FILM RESULTS BE DISPUTED.
VIII. A COPY OF THE VPAR THAT APPROVED THE RT PROCEDURE SHALL BE ATTACHED TO THE PQR RT VPAR SUBMITTAL. SEE SECTION VI.D.5.

5) PRIOR TO RT OF A PQR TEST ASSEMBLY, ANY ACTIVITY PERFORMING THE RT EVALUATION OF WELDING PQR TEST ASSEMBLIES SHALL HAVE THEIR RT PROCEDURE APPROVED BY THE BUYERS NON-DESTRUCTIVE TEST (NDT) ENGINEERING. THE SUBMITTAL OF A VPAR FOR AN RT PROCEDURE FOR APPROVAL OR EXTENDING A PREVIOUS APPROVAL SHALL BE IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD CLAUSE 60-67.

I. FOR PQRS IN ACCORDANCE WITH NAVSEA TECHNICAL PUBLICATIONS, RT PROCEDURES SHALL BE WRITTEN TO NAVSEA T9074-AS-GIB-010/271
II. FOR PQRS IN ACCORDANCE WITH MILITARY STANDARDS, RT PROCEDURES SHALL BE WRITTEN TO NAVSEA T9074-AS-GIB-010/271 OR MIL-STD-271F.

6) RADIOGRAPHIC FILMS SUBMITTED FOR REVIEW SHOULD CONTAIN, AT A

MINIMUM, 2 FILMS PER VIEW IN THE CASE THAT AN ARTIFACT IS FOUND WHICH IMPAIRS FILM INTERPRETATION.

VII) WPS, BPS, PQR REVISION CONTROL:

A) WHEN REVISIONS ARE REQUIRED TO CORRECT DISCREPANCIES TO WPS, BPS AND/OR PQR/SUPPORTING DOCUMENTATION, THE FOLLOWING SHALL APPLY:

1) WPS OR BPS THAT HAVE BEEN PREVIOUSLY ISSUED FOR PRODUCTION SHALL REQUIRE BOTH A CHANGE IN THE REVISION LEVEL AND THE DATE. PROCEDURES THAT HAVE NOT BEEN PREVIOUSLY ISSUED FOR PRODUCTION NEED NOT CHANGE THE REVISION LEVEL, BUT SHALL HAVE THE DATE CHANGED.
2) PQR/SUPPORTING DOCUMENTS SHALL LIST THE ORIGINAL DATE THAT THE TEST ASSEMBLY WAS WELDED/BRAZED. THE CORRECTIONS SHALL IDENTIFY WHAT ITEMS WERE CORRECTED AND THE DATE. PQR DATE AND A NEW CERTIFICATION DATE SHALL BE APPLIED WHEN CORRECTIONS ARE MADE.

VIII) USE OF NAVWELD FOR WELDING/BRAZING PROCEDURES AND QUALIFICATION RECORDS

A) NAVWELD (HTTP://WWW.NAVWELD.COM) IS A SECURE, INTERNET-BASED APPLICATION THAT ASSISTS THE USER IN DEVELOPING PQRS, WPS, BPS, AND WELDER PERFORMANCE QUALIFICATION RECORDS (WPQ) THAT MEET THE REQUIREMENTS OF VARIOUS U.S. NAVY SPECIFICATIONS.

B) ALTHOUGH USE OF NAVWELD IS NOT A PURCHASE ORDER REQUIREMENT, GDEB AND HII-NNS STRONGLY RECOMMEND SUPPLIERS UTILIZE THIS SOFTWARE, AS IT HAS BEEN SHOWN TO DRAMATICALLY REDUCE THE NUMBER OF ERRORS IN SUPPLIER SUBMITTALS. THIS SIGNIFICANTLY REDUCES APPROVAL CYCLE TIME. THE CREATION OF DETAILED WELDING/BRAZING PROCEDURES OR QUALIFICATION RECORDS REQUIRING CUSTOMER APPROVAL IS AN AREA WHERE SUPPLIERS, ESPECIALLY THOSE WITH LITTLE OR NO EXPERIENCE, HAVE DIFFICULTIES OBTAINING APPROVAL. DELAYS IN RECEIVING APPROVAL CAN RESULT IN DELAYS TO THE START OF FABRICATION OR HARDWARE DELIVERY BY THE SUPPLIER.

C) THERE IS NO COST TO THE SUPPLIERS OF GDEB OR HII-NNS FOR USE OF NAVWELD. THIS INCLUDES BOTH DIRECT SUPPLIERS AND SUB-TIER SUPPLIERS.

D) TO OBTAIN ACCESS TO NAVWELD, CONTACT TROY PASKELL AT PASKELL@WELDQC.COM OR 614-487-7207 TO OBTAIN A USER-AGREEMENT. ONCE THE USER-AGREEMENT IS RETURNED, A USER-NAME AND PASSWORD IS PROVIDED.

E) NAVWELD CONTAINS THE REQUIREMENTS FOR ARC WELDING, STUD WELDING, BRAZING AND RESISTANCE WELDING ACCORDING TO THE FOLLOWING SPECIFICATIONS:

1) NAVSEA S9074-AQ-GIB-010/248
2) NAVSEA S9074-AR-GIB-010/278
3) MIL-STD-1689A
4) NAVSEA T9074-AD-GIB-010/1688
5) ABS/ NVR - 2007
6) NAVSEA 0900-LP-001-7000
7) AMERICAN WELDING SOCIETY D17.2

F) NAVWELD AUTOMATICALLY DETERMINES:

1) ESSENTIAL ELEMENTS FOR PQR, WPS/BPS & WPQ

2) NON-DESTRUCTIVE TESTS FOR PQR & WPQ
3) DESTRUCTIVE TESTS FOR PQR & WPQ
4) QUALIFIED RANGES OF THE ESSENTIAL ELEMENTS FOR PQR & WPQ
5) REQUIREMENTS OF THE FABRICATION DOCUMENT FOR PQR & WPS/BPS
6) PREHEAT & INTERPASS TEMPERATURES
7) BASE & FILLER COMBINATIONS

G) ADDITIONAL FEATURES INCLUDE:

1) LOCATIONS FOR ENTRIES ARE MARKED "AS REQUIRED" OR "OPTIONAL", AND DOCUMENTS ARE MARKED AS "COMPLETE" OR "INCOMPLETE".
2) NAVWELD AUTOMATICALLY CREATES A WPS/BPS BASED ON THE QUALIFIED RANGES OF A PQR.
3) PROVIDES THE ABILITY TO TRACK VISION TESTS, WORKMANSHIP TRAINING AND WELDING/BRAZING HISTORY FOR PERSONNEL.
4) PROVIDES THE ABILITY TO SEARCH FOR WELDERS & BRAZERS BASED ON THEIR QUALIFICATIONS.

IX) CLARIFICATION OF REQUIREMENTS FOR SINGLE PASS WELD QUALIFICATION, BUTTERING UNDER HARDFACING OR CLADDING, SUBMERGED ARC WELDING OF HY-MATERIALS, AND REPAIR OF BASE MATERIALS

A) SINGLE PASS WELD QUALIFICATION:

1) MULTI PASS WELD QUALIFICATIONS CAN QUALIFY SINGLE PASS WELDING FOR THE FOLLOWING CONDITIONS, PROVIDED THE REQUIREMENTS OF NAVSEA S9074-AQ-GIB-010/248 ARE MET:

I. FILLET WELDS
II. BUILD UP OR REPAIR WELDING
III. JOINT DESIGNS LISTED IN MIL-STD-22 WHICH ARE RESTRICTED TO BASE MATERIAL THICKNESSES LESS THAN 1/4- INCH E.G. B1S.1, B1S.2, C1S.1, ETC.

B) BUTTERING UNDER HARDFACING OR CLADDING (SOME DRAWINGS REFER TO THIS AS A BUFFER LAYER):

1) IF A PROCEDURE IS QUALIFIED WITHOUT BUTTERING, THE ADDITION OF BUTTERING SHALL REQUIRE REQUALIFICATION.
2) THE MINIMUM QUALIFIED THICKNESS OF THE BUTTERING LAYER IS T (THE THICKNESS USED FOR THE QUALIFICATION WELD). THE MAXIMUM QUALIFIED THICKNESS OF THE BUTTERING LAYER IS 2T.
3) THE MINIMUM QUALIFIED NUMBER OF BUTTERING LAYERS IS EQUAL TO THE NUMBER OF BUTTERING LAYERS UTILIZED FOR THE QUALIFICATION TEST ASSEMBLY (RECORD NUMBER OF LAYERS ON PQR).
4) ELIMINATION OF BUTTERING SHALL REQUIRE REQUALIFICATION.
5) THE FINAL BUTTERING LAYER SURFACE SHALL BE VT AND PT INSPECTED IN ACCORDANCE WITH NAVSEA S9074-AQ-GIB-010/248 BEFORE HARDFACING OR CLADDING.
6) IF A BUTTER LAYER IS APPLIED BY ITSELF (I.E. IT FORMS THE FINAL WELD SURFACE) THEN IT IS A PAD AND SHALL REQUIRE QUALIFICATION BY A BUTT WELD AS SPECIFIED IN NAVSEA S9074-AQ-GIB-010/248.

C) REPAIR OF BASE MATERIALS:

WELD REPAIR OF BASE MATERIALS SHALL BE CONDUCTED IN ACCORDANCE WITH THE REQUIREMENTS OF EB-4186.

1) WHEN REQUIRED BY EB-4186, PERMISSION TO PERFORM REPAIR WELDING SHALL BE REQUESTED VIA A PROPERLY COMPLETED VIR SUBMITTED BY THE SUPPLIER ELECTRONICALLY USING THE APPROVED SPARS VES (VIRTUAL ENTERPRISE SERVER). THE SUPPLIER SHALL SEND THESE DOCUMENTS TO THE BUYER DESIGNATED ON THE PURCHASE ORDER. WHERE PERMISSION TO PERFORM REPAIRS IS REQUIRED, BUYER AUTHORIZATION SHALL BE OBTAINED PRIOR TO PERFORMING THE REPAIRS

D) SUBMERGED ARC WELDING OF HY-80/100 AND HSLA-80 STEELS:

1) ADDITIONAL PREHEAT/INTERPASS, HEAT SOAKING AND FLUX HANDLING REQUIREMENTS FOR SUBMERGED ARC WELDING OF HY-80/100 AND HSLA-80 STEELS ARE SPECIFIED IN EB-4906. CONTACT THE BUYER FOR COPIES OF ELECTRIC BOAT SPECIFICATIONS.

X) WELDER WORKMANSHIP TRAINING (WWT) APPLICABLE TO NAVSEA TECHNICAL PUBLICATION OR MILITARY STANDARD FABRICATION DOCUMENTS

A) WELDER WORKMANSHIP TRAINING SHALL COMPLY WITH EB-4186 APPENDIX A OR APPENDIX B, AS APPLICABLE. IF REQUESTED, THE BUYER CAN PROVIDE ADDITIONAL DOCUMENTATION TO THE SUPPLIER TO SUPPORT THIS TRAINING. COMPLIANCE WITH EB 4186 APPENDIX A OR APPENDIX B IS NOT APPLICABLE TO FABRICATORS THAT HAVE WELDER WORKMANSHIP PROCEDURES THAT ARE PREVIOUSLY APPROVED BY NAVSEA OR A NAVSEA AUTHORIZED REPRESENTATIVE.

B) NAVNDT CAN BE USED TO ASSIST IN CREATING A WELDER WORKMANSHIP TRAINING PROGRAM. THE COGNIZANT NDT LEVEL III MUST STILL VERIFY AND CERTIFY THAT THE PROGRAM IS IN ACCORDANCE WITH EB-4186, APPENDICES A OR B, AS APPLICABLE. FOLLOW SECTION VIII.D OF THIS STANDARD CLAUSE TO OBTAIN ACCESS TO NAVNDT.

XI) HUNTINGTON INGALLS INDUSTRIES NEWPORT NEWS SHIPBUILDING SUBMITTALS:

A) FOR PURCHASE ORDERS THAT ORIGINATE FROM NEWPORT NEWS SHIPBUILDING, REFER TO STANDARD CLAUSE 38-4 FOR SUBMITTAL OF ALL UNAPPROVED PURCHASE ORDER SOFTWARE DELIVERABLES.

B) SOFTWARE DELIVERABLES PREVIOUSLY APPROVED SHALL BE PROVIDED AS PART OF THE HARDWARE DELIVERABLES.

XII) COMMERCIAL WELDING / BRAZING:

A) COMMERCIAL WELDING / BRAZING SHALL BE PERFORMED IN ACCORDANCE WITH WRITTEN PROCEDURES APPROVED BY THE BUYER PRIOR TO THE START OF PRODUCTION. THIS REQUIREMENT DOES NOT APPLY WHERE SUBMITTAL / APPROVAL OF SUCH PROCEDURES IS EXPLICITLY EXEMPTED BY THE PURCHASE ORDER, PART DATA, OR PROCUREMENT SPECIFICATION, OR IS OTHERWISE SPECIFICALLY WAIVED BY THE BUYER VIA VIR.

B) COMMERCIAL STANDARD WELDING / BRAZING: DEFINED AS WELDING / BRAZING PERFORMED TO AN ESTABLISHED COMMERCIAL STANDARD, SUCH AS ABS, AWS, ASME BOILER & PRESSURE VESSEL CODE, ETC.

1) WHERE COMMERCIAL STANDARD WELDING / BRAZING IS SPECIFIED OR AUTHORIZED, ALL APPLICABLE REQUIREMENTS OF THE STANDARD SHALL BE MET.
2) COMMERCIAL STANDARD WELDING / BRAZING PROCEDURES AND SUPPORTING QUALIFICATION DATA (IF REQUIRED) SHALL STATE THE STANDARD AND REVISION USED.

3) PRE-QUALIFIED PROCEDURES ARE NOT EXEMPTED FROM THE SUBMITTAL AND APPROVAL REQUIREMENTS SPECIFIED IN SECTION XII.A.
4) THE SUPPLIER IS ADVISED THAT COMMERCIAL STANDARD PROCEDURES USED FOR WELDING OF TUBULAR JOINTS MAY REQUIRE ADDITIONAL QUALIFICATION.
5) FOR APPLICATIONS WHERE A DRAWING SPECIFIES WELD JOINT DESIGNS IN ACCORDANCE WITH MIL-STD-22, BUT AWS PRE-QUALIFIED WELDING PROCEDURES ARE TO BE USED, THE SUPPLIER SHALL SUBMIT A VIR TO THE BUYER TO OBTAIN VERIFICATION THAT THE PRE-QUALIFIED JOINT DESIGNS ARE EQUIVALENT TO THOSE SPECIFIED ON THE DRAWING. A COPY OF THE APPROVED VIR SHALL BE SUBMITTED WITH THE VPAR FOR THE PRE-QUALIFIED PROCEDURE.

C) COMMERCIAL BEST PRACTICE WELDING / BRAZING: DEFINED AS WELDING / BRAZING PERFORMED WITHOUT DIRECTION FROM ANY PARTICULAR SPECIFICATION, BASED ON SUPPLIERS KNOWLEDGE AND EXPERIENCE.

1) COMMERCIAL BEST PRACTICE WELDING / BRAZING PROCEDURES SHALL DEFINE ALL PARAMETERS NECESSARY TO PRODUCE A SOUND WELD, INCLUDING CLEANING PRIOR TO WELDING / BRAZING, AND WORKMANSHIP EXAMINATION REQUIREMENTS.
2) THE BUYER RESERVES THE RIGHT TO REQUEST TESTING IN ORDER TO PROVIDE OBJECTIVE QUALITY EVIDENCE THAT THE PROCEDURE WILL PRODUCE SATISFACTORY RESULTS.

D) WHERE COMMERCIAL STANDARD OR COMMERCIAL BEST PRACTICE WELDING / BRAZING IS SPECIFIED OR AUTHORIZED, THE SUPPLIER SHALL, AT A MINIMUM, ENSURE THAT BASE MATERIALS ARE CLEANED TO BRIGHT METAL FREE OF GREASE, PAINT, OIL, DIRT, RUST, OR OTHER CONTAMINANTS PRIOR TO WELDING / BRAZING, AND THAT A WORKMANSHIP EXAMINATION OF COMPLETED WELDS / BRAZES IS PERFORMED TO ENSURE FREEDOM FROM CRACKS, EXCESSIVE POROSITY, POOR FUSION, OR OTHER CONDITIONS DETRIMENTAL TO THE OPERATION OF THE HARDWARE, AND THAT ANY DRAWING-SPECIFIED WELD / BRAZE SIZE REQUIREMENTS ARE MET.

E) SUPPLIERS THAT ARE UNSURE OF WHETHER COMMERCIAL STANDARD OR COMMERCIAL BEST PRACTICE WELDING / BRAZING IS ALLOWED FOR A PARTICULAR APPLICATION SHOULD SUBMIT A VIR, THROUGH THE BUYER, TO THE COGNIZANT ELECTRIC BOAT COMPONENT ENGINEER FOR APPROVAL. WHERE APPROVED, A COPY OF THE VIR SHALL BE SUBMITTED WITH THE WELDING / BRAZING PROCEDURE VPAR.

XIII) EB TRANSFER OF WPS OR PQR ALLOWANCE

A) FOR EB PURCHASED MATERIAL, IF THE SUPPLIER IS IN NEED OF A WPS, UNDER LIMITED CONDITIONS A QUALIFIED PQR/WPS PACKAGE FROM ELECTRIC BOAT CAN BE TRANSFERRED TO THE SUPPLIER. THESE TRANSFERRED PQR/WPS WILL BE MANAGED ON A CASE BY CASE BASIS AND THE SUPPLIER SHOULD REQUEST THE BUYER TO PROVIDE EB SPECIFICATION 5877 FOR SPECIFIC GUIDANCE ON THE TRANSFER AND USE OF ELECTRIC BOAT TRANSFERRED PROCEDURES.

XIV) USE OF AWS NAVSEA SWPS-N PROCEDURES

A) FOR EB PURCHASED MATERIAL, NAVAL SEA SYSTEMS COMMAND (NAVSEA) CURRENTLY ALLOWS THE USE OF AMERICAN WELDING SOCIETY (AWS)-NAVSEA STANDARD WELDING PROCEDURE SPECIFICATIONS FOR NAVAL APPLICATIONS (SWPS-NS) FOR SHIP CONSTRUCTION IN LIEU OF FULL NAVSEA TECHNICAL PUBLICATION S9074-AQ-GIB-010/248 QUALIFICATION. EB HAS BEEN GIVEN PERMISSION TO ALLOW SUPPLIERS TO UTILIZE AWS-NAVSEA SWPS-NS. AWS AND

NAVSEA MAINTAIN A PROCEDURE LIBRARY OF PUBLISHED AWS-NAVSEA SWPS-NS. THEY CAN BE FOUND BY SEARCHING "AWS-NAVSEA" AT THE AWS ONLINE BOOKSTORE HTTP://PUBS.AWS.ORG. NEW "AWS-NAVSEA" PROCEDURES CONTINUE TO BE ADDED, THEREFORE, THIS WEBSITE SHOULD BE CHECKED OFTEN FOR NEW PROCEDURES. THE SUPPLIER SHOULD REQUEST THE BUYER TO PROVIDE EB SPECIFICATION EB-5877 FOR SPECIFIC GUIDANCE ON THE USE OF AWS NAVSEA SWPS-N PROCEDURES FOR THESE PRE-QUALIFIED WELDING PROCEDURES.

XV) COMPLIANCE REQUIREMENT STATEMENT

A) THE ABOVE REQUIREMENTS DO NOT RELIEVE THE SUPPLIER OF ITS RESPONSIBILITY TO COMPLY WITH THE REQUIREMENTS OF THE PURCHASE ORDER. ANY DEVIATIONS FROM OR REQUESTS FOR WAIVERS TO THE PURCHASE ORDER REQUIREMENTS MUST BE CLEARLY IDENTIFIED AND JUSTIFIED AS SUCH BY THE SUPPLIER AND MUST BE SUBMITTED FOR APPROVAL VIA A VIR AND APPROVED AS SOON AS POSSIBLE PRIOR TO THE START OF PRODUCTION.

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GENERAL DYNAMICS
Electric Boat

Purchase Order Standard Clauses

New Search

Number 60-86

Revision 4

Title CONTRACTING VENDOR NONDESTRUCTIVE SERVIC ES

Clause TITLE CONTRACTING VENDOR NONDESTRUCTIVE SERVICES

STANDARD CLAUSE 60-86 DETAILS THE REQUIRED INFORMATION THAT A VENDOR MUST PROVIDE WHEN A REQUEST FOR NONDESTRUCTIVE TESTING (NDT) SERVICES IS ISSUED IN DIRECT SUPPORT OF AN ELECTRIC BOAT (EBC) AUTHORIZED CONSTRUCTION CONTRACT TO PERMIT CERTIFICATION OF THE NDT PERFORMED.

APPLICABLE DOCUMENTS

THE FOLLOWING DOCUMENTS ARE APPLICABLE, UNLESS OTHERWISE SPECIFIED.

NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271 DATED 30 APRIL 1997 AS MODIFIED BY NOTICE 1 DATED 16 FEBRUARY 1999

NAVSEA TECHNICAL PUBLICATION T9074-AD-GIB-010/1688 DATED 1 MAY 1997

NAVSEA TECHNICAL PUBLICATION S9074-AR-GIB-010/278 DATED 1 AUGUST, 1995

MIL-STD-2035, REVISION A, DATED 15 MAY 1995

EB 3900 MODIFICATIONS TO MIL-STD-271 AND T9074-AS-GIB-010/271

STANDARD CLAUSE 60-67 NONDESTRUCTIVE TEST PROCEDURE APPROVAL

THE AMERICAN SOCIETY FOR NONDESTRUCTIVE TESTING (ASNT) RECOMMENDED PRACTICE NO. SNT-TC-1A (2011)

A. PERSONNEL AND EQUIPMENT

THE FOLLOWING ARE THE MANDATORY MINIMUM REQUIREMENTS EXPECTED OF A VENDOR IN SUPPORT OF A REQUEST TO PROVIDE EXPERIENCED NDT INSPECTION PERSONNEL TO SUPPORT CONSTRUCTION SCHEDULES AT THE LOCATION(S) AS DETAILED IN THE PURCHASE ORDER, UNLESS OTHERWISE SPECIFIED.

1. THE NDT METHOD(S) THAT MAY BE REQUIRED ARE LIQUID PENETRANT TESTING (PT), MAGNETIC PARTICLE TESTING (MT), PHASE ANALYSIS EDDY CURRENT (PAET), RADIOGRAPHY (RT), ULTRASONIC TESTING (UT), AND VISUAL TESTING (VT) OF COMPLETED FABRICATION WELDMENTS TO BE USED FOR THE INSPECTION OF NAVSEA TECHNICAL PUBLICATION T9074-AD-GIB-010/1688 AND NAVSEA TECHNICAL PUBLICATION S9074-AR-GIB-010/278 APPLICATIONS.

2. VENDOR PERSONNEL MUST BE CERTIFIED TO PERFORM THE REQUESTED NDT IN ACCORDANCE WITH THE REQUIREMENTS OF THE AMERICAN SOCIETY FOR NONDESTRUCTIVE TESTINGS RECOMMENDED PRACTICE SNT-TC-1A (2011) AS MODIFIED BY NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271, SECTION 1. LEVEL OF CERTIFICATION SHALL BE SUCH THAT THE INDIVIDUAL IS

PERMITTED TO MAKE SPECIFIC EVALUATIONS FOR ACCEPTANCE OR REJECTION DETERMINATIONS.

3. THE VENDOR WILL BE REQUIRED TO PROVIDE ON-SITE LEVEL III TEST EXAMINER OVERSIGHT OF THE TECHNICAL PERFORMANCE OF THEIR NDT PERSONNEL WHO PERFORM ACCEPTANCE INSPECTIONS AT A PERIODICITY OF EVERY SIX MONTHS. COPIES OF THESE PERFORMANCE OVERSIGHTS SHALL BE PROVIDED TO THE RESPONSIBLE HOST DEPARTMENT MANAGEMENT.

4. SUPERVISION OF NDT INSPECTORS, TECHNICAL DIRECTION FOR WORK, AND SHIFT ASSIGNMENTS WILL BE AT THE DISCRETION OF EBC MANAGEMENT.

5. THE VENDOR SHALL PROVIDE ALL THE EQUIPMENT AND CONSUMABLES NECESSARY TO PERFORM THE SPECIFIED NDT INSPECTIONS. THIS INCLUDES BUT IS NOT LIMITED TO AC YOKES, PAET EQUIPMENT, UT INSTRUMENTS, PENETRANT MATERIALS, ETC. ALL HAZARDOUS MATERIALS MUST BE APPROVED AND PROCESSED THROUGH THE EBC HAZMAT PROGRAM.

B. QUALITY ASSURANCE

PRIOR TO THE PERFORMANCE OF ANY INSPECTIONS, THE VENDOR IS REQUIRED TO PROVIDE THE FOLLOWING INFORMATION:

1. NDT PERFORMANCE PROCEDURES: THE VENDOR SHALL SUBMIT ALL NDT PERFORMANCE PROCEDURES ON A VENDOR PROCEDURE APPROVAL REQUEST (VPAR) TO THE BUYER FOR REVIEW AND APPROVAL PRIOR TO USAGE PER THE REQUIREMENTS OF STANDARD CLAUSE 60-67.

A. PROCEDURES SHALL MEET THE REQUIREMENTS OF NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271, AS MODIFIED BY EB SPEC 3900.

B. ALL PROCEDURE CHANGES OR REVISIONS SHALL BE RESUBMITTED FOR WRITTEN APPROVAL PRIOR TO USAGE.

C. FOR MULTIPLE OR REPETITIVE ORDERS THAT APPLY TO SIMILAR ITEMS, IT IS NOT ALWAYS NECESSARY TO SUBMIT VPARS FOR EVERY APPLICATION. PREVIOUSLY APPROVED PROCEDURES MAY BE USED PROVIDED THE CONDITIONS DETAILED IN STANDARD CLAUSE 60-67 ARE SATISFIED:

NOTIFICATION OF INTENT TO USE A PREVIOUSLY APPROVED PROCEDURE MUST BE SUBMITTED VIA VTDX TO THE BUYER PRIOR TO USAGE.

2. PERSONNEL CERTIFICATION PROCEDURE: THE VENDOR SHALL SUBMIT A COPY OF THE COMPANYS WRITTEN PRACTICE THAT GOVERNS THE CERTIFICATION OF NDT PERSONNEL ON A VPAR TO THE BUYER FOR REVIEW AND APPROVAL. ANY SUBSEQUENT PROCEDURE CHANGES OR REVISIONS SHALL BE RESUBMITTED FOR WRITTEN APPROVAL PRIOR TO USAGE.

A. THIS PROCEDURE SHALL BE IN ACCORDANCE WITH NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271, SECTION 1.6 AND THE GUIDELINES OF ASNT RECOMMENDED PRACTICE NO. SNT-TC-1A (2011) SHALL BE INVOKED AS MANDATORY MINIMUM REQUIREMENTS.

B. LEVEL III TEST EXAMINER(S) SHALL BE CERTIFIED BY EXAMINATION, WHICH SHALL INCLUDE A COMPANY SPECIFIC EXAMINATION AS REQUIRED BY NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271, PARAGRAPH 1.6.1.

C. ALL PERSONNEL SHALL BE RE-CERTIFIED BY EXAMINATION ONLY, AT INTERVALS NOT GREATER THAN 3 YEARS FOR LEVEL I AND II PERSONNEL AND 5

YEARS FOR LEVEL III TEST EXAMINERS.

D. LEVEL I AND II PERSONNEL SHALL BE ADMINISTERED AN OPERATIONAL EXAMINATION, AS A MINIMUM, IF THEY HAVE NOT PERFORMED PRODUCTION INSPECTIONS FOR A PERIOD OF 9 MONTHS.

E. THE JAEGER J1 VISION TEST SHALL BE ADMINISTERED ANNUALLY AND THE DOCUMENTATION MUST INDICATE IF CORRECTIVE AIDS ARE REQUIRED.

3. PERSONNEL CERTIFICATION RECORDS: THE VENDOR SHALL PROVIDE A COPY OF THE CERTIFICATION RECORD(S), BY NDT DISCIPLINE, FOR EACH INDIVIDUAL, INCLUDING THOSE OF THE RESPONSIBLE LEVEL III TEST EXAMINER(S), VIA VTDX TO THE BUYER FOR REVIEW PRIOR TO THE PERFORMANCE OF ANY PRODUCTION INSPECTIONS. UPDATED RECORDS SHALL BE PROVIDED AS RECERTIFICATION DATES BECOME DUE.

A. AS A MINIMUM, INDIVIDUAL CERTIFICATION RECORDS TO BE PROVIDED SHALL INCLUDE THE EYE TEST, EVIDENCE OF PERFORMANCE INSPECTIONS BEING CONDUCTED WITHIN THE LAST 9 MONTHS, AND EVIDENCE OF SATISFACTORY COMPLETION OF EXAMINATIONS.

B. THE VENDORS CERTIFICATION PRACTICE AND PERSONNEL RECORDS MAY BE THE SUBJECT OF AN ON-SITE AUDIT AT THE DISCRETION OF EBC MANAGEMENT.

C. REQUIRED DOCUMENTATION

UPON ARRIVAL AT THE JOB SITE, THE VENDOR IS REQUIRED TO PROVIDE COPIES OF THE FOLLOWING DOCUMENTATION TO THE EBC SITE MANAGEMENT REPRESENTATIVE:

1. THE VENDORS INSPECTION PROCEDURE(S) WITH THE APPROVING VPAR(S).

2. THE INSPECTOR(S) AND LEVEL III TEST EXAMINER(S) CERTIFICATION RECORDS.

3. EQUIPMENT QUALIFICATION FILES, AS APPROPRIATE. AS QUALIFICATION DATES BECOME DUE, THE FILES SHALL BE UPDATED AND MAINTAINED ON-SITE. COPIES OF THE FILES SHALL BE PROVIDED TO EBC UPON COMPLETION OF ALL THE REQUIRED INSPECTIONS.

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GENERAL DYNAMICS
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Purchase Order Standard Clauses

New Search

Number	SC-76-9HD
Revision	6
Title	TORQUE REQUIREMENTS TEST
Clause	

1 COPY OF TEST REPORTS SHOWING THE RESULTS OF TORQUE REQUIRMENTS TEST IS REQUIRED.

TEST REPORTS AND/OR OTHER VERIFICATION OF CONFORMANCE DOCUMENTS SHALL BE SIGNED AND DATED BY THE SELLER'S AUTHORIZED REPRESENTATIVE AND MUST INDICATE THE SPECIFICATION/DRAWING REVISION TO WHICH THE SPECIFIED TEST WAS PERFORMED.

EVIDENCE OF ALL TESTS AND INSPECTIONS PERFORMED AS REQUIRED BY THE SPECIFICATIONS MUST BE MAINTAINED BY THE SELLER. HOWEVER, RECORDS FOR ONLY THOSE TESTS REQUESTED ABOVE SHALL BE FORWARDED WITH THE SHIPMENT.

TEST REPORTS SHALL BE ATTACHED TO THE PACKING LIST. WHERE MORE THAN ONE CONTAINER OR PACKAGE IS INCLUDED IN THE SHIPMENT, THE TEST REPORTS SHALL BE ATTACHED SECURELY TO OR PLACED IN ONE CONTAINER OR PACKAGE AND CLEARLY IDENTIFIED ON THE OUTSIDE.

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GENERAL DYNAMICS
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Purchase Order Standard Clauses

New Search

Number 76-22L

Revision 1

Title NDT IAW COMPONENT DRAWING AND/OR SPECIFICATION

Clause

1 COPY TEST REPORTS SHOWING THE RESULTS OF ALL NDT REQUIRED BY THE COMPONENT DRAWING, AND/OR THE MATERIAL SPECIFICATION(S), IS REQUIRED. SELLER SHALL RECORD:

A. THE NDT METHOD/S USED.
B. DESCRIPTION OR UNIQUE IDENTIFICATION OF THE ITEM INSPECTED.
C. PROCEDURE INDENTIFICATION.
D. THE PERFORMING ACTIVITY, WHETHER IT BE THE SELLER, A SUB-TIER SUPPLIER OR A TEST LAB.
E. QUANTITY INSPECTED.
F. ACCEPTANCE STANDARD USED.
G. QUANTITY ACCEPTED/REJECTED.
H. DATE OF INITIAL INSPECTION AND INSPECTOR IDENTIFICATION.
I. SIGNATURE OF THE INSPECTOR

2. IN ADDITION, THE SELLER SHALL ATTACH A COPY OF THE BUYERS VPAR THAT APPROVED THE PROCEDURE TO THE TEST REPORT.

3. TEST REPORTS AND/OR OTHER VERIFICATION OF CONFORMANCE DOCUMENTS SHALL BE SIGNED AND DATED BY THE SELLERS AUTHORIZED REPRESENTATIVE.

EVIDENCE OF ALL TESTS AND INSPECTIONS PERFORMED AS REQUIRED BY THE SPECIFICATION MUST BE MAINTAINED BY THE SELLER; HOWEVER, RECORDS FOR ONLY THOSE TESTS REQUESTED ABOVE SHALL BE FORWARDED WITH THE SHIPMENT.

TEST REPORTS SHALL BE ATTACHED TO THE PACKING LIST. WHERE MORE THAN ONE CONTAINER OR PACKAGE IS INCLUDED IN THE SHIPMENT, THE TEST REPORTS SHALL BE ATTACHED TO OR PLACED IN ONE CONTAINER OR PACKAGE AND CLEARLY IDENTIFIED ON THE OUTSIDE.

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Purchase Order Standard Clauses

New Search

Number 76-24

Revision 8

Title REQMTS FOR RADIOGRAPHY-CASTINGS

Clause

ELECTRIC BOAT STANDARD CLAUSE 76-24
REQUIREMENTS FOR RADIOGRAPHY OF CASTINGS

1. ALL RADIOGRAPHY OF CASTINGS, WHEN INVOKED BY THIS PURCHASE ORDER OR ANY SUB-TIER DOCUMENTS MUST BE PERFORMED IN ACCORDANCE WITH AN APPROVED RSSS.

2. RADIOGRAPHY OF MORE THAN ONE CASTING PER FILM IS PROHIBITED

3. THE SELLER OR THE PERFORMING ACTIVITY SHALL CONTACT THE BUYER PRIOR TO PERFORMING RADIOGRAPHY OF ANY CASTING(S) TO DETERMINE IF A PREVIOUSLY APPROVED RSSS IS AVAILABLE. ELECTRIC BOAT HAS AN RSSS DATABASE WITH THOUSANDS OF APPROVED TECHNIQUES.

4. IF A PREVIOUSLY APPROVED RSSS IS NOT AVAILABLE, THE SELLER OR ACTIVITY PERFORMING THE RADIOGRAPHY SHALL PREPARE AN RSSS IN ACCORDANCE WITH NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271, PARAGRAPH 3.3.1.1 THAT ASSURES ADEQUATE RADIOGRAPHIC COVERAGE, AS SPECIFIED BY THE ENGINEERING DRAWING, AND TO AID IN THE PROPER INTERPRETATION OF THE RADIOGRAPHS. AS A MINIMUM, THE RSSS SHALL BE CREATED USING THE TEMPLATE COVER SHEET ATTACHED, A DRAWING WHICH SHOWS LOCATION MARKERS, FILM PLACEMENTS AND RADIATION DIRECTIONS IN RELATION TO THE PART, AND THE DRAWING VIEW THAT PROVIDES THE DESIGN DIMENSIONS USED TO DETERMINE MATERIAL THICKNESSES FOR PENETRAMETER SELECTION. THE SELLER SHALL FORWARD THE RSSS TO THE BUYER VIA SPARS (EVPAR), AS WELL AS ALL QUALIFYING RADIOGRAPHS. THE RSSS MUST BE APPROVED PRIOR TO SHIPMENT OF THE HARDWARE.

5. IF A PREVIOUSLY APPROVED RSSS IS AVAILABLE, THE SELLER OR ACTIVITY SHALL PERFORM THE RADIOGRAPHY IN ACCORDANCE WITH THE APPROVED RSSS. ADMINISTRATIVE CHANGES TO REFLECT THE USE OF LATEST REVISION OF THE PERFORMANCE OR FABRICATION SPECIFICATION DO NOT REQUIRE REAPPROVAL. HOWEVER, DEVIATIONS (EXCEPT AS NOTED BELOW) FROM AN APPROVED RSSS SHALL BE SUBMITTED TO THE BUYER FOR RE-APPROVAL USING A VIR HIGHLIGHTING THE CHANGES AND PROVIDING TECHNICAL JUSTIFICATION FOR EBC APPROVAL. ACCEPTABLE VARIATIONS OR SUBSTITUTIONS NOT REQUIRING REAPPROVAL ARE AS FOLLOWS:
* SOURCE TYPE. ANY SOURCE MAY BE SUBSTITUTED FOR THAT SHOWN ON THE RSSS PROVIDED THE MATERIAL THICKNESS VERSUS ENERGY RANGES USED ARE CONSISTENT WITH THOSE RECOMMENDED BY NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271, FIGURES 1, 2 AND 3. HOWEVER, IF THE APPROVED RSSS ALLOWS 2-4T SENSITIVITY, THIS QUALITITY LEVEL DOES NOT APPLY TO THE SOURCE SUBSTITUTED IF 2-2T IS REQUIRED.
* SOURCE SIZE.
* SOURCE STRENGTH (CURIES OR KV).
* SOURCE-TO-FILM DISTANCE.

* PENETRAMETER OR BLOCK MATERIAL GROUP. ONLY LOWER GROUP THAN REQUIRED (I.E. CASTING IS GR. IV, THE PREVIOUSLY APPROVED RSSS USED GR. I PENE?S/BLOCKS, A NEW RSSS USING GR. II OR GR.III DO NOT REQUIRE RE-APPROVAL)
* PENETRAMETER SIZE. ONLY SMALLER THAN APPROVED.
* BLOCK SIZE. ONLY THICKER THAN APPROVED.
* PENETRAMETER PLACEMENT. RELOCATING PENETRAMETERS FROM THE PART TO A REPRESENTATIVE BLOCK OF EQUAL OR GREATER THICKNESS, OR FROM A BLOCK TO THE PART.
* FILM SIZE, TYPE, AND QUANTITY.

6. A SYSTEM OF POSITIVE IDENTIFICATION OF THE FILM SHALL BE USED AND EACH FILM SHALL HAVE A UNIQUE IDENTIFICATION RELATING IT TO THE ITEM BEING INSPECTED. AS A MINIMUM, THE FOLLOWING ADDITIONAL INFORMATION SHALL APPEAR ON EACH RADIOGRAPH OR IN THE RECORDS ACCOMPANYING EACH RADIOGRAPH:
* IDENTIFICATION OF THE ORGANIZATION MAKING THE RADIOGRAPH.
* DATE OF EXPOSURE.
* UNIQUE IDENTIFICATION OF THE PART.
* WHETHER THE RADIOGRAPH IS OF THE ORIGINAL AREA OR A REPAIR AREA.

7. RADIOGRAPHY OF A REPAIRED AREA SHALL BE IN ACCORDANCE WITH THE SAME TECHNIQUE AS THAT USED FOR ORIGINAL RADIOGRAPHY. RADIOGRAPHS SHALL BE IDENTIFIED WITH THE SAME SERIAL NUMBER USED FOR ORIGINAL RADIOGRAPHS FOLLOWED BY THE LETTER R AND A NUMBER (1, 2, ETC.) TO INDICATE THE TIMES THE AREA INVOLVED HAS BEEN REPAIRED. (NOTE: ONLY ONE RT NUMBER PER CASTING IS PERMITTED).

8. ELECTRONIC VPAR SUBMITTALS OF A NEW SHOOTING SKETCH SHALL CONTAIN THE FOLLOWING INFORMATION IN THE DESCRIPTION OF DOCUMENT BLOCK FOR RECORDS PURPOSES.

1. A STATEMENT DESCRIBING THE PURPOSE OF THE SUBMITTAL, I.E. ?NEW SHOOTING SKETCH SUBMITTAL?.
2. PART NAME_____
3. PART NUMBER_____
4. DRAWING NUMBER_____
5. BASE MATERIAL TYPE_____
6. RT PROCEDURE IDENTIFIED BY PERFORMING ACTIVITY, NUMBER_____, REVISION, AND DATE (AND ANY ADDENDA)
7. RT PERFORMANCE SPECIFICATION
8. FABRICATION SPECIFICATION
9. ACCEPTANCE CRITERIA

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Purchase Order Standard Clauses

New Search

Number 76-57

Revision 6

Title ORIGIN OF TEST REPORTS FOR CHEMICAL MECHANICAL PROPERTIES

Clause

ORIGIN OF TEST REPORTS FOR CHEMICAL MECHANICAL PROPERTIES

THE TEST REPORTS FOR CHEMICAL AND MECHANICAL PROPERTIES REQUIRED ELSEWHERE IN THIS PURCHASE ORDER SHALL BE THOSE ISSUED BY THE ORIGINAL PRODUCER OF THE MATERIAL WHICH CERTIFY CONFORMANCE TO THE SPECIFICATION(S) INVOKED HEREIN.

IN CASES WHERE THE PRODUCER OR MELT SOURCE IS NOT A DOMESTIC SOURCE, THE COUNTRY OF ORIGIN SHALL BE INDICATED ON THE TEST REPORT, OR IF NOT IDENTIFIED, ANNOTATED ON THE TEST REPORT BY THE SUPPLIER. IF THE PRODUCER OR MELT SOURCE IS A DOMESTIC SOURCE, THE TEST REPORT SHALL BE CLEARLY INDICATED AS SUCH, OR ANNOTATED ON THE TEST REPORT BY THE SUPPLIER AS PRODUCED OR MELTED BY A DOMESTIC SOURCE (UNITED STATES OF AMERICA OR ITS OUTLYING AREAS).

IF THE MATERIAL RECEIVES SUBSEQUENT PROCESSING (I.E. HEAT TREAT, HOT OR COLD FORMING/WORKING ETC.) BY THE SUPPLIER OR HIS SUB-TIER SUPPLIER(S) TO MAKE IT CONFORM TO THE REQUIRED SPECIFICATION, THE TES REPORTS FOR THE MATERIAL IN ITS FINAL CONDITION (AS SUPPLIED TO THE BUYER) SHALL BE ACCOMPANIED BY A COPY(IES) OF THE ORIGINAL PRODUCER'S CERTIFICATION(S).

WHEN HEAT TREATMENT IS REQUIRED OR PERFORMED, A RECORD OF THE HEAT TREATMENT IS REQUIRED.

RECORDS OF HEAT TREATMENT SHALL INCLUDE AS A MINIMUM:

A. SPECIFIC TIMES AND TEMPERATURES.
B. QUANTITY OF ITEMS AND ITEM NAME.
C. DATE OF HEAT TREATMENT.
D. NAME OF THE ACTIVITY PERFORMING HEAT TREATMENT.
E. THE MATERIAL IDENTIFICATION THAT PROVIDES POSITIVE TRACEABILITY TO OBJECTIVE QUALITY EVIDENCE.

WHERE THE NUMBER OF TEST SPECIMENS IS DEPENDENT UPON THE ORIGINAL TOTAL LOT SIZE, THE VENDOR SHALL IDENTIFY THE ORIGINAL TOTAL LOT SIZE IN ADDITION TO THE QUANTITY SHIPPED TO ALLOW VERIFICATION DURING INDEPENDENT REVIEW THAT THE APPROPRIATE NUMBER OF TESTS WERE PERFORMED.

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New Search

Number 76-95

Revision 3

Title RADIOGRAPHIC FILM RETENTION BY ELECTRIC BOAT CORPORATION

Clause
ALL RADIOGRAPHS AND ATTENDANT RECORDS APPROVED BY THE PURCHASER
WILL BECOME THE PROPERTY OF THE PURCHASER
AND WILL BE PERMANENTLY RETAINED BY THE PURCHASER.
RADIOGRAPHS AND ATTENDANT RECORDS APPROVED AT THE SELLER'S PLANT
SHALL BE FORWARDED TO THE COGNIZANT BUYER, PURCHASING DEPARTMENT.

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New Search

Number 78-1A

Revision 4

Title SPCL TOOLING & SPCL TEST EQUIPMENT

Clause APPLICABLE TO PRIME CONTRACTS ISSUED ON OR AFTER JUNE 14, 2007 SPECIAL TOOLING AND SPECIAL TEST EQUIPMENT (HEREIN AFTER JOINTLY CALLED TOOLING) IS DEFINED IN FAR 2.101.

I. INITIAL PROCUREMENT

A. SELLER AGREES THAT IT WILL FABRICATE AND FURNISH TO BUYER (PURSUANT TO DELIVERY OR DISPOSITION) ALL TOOLING (INCLUDING ALL MODIFICATIONS THERETO) NECESSARY TO PRODUCE PARTS TO BE DELIVERED BY SELLER UNDER THE PURCHASE ORDER AS SPECIFIED IN THE SCHEDULE HERETO.

B. SELLER AGREES THAT TOOLING COSTS (FOR NEW OR REWORK OF EXISTING TOOLING) INCLUDED IN THIS PURCHASE ORDER SHALL BE SUBJECT TO AUDIT BY BUYER AND REVISION DOWNWARD ONLY, TO REFLECT FAIR AND REASONABLE REIMBURSEMENT TO SELLER FOR TOOLING COSTS BASED UPON SELLER'S ACTUAL TOOLING COSTS AND UPON BUYERS AUDIT. IN NO EVENT WILL SUCH REVISED AMOUNT EXCEED:

(1) SELLER'S ACTUAL TOOLING COSTS, OR

(2) THE AMOUNT OF TOOLING COSTS INCLUDED IN THIS ORDER, WHICHEVER IS LESS.

C. UPON COMPLETION OF TOOLING UNDER THIS PURCHASE ORDER, SELLER SHALL SUBMIT TO BUYER A VENDOR TOOL RECORD (VTR, 84-00-3156) PROVIDED HEREWITH OF ALL TOOLING REQUIRED TO FABRICATE/TEST SAID PARTS ALONG WITH AN ACTUAL DETAIL COST OF EACH TOOL AND DRAWING, SKETCHES OR PHOTOGRAPHS OF SAID TOOLING. SELLER SHALL ALSO INCLUDE A COPY OF THE GOVERNMENT LETTER APPROVING THEIR PROPERTY CONTROL SYSTEM OR, AT A MINIMUM, A COPY OF THEIR PROPERTY CONTROL PROCEDURE(S). AFTER THE PURCHASER APPROVAL OF VTR, SELLER SHALL INVOICE AND PAYMENT BE MADE FOR SAID TOOLING, AND TITLE TO THE TOOLING SHALL VEST IN THE BUYER OR THE GOVERNMENT AS SPECIFIED IN THE BUYER'S PRIME CONTRACT WITH THE GOVERNMENT.

D. SELLER AGREES NOT TO USE ANY ITEM OF TOOLING COVERED BY THIS PURCHASE ORDER EXCEPT IN THE PERFORMANCE OF PURCHASE ORDERS ISSUED BY BUYER. SELLER AGREES NOT TO INCLUDE IN THE PRICE FOR ANY SUCH PURCHASE ORDER THE COST OF THIS TOOLING OR ANY ALLOWANCES OR CHARGES TO COVER DEPRECIATION OR AMORTIZATION.

E. SELLER AGREES THAT IT WILL COMPLY WITH THE PROVISIONS OF THE FOLLOWING DOCUMENTS, WHICH BY THIS REFERENCE ARE INCORPORATED

HEREIN:
(1) "SELLERS TOOL REQUIREMENTS INSTRUCTION" (SEE BELOW).
(2) IF THE TOOLING IS GOVERNMENT PROPERTY, PARTS 45,52.245-1 AND 52.245-2 OF FAR SHALL PREVAIL IN THE EVENT OF INCONSISTENCY WITH THE ABOVE REFERENCED DOCUMENT.

F. SELLER SHALL REQUEST DISPOSITION INSTRUCTIONS FOR TOOLING AS SOON AS IT BECOMES KNOWN THAT THE TOOLING IS NO LONGER REQUIRED BY SELLER. BUYER AGREES TO PAY REASONABLE TRANSPORT CHARGES CONNECTED WITH DELIVERY OR DISPOSITION IN ACCORDANCE WITH BUYERS WRITTEN INSTRUCTION.

II. FOLLOW ON PRODUCTION
TOOLING REQUIRED FOR PERFORMANCE HEREUNDER IS FURNISHED TO SELLER UNDER BUYER'S PURCHASE ORDER. EXCEPT FOR SUCH ADDITIONAL TOOLING OR TOOLING MODIFICATION AS MAY BE SPECIFICALLY AUTHORIZED HEREIN, SELLER CERTIFIES THAT ADDITIONAL TOOLING OR TOOLING MODIFICATIONS IS NOT REQUIRED FOR PERFORMANCE HEREUNDER, AND THAT THE PRICE OF THIS PURCHASE ORDER DOES NOT INCLUDE ANY AMOUNT FOR TOOLING. IF CHARGES FOR TOOLING OR MODIFICATIONS THERETO ARE SPECIFIED HEREIN, TITLE TO SUCH TOOLING OR MODIFICATIONS SHALL VEST IN THE BUYER OR THE GOVERNMENT AS THE CASE MAY BE.

III. BUYER FURNISHED TOOLING

A. BUYER WILL FURNISH TO SELLER, ON A LOAN BASIS AND AT NO CHARGE, THE TOOLING REFERENCED IN THIS ORDER (WITH SUCH MODIFICATIONS AS MAY HAVE BEEN REQUESTED BY SELLER AND AGREED TO BY BUYER) FOR SUCH USE, IF ANY, AS SELLER REASONABLY MAY ELECT TO MAKE OF SUCH TOOLING FOR THE SOLE PURPOSE OF PERFORMANCE AGAINST THIS ORDER. UPON REQUEST, BUYER WILL ADVISE SELLER WHERE PURCHASER-FURNISHED TOOLING MAY BE EXAMINED. BUYER ASSUMES NO RESPONSIBILITY OF ANY KIND FOR THE ACCURACY OR SUITABILITY OF SUCH TOOLING FOR THE PURPOSES OF THIS ORDER. BY HIS ACCEPTANCE AND USE OF SUCH TOOLING, SELLER EXPRESSLY ASSUMES THE ENTIRE RISK OF THEIR ACCURACY AND SUITABILITY AND THEREFORE CAUTIONED TO TAKE NECESSARY STEPS TO ASSURE SAME BEFORE USING THEM. THE FURNISHING OF SUCH TOOLING BY BUYER, UNDER THE CONDITIONS SET FORTH ABOVE, SHALL NOT IN ANY WAY, RELIEVE SELLER OF COMPLETE RESPONSIBILITY FOR FURNISHING THE SUPPLIES COVERED BY THIS ORDER IN STRICT ACCORDANCE WITH THE DRAWINGS AND SPECIFICATIONS AND ALL OTHER REQUIREMENTS OF THIS ORDER. SELLER MAY NOT USE BUYER FURNISHED TOOLING TO ACCOMPLISH WORK FOR OTHER CUSTOMERS WITHOUT EXPRESS WRITTEN CONSENT OF BUYER.

B. THE TOOLING DETAILED IN THIS ORDER IS GOVERNMENT-OWNED OR PURCHASER-OWNED. SELLER AGREES THAT IT WILL COMPLY WITH THE PROVISIONS OF THE FOLLOWING DOCUMENTS:
(1) "SELLERS'S TOOL REQUIREMENTS INSTRUCTION" (SEE BELOW).
(2) IF THE TOOLING IS GOVERNMENT PROPERTY, PARTS 45,52.245-1 AND 52.245-2 OF FAR SHALL PREVAIL IN THE EVENT OF INCONSISTENCY WITH THE ABOVE REFERENCED DOCUMENT.
(3) THE SELLER AGREES TO ASSUME THE RISK OF LIABILITY FOR LOSS, DAMAGE OR DESTRUCTION OF GOVERNMENT PROPERTY IN THEIR POSSESSION IN ACCORDANCE WITH FAR PROPERTY CLAUSE 52.245-2 WHEN INVOKED.

IV. SELLER'S TOOL REQUIREMENTS INSTRUCTION

SELLERS SHOULD BE PREPARED TO SHOW POSITIVE EVIDENCE OF THE FOLLOWING:

A. PROCEDURES

THE SELLER SHALL ESTABLISH AND MAINTAIN A SYSTEM TO CONTROL, PROTECT, PRESERVE AND MAINTAIN ALL GOVERNMENT-OWNED AND PURCHASER-OWNED PROPERTY WHILE IN HIS POSSESSION. THE PROPERTY CONTROL SYSTEM SHALL BE IN WRITING AND WILL BE SUBJECT TO REVIEW BY PURCHASER. A COPY OF SELLER'S GOVERNMENT PROPERTY CONTROL PROCEDURE SHALL BE SUBMITTED TO THE BUYER.

B. IDENTIFICATION

PHYSICAL MARKING OF SPECIAL TOOLING AND/OR SPECIAL TEST EQUIPMENT WILL BE AS FOLLOWS:

(1) A SEVEN-DIGIT IDENTIFICATION NUMBER ALONG WITH A PREFIX STARTING WITH "USN8" OR "EB8" WILL BE STAMPED OR ETCHED ONTO A NAMEPLATE ATTACHED TO THE SURFACE OF THE TOOL IN A LEGIBLE, PERMANENT, CONSPICUOUS, TAMPERPROOF METHOD. ALSO, THE TOOL MUST BE STAMPED WITH THE SAME SEVEN-DIGIT IDENT-IFICATION NUMBER SO THAT IT CAN BE MATCHED WITH THE NAMEPLATE, SHOULD THEY BECOME SEPARATED.

(2) IN INSTANCES WHERE IT IS IMPRACTICAL TO USE METHODS LISTED ABOVE, ALTERNATIVE METHODS MAY BE IMPROVISED, I.E., A SMALL HOLE MAY BE DRILLED THROUGH THE TOOL FOR ATTACHMENT OF A STOCK NAMEPLATE BY WIRE. THIS HOLE, HOWEVER, MUST BE IDENTIFIED AS A TAG ATTACHMENT HOLE BY SHOWING A PROMINENT "T" NEXT TO IT. ALSO, THE TOOL MUST BE MARKED WITH THE SEVEN-DIGIT IDENTIFICATION NUMBER SO THAT IT CAN BE MATCHED WITH THE NAMEPLATE, SHOULD THEY BECOME SEPARATED.

(3) THE IDENTIFICATION NUMBER (USN8000000 OR EB8000000) WILL BE PROVIDED TO THE SELLER IN THE COLUMN "FOR THE PURCHASER USE ONLY" ON THE COMPLETED VENDOR TOOL RECORD (FORM 84-00-3156) RETURNED TO SELLER UPON APPROVAL/PAYMENT OF THE SPECIAL TOOL AND/OR SPECIAL TEST EQUIPMENT.

C. TOOLING INVENTORY AND RECORD REQUIREMENTS

THE SELLER SHALL MAINTAIN AT ALL TIMES A CURRENT INVENTORY LISTING AND RECORD OF ACCOUNTABILITY OF THE PURCHASER AND/OR GOVERNMENT-OWNED TOOLS LOCATED AT SELLER'S FACILITY OR AT THE FACILITY OF HIS SUBCONTRACTOR. UPON REQUEST, THE INVENTORY RECORDS OF ALL PURCHASER-OWNED AND/OR GOVERNMENT-OWNED TOOLS SHALL BE SUBMITTED TO THE PURCHASER. READILY ACCESSIBLE FILES OF DOCUMENTS AND OTHER DOCUMENTS ARE REQUIRED TO SUPPORT THE ACTIVITIES DESCRIBED IN PARAGRAPHS A THROUGH K, AS WELL AS SUCH OTHER PROPERTY RECORDS AS MAY BE REQUIRED UNDER THE PURCHASE AGREEMENT. ORDINARILY, THE PROPERTY RECORD FOR EACH ITEM OF SPECIAL TOOLING AND SPECIAL TEST EQUIPMENT WILL INDICATE THE FOLLOWING:

(1) PURCHASE ORDER NUMBER
(2) NOMENCLATURE/DESCRIPTION
(3) QUANTITY RECEIVED OR FABRICATED

(4) LOCATION OR DISPOSITION
(5) UNIT PRICE (AS REQUIRED)
(6) POSTING REFERENCES FOR EACH TRANSACTION
(7) IDENTIFICATION NUMBER (SEVEN-DIGIT NUMBER PREFIXED BY USN OR EB) OR AS DESIGNATED BY THE PURCHASER
(8) USAGE INFORMATION (WHEN USED)
(9) ITEM ON WHICH USED

D. ACQUISITION

THE SYSTEM SHOULD HAVE THE ABILITY TO SHOW THE AUTHORITY BY WHICH THE PROPERTY WAS ACQUIRED. SUCH AUTHORIZATION USUALLY CONSISTS OF A FULLY EXECUTED VENDOR TOOL RECORD (FORM 84-00-3156) AND THE PURCHASE ORDER.

E. MAINTENANCE AND PROTECTION

AN EFFECTIVE PROGRAM FOR PREVENTIVE AND REPAIR MAINTENANCE FOR PROTECTION OF SPECIAL TOOLING AND SPECIAL TEST EQUIPMENT IN ACCORDANCE WITH SOUND INDUSTRIAL PRACTICES IS REQUIRED INCLUDING RECORDS OF SUCH ACTIONS.

F. ALTERATION AND/OR REIDENTIFICATION

NO TOOL SHALL BE ALTERED OR REIDENTIFIED IN ANY MANNER BY THE SELLER WITHOUT PRIOR WRITTEN APPROVAL BY THE BUYER.

G. LOSS, DAMAGE OR DESTRUCTION

THE SELLER SHALL REPORT TO THE PURCHASER ALL CASES OF LOSS, DAMAGE OR DESTRUCTION OF ELECTRIC BOAT OR GOVERNMENT-OWNED TOOLING IN HIS POSSESSION OR CONTROL (INCLUDING SUCH TOOLING IN THE POSSESSION OR CONTROL OF HIS SUBCONTRACTOR) AS SOON AS THE FACT BECOMES KNOWN.

AS SOON AS FACTUAL DATA CAN BE OBTAINED, THE FOLLOWING INFORMATION SHALL BE SUBMITTED.

(1) SELLERS NAME AND PURCHASE ORDER,
(2) DESCRIPTION OF ITEMS LOST, DAMAGED, DESTROYED OR UNREASONABLY CONSUMED,
(3) COST OF TOOLING LOST, DAMAGED, ETC.
(4) DATE, TIME (IF PERTINENT) AND CAUSE OR ORIGIN OF THE LOSS, DAMAGE, ETC.,
(5) KNOWN INTERESTS IN ANY COMMINGLED TOOLING OF WHICH PURCHASER-OWNED OR GOVERNMENT-OWNED TOOLING LOST, DAMAGED, ETC., IS (OR WAS) A PART,
(6) INSURANCE, IF ANY, COVERING THE TOOLING AND
(7) ACTIONS TAKEN BY THE SELLER TO PREVENT REPETITION OF SIMILAR INCIDENTS.

H. INACTIVE TOOLS

THE SELLER AND/OR HIS SUBCONTRACTOR WHO HAS IN HIS POSSESSION TOOLS WHICH HAVE BECOME INACTIVE SHALL OBSERVE THE FOLLOWING;

(1) PREPARE A LETTER TO THE PURCHASER REQUESTING DISPOSITION OF THE TOOLS LISTED, AND
(2) STATING THE LENGTH OF TIME THAT THE TOOLS HAVE BEEN

INACTIVE

SELLER SHALL NOT TRANSFER OR OTHERWISE DISPOSE OF ANY TOOL WITHOUT SPECIFIC WRITTEN AUTHORITY FROM THE PURCHASING BUYER.

I. PHYSICAL INVENTORIES

THE SELLER SHALL ANNUALLY (IN THE SECOND QUARTER OF THE YEAR) PHYSICALLY INVENTORY ALL PURCHASER-OWNED AND GOVERNMENT OWNED PROPERTY IN HIS POSSESSION AND SHALL CAUSE SUBCONTRACTORS TO DO LIKEWISE. RESULTS OF PHYSICAL INVENTORIES SHALL BE FORWARDED TO THE PURCHASER AND SHALL INCLUDE:

(1) A LISTING (BY ID NUMBER) OF ALL ITEMS INVENTORIED WITH WRITTEN CERTIFICATION THAT THE ITEMS WERE SIGHTED, AND
(2) A LISTING OF DISCREPANCIES NOTED.

J. CONTRACT CLOSEOUT

THE SELLER SHALL REPORT, INVESTIGATE, AND SECURE CLOSURE OF ALL LOSS, THEFT, DAMAGE, OR DESTRUCTION CASES; PHYSICALLY INVENTORY ALL PROPERTY UPON TERMINATION OR COMPLETION OF THIS CONTRACT; AND REQUEST DISPOSITION OF ITEMS AT THE TIME THEY ARE DETERMINED TO BE EXCESS TO CONTRACTUAL NEEDS.

K. SUBCONTRACTOR CONTROL

THE SELLER SHALL REQUIRE ANY OF HIS SUBCONTRACTORS TO COMPLY WITH THIS INSTRUCTION AND FAR PARTS 45, 52.245-1 AND 52.245-2 (ONLY WHEN GOVERNMENT PROPERTY IS INVOLVED).

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GENERAL DYNAMICS
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Purchase Order Standard Clauses

New Search

Number	SC-EB3900
Revision	5
Title	MODIFICATIONS TO MIL-STD-271 AND T9074-AS-GIB-010/271
Clause	ELECTRIC BOAT CORPORATION SPECIFICATION 3900 REVISION D FORMS A PART OF THIS ORDER. THE PROVISIONS OUTLINED IN THIS EB SPECIFICATION IDENTIFY SPECIFICS RELATED TO PROCESSES, MARKING, TESTS AND CERTIFICATION DOCUMENTS WHICH MAY OR MAY NOT BE IDENTIFIED ELSEWHERE IN THIS ORDER, AND REQUIRE COMPLIANCE ON THE PART OF THE SUPPLIER OF MATERIAL DELIVERED TO THE BUYER.

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