



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.

Seller shall flow down the substance of this provision to all of its suppliers for the procurement of materials contained within this Pervasive Commodity provision in each sub-tier purchase order.

Manufacturers, Distributors, Primes, & etc. must submit a VIR for approval to use a manufacturer who is not on the Pervasive List. Mechanical (post heat-treat final conditions) and chemical test reports are to be submitted with the VIR for NNS Engineering approval.

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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. Approval is provided for the supplier source, supplier number and location identified as listed. If a location is not listed, that location is not approved. 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/



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Supplier #	Supplier	Location	Telephone
ST0002	Badger Alloys	Milwaukee, Wisconsin 53208	(414) 258-8200
ST0006	Bridesburg Foundry Company	Whitehall, PA 18052	(610) 266-0900
122659	Delta Centrifugal, LLC (Centrifugal Castings only)	Temple, TX 76504	(254) 410-7360
123816	Effort Foundry	Bath, PA 18014	(610) 837-1837
27514A	Federal Bronze Casting Industries, Inc	Newark, NJ 07105	(973) 589-7575
108913	Johnson Brass & Machine Foundry, dba Johnson Centrifugal Technology (Centrifugal Castings only)	Saukville, WI 53080	(262) 377-9440
	Deleted - Lee Brass Foundry LLC		
87195B	Metaltek International, Wisconsin Centrifugal Division	Waukesha, WI 53188-3898	(262) 544-7824
ST0036	Stainless Foundry and Engineering Inc.	Milwaukee, Wisconsin 53209	(414) 462-7400
	Deleted - West Philadelphia Bronze Corporation		
86558A	Wollaston Alloys, Inc. - CPP Boston	Braintree, MA 02184	(781) 848-3333
Table Revision - 01-31-2024 - Changes Boldfaced			

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.

In addition to using one of these approved manufacturers, Seller shall flow down the additional CuNi 70/30 casting requirements from the previous page so that the manufacturer is aware that those additional NNS/EB requirements are applicable.

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