



Newport News  
Shipbuilding  
A Division of HII

# memo

To: Newport News Shipbuilding (NNS) Suppliers and Manufacturers

From: Newport News Shipbuilding Supplier Quality

Date: November 2023

Subject: Quality Alert - Welding and Weld Procedure Approval

Enclosure: NNS Coded Note W3030 Revision C005 dated May 12, 2020

Dear Valued Supplier,

In recent and past history, suppliers have sent material to NNS where welding was performed without the required NNS authorization. You are receiving this alert because your company supplies material to NNS where welding must be authorized by NNS prior to performing the weld, whether by your company or a subcontracted company. Supplying material with unauthorized welds causes major delays and rework to NNS and the Navy customer to evaluate the non-conformance for weld effectiveness in ensuring the safety of Navy personnel that rely on the quality of the weld.

The enclosed NNS coded note W3030 prohibits any welding/brazing without written approval from NNS. Requests to weld/braze must be submitted to NNS on a Vendor Information Request (VIR) and include the weld/braze procedure and procedure qualification record (PQR).

AFTER the weld procedure and PQR are approved, W3030 authorizes certain minor and nominal weld repairs using the applicable NNS-approved weld procedure, provided the material specifications explicitly allow the weld repair and the Purchase Order does not otherwise prohibit the weld repair.

Per W3030, if your company or a welding subcontractor does not have NNS approval of the weld procedure for performing the weld repair, that weld shall not be performed regardless of any other specification requirement that might otherwise allow welding.

For example, S9074-AR-GIB-010/278 Section 13.2.5 "Authority for repair of castings" states minor repairs may be made at the discretion of the supplier/foundry. W3030 prohibits these welds without an NNS approved weld procedure.

NNS PO Notes W3030, W4020, LI068, LI069, 60-77, and EB2678 are several notes that require NNS approved welding procedures prior to welding. Regardless of other specification requirements, the applicable weld procedure MUST be approved prior to welding.

If your company or your subcontractor has supplied material with a weld performed without using an NNS-approved weld procedure and without the required NNS authorization, please submit a Letter of Advisement including the NNPN, PO, and Line Item for NNS engineering to evaluate the technical impact to the safety of the weld for US Navy service.

Instructions for submitting an LOA are attached. Please submit LOA's to [LettersofAdvisement@hii-nns.com](mailto:LettersofAdvisement@hii-nns.com).

Your company is expected to review and confirm whether unauthorized welding by you or a subcontractor have occurred on material shipped from your company to NNS. If your review determines an LOA needs to be submitted, the LOA will be expected immediately. **NNS expects completion of the review and LOA submissions no later than 1/15/2024.**

If you have any questions or concerns regarding this Alert, please contact Aaron Loehr, NNS Supplier Quality Engineer, at [Aaron.J.Loehr@hii-nns.com](mailto:Aaron.J.Loehr@hii-nns.com) or phone (757) 380-3463.

Thank you for your efforts and support as an essential component of building safe and reliable ships for the US Navy and for our national security. Never forget the importance of your work to the safety of our sailors and our country.

Sincerely,

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R. L. Simpson  
Manager, NNS Supplier Quality

Coded Note Number: **W3030**

Revision: **C005**

Date: **May 12, 2020**

Title: **NO WELDING/BRAZING WITHOUT AUTHORIZATION**

## **1.0. Fabrication**

- 1.1. No welding/brazing fabrication of any kind is authorized without written approval from NNS.
- 1.2. Requests to fabricate via welding/brazing are to be submitted to NNS for approval via a Vendor Information Request (VIR). VIR shall include the applicable welding/brazing procedure and procedure qualification records/reports (PQR). Purchase Order (PO) Appendix K applies.

## **2.0. Weld Repair**

- 2.1. Base Metal. Minor weld repair of base metal, as defined in NAVSEA Technical Publication S9074-AR-GIB-010/278, is authorized provided all the following conditions are met:
  - 2.1.1. An NNS approved weld repair procedure in accordance with the applicable fabrication specification as modified by PO Appendix K is used.
  - 2.1.2. The weld repair is specifically permitted by the weld repair procedure, fabrication specification, equipment/material specification, or approved drawing.
  - 2.1.3. Weld repair is not otherwise restricted within the PO.
- 2.2. Castings. Minor and nominal weld repair of castings, as defined in NAVSEA Technical Publication S9074-AR-GIB-010/278, is authorized provided the the following conditions are met:
  - 2.2.1. An NNS approved weld repair procedure in accordance with the applicable fabrication specification as modified by PO Appendix K is used.
  - 2.2.2. The weld repair is specifically permitted by the weld repair procedure, fabrication specification, equipment/material specification, or approved drawing.
  - 2.2.3. Weld repair is not otherwise restricted within the PO.
  - 2.2.4. For nominal repairs, the casting identification number, welding procedure number or title, welder identification, and name of the

authorized representative are recorded and documentation retained as required in NAVSEA Technical Publication S9074-AR-GIB-010/278.

2.3. Weld repair procedures and PQRs are to be submitted to NNS for approval via a VIR, as necessary. PO Appendix K applies.

2.4. When base metal or casting weld repair has been determined necessary, yet the fabrication specification, equipment/material specification, or approved drawing doesn't cover weld repair or doesn't specifically permit weld repair, a VIR must be submitted to NNS for approval. PO Appendix K applies.

Revision History Table		
Rev	Description	Revision Date
C005	Correction of font color and syncing the revision dates	05/12/2020
C004	<p><u>Added:</u></p> <ol style="list-style-type: none"> <li>Verbiage clarifying requirements regarding NNS authorization to perform minor repair on base metal and minor and nominal repair of castings.</li> </ol> <p><u>REVISED:</u></p> <ol style="list-style-type: none"> <li>The title was revised to include brazing.</li> <li>Coded Note re-written / reorganized.</li> <li>Verbiage providing authorization to perform weld repair on base metal or castings using NNS approved procedures, "except where specifically restricted" verbiage changed to "where specifically permitted".</li> </ol> <p><u>REMOVED:</u></p> <ol style="list-style-type: none"> <li>Removed "the government" as a procedure approval agent.</li> <li>Removed sentence regarding "Level I" material requiring NDT procedures be submitted for NNS approval when subject to weld repair.</li> <li>Removed sentence regarding all requirements contained herein apply to each level of the supply chain.</li> </ol> <p>REASONS: (1) To differentiate between weld repair of base metal and castings. Weld repair on base metal not defined as minor is not authorized and requires submittal of a VIR for NNS approval. Special repair, as defined in NAVSEA Tech Pub 278, of castings is not authorized and requires submittal of VIR for NNS approval.(2) Brazing is discussed in the note but was not included in the title; (3) To simplify/clarify requirements, organize to clearly differentiate fabrication welding and base metal weld repair. (4) The "except where specifically restricted" verbiage could be misconstrued to authorize weld repair when NNS does not intend to (e.g. specification, drawing or purchase order does not address weld repair, neither restricting it or permitting it) (5) weld repair procedures approved by the government would not include any NNS Appendix K modifications to the associated fabrication</p>	05/06/2020

specification and may not align with the document revision(s) required by NNS Appendix K. (6) Coded Note is about fabrication welding and base metal weld repair, NDT procedure requirement is out of place. (7) Requirement is conveyed to vendors in Coded Note E1010, and is not limited to welding requirements.

**This revision history is provided for convenience and does not alleviate the supplier's responsibility with understanding and complying with the full coded note.**