



NDT Supplier Bulletin

SNB-0037
May 2026



Standard Clause 60-67 Revision 28 Changes

REFERENCES

- (a) Electric Boat Purchase Order Standard Clause 60-67, Revision 28, “Nondestructive Test Procedure Approval
- (b) NAVSEA Technical Publication T9074-AS-GIB-010/271 Revision 0, ACN-1, Dated February 16, 1999, “Requirements for Nondestructive Testing Methods”
- (c) NAVSEA Technical Publication T9074-AD-GIB-010/1688 Revision 1, Dated July 13, 1999, “Requirements for Fabrication, Welding, and Inspection of Submarine Structure”
- (d) NAVSEA Technical Publication S9074-AR-GIB-010A/278 Revision 0 Change A, Dated February 14, 2013, “Requirements for Fabrication Welding and Inspection, and Casting Inspection and Repair for Machinery, Piping, and Pressure Vessels”
- (e) MIL-STD-2035 Revision A, Dated July 4, 1991, “Nondestructive Testing Acceptance Criteria”

ENCLOSURE:

- (1) Highlighted Changes to SC 60-67 Revision 28

DISCUSSION

In December 2025, Electric Boat (EB) updated Standard Clause 60-67 to revision 28. Within this revision, there are several new additions and changes compared to the previously issued revisions. The purpose of this bulletin is to explain the changes made and to provide more discussion on Standard Clause (SC). Additionally, Enclosure (1), attached at the end of this bulletin, outlines the sections of Reference (a) that have been changed as highlighted in yellow.

Within each Purchase Order (PO), effective for POs after 6/1/25, revisions for SC are now based upon effective date and not the revision number. At a minimum, suppliers are required to work the revision of the SC corresponding to the effective date, but suppliers are authorized to work in accordance with any newer SC revision. The SC effective date is available on gdeb.com/supplier website under “Standard Clauses”. Any questions regarding this should be directed to the supplier’s EB Buyer.

Changes in Reference (a) in general include adding clarifying language to NDT requirements, discussing effective specifications of related NAVSEA Technical Publications, clarifying the use of approved revisions

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of procedures, clarifying Vender Procedure Approval Request (VPAR) submittals, and expanding allowances for previously approved procedures.

Notable changes to Reference (a) section (A) were added in paragraph's A(6)-A(9). These changes detail that suppliers shall work to the most recently approved procedure revision from a VPAR. Each VPAR approval will supersede the previous procedure's revision. A(7) details that supplier's shall be responsible for obtaining the latest revision used by sub-tiers for approval and sub-tiers shall notify the prime supplier of any changes made.

Notable changes to Reference (a) section (B) were made to clarify that References (b), (c), (d), and (e) have the effective revision in accordance with EB-5341 and that a component specification takes precedence in the case of a conflict.

Notable changes to Reference (a) section (C) were made to provide clarification on VPAR submittals. Previously SC-60-67 section (C) was written for paper VPAR submittals. This has been updated for electronic submittals in Shipbuilding Partners and Suppliers (SPARS). Paragraph C(1) now requires that each procedure and applicable addendum, scan plan, or technique sheet be submitted on separate VPARS. Paragraph C(2) now provides more details on how to fill out the VPAR request and the pertinent information required to be included.

Minor changes to Reference (a) section (D) were made that require the RT acceptance criteria to be self contained within the procedure unless reference radiographs are being used.

Minor changes to Reference (a) section (G) were made to include changes to Alloy Identification Procedure Review.

Notable changes to Reference (a) section (I) include the process for submittal of procedures previously approved by Electric Boat, Newport News Shipbuilding (NNS), and Bechtel Plant Machinery, Inc. (BPMI) to be accepted by all three organizations for both Colombia and Virginia programs given the procedure meets the detailed criteria in Reference (a) paragraph I(4.A).

Suppliers are requested to share this bulletin with any sub-tiers that perform NDT services.

Any questions regarding the content of this Quality Bulletin should be forwarded to Electric Boat NDT Supplier Support Group at EBSupplierNDTSupport@gdeb.com.

This bulletin is considered to be within the scope of each of the Electric Boat purchase orders awarded to your company and no changes in the price, terms, or schedule of the purchase orders are authorized as a result of this bulletin.

This bulletin has been reviewed and approved by the manager of the Welding and NDT Engineering – Suppliers and Strategic Sourcing.

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Highlighted Changes to SC 60-67 Revision 28

GENERAL DYNAMICS

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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) THIS STANDARD CLAUSE DOES NOT BY ITSELF REQUIRE NONDESTRUCTIVE TESTING TO BE PERFORMED. NONDESTRUCTIVE TESTING PROCEDURES ARE ONLY REQUIRED TO BE SUBMITTED IN ACCORDANCE WITH THIS STANDARD CLAUSE WHEN NONDESTRUCTIVE TESTING IS REQUIRED BY THE PROCUREMENT DOCUMENTS (E.G., MATERIALS SPECIFICATIONS, EB SPECS, PART DRAWINGS, ETC.).
- 2) ALL RADIOGRAPHY, MAGNETIC PARTICLE, LIQUID PENETRANT, ULTRASONIC, EDDY CURRENT, AND VISUAL TESTING MUST BE PERFORMED IN ACCORDANCE WITH WRITTEN PROCEDURES APPROVED BY THE BUYER.
 - A) VISUAL TESTING, AS IT PERTAINS TO THIS STANDARD CLAUSE, IS ONLY APPLICABLE TO THE INSPECTION OF COMPLETED FABRICATION WELDMENTS.
- 3) ALL PROCEDURES SHALL BE UNIQUELY IDENTIFIED BY A PROCEDURE NUMBER, WITH A REVISION AND DATE.
- 4) 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.
- 5) 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.
- 6) SUPPLIERS SHALL PERFORM WORK TO THE MOST RECENT APPROVED REVISION OF THEIR PROCEDURE LISTED IN THE CORRECTIVE ACTION BLOCK FOR ELECTRONIC VPARS. EACH VPAR APPROVAL FOR A NEW PROCEDURE REVISION SUPERSEDES THE PREVIOUS REVISION APPROVAL.
 - A) 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. THE VIR SHALL PROVIDE JUSTIFICATION FOR USING THAT REVISION OF THE PROCEDURE.
- 7) SUPPLIERS SHALL CONTACT SUB-TIER NDT PROVIDERS TO OBTAIN THE LATEST REVISION OF THE TESTING PROCEDURE PRIOR TO BEING SUBMITTED FOR APPROVAL. SUB-TIER NDT PROVIDERS SHALL NOTIFY THE SUPPLIER OF ANY NEW REVISIONS TO NDT PROCEDURES THAT ARE UTILIZED FOR TESTING PRODUCTS WITH THIS STANDARD CLAUSE INVOKED FOLLOWING SECTION I FOR PREVIOUSLY APPROVED PROCEDURES.
- 8) IF A VPAR APPROVAL IS RESCINDED, USE OF A PREVIOUSLY APPROVED REVISION OF THE PROCEDURE IS NOT AUTHORIZED.
- 9) ATTACHMENTS, ADDENDAS AND SUPPLEMENTS SHALL NOT BE USED TO MAKE CORRECTIONS OR REVISIONS TO A BASE PROCEDURE.
 - A) ATTACHMENTS, ADDENDAS, AND SUPPLEMENTS TO PROCEDURES SHALL ONLY BE USED TO INCLUDE SPECIFIC INSTRUCTIONS (SCAN PLANS, TECHNIQUE CARDS, ETC.) AND ACCEPTANCE CRITERIA.

B) NDT PERFORMANCE SPECIFICATIONS

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- 1) WHERE REFERENCE IS MADE TO THE FOLLOWING PERFORMANCE SPECIFICATIONS, THE EFFECTIVE ISSUES SHALL BE AS FOLLOWS
 - A) MIL-STD-271 SHALL BE NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271, REVISION F MAY ONLY BE USED AS PERMITTED IN PARAGRAPH B.4 BELOW.
 - B) NAVSEA 0900-LP-003-8000, NAVSEA 0900-LP-003-9000, AND NAVSEA 0900-LP-006-3010 SHALL BE MIL-STD-2035.
 - C) MIL-STD-2035 SHALL BE REVISION A as modified by EB-5341.
 - D) NAVSEA 250-1500-1 SHALL BE REVISION 17.
 - E) MIL-STD-2132 SHALL BE REVISION D.
 - F) NSTR-99 SHALL BE REVISION 4.
 - 2) FOR THE FOLLOWING FABRICATION AND PERFORMANCE SPECIFICATIONS, THE EFFECTIVE REVISION SHALL BE THE REVISION LISTED IN THE APPLICABLE VERSION OF EB-5341:
 - A) NAVSEA TECHNICAL PUBLICATION S9074-AR-GIB-010/278 AS MODIFIED BY EB-5341
 - B) NAVSEA TECHNICAL PUBLICATION T9074-AD-GIB-010/1688 AS MODIFIED BY EB-5341
 - C) NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271 AS MODIFIED BY EB-3900
 - 3) IF AN ELECTRIC BOAT COMPONENT SPECIFICATION NAVSEA APPROVED INVOKES SPECIFICATION REVISIONS THAT CONFLICT WITH THE ABOVE, THE COMPONENT SPECIFICATION SHALL TAKE PRECEDENCE.
 - 4) 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 SUBMITTED TO THE BUYER VIA A PROPERLY COMPLETED VENDOR PROCEDURE APPROVAL REQUEST (VPAR). EACH PROCEDURE SHALL BE SUBMITTED ON A SEPARATE VPAR, WITH THE ADDENDUM, SCAN PLAN, TECHNIQUE SHEET, ETC., AS APPLICABLE. THE SELLER SHALL SEND THE VPAR AND A COPY OF THE PROCEDURE TO THE BUYER DESIGNATED ON THIS PURCHASE 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 PROPERLY COMPLETE THE VPAR REQUEST AND INCLUDE ALL PERTINENT INFORMATION. THE FOLLOWING INFORMATION IS REQUIRED TO BE PROPERLY FILLED OUT TO AID IN THE BUYERS REVIEW UNLESS OTHERWISE WAIVED BY THE PURCHASER:
 - A) DRAWING REFERENCE NUMBER SECTION: IDENTIFY THE APPLICABLE DRAWING AND PIECE NUMBER. THE BUYER NEEDS THIS INFORMATION TO VERIFY WHICH ITEMS WILL BE INSPECTED WITH THE SUBMITTED PROCEDURE. IF THE SAME PROCEDURE WILL BE APPLIED TO NUMEROUS DRAWINGS, "VARIOUS" SHALL BE ENTERED IN THIS SECTION AND AN EXPLANATION ENTERED IN THE "DESCRIPTION OF DOCUMENT" WITHIN THE VPAR. IF DRAWINGS ARE NOT APPLICABLE TO THIS ORDER, "N/A" SHALL BE ENTERED.
 - B) VPAR SPECIFICATION NUMBER: IDENTIFY THE NDT PERFORMANCE SPECIFICATION AND ACCEPTANCE SPECIFICATION FOR WHICH THE PROCEDURE APPROVAL IS BEING REQUESTED. FOR EXAMPLE, T9074-AS-GIB-010/271 CHANGE NOTICE 1 AND MIL-T-16420K (1), OR MIL-STD-2132D AND MIL-F-23509F (1), ETC.
 - C) DESCRIPTION OF DOCUMENT: THIS FIELD 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. ALSO DESCRIBE THE APPLICATIONS FOR WHICH APPROVAL IS BEING REQUESTED (E.G., WELDS,

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CASTINGS, FORGINGS, WELD REPAIR, ETC.) 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.

- (1) AS A MINIMUM, THE BELOW IS REQUIRED TO BE INCLUDED IN THE "DESCRIPTION OF DOCUMENT FIELD:
 - (a) NAME OF THE ORGANIZATION PERFORMING THE NDT
 - (b) PROCEDURE NUMBER, REVISION, AND DATE
 - (c) PERFORMANCE SPECIFICATION
 - (d) ACCEPTANCE CRITERIA
 - (e) ADDENDUM/TECHNIQUE NUMBER, REVISION, AND DATE IF INCLUDED WITH THE SUBMITTAL
 - (f) A BRIEF DESCRIPTION OF THE PROCEDURE AND APPLICATION(S) SUBMITTED FOR APPROVAL
 - (g) ANY PREVIOUS VPARS THAT THE PROCEDURE WAS EITHER APPROVED OR DISAPPROVED ON
 - (i) THIS WOULD INCLUDE DOCUMENTATION OF PROCEDURE APPROVALS FROM NNS AND/OR BPMI.
- (2) IF CLARIFICATION TO ANY OF THE ABOVE, OR OTHER ATTRIBUTES ARE REQUIRED, THE "DESCRIPTION OF DOCUMENT FIELD SHALL BE USED.
- (3) IF PROCEDURE APPROVAL IS BEING REQUESTED FOR MORE THAN ONE APPLICATION, EACH APPLICATION AND ACCEPTANCE SPECIFICATION SHOULD BE CLEARLY STATED E.G., PT OF NUCAL 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. THE PRODUCTION FILM SHALL BE SUBMITTED IN ACCORDANCE WITH STANDARD CLAUSE 76-25, FILM PACKAGING REQUIREMENTS.

D) GENERAL REQUIREMENTS FOR PROCEDURE APPROVAL

- 1) THE BUYER REVIEWS SELLER AND SUB-TIER SUPPLIER NDT PROCEDURES TO ASSURE COMPLIANCE WITH APPLICABLE FABRICATION, MATERIAL, PERFORMANCE DOCUMENTS AND ACCEPTANCE CRITERIA SPECIFICATIONS.
 - A) 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 ACTIVITIES' COGNIZANT LEVEL III TEST EXAMINER DENOTING APPROVAL.
- 3) ALL NDT PROCEDURES 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 AND REFERENCE RADIOGRAPHS FOR RADIOGRAPHY DO NOT NEED TO BE CONTAINED WITHIN THE PROCEDURE HOWEVER, THE APPLICABLE SPECIFICATION(S) CONTAINING THESE SHALL BE CITED APPROPRIATELY.

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

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- 1) WHENEVER NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271 IS INVOKED, THE FOLLOWING MUST BE INCLUDED IN ALL NDT PROCEDURES:
 - A) A "CERTIFYING" 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.
 - B) 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.
 - C) 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. IT IS ALSO RECOGNIZED THAT UT INSPECTION IS TYPICALLY PERFORMED WHEN THE PART HAS A SIMPLE GEOMETRY (I.E. PRIOR TO FINAL MACHINING PER NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271 CHANGE NOTICE 1, 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:
 - A) MAGNETIC PARTICLE TESTING:
 - (1) LIGHTING REQUIREMENTS
 - (2) FINAL CLEANING
 - B) LIQUID PENETRANT TESTING:
 - (1) MATERIAL TO BE TESTED; E.G., WELDS, WELD REPAIRS, CASTINGS, ETC.
 - (2) SURFACE PREPARATION
 - (3) LIGHTING REQUIREMENTS
 - (4) ALL PENETRANTS, EMULSIFIERS, REMOVERS, AND DEVELOPERS SHALL BE INCLUDED ON THE QUALIFIED PRODUCTS LIST OF THE LATEST REVISION OF AMS 2644.
 - C) ULTRASONIC TESTING:
 - (1) THE INSTRUMENT MODEL/S ALLOWED FOR THE INSPECTION
 - (2) EQUIPMENT QUALIFICATION METHOD OR REFERENCE TO A QUALIFICATION PROCEDURE
 - (3) DESCRIPTION OF THE REFERENCE CALIBRATION STANDARD
 - D) VISUAL TESTING
 - (1) 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) BUYER 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.
 - A) 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

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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 THE "DESCRIPTION OF DOCUMENT" FIELD OF THE VPAR, 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 ACTIVITIES 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) THIS STANDARD CLAUSE DOES NOT BY ITSELF REQUIRE ALLOY IDENTIFICATION TO BE PERFORMED. ALLOY IDENTIFICATION PROCEDURES ARE ONLY REQUIRED TO BE SUBMITTED IN ACCORDANCE WITH THIS STANDARD CLAUSE WHEN ALLOY IDENTIFICATION IS REQUIRED BY THE PROCUREMENT DOCUMENTS (E.G., MATERIALS SPECIFICATIONS, EB SPECS, PART DRAWINGS, ETC.).
- 2) ALL PROCEDURES SHALL BE UNIQUELY IDENTIFIED BY A PROCEDURE NUMBER, WITH A REVISION AND DATE.
- 3) THE ALLOY IDENTITY PROCEDURE SUBMITTED FOR APPROVAL SHALL CONTAIN THE FOLLOWING AS A MINIMUM: IF ANY OF THE FOLLOWING SECTIONS (E.G., OVERLAP) DO NOT APPLY TO THE PROCEDURE BEING SUBMITTED FOR REVIEW, THE PROCEDURE SHALL STATE WHICH SECTION ARE NOT APPLICABLE. ALLOY IDENTIFICATION PROCEDURES THAT ARE TECHNICALLY ACCEPTABLE IN ACCORDANCE WITH MIL-STD-2132 MEET THE REQUIREMENTS OF THIS STANDARD CLAUSE; HOWEVER, THE PROCEDURE MUST STILL BE SUBMITTED FOR REVIEW.
 - 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.

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- 4) 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.
 - A) NICAL-CHROMIUM-IRON BASE ALLOYS INCONELS AND HASTELLOYS
 - B) K-MONEL
 - C) COPPER-NICAL ALLOYS CUPRO-NICKELS
 - D) NICKEL-COPPER ALLOYS MONELS
 - E) AUSTENITIC STAINLESS STEELS AISI 300 SERIES
 - F) MARTENSITIC & FERRITIC STAINLESS STEELS AISI 400 SERIES & 17-4 PH CLASS
 - G) CARBON AND ALLOY STEELS
 - H) TITANIUM ALLOYS
 - I) COBALT BASE ALLOYS STELLITES
 - J) NICKEL-CHROMIUM-BORON ALLOYS COLMONOYS
 - K) COPPER
 - L) BRONZE
 - M) NICKEL-ALUMINUM BRONZE
 - N) BRASS
 - O) SILVER BRAZING MATERIAL
- 5) 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.

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- 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 ACTIVITIES COGNIZANT LEVEL III TEST EXAMINER.
 - 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 VPAR MEETING ALL THESE CONDITIONS SHALL BE FURNISHED WITH THE SHIPMENT.
 - A) 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 **IN THE FORM OF A LETTER TO THE APPLICABLE BUYER THAT:**
 - (1) THIS CHANGE IS ADMINISTRATIVE IN NATURE,
 - (2) THIS IS NOT CONSIDERED TO BE A TRANSFER OF PROCEDURES AS GOVERNED BY TECH PUB 271, PARAGRAPH 1.7.4, AND
 - (3) 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, NEWPORT NEWS SHIPBUILDING **OR BECHTEL PLANT MACHINERY, INC. (BPMI)** ARE ACCEPTED BY ALL THREE PROCURING ACTIVITIES.
 - A) IF THE SELLER ELECTS TO USE PROCEDURES PREVIOUSLY APPROVED BY ELECTRIC BOAT, NEWPORT NEWS SHIPBUILDING OR BPMI FROM AN ALTERNATE PROCURING ACTIVITY, THE PROCEDURE NEEDS TO BE SUBMITTED TO THE PROCURING ACTIVITY IDENTIFYING THAT IT WAS PREVIOUSLY APPROVED AND ATTACHING THE APPLICABLE OQE OF THE APPROVAL.
 - (1) THE CRITERIA REQUIRED TO USE THIS GENERIC APPROVAL PROCESS IS AS FOLLOWS:
 - (a) THE DATE OF THE NDT PROCEDURE'S PRIOR APPROVAL IS 1 JANUARY 2020 OR LATER.
 - (b) THE PROCEDURE IS FOR INSPECTION OF WELDS, CASTINGS, FORGINGS, PLATE, WELD REPAIRS, OR FASTENERS.
 - (c) THE PROCEDURE IS WRITTEN TO NAVSEA TECHNICAL PUBLICATION T9074-AS-GIB-010/271, NAVSEA TECHNICAL PUBLICATION S9074-AR-GIB-010/278, NAVSEA TECHNICAL PUBLICATION T9074-AD-GIB-010/1688, OR NAVSEA TECHNICAL PUBLICATION T9074-BD-GIB-010/0300 AND
 - (i) IS IN ACCORDANCE WITH THE INVOKED REVISION OF THE ABOVE SPECIFICATIONS, AND
 - (ii) COVERS THE ENTIRETY OF APPLICABLE SECTIONS WITHIN THE SPECIFICATIONS FOR THE METHOD BEING SUBMITTED AGAINST.
 - (d) THE PROCEDURE MUST CONTAIN ALL APPLICABLE ACCEPTANCE CRITERIA.
 - (e) THE PROCEDURE MUST BE FOR VT, MT YOKE TECHNIQUE, PT, OR RT.
 - (i) SPECIFIC TECHNIQUES/SKETCHES TO ENSURE APPROPRIATE INSPECTION COVERAGE FOR ALL METHODS ARE STILL REQUIRED PER COMPONENT AND RESPECTIVE PURCHASE ORDER.
 - (f) ALL ATTRIBUTES OF THE APPLICABLE PURCHASE ORDER MUST STILL BE MET
 - 5) SUB-TIER NDT PROCEDURES PREVIOUSLY APPROVED THROUGH A PRIME SUPPLIER DO NOT NEED TO BE RESUBMITTED THROUGH AN ALTERNATE PRIME SUPPLIER AS LONG AS SECTION I IS MET.
- J) TEST REPORTS FOR PERFORMANCE OF NDT

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- 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) AND TECHNIQUE USED
 - B) DESCRIPTION OR UNIQUE IDENTIFICATION OF THE ITEM INSPECTED
 - C) PROCEDURE IDENTIFICATION (NAME/NUMBER, REVISION, DATE, AND ANY ADDENDA'S/SUPPLEMENTS)
 - 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
- 5) 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.
- 6) 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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