

Quality Clause 240502 - Welding/Brazing/NDT, AWS or ASME (updated 02/06/2024)

Welder/Brazer Qualification: All welders/brazers and procedures shall be qualified in accordance with AWS D1.1/D1.1M, ASME code/standard or ABS standards as defined by the drawing. Procedures shall be approved by Rolls-Royce prior to welding/brazing.

Welding/Brazing: All welding/brazing shall be performed in accordance with AWS D1.1/D1.1M or applicable ABS or ASME code.

Non-Destructive Testing (NDT): Unless otherwise specified by the drawing or standard, all welds/braze shall be VT inspected (documented) at a minimum. All welds shall meet the Visual Inspection criteria of Mil-Std-2035A Class 1. The Visual Inspection criteria of Mil-Std-2035A takes precedent over the criteria of AWS D1.1/D1.1M.

NDT Personnel: Personnel performing NDT shall be qualified in accordance with the AWS D1.1/D1.1M standard or other recognized standard.

Acceptance Criteria: Acceptance criteria for NDT of welds shall be as required by drawing or applicable standard.

Procedures: Copies of applicable weld, braze and NDT procedures and personnel qualifications shall be available to Rolls-Royce for review upon request.