

Quality Clause 240504 - Welding Requirements, ABS NVR (08/10/18)

This quality clause provides the requirements for supplier welding procedure approval. Specific requirements associated with welding are provided on the drawing or in specification documents referenced by the drawing.

All welding procedures for parts provided on this order shall be qualified in accordance with the contract applicable version of American Bureau of Shipping (ABS) Naval Vessel Rules (NVR).

Each Supplier or subtier Supplier shall have their own welding procedures and supporting qualification records. Copies of ABS weld procedure approval records must be submitted to the Rolls-Royce Quality Manager electronically to the following email address: [RRNMI.Certs@Rolls-Royce.com](mailto:RRNMI.Certs@Rolls-Royce.com). The email is to have the words "Weld Procedure" in the email subject line. Supplier emails must be less than 10 MB in size due to Rolls-Royce email system limitations. We recommend the email be identified as "1st of X Emails" should multiple emails be required due to file size limitations. Documentation must be legible and of reproducible quality. Files cannot contain macros or executables.

All costs associated with becoming qualified to perform welding under this program are the Supplier's responsibility. The Supplier shall obtain test plates, filler metal, testing and equipment as needed to become qualified.

ABS approval for welding procedure(s) must be obtained prior to the commencement of any production welding by the Supplier.