

Quality Clause 240701 - Weld Wire Certification, MIL STD (updated 17-May 2024)

Materials on this order shall be certified according to the requirements of MIL-E-19933E, MIL-E-23765/1E, MIL-E-23765/3A(SH), or MIL-E-24403/1.

- MIL-E-19933E applies to chromium and chromium-nickel alloy bare welding electrodes and cut length rods for use with the inert gas metal-arc (GMA) and the tungsten-arc welding processes as well as bare welding electrode in coils for submerged-arc welding processes.
- MIL-E-23765/1E applies to carbon and low-alloy steel electrodes and cut length rods for use with the gas metal-arc (GMA) and gas tungsten-arc (GTA) welding processes.
- MIL-E-23765/3A(SH) applies to solid bare copper alloy electrodes and cut length rods for use with the gas metal-arc (GMA) and gas tungsten-arc (GTA) welding processes.
- MIL-E-24403/1 applies to general requirements for flux cored welding electrodes designed for use with the flux cored arc welding process with or without gas shielding.

Quality conformance inspection and documentation shall meet the requirements of the referenced MIL specs.

Actual certified chemical, physical and NDT test results shall be provided by a qualified laboratory which is independent from the wire manufacturer and be done in accordance with MIL-E-19933E, MIL-E-23765/1E, MIL-E-23765/3A(SH), or MIL-E-24403/1.

Packaging and special marking shall be in accordance with the referenced MIL specs.

Subject to US export requirements, a copy of the certification shall be emailed to RRNMI.Certs@Rolls-Royce.com.

- 1) The Rolls-Royce purchase order (PO) number and Rolls-Royce part number shall be referenced in the email subject line in the following format: "Report(s) for PO XXXXXXXXXXXX Part Number YYYYYYYYYY" or "Report(s) for PO XXXXXXXXXXXX, Multiple Part Numbers".
- 2) Supplier emails with attached files must be less than 10 MB in size due to Rolls-Royce email system limitations. We recommend the email subject line format: "Report(s) for PO XXXXXXXXXXXX, Part Number YYYYYYYYYY 1st of X Emails" should multiple emails be required due to file size limitations.
- 3) Documentation (including hard copy or faxed documents when requested by Rolls-Royce) must be legible and of reproducible quality. Files cannot contain macros or executables. No hard copy certifications are required to accompany the shipment.