

Quality Clause 240501 - Welding/Brazing/NDT, MIL STD/ASME (08/10/18)

Welding and Brazing Procedure Qualification: All welders, brazers and procedures shall be qualified in accordance with S9074-AQ-GIB-010/248 or, if specified on the drawing, ASME Code 9.

Welding: All welding shall be performed in accordance with S9074-AR-GIB-010/278 unless otherwise stated on the drawing.

Non-Destructive Testing (NDT): All welds shall be inspected in accordance with the requirements of S9074-AR-GIB-010/278 unless otherwise stated on the drawing.

NDT Procedures and Personnel: NDT personnel and procedures shall be qualified in accordance with the requirements of T9074-AS-GIB-010/271 unless otherwise stated on the drawing.

Acceptance Criteria: Acceptance criteria for NDT of welds or metals unless otherwise specified shall be per MIL-STD-2035A. NDT reports shall be forwarded to RRNMI.Certs@Rolls-Royce.com for all NDT tested parts. Documentation must be legible and of reproducible quality. Files cannot contain macros or executables.

Procedures and Qualifications: Copies of applicable weld and NDT procedures along with procedure and personnel qualification records shall be provided to Rolls-Royce and approved prior to use.