

Quality Clause 240701 - Weld Wire Certification, MIL STD (10/19/18)

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

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, or MIL-E-23765/3A(SH).

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.

The purchase order (PO) number and part number shall be referenced in the email subject line in the following format: "Report(s) for PO XXXXXXXXXX, Part Number YYYYYYYY" or "Report(s) for PO XXXXXXXXXX, Multiple Part Numbers".

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 XXXXXXXXXX, Part Number YYYYYYYY 1st of X Emails" should multiple emails be required due to file size limitations.

Documentation (including hard copy and 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.