Quality Clause 240504 - Welding Requirements, ABS NVR (07/01/2025 - Rev A)

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 Bird Johnson Propeller Company Quality Manager electronically to the following email address: BirdJohnsonCerts@fmdefense.com. The email is to have the words "Weld Procedure" in the email subject line. 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.