Quality Clause 240701 – Weld Wire Certification, MIL STD (07/01/2025 - Rev A)

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

[BirdJohnsonCerts@fmdefense.com](mailto:BirdJohnsonCerts@fmdefense.com).

1) The Bird Johnson Propeller Company purchase order (PO) number and Bird Johnson Propeller Company part number shall be referenced in the email subject line in the following format: “Report(s) for PO XXXXXXXXXX Part Number YYYYYYYYY” or “Report(s) for PO XXXXXXXXXXX, Multiple Part Numbers”.

2) 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.