



## WE-005 - Supplier Weld Procedure Process

### Scope

- 1.1 This procedure establishes the process for handling supplier welding procedures at the Aiken, Elgin, Sterling Heights, and York sites.
- 1.2 The supplier shall submit all necessary paperwork in accordance with the requirements found in 091869 Weld Submittal Requirements and Instructions (LAA-5272).

### Definitions

**Aluminum Code** – Ground Combat Vehicle Welding Code – Aluminum (Dwg. 12472301)

**Steel Code** – Ground Combat Vehicle Welding Code – Steel (Dwg. 12479550)

**PQR** – Procedure Qualification Record

**WPS** – Welding Procedure Specification

**Approved Supplier** – A supplier that has met the requirements of the Purchasing Quality Assurance Department

**Approved Weld Supplier** – A supplier that has met all of the requirements of Section 2.1 and is qualified to use BAE System weld procedures

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## Qualification

- 2.1 In order for a supplier to become an approved weld supplier to perform welding for BAE Systems using a BAE weld procedure representatives from that company shall attend a BAE weld code class and at least one of the representatives must pass the written examination with a score of at least 70%. (Objective evidence will be retained) Upon successful completion of the exam and the requirements specified below in 2.1.1 – 2.1.3, the Weld Engineering Department shall add that supplier to the list of qualified suppliers within five (5) business days. This is illustrated in Figure 1. Prerequisites of the supplier attending the class shall include:
  - 2.1.1 The supplier shall be an approved supplier as defined by the BAE Purchasing Quality Assurance Department.
  - 2.1.2 The supplier shall submit evidence of a weld machine calibration program in accordance with current NIST standards.
  - 2.1.3 The supplier shall submit a sample of their welder performance qualifications for steel, aluminum, or both materials.
- 2.2 Suppliers who elect to do so may submit their own weld procedures for approval by BAE Systems provided Purchasing Quality Assurance has designated the supplier as an approved supplier.

## Administration

- 3.1 Weld Engineering shall log-in a supplier weld procedure upon receipt and maintain a record of the procedure status throughout the process. The appropriate section of the latest 089136 Welding Procedure Submission Form (LAA-5128) will be completed for each supplier submittal. Weld Engineering shall maintain a supplier procedure status database and update BAE Systems ERP system when a procedure is approved.
- 3.2 Weld Engineering shall review for approval all supplier submitted procedures, extension requests, qualification data, and test samples.
- 3.3 Government approval is required prior to Weld Engineering acceptance of supplier ballistic weld procedures.
- 3.4 Weld Engineering shall maintain a record of supplier submitted documentation and approval/reject documentation. A copy of the Approval/reject documentation shall be sent to the supplier.

## Process Flow

- 4.1 The supplier can submit arc welding procedure documentation in the following ways:

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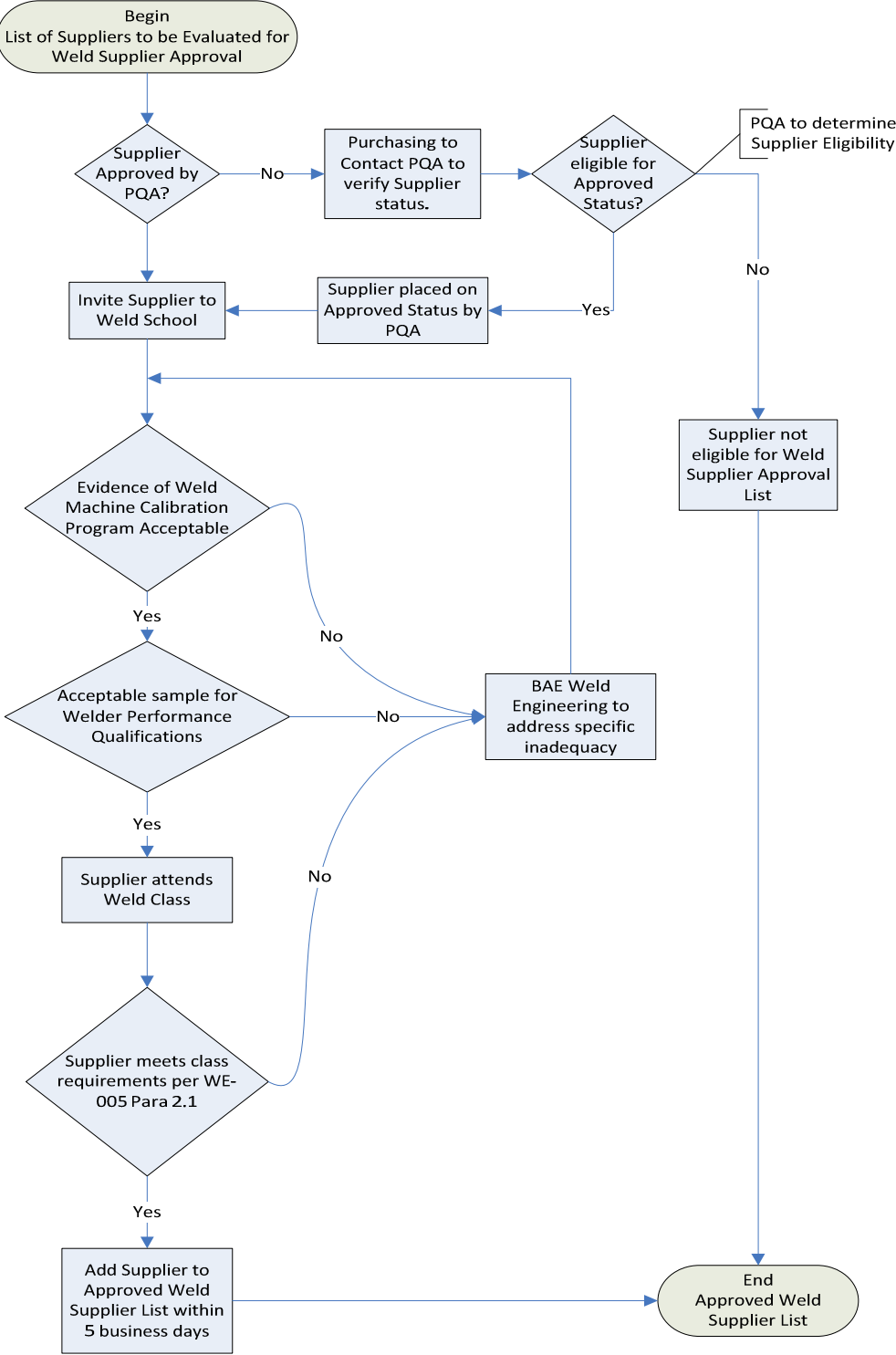
- 4.1.1 PQR and WPSs – The supplier performs their own procedure qualification, generates a welding procedure, and submits the PQR and WPS documentation for acceptance. These submissions shall be attached to and made using the latest 089136 Welding Procedure Submission Form (LAA-5128).
- 4.1.2 Procedure Flow down Use – The supplier wishes to use BAE Systems qualified procedures: The supplier must be qualified by BAE Systems to use these procedures. To be qualified, the supplier must meet all the requirements specified in Section 2 of this procedure. For a supplier that contracts the welding to another supplier, the first tier supplier is responsible for attending a BAE Systems training seminar, and also is responsible for the verification of welder qualifications and power source calibrations of the contracted company. The contracted company documents, as specified in Section 2, must be forwarded to BAE Systems Weld Engineering Department for approval before welding is started. This request is made using the latest 089136 Welding Procedure Submission Form (LAA-5128) preferably submitted electronically but not limited to.
- 4.2 The Weld Engineering Department shall notify the supplier of the approval or rejection status of their submittal within three (3) business days of receipt of all pertinent information by the Weld Engineering Department.
- 4.3 Figure 2 illustrates the process for submitting arc welding procedures.

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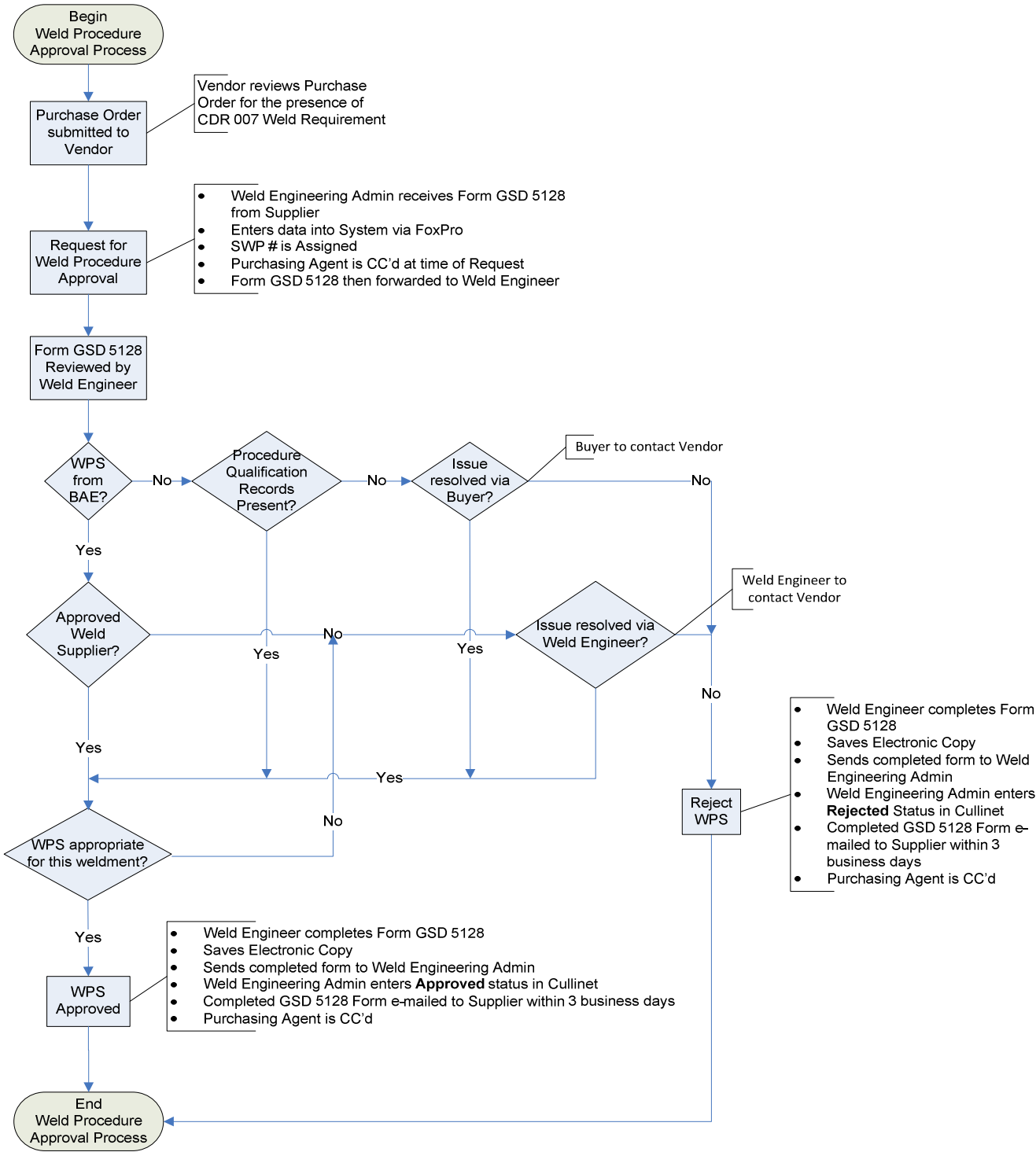
Figure 1, Weld Engineering Supplier Approval Process



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Figure 2, Weld Procedure Approval Process



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Revision History

Rev	Date	Change Description	Approved By	Change Request #
01	4/8/2008	No change history documented, document migrated over from EPF		
02	5/5/2015	Removed "process owner approval" on 1st page. Removed "title" from title on pg. 1. Modified 1.2, 4.1.1, and 4.1.2. Removed LAA-5128 example. Added page numbers, rev #, rev. date, form #, and disclaimer to footer. Changed BAE logo in header. Added revision history.	Michael Davis	BPMS-02260

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