

## CDR007-Supplier Welding Procedure Submission Form

Per CDR007, 089136 **SHALL** be submitted and approved **PRIOR** to the start of fabrication. Failure to submit **PRIOR** to fabrication **MAY** result in the rejection of part(s) at the Supplier's expense.

	Required	Detailed Explanation
BAE Systems Buyer	X	Provide BAE Systems Buyer's Name.

**Supplier Information:**

Company Name	X	Provide the Supplier's Company Name.
Company Address	X	Provide the Supplier's Company Address.
Contact Name	X	Provide the Supplier's Point of Contact's Name.
Contact Phone #	X	Provide the Supplier's Point of Contact's Phone Number.
Contact Email	X	Provide the Supplier's Point of Contact's Email Address.
Vendor Number	X	Provide the Supplier's BAE Systems appointed Vendor Number.

**Fabricator Information\*:** (if different from First-Tier Supplier)

Company Name		Only applicable if the Fabricator is different from the Supplier.
Company Address		Only applicable if the Fabricator is different from the Supplier.
Contact Name		Only applicable if the Fabricator is different from the Supplier.
Contact Phone #		Only applicable if the Fabricator is different from the Supplier.
Contact Email		Only applicable if the Fabricator is different from the Supplier.

**Weldment Information:**

Vehicle Contract Number	X	Provide the current active Vehicle Contract Number associated with the Weldment, listed on the current, active Purchase Order Number
P.O. Number	X	Provide the current, active Purchase Order Number associated with the Weldment.
P.O. Part Number	X	Provide the P.O. Part Number that is associated with the Weldment to be reviewed.
Weldment Part Number	X	Provide the weldment/part number to be fabricated. Only list <b>ONE</b> part per submission form. If similar parts are fabricated but have different Drawing Numbers, the Vendor shall submit separate form(s) for review. Weldment part numbers shall be located in the drawing title block in the bottom, right hand corner of BAE Systems' drawings.
Weldment Revision	X	Provide the revision of the Weldment Part Number. Revision shall be located in the drawing title block in the bottom, right hand corner of BAE Systems' drawings.

**Weldment Component Information:**

Weldment Component Part Number(s)	X	Provide the Weldment Component Part Number(s) listed in the Bill of Materials and/or Parts List. If the Weldment Drawing does not contain a BOM and/or Parts List, list all components referenced on the drawing within the table provided on Page 4 of this document under Weldment Component Base Material Information.
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Component Base Material to be <b>Used</b>	X	Provide <b>ONLY</b> Base Material Used to fabricate the listed component(s)/part(s). Do <b>NOT</b> list all Optional Material(s) from the associated Weldment and/or Weldment Component drawing(s). Base Material(s) Used shall include Material Specification, Grade, Type, Condition, and/or Lot Number <b>if applicable</b> . Lot Number is applicable for Armor Material(s) only and is for BAE Systems reference purposes only.
Weld/Braze Procedure(s) to be <b>Used</b>	X	<p>Provide the BAE Systems Weld Procedure(s) associated with fabricating the adjoining Weldment Components. The supplier shall list the WPS(s) to be utilized. WPS(s) shall be listed on page 4 of this document under 'Weld Procedure(s)'.</p> <p>When selecting a WPS the supplier shall consider the following for adequacy:</p> <ul style="list-style-type: none"> <li>- Base Material(s)</li> <li>- Base Material Thickness(es)</li> <li>- Weld Callouts</li> <li>- Joint Geometry</li> <li>- Welding Process</li> <li>- Code/Specification Requirements</li> <li>- Additional Essential Variables</li> </ul> <p><b>IF</b> a singular WPS is adequate for the supplier to complete the fabrication of the Weldment, the 'Weld Procedure(s)' field on page 4 shall contain the same WPS for ALL Weldment Components.</p> <p><b>IF</b> the supplier chooses to submit more than one WPS per Weldment, the supplier shall indicate the additional WPS(s) to be approved by component.</p> <p><b>IF</b> the supplier chooses to request an alternate and/or optional WPS with a process varying from the original WPS listed, the supplier shall indicate the optional WPS in the 'Weld Procedure(s)' field on page 4 of this document:</p> <p>Ex: M1G1-GMP-1 (Optl. M1G1-GT-1)</p> <p>Supplier provided PQR(s)/WPS(s) shall be attached to this form for review.</p> <p><b>Please Note:</b> BAE Systems <b>SHALL NOT</b> qualify Weld Procedures on behalf of the Supplier. It <b>SHALL</b> be the Supplier's responsibility to provide and/or qualify a procedure in the event BAE Systems does <b>NOT</b> have an applicable procedure available.</p> <p><b>Suppliers SHALL reference WE-005 for additional requirements.</b></p>
BAE Systems Weld Procedure Book Revision		<b>IF</b> utilizing the BAE Systems Qualified Weld Procedure(s), provide the revision of the book referenced. Supplier <b>SHALL</b> be using the latest released BAE Systems Weld Procedure(s).
Manual/Robotic	X	Provide the method of welding per Weld Procedure listed.
<p>The following changes shall require the vendor to resubmit the Supplier Welding Procedure Submission Form for the applicable part:</p> <ul style="list-style-type: none"> <li>- Change in material and/or the use of optional materials</li> <li>- Change in and/or the use of a different Weld Procedure</li> <li>- Change in Part Number Configuration</li> </ul> <p><b>CDR007 submittals of 089136 SHALL remain indefinitely and do NOT expire, unless the above changes have occurred.</b></p> <p>When submitting the Welding Procedure Submission Form, 089136, be sure to frequently check the BAE Systems' Purchasing Website for latest revisions of the form and updates.</p> <p>Failure to provide the requirements above and/or not utilizing the latest form revision <b>SHALL</b> result in immediate rejection of the Welding Procedure Submission Form.</p> <p>*The First-Tier Supplier <b>SHALL</b> be responsible for obtaining and submitting the Fabricator's Information required on the Supplier Welding Procedure Submission Form</p> <p>Material Classifications and Groupings shall be determined using the following tables <b>unless otherwise specified</b>:</p> <p><b>Aluminum</b>: Ground Combat Vehicle Welding Code-Aluminum, 19207-1247301, Page 13, M-Number Listing</p> <p><b>Steel</b>: Ground Combat Vehicle Welding Code-Steel, 19207-12479550, Page 21-22 Table 3.1, <b>OR</b> Page 88- 100, Appendix A, <b>OR</b> ANS/AWS B2.1/B2.1M Specification for Welding Procedure and Performance Qualification.</p>		

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**BAE Systems Buyer:** \_\_\_\_\_

**Supplier Information:**

Company Name	
Company Address	
Contact Name	
Contact Phone Number	
Contact Email	
Vendor Number	

**Fabricator Information (if different from Supplier):**

Company Name	
Company Address	
Contact Name	
Contact Phone Number	
Contact Email	

**Weldment Information:**

Vehicle Contract Number	
P.O. Number	
P.O. Part Number	
Weldment Part Number	
Weldment Revision	

**Weldment Component Information:**

See table on Page 4 to provide Weldment Component Information details.

Please attach a copy of WPS(s), supporting PQR(s), and Mechanical Testing Data if planning to utilize WPS(s) **NOT** qualified by BAE Systems. See instructions in the Attachments of the PDF.

**Submit By Email** Click here to E-Mail this form to [swps.payk@baesystems.com](mailto:swps.payk@baesystems.com)

**For BAE Systems Weld Engineering Use ONLY:**

SWPS Number: \_\_\_\_\_ Date In: \_\_\_\_\_ Date Out: \_\_\_\_\_

Approved \_\_\_\_\_ Rejected \_\_\_\_\_ Submission Number: \_\_\_\_\_

Comments: \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

Weld Engineer Signature \_\_\_\_\_



