



Newport News  
Shipbuilding

October 15, 2019

Dear Valued Supplier,

Newport News Shipbuilding (NNS) has recognized an issue in the welding supply base with understanding the impact of the welding arc travel speed through the weld joint affecting the heat input and potentially the weld quality. You are receiving this alert because you supply material that has coded notes associated with welding. If you subcontract any welding, it is your responsibility to pass this information to your suppliers to ensure they too are in compliance.

**Arc travel speed, both slower and faster than required, can have a negative impact on the overall weld quality. The heat input will impact cooling rates affecting microstructure, weld penetration, weld thickness, burn-through, and tie in at the toes. Procedures which have been approved by NNS, have been reviewed to ensure the travel speed in those procedures meet requirements. However, it is difficult for welders to monitor travel speed and heat input while also performing welding. Care must be taken when implementing the procedures to provide a method or process to monitor travel speed and heat inputs while welding is being performed, such as a second welder or auditor to perform verifications.**

**If for any reason you cannot operate to the parameters of your procedures, it is your responsibility to submit a new procedure for approval with the new parameters. Operating outside of any approved parameters on NNS material is considered a non-conformance and must be reported immediately to NNS.**

Please note that this alert should not be used as a basis for any price, delay in delivery, or any other modification of NNS purchase order requirements.

If you have any questions or concerns with regards to this Alert, please contact Marian Morrow, NNS Supplier Quality, email [Marian.M.Morrow@hii-nns.com](mailto:Marian.M.Morrow@hii-nns.com) or phone (757) 688-0208.

Sincerely,

R. L. Simpson  
Manager, NNS Supplier Quality

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