

Supplier CDR007/CDR008 Submittal Form Instruction Guide

CMS Supplier Weld/Braze Procedure Submission Form

Per CDR007/CDR008, 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.

Submittal Form Field	Required	Detailed Explanation
CDR007/CDR008/CDR008A	X	Select the checkbox for the applicable CDR
BAE Systems Buyer	X	List the BAE Systems Buyer's Name associated with the Purchase Order

Supplier Information: *The Supplier in which BAE Systems has a Purchase Order with*

Company Name	X	List the Supplier's Company Name
Company Address	X	List the Supplier's Company Address
Company POC	X	List the Supplier's Point of Contact's Name
Contact Phone Number	X	List the Supplier's Point of Contact's Phone Number
Contact Email	X	List the Supplier's Point of Contact's Email Address (NOTE: this is the E-Mail address that the form will be returned to once complete)
Vendor Number	X	List the Supplier's BAE Systems appointed Vendor Number

Sub-Tier Fabricator Information (if different from Supplier above):

Company Name		Only applicable if the Sub-Tier is different from the Supplier
Company Address		Only applicable if the Sub-Tier is different from the Supplier
Company POC		Only applicable if the Sub-Tier is different from the Supplier
Contact Phone Number		Only applicable if the Sub-Tier is different from the Supplier
Contact Email		Only applicable if the Sub-Tier is different from the Supplier

Purchase Order Information:

Contract Number	X	List the current Contract Number associated with the Purchase Order Part Number, as listed on the BAE Systems Purchase Order
P.O. Number	X	List the BAE Systems Purchase Order Number associated with the Weldment/Brazement
P.O. Part Number	X	List the Purchase Order Part Number/Deliverable Item Number that is associated with the Weldment/Brazement to be reviewed. Include all suffixes, as applied on the Purchase Order NOTE: Only 1 Purchase Order Part Number to be listed per submittal form

Weldment/Brazement Information:

Weldment/Brazement Part Number	X	List the BAE Systems drawing number that is associated with the Purchase Order Part Number. NOTE: this is the drawing that lists the Weld/Braze Code and other weld callouts. Drawing number may be the same as the Purchase Order Part Number.
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Weldment/Brazement Part Number Drawing Revision	X	List the revision of the BAE Systems drawing number that is associated with the Purchase Order Part Number.
Fabrication Specification	X	List the Fabrication Specification (AWS D1.1, D1.2, D17.1, Ground Combat Vehicle Welding Code (12479550 or 12472301), Hybrid Weld Code (4399307 or 4399308), TP-278, WS19143, WS19181, Mil-W-21157, etc. as required per the BAE Systems Purchase Order and/or drawing, which ever takes precedence.
BAE Systems Procedure		<u>CDR007 ONLY:</u> If utilizing the BAE Systems Qualified Weld Procedure(s), select the checkbox
WPS Book Revision		<u>CDR007 ONLY:</u> If utilizing the BAE Systems Qualified Weld Procedure(s), list the revision of the WPS book referenced. Suppliers <u>SHALL</u> be using the latest released BAE Systems Weld Procedure(s).
Additional Information		<p>List any applicable information that the Reviewer should be made aware of that would impact fabrication.</p> <p>Information may include the following: Variances, Vendor Information Requests (VIR), superseded Weld/Braze and/or Material Specifications</p> <p>For submittals that have previously been rejected and/or are being resubmitted, please identify the reason for resubmittal and any changes that occurred.</p>
Welded/Brazed Component Part Number Combinations	X	<p>List the Weldment/Brazement Component Part Number(s) provided in the Bill of Materials and/or Parts List. If the Weldment/Brazement Drawing does not contain a BOM and/or Parts List, list all components referenced on the drawing.</p> <p>Part X is welded/brazed to Part Y Example: Part -1 is welded to Part -2 Part -1 is welded to Part -3 Part -1 is welded to Part -4</p> <p>NOTE: Should the Supplier need additional space to list Component Combinations, please utilize the additional sheet supplied in the 'Attachments Section' of the form and attach the sheet to the form. Do not complete and submit a new form for additional space.</p>

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Component Base Material Combinations		X	<p>List the Base Material to be utilized, as well as the Base Material Thicknesses, to fabricate the listed component(s)/part(s). Do NOT list all Optional Material(s) from the associated Weldment/Brazement Component drawing(s). Base Material(s) Used SHALL include Material Specification, Grade, Type, Condition, and/or Lot Number if applicable.</p> <p>Part X is welded/brazed to Part Y <i>Example: Part -1 ASTM A36 .25" is welded to Part -2 ASTM A36 .25"</i> <i>Part -1 ASTM A36 .25" is welded to Part -3 ASTM A108 .25"</i> <i>Part -1 ASTM A36 .25" is welded to Part -4 ASTM A1011.25"</i></p>
Weld/Braze Procedure(s)		X	<p>List the Weld/Braze Procedure(s) associated with fabricating the adjoining Weldment/Brazement Components. The Supplier SHALL list the WPS/BPS(s) to be utilized.</p> <p>When selecting a WPS/BPS the Supplier SHALL consider the following for adequacy, at a minimum:</p> <ul style="list-style-type: none"> - Base Material(s) - Base Material Thickness(es) - Weld Callouts - Joint Geometry - Welding/Brazing Processes - Code/Specification Requirements - Additional Essential Variables <p>Should the Supplier choose to submit more than one WPS/BPS per Weldment/Brazement, the Supplier SHALL indicate the additional WPS/BPS(s) to be reviewed and approved by component.</p> <p><i>NOTE: Unless the Supplier is utilizing BAE Systems Weld Procedures for CDR007, the Supplier SHALL attach all supporting documentation to the submittal form for review. Should the Supplier fail to attach the documentation, the submittal will be returned to the Supplier without further review.</i></p>
Robotic			<p>Select the checkbox if Robotic processes are to be utilized.</p>

General Notes:

- The following changes **SHALL** require the Supplier to resubmit the CMS Supplier Weld/Braze Procedure Submittal Form for the applicable Purchase Order Part Number:
 - **Change in Base Material from the previous approval**
 - **Change/revision in and/or the use of an alternate Weld/Braze Procedure from the previous approval**
 - **Change in Part Number Configuration/Suffix**

*Example: XYZ*00 to XYZ*01, XYZ-TAN to XYZ-GRN, XYZ*00 to XYZ-WELDHYBRID*

NOTE: The processes and procedures that are to be used in fabrication shall directly align with the latest approval on record. Should the Supplier resubmit and gain approval on the Purchase Order Part Number and Weldment Part Number combination, any previous approvals containing that specific

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combination are superseded by the most recent approval.

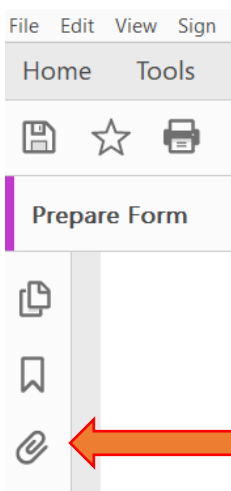
Example: If the Supplier has a previously approved process (GMAW) and wishes to add an additional process (GTAW), both procedures and processes must be included in the resubmittal if they are intended to be used on the subject part.

- CDR007/CDR008 approvals do **NOT** expire but become obsolete and non-compliant if the above changes have occurred.
- CDR007/CDR008 approvals are based on Purchase Order Part Number/Deliverable Item Numbers, **NOT** Purchase Orders, therefore, a new Purchase Order does **NOT** require a new approval as long as the above requirements have been satisfied.
- Suppliers are responsible for attaching all Supporting Documentation to their submittal. Reference the 'Attachment Instructions' sections below for guidance.
- The submittal form **SHALL** be filled out electronically and submitted to the SWPS.payk@baesystems.us for processing. Forms that have been completed by hand and/or scanned will be returned to the Supplier without further processing.
- Questions regarding the status of the submittal **SHALL** be sent to SWPS.payk@baesystems.us
- Please defer to the applicable CDR for submittal requirements when completing this form
- For Suppliers utilizing Sub-Tier Suppliers to Weld/Braze BAE Systems products, the Supplier in which BAE Systems has a Purchase Order with is responsible for their Sub-Tier Suppliers and the submittal of this form.

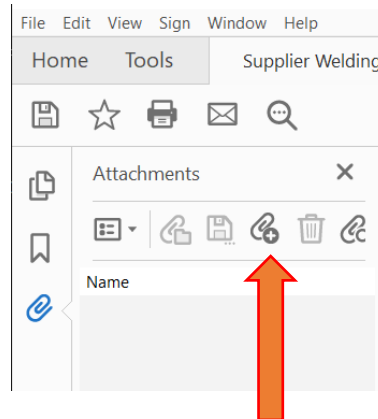
Attachment Instructions:

Reference the instructions below as a guide to attach Supporting Documentation to the submittal form

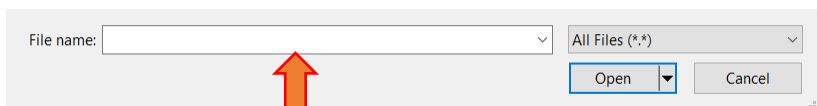
Attachment Instructions For Adobe Acrobat Pro DC: Steps 1-5



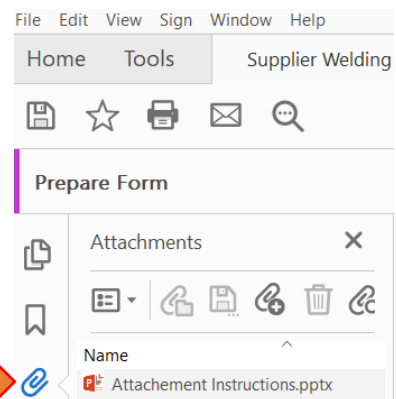
Step 1. On the top of the Form, click on the "Attachments" icon (paperclip)



Step 2. Click on "Add a new attachment" icon



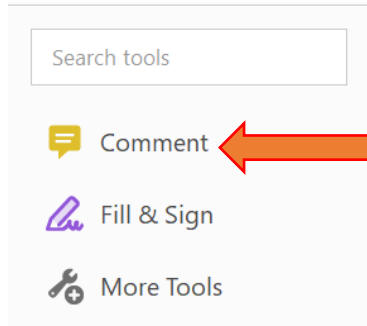
Step 3. Select the file(s) to be attached.



Step 5. **Effort Completed.** All uploaded documents will show up as shown in the example to the right.

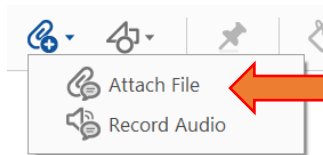
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Attachment Instructions For Adobe Acrobat Reader DC: Steps 1-9

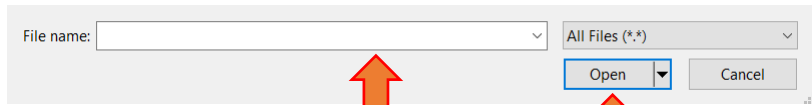


Step 1. On the top of the Form, click on the "Comment" icon as shown to the left.

Step 2. The "Comment" options will open on the top of the page and click "Add a new attachment", icon as shown below.

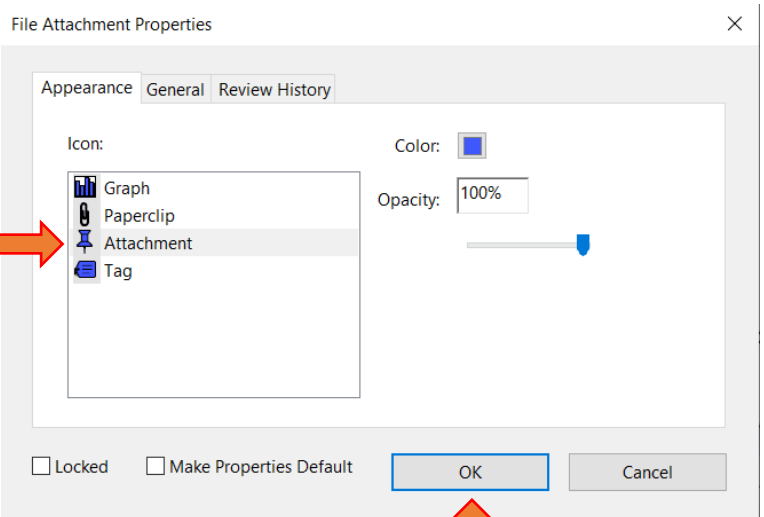


Step 3. Under the dropdown, click "Attach File".



Step 4. Click anywhere on the document and select the file(s) to be attached/pinned to the form.

Step 5. Click "Open".



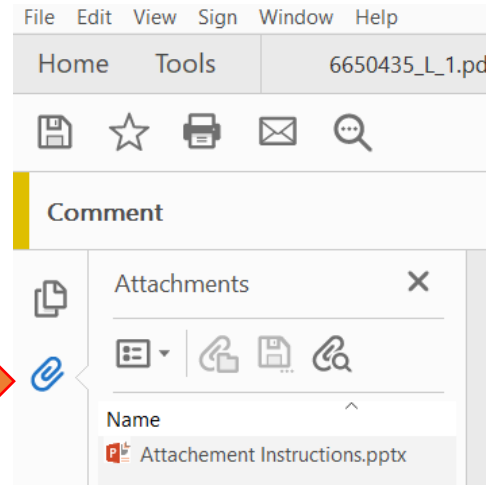
Step 6. Under "File Attachment Properties, select "Attachment"

Step 7. Click "OK".

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Step 8. This icon should show up in your document for attached files.



Step 9. **Effort Completed.** All uploaded documents will show up as shown in the example to the right.



Instruction Guide Legend:

Submittal Form Field- the requirement listed on the 089136 CMS Supplier Weld/Braze Procedure Submittal Form
Required- Items marked with 'X' are required to be filled out on each 089136 CMS Supplier Weld/Braze Procedure Submittal Form upon submittal.

Detailed Explanation- provides the explanation of each Form Field and the expectation of the Supplier.

WPS- Welding Procedure Specification

BPS- Brazing Procedure Specification

Supporting Documentation- may include the following: PQR/BPQR, WPS/BPS, Welder/Brazer Performance Qualifications, NAVSEA approval letter, and Filler Material Certificate of Conformance

WPQR and/or WQR- Welder Performance Qualification Record/Welder Qualification Record; the qualification of the personnel performing the Welding/Brazing operations.

PQR- Procedure Qualification Record; the qualification of the Welding/Brazing process and variables to be used in operations.