



# Sandia National Laboratories

Procurement Center  
Albuquerque, New Mexico 87185

## ARTICLES FOR PROCESS AND FABRICATION LABORATORY PROCUREMENT

### 1. GENERAL PRODUCT REQUIREMENTS

Unless otherwise specified in this procurement or superseded by specific drawing requirements, all product submitted to Sandia for acceptance shall meet the requirements of Sandia Specification 9900000 - General Requirements And Drawing Interpretations. Product must be adequately packaged for safe delivery to destination.

### 2. INSPECTION REPORTS

An inspection report covering items of purchase must be submitted with each shipment of material. The contractor must select an inspection procedure and sampling plan to insure product(s) will meet the specifications. This inspection report must contain the purchase number, item number, nomenclature, drawing and specification number, issue, drawing dimensions and tolerances, and the actual readings recorded by the Contractor's inspector. Positional Tolerance dimensions must be recorded in X and Y dimensions and the Positional Deviation.

In the event normal inspection techniques cannot be used, the Contractor shall discuss the exception with the Sandia Contracting Representative and state the circumstances on his inspection report. Parts inspected must be identified and referenced on the inspection report. Whenever product deviates from drawings and/or specifications, contractor shall notify Sandia Contracting Representative prior to shipment of product. Record any action taken by Sandia regarding the deviation on your inspection report.

### 3. WELDING REQUIREMENTS - CLASS II

The applicable specification, Steel 9912119, or Aluminum 9912117, covering the welding to be performed on the product being purchased under this procurement includes the following:

- (A) Qualification of welders and welding operators by an approved certifying agency.
- (B) Inspection: 100% visual inspection  
penetrant inspection of a 10% sample of each lot
- (C) Qualification of penetrant inspection personnel by an approved certifying agency.
- (D) Written certification to accompany the product.

### 4. WELDING REQUIREMENTS - CLASS I

The applicable specification; Steel 9912119 or Aluminum 9912117, covering the welding to be performed on the product being purchased under this procurement includes the following:

- (A) Buyer approval of the welding procedure.
- (B) Qualification of welders and welding operators by an approved certifying agency.
- (C) Inspection: 100% visual inspection  
100% magnetic particle or penetrant  
100% radiographic inspection
- (D) Qualification of magnetic particle and/or penetrant inspection personnel by an approved certifying agency.
- (E) Records must be maintained for at least one year.
- (F) Written certification to accompany the product.

### 5. DELEGATION OF AUTHORITY - 404-KDB

The Sandia personnel are hereby authorized to act as official representatives of Sandia for the specific purpose(s) shown.

Delegated representatives shall exercise no supervision over the Contractor's employees.

### 6. SANDIA FURNISHED MATERIAL - 515-SM

Sandia will furnish at no charge, FOB Destination the items listed for incorporation into the end product or for use in the performance of the Statement of Work. The amount of material furnished is:

- the exact quantity of material required for the work to be performed under this procurement, or
- the exact quantity of material required to be utilized under this procurement plus a small amount of excess valued at such a low amount making it impractical to return same to Sandia.

Therefore, at the completion of this contract, any residual material shall be disposed of by the Contractor at no cost to Sandia.