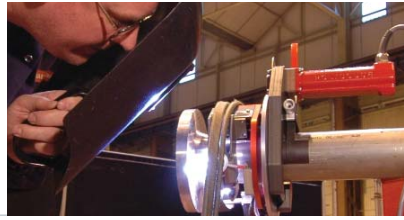


BAE SYSTEMS Submarines Total Pipe Fabrication Service offers a pipe welding facility that conforms to the highest military and commercial standards or to any standards or specifications required by the individual customer.



Pipework Welding and Fabrication

All welders are fully trained in-house and undergo periodic certified continuation training. A computerised Welder Qualification System ensures that only appropriately qualified welders are used for any given task. All Nuclear pipework storage and manufacture is undertaken in a totally segregated facility with designated clean areas.

The pipe fabrication areas are configured along lean manufacturing lines with separate shop areas for machining, engineering preparation and flanging, non destructive testing and examination. A large adjacent shop area is designated for modular assemblies.

A Pipe Cleaning Facility adjacent to the Pipe Production Shop brings materials to Grade B cleanliness.

Target materials are segregated at all times and transferred to the higher Grade A Cleaning facility.

Production Data

Processes:	Base Materials:	Applications:	Standards:
TIG/ Orbital TIG/Mechanized TIG	Stainless Steel	Root Fusion (TIG and Metal Arc)	Ministry of Defence
Metal Arc	Carbon Steel	Flux Coated Around Wire	Lloyds
Submerged Arc	NQ1 Steel	Weld Inserts	ASME 1X
Semi Automatic MIG	Copper Nickel	Toroids	BS EN 287/288
	Monel	Dissimilar Metals	Rolls-Royce
	Copper	Cladding	Any customer specification
	Manganese Molybdenum	Pipe Fabrication	
	Chrome Molybdenum	Modular Build	



BAE Systems Submarines is investing £1.9m in improving the Pipe Production Shop buildings, facilities and tooling to achieve even better production flow and performance gain.