

# ROLLS-ROYCE plc

## TURBINES

*Expires: October 31, 2010*



Subscriber Holding  
Nadcap User Compliance and Audit Program  
(NUCAP)  
Certificate & Scope of Approval



December 1, 2009

Jon Biddulph  
Rolls-Royce plc-Turbine Systems  
PO Box 31  
Elton Road ELT 18  
Derby DE24 8BJ  
UNITED KINGDOM

Dear Mr. Biddulph:

Your facility has been approved for NUCAP. Please note that your NUCAP certificate is valid until **October 31, 2010**. Accordingly, we have enclosed your certificate(s) of approval, your scope of approval, and logo sheet.

**Please note that if any changes occur within your company (i.e., ownership, key managerial staff, equipment, company name, quality manager, address, etc.) that may affect your capability or scope of approved activities, you are required to notify PRI Staff by completing the "Notification of Change/Request for Revised Certification" form located in [eAuditNet.com/Resources/Public Documents/General Documents](http://eAuditNet.com/Resources/Public/Documents/General Documents), immediately.**

We would like to congratulate you on your achievement in meeting the stringent requirements of NUCAP Approval.

If you have any questions concerning the NUCAP Process, please contact PRI Headquarters at (724)772-8660.

Sincerely,

A handwritten signature in black ink that reads "Lisa Shultz". The signature is fluid and cursive.

Lisa Shultz  
Prime Support Engineer  
Industry Managed Programs, Research & Development

LS/emm  
Enclosures  
Certificate(s)  
Scope of Approval  
Logo Sheet



*In accordance with Program Document PD3000, to the revision in effect at the time of the audit, this certificate is granted and awarded by the authority of the Nadcap Users Compliance and Audit Program (NUCAP) Management Council to:*

## *Rolls Royce plc Turbine*

*at*

*See Attached Supplement*

*They have demonstrated conformance and are awarded approval for specific services, listed in the Scope of Approval, as listed in [www.pri-network.org](http://www.pri-network.org) on the Approved User's Listing (AUL), to the revision in effect at the time of the audit for:*

*Chemical Processing, Coatings, Heat Treating, Nonconventional Machining, Nondestructive Testing, and Welding*

*Expiration Date: October 31, 2010  
Certificate Number: 134056  
Issue Date: December 1, 2009*

A handwritten signature in black ink, appearing to read "W. G. Wagner", is written over a horizontal line.

*William G. Wagner, Vice President and General Manager*



## SCOPE OF APPROVAL NUCAP

Approval Date: December 1, 2009  
Expiration Date: October 31, 2010

Audit #134056  
Certificate #134056-D

### ROLLS-ROYCE PLC TURBINE

BTF  
Gypsy Patch Lane, Filton Patchway  
Bristol BS34 7QE  
UNITED KINGDOM

**Chemical Processing, Heat Treating, Nonconventional Machining,  
Non-Destructive Testing and Welding**

In recognition of the successful completion of the PRI evaluation process,  
approval is granted to this facility to perform the following:

#### **Chemical Processing (AC7108) – Audit #132070**

AC7108/2 - Etching: Pre-Penetrant

#### **Heat Treating (AC7102) – Audit #132068**

AC7102 - Nickel and Cobalt Alloys: (Age, Anneal, & Stress Relieve), Customer Specifications / Other

Vacuum Heat Treating: Customer Specifications / Other

AC7102/1 - Vacuum Furnace Brazing

AC7102/S - Supplemental Audit Criteria for Heat Treating:  
U3 – Rolls-Royce plc.

#### **Nonconventional Machining (AC7116) – Audit #132071**

AC7116/3 - Electrical Discharge Machining (EDM): Fast Hole, Sinker

AC7116/4 - Laser Beam Machining (LBM): Cutting, Drilling

#### **Non-Destructive Testing (AC7114 / AC7114 S) – Audit #132069**

AC7114/1 - Liquid Penetrant

AC7114/1S - S-U3 Rolls-Royce plc

**Welding (AC7110) – Audit #132072**

- AC7110/5 - Fusion Welding:  
Baseline (All Audits)  
Supplement E – Casting Repairs (Additional Requirements)  
Supplement F – Filler Materials (Additional Requirements)  
Supplement G – Processes using Gas (for example GTAW, PAW)  
(Additional Requirements)  
Supplement J – Tack Welding (Additional Requirements)  
Supplement K – Verification of Defect Removal (Additional Requirements)  
Supplement M – Filler Material Approved Sources (Additional  
Requirements)  
Supplement N – Gas Contamination at Point of Use (Additional  
Requirements)
- AC7110/12 - Welder/Welding Operator Qualification:  
Baseline (All Audits)
- AC7110/13 - Metallographic Evaluation of Welds:  
Supplement A - Evaluation of Welder / Welding Operator Qualifications  
Supplement B – Evaluation of Fusion Welds

**ROLLS-ROYCE PLC**  
**TURBINE**

**Gate 6 Wilmore Road**  
**Derby, DE24 8BJ**  
**UNITED KINGDOM**

**Chemical Processing, Nonconventional Machining,  
Non-Destructive Testing and Welding**

In recognition of the successful completion of the PRI evaluation process,  
approval is granted to this facility to perform the following:

**Chemical Processing (AC7108) – Audit #132503**

AC7108/2 - Etching: Pre-Penetrant

**Nonconventional Machining (AC7116) – Audit #132504**

AC7116/3 - Electrical Discharge Machining (EDM): Fast Hole, Sinker

**Non-Destructive Testing (AC7114 / AC7114 S) – Audit #132502**

AC7114/1 - Liquid Penetrant

AC7114/1S - S-U3 Rolls-Royce plc

AC7114S - S-U3 Rolls-Royce plc

**Welding (AC7110) – Audit #132505**

AC7110/5 - Fusion Welding:  
Baseline (All Audits)  
Supplement F – Filler Materials (Additional Requirements)  
Supplement G – Processes Using Gas (For Example GTAW, PAW)  
(Additional Requirements)  
Supplement M – Filler Material Approved Sources (Additional  
Requirements)  
Supplement N – Gas Contamination at Point of Use (Additional  
Requirements)

AC7110/12 - Welder/Welding Operator Qualification:  
Baseline (All Audits)

AC7110/13 - Metallographic Evaluation of Welds:  
Supplement A – Evaluation of Welder / Welding Operator Qualifications  
Supplement B – Evaluation of Fusion Welds

**ROLLS-ROYCE PLC**  
**TURBINE**

**Coomsfield Road**  
**Ansty Coventry, CV7 9JR**  
**UNITED KINGDOM**

**Coatings, Nonconventional Machining,**  
**Non-Destructive Testing and Welding**

In recognition of the successful completion of the PRI evaluation process,  
approval is granted to this facility to perform the following:

**Coatings (AC7109) – Audit #132475**

- AC7109/3- Nadcap Audit Criteria for Diffusion Coating Processes  
Pack Process - In Pack
- AC7109/5- Nadcap Audit Criteria for Coating Evaluation Laboratory Practices  
Metallography  
Specimen Preparation  
Thickness - Metallographic
- AC7109/7- Nadcap Audit Criteria for Heat Treating For Suppliers of Coatings

**Nonconventional Machining (AC7116) – Audit #132471**

- AC7116/3 - Electrical Discharge Machining (EDM): Fast Hole, Sinker

**Non-Destructive Testing (AC7114 / AC7114 S) – Audit #132477**

- AC7114/1 - Liquid Penetrant
- AC7114/1S - S-U3 Rolls-Royce plc
- AC7114S - S-U3 Rolls-Royce plc

**Welding (AC7110) – Audit #132480**

- AC7110/5 - Fusion Welding:  
Baseline (All Audits)  
Supplement F – Filler Materials (Additional Requirements)  
Supplement G – Processes Using Gas (For Example GTAW, PAW)  
Supplement K - Verification of Defect Removal  
Supplement L - Traceability of Filler Material Heat Lot  
Supplement M – Filler Material Approved Sources  
Supplement N – Gas Contamination at Point of Use
- AC7110/12 - Welder/Welding Operator Qualification:  
Baseline (All Audits)
- AC7110/13 - Metallographic Evaluation of Welds:  
Supplement A – Evaluation of Welder / Welding Operator Qualifications  
Supplement B – Evaluation of Fusion Welds