

NAVSEA  
STANDARD ITEM

FY-19

ITEM NO: 009-122

DATE: 01 OCT 2017

CATEGORY: I

1. SCOPE:

1.1 Title: Temporary Padeye; install and remove

2. REFERENCES:

2.1 Standard Items

2.2 804-5184133, Padeye, Machinery Lifting

2.3 MIL-STD-1689, Fabrication, Welding, and Inspection of Ships Structure

**2.4 S0600-AA-PRO-160, Underwater Ships Husbandry Manual**

3. REQUIREMENTS:

3.1 Fabricate each temporary padeye and rigging attachment in accordance with 2.2 and 2.3.

**3.1.1 Except as specified in 3.1.1.1, each temporary padeye for weight handling on surface ship and non-nuclear loads shall be designed with a safety factor of six, based on ultimate strength of materials for safe working load.**

**3.1.1.1 Configuration and safety factors for temporary padeyes used solely in the handling and attachment of cofferdams or other underwater fixtures shall meet the requirements of 2.4.**

3.1.2 Submit one legible copy, in hard copy or approved transferrable media, of a report listing the design of each planned temporary padeye not in compliance with 2.2 for SUPERVISOR approval 7 days prior to planned installation. Include material specification, dimensional drawing(s), weld joint design, and installation location.

3.2 Install and inspect each temporary padeye in accordance with 2.2 and 2.3.

3.2.1 Inspect each temporary padeye and support structure for cracks and deformation prior to installation.

3.2.1.1 Submit one legible copy, in hard copy or approved transferrable media, of a report listing results of the requirements of 3.2 and 3.2.1 to the SUPERVISOR.

3.2.2 Accomplish the requirements of 009-12 of 2.1, including Table 2, Columns A, B, or C, lines one through 7.

3.2.3 Maintain a log of each temporary padeye installed to include a unique serial number, Safe Working Load, location by Compartment and approximate frame, date installed and date removed.

(I) " **Non-Destructive Testing**"

3.3 Accomplish a **NDT** of each temporary padeye, attachment weld, and attachment point to ship's structure for deformation, elongation, and cracking. Allowable Defects: None.

**3.3.1 For steel temporary padeyes with a Safe Working Load (SWL) over "2,000" accomplish MT in accordance with 2.3. For steel temporary padeyes with a SWL less than "2,000" accomplish VT in accordance with 2.3.**

**3.3.2 For aluminum temporary padeyes with a SWL over "1,500" pound accomplish PT in accordance with 2.3. For aluminum temporary padeyes with a SWL less than "1,500" pound accomplish VT in accordance with 2.3.**

3.4 Upon completion of satisfactory testing and inspection, label each temporary padeye with paint, paint stick or other permanent marking. Include the padeye serial number, "T" for Temporary, and Safe Working Load (Example: NNN T SWL "2000" lbs).

3.5 Chip and grind surfaces in way of removals each temporary padeye at the conclusion of the work for which they were installed. Removal shall be in accordance with Section 14.10 of 2.3

3.5.1 Weld repair each temporary padeye removal site in accordance with Section 14.10 of 2.3.

3.5.1.1 Accomplish the requirements of 009-12 of 2.1, including Table 2, Columns A, B, or C, lines one through 7.

3.6 Accomplishment of the requirements of 009-32 of 2.1 for new and disturbed surfaces.

3.7 Submit one legible copy, in hard copy or approved transferrable media, of completed log of 3.2.3 to the SUPERVISOR within 72 hours after removing all temporary padeyes, or prior to ship's departure, whichever occurs first.

4. NOTES:

4.1 Weight handling padeyes or devices which are proof-tested **to 200 percent of their SWL with a post-test visual inspection in accordance with paragraph 3.3** do not require inspection of welds by penetrant or magnetic methods unless otherwise specified.