

NAVSEA  
STANDARD ITEM

FY-27

ITEM NO: 009-122  
DATE: 01 OCT 2024  
CATEGORY: I

1. SCOPE:

1.1 Title: Temporary Padeye; install and remove

2. REFERENCES:

2.1 804-5184133, Padeye, Machinery Lifting

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

2.3 ASME BTH-1-2017. Design of Below-the-Hook Lifting Devices

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

3. REQUIREMENTS:

3.1 Design and fabricate each temporary padeye and rigging attachment in accordance with 2.1 through 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 must be designed in accordance with 2.1 and 2.3.

3.1.1.1 Configuration and safety factors for temporary padeyes used solely in the handling and attachment of cofferdams or other underwater fixtures must 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 2.1 and 2.3 for SUPERVISOR approval 7 days prior to planned installation. Include material specification, dimensional drawing(s), weld joint design, intended use, and installation location.

3.1.2.1 Submittal of a design is not required for each temporary padeye (location, material, and dimension) detailed on a NAVSEA-approved drawing in the work item.

3.2 Install and inspect each temporary padeye in accordance with 2.1 through 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 Welding, fabrication, and inspection requirements must be in accordance with NAVSEA Standard Items (See Note 4.2).

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 pounds accomplish VT and MT in accordance with 2.2.

3.3.2 For steel temporary padeyes with a SWL 2,000 pounds and less accomplish VT in accordance with 2.2.

3.3.3 For aluminum temporary padeyes with a SWL over 1,500 pounds accomplish VT and PT in accordance with 2.2.

3.3.4 For aluminum temporary padeyes with a SWL 1,500 pounds and less accomplish VT in accordance with 2.2.

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 "2,000" pounds).

#### (I) NON-DESTRUCTIVE TESTING

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 must be in accordance with Section 14.10 of 2.2.

3.5.1 Inspect each removal site in accordance with 2.2, and inspection requirements of NAVSEA Standard Items (See Note 4.3).

3.5.1.1 MT inspection requirements must be in accordance with NAVSEA Standard Items (See Note 4.4).

3.5.2 Weld repair is in accordance with 2.2, and weld repair requirements of NAVSEA Standard Items (See Note 4.5).

3.6 Accomplish the requirements of 009-032 of NAVSEA Standard items for each new and disturbed surface.

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.

4.2 If welding, fabrication, and inspection requirements including Table 2, Columns A, B, or C, lines one through 7 is required; the use of Category II Standard Item 009-012 "Welding, Fabrication, and Inspection Requirements; accomplish" of NAVSEA Standard Items will be specified in the Work Item.

4.3 If inspection requirements including Table 2, Columns A, B, or C, lines 6, 7, 10, and 11 is required; the use of Category II Standard Item 009-012 "Welding, Fabrication, and Inspection Requirements; accomplish" of NAVSEA Standard Items will be specified in the Work Item.

4.4 If MT requirements including Table 2, Column B, line 11 for all temporary padeye removals from HY-80/100 and HSLA 100/115 primary structure (CVN only) is required; the use of Category II Standard Item 009-012 "Welding, Fabrication, and Inspection Requirements; accomplish" of NAVSEA Standard Items will be specified in the Work Item.

4.5 If welding repair requirements including Table 2, Columns A, B, or C, lines One through 11 is required; the use of Category II Standard Item 009-012 "Welding, Fabrication, and Inspection Requirements; accomplish" of NAVSEA Standard Items will be specified in the Work Item.