

Coded Note Number: **N3470**

Revision: **C001**

Date: **January 3, 2019**

Title: **MOD REQTS FOR MCL STD STL FITTINGS**

Purchase Order (PO) items referencing this note shall meet the following requirements:

1. Material. Fittings shall be manufactured from forgings, where possible, or formed from seamless tubing. Pipe caps may be made from plate if they are formed seamless. As allowed in ASTM A234, pipe caps 4 inch NPS and less may be machined from bar, but shall be subjected to Liquid Penetrant (PT) or Magnetic Particle (MT) inspection.

1.1. The use of welded starting material and weld repair is strictly prohibited.

1.2. The maximum carbon content for all starting material options shall be 0.30 percent.

2. Non-Destructive Test (NDT) Inspection (Caps and Tees Only).

2.1. All caps 4 inch NPS and less machined from bar stock shall be examined by PT or MT in accordance with ASTM A234.

2.1.1. Acceptance shall be in accordance with MIL-STD-2035 and all inspected surfaces of fittings shall be free of linear indications greater than 1/16 inch and linearly disposed rounded indications when there are four or more such rounded indications in a line and each is separated from the adjacent indication by less than 1/16 inch.

2.2. All tees manufactured by cold-forming method(s) shall be PT or MT examined and evaluated in accordance with ASTM A234 requirements in way of the branch, after final heat treat.

Revision History Table		
Rev	Description	Revision Date
C001	Initial Issue	01/03/2019