

Coded Note Number: **N3490**

Revision: **C001**

Date: **June 19, 2020**

Title: **Heat Treatment Requirements: ASTM-B366, ASTM-B564, and QQ-N-281**

- 1.0. This Purchase Order (PO) item shall be heat treated after forming and welding operations (when applicable) are complete. Items machined directly from starting material in the annealed condition detailed herein do not require reannealing.
  - 1.1. The temperature of the item shall be as follows. Hold times shall be as necessary to obtain specification compliant mechanical properties.
    - NICU (UNS N04400): 1425-1475°F +/- 25°F
    - NICRMOCB ALY625 (UNS N06625): 1600°F minimum
  - 1.2. Heat treatment hardware/control equipment shall be in accordance with AMS-H-6875 and shall meet the calibration periodicity requirements in AMS2750.
- 2.0. Heat treatment documentation including a written procedure, certifications, graphs/charts, and calibration records shall be maintained by the Supplier.
- 3.0. Cold work operations after heat treatment are prohibited with the exception of slight cold forming operations in way of the weld prep areas on pipe fittings and flanges. Cold forming operations in way of the weld prep area is only allowed where sizing or shaping does not exceed 2% of the outside diameter (OD).

Revision History Table		
Rev	Description	Revision Date
C001	Initial Issue	06/19/2020