

Y1020-19960324

PARAGRAPH 6.2 - ORDERING DATA

- A. MILITARY SPECIFICATION TUBE AND PIPE, CARBON STEEL, SEAMLESS, MIL-T-20157C DATED 22 JULY 1964 AND IAM#1 DATED 23 SEPT, 1987.
- B. TYPE "E", COLD DRAWN (EXCEPT AS NOTED BELOW FOR SIZES 10" NOMINAL AND LARGER).
- C. AS LISTED IN ORDER.
- D. NOT REQUIRED.
- E. RANDOM LENGTHS, 17 TO 24 FT., WITH ENDS CUT SQUARE.
- F. NOT REQUIRED FOR CLOSE COILING, SEE MODIFICATION TO CYLINDRICAL MANDREL IN NOTES BELOW.
- G. MATERIAL SHALL BE PREPARED FOR DOMESTIC SHIPMENT - IMMEDIATE USE. A THIN FILM OF LIGHT SLUSHING OIL SHALL BE USED AS PROTECTION AGAINST CORROSION. HEAVY OIL OR GREASE WILL NOT BE ACCEPTABLE.
- H. NOT REQUIRED.
- I. THE MATERIAL FURNISHED SHALL BE SUBSTANTIALLY TAGGED OR CLEARLY MARKED FOR IDENTIFICATION WITH THE ITEM AND PURCHASE ORDER NUMBER THEREOF. DIE STAMPING IS NOT PERMITTED.

PARAGRAPH 3.11.1.1 - ADD THE FOLLOWING:

"THE PERMISSIBLE VARIATIONS IN OUTSIDE DIAMETER OF TYPE E TUBING FURNISHED SHALL BE AS SPECIFIED IN TABLE VII FOR TYPE A, B, C AND D TUBING."
IN TABLE VII, PAGE 7, UNDER "TYPES", CHANGE "A, B, C AND D" TO READ A, B, C, D AND E. DELETE THE REFERENCE TO "ALL SIZES" AND "1.00 PERCENT" SHOWN FOR TYPE

E TUBING.

PARAGRAPH 4.4.5 - IN THE THIRD LINE, DELETE
"12 TIMES" AND SUBSTITUTE "10 TIMES".

PIPE AND TUBING IN SIZES 10" NOMINAL AND
LARGER ARE TO BE FURNISHED IN ACCORDANCE
WITH MIL-T-20157C IAM#1 EXCEPT AS FOLLOWS:

- . PARAGRAPH 3.1 - ADD THE FOLLOWING
SENTENCE: "PIPE MAY BE MADE BY THE
BASIC-OXYGEN PROCESS."
- . PARAGRAPHS 3.5, 4.2.2.3 AND 4.3 - ADD THE
FOLLOWING: "FLATTENING TEST REQUIREMENTS
TO BE SAME AS FLATTENING TEST REQUIRE-
MENTS OF ASTM-A106, GRADE B."
- . PARAGRAPH 3.13 - ADD THE FOLLOWING
SENTENCE: "THE PIPE SURFACE FINISH SHALL
BE IN THE HOT-ROLLED AS-ROLLED CONDITION."
- . PARAGRAPH 3.16 - ADD THE FOLLOWING
SENTENCE: "ALLOWABLE SURFACE DEFECTS
SHALL BE AS DEFINED IN ASTM-A106. NO SUR-
FACE DEFECTS REDUCING THE WALL THICKNESS
BELOW MINIMUM ALLOWABLE WILL BE PERMITTED."
- . PARAGRAPH 4.4.1 - ADD THE FOLLOWING:
"THE CHEMICAL ANALYSIS OF PIPE MANUFAC-
TURED IN ACCORDANCE WITH ASTM-A106 SHALL
BE MADE FROM ONE SAMPLE FROM EACH OF TWO
PIECES OF PIPE FROM EACH HEAT AND SEPARA-
TELY ANALYZED TO DETERMINE COMPLIANCE
WITH PARAGRAPH 3.3 OF MIL-T-20157C IAM#1".