

Coded Note Number: **Y1020**

Revision: **C001**

Date: **September 4, 2017**

Title: **STEEL PIPE & TUBING REQUIREMENTS**

**This revision history is provided for convenience and does not alleviate the supplier's responsibility with understanding and complying with the full coded note.**

**Change from Revision A – Editorial change to reformat to current standard.**

**Bolded font indicates changed/added content.**

**[Text deleted] inserted in the document indicates the removal of content.**

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 requirements 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 surface defects reducing the wall thickness below minimum allowable will be permitted."

Paragraph 4.4.1 - Add the following: "The chemical analysis of pipe manufactured in accordance with ASTM-A106 shall be made from one sample from each of two pieces of pipe from each heat and separately analyzed to determine compliance with paragraph 3.3 of MIL-T-20157C IAM#1".