

Y1310-19960324

ALL MIL-C-15726 COPPER NICKEL RAW MATERIAL AND ALL MIL-C-15726 PARTS IN AN ASSEMBLY THAT MAY BE WELDED BY THE SHIPBUILDER SHALL BE FURNISHED TO MIL-C-15726E DATED 20 AUGUST 1965, AMENDMENT 3 DATED 22 DECEMBER 1980 AND MODIFIED AS FOLLOWS:

ONLY GRADE 2 MATERIAL SHALL BE PROVIDED.

PG. 1, PARAGRAPH 1.2, ADD;

"GRADE:

- 1 - MATERIAL SUPPLIED WITHOUT HEAT IDENTIFICATION
- 2 - MATERIAL SUPPLIED WITH HEAT IDENTIFICATION"

PG. 2, TABLE I, DELETE AND SUBSTITUTE;

"TABLE I. CHEMICAL COMPOSITION.

ELEMENT	90-10 COPPER	70-30 COPPER
	NICKEL	NICKEL
PERCENT MAXIMUM (UNLESS SHOWN AS A RANGE OR MINIMUM)		
COPPER (INCLUDING SILVER), MINIMUM	86.5	65.0
NICKEL (INCLUDING COBALT)	9.0 - 11.0	29.0 - 33.0
IRON	1.0 - 1.8	0.40 - 1.0
MANGANESE	1.0	1.0
ZINC	0.50	0.50
LEAD	0.02	0.02
PHOSPHORUS	0.02	0.02
SULFUR	0.02	0.02
CARBON	0.05	0.05
COPPER PLUS ELEMENTS WITH SPECIFIC LIMITS, MINIMUM	99.5	99.5

PG. 6, PARAGRAPH 4.3, DELETE AND SUBSTITUTE:

"4.3 LOT DEFINITION

4.3.1 ROD AND FLAT PRODUCTS - UNLESS OTHERWISE SPECIFIED IN THE CONTRACT OR ORDER (SEE 6.1), A LOT SHALL CONSIST OF 5000 POUNDS OR FRACTION THEREOF OF MATERIAL OF THE SAME COMPOSITION, FORM, TEMPER, AND SIZE, SUBMITTED FOR DELIVERY AT THE SAME TIME. IN ADDITION, GRADE 2 MATERIAL SHALL BE FROM THE SAME HEAT AND SHALL BE IDENTIFIED WITH RESPECT TO HEAT. LOTS OF GRADE 2 MATERIAL SHALL BE RESTRICTED TO A SINGLE UNIQUE HEAT.

4.3.2 FORGINGS -

A. FORGINGS WEIGHING 250 POUNDS OR LESS - A LOT SHALL CONSIST OF FORGINGS HAVING A TOTAL WEIGHT OF 1000 POUNDS OR LESS, OF THE SAME DESIGN, AND FROM THE SAME HEAT TREATMENT BATCH. GRADE 2 MATERIAL SHALL BE FROM THE SAME HEAT AND SHALL BE IDENTIFIED WITH RESPECT TO HEAT. LOTS OF GRADE 2 MATERIAL SHALL BE RESTRICTED TO A SINGLE UNIQUE HEAT.

B. FORGINGS WEIGHING OVER 250 POUNDS - A LOT SHALL CONSIST OF EACH INDIVIDUAL FORGING. FOR GRADE 2 MATERIAL EACH FORGING SHALL BE IDENTIFIED WITH RESPECT TO HEAT."

PAGE 6, PARAGRAPH 4.5, DELETE AND SUBSTITUTE:

"4.5 SAMPLING FOR CHEMICAL ANALYSIS

4.5.1 ROD AND FLAT PRODUCTS - SAMPLES SHALL BE TAKEN FROM TWO DIFFERENT REPRESENTATIVE PRODUCTION PIECES SELECTED AT RANDOM FOR EACH LOT.

4.5.2 FORGINGS

4.5.2.1 FORGINGS LESS THAN 250 POUNDS IN AS FORGED WEIGHT - SAMPLES SHALL BE TAKEN FROM TWO DIFFERENT PRODUCTION FORGINGS SELECTED AT RANDOM FROM EACH LOT.

4.5.2.2 FORGINGS WEIGHING 250 POUNDS OR MORE IN AS FORGED WEIGHT - EACH FORGING SHALL BE SAMPLED.

PG. 7, PARAGRAPH 4.8.1, DELETE AND SUBSTITUTE

"4.8.1 CHEMICAL ANALYSIS - FROM EACH SAMPLE (SEE 4.5), NOT LESS THAN 2 OUNCES OF CLEAN MILLINGS, DRILLINGS OR CHIPPINGS SHALL BE OBTAINED FOR CHEMICAL ANALYSIS. EITHER THE WET CHEMICAL METHOD 111 OR THE SPECTROGRAPHIC

METHOD 112 OF FED-STD-151 MAY BE USED. IN CASE OF DISPUTE, A WET CHEMICAL METHOD SHALL BE THE BASIS FOR ACCEPTANCE. WHEN ANALYZING FOR PHOSPHORUS AND SULFUR CONTENT, EACH HEAT OR EACH INGOT SHALL BE SAMPLED. IF ANY SAMPLE FAILS TO MEET THE REQUIREMENTS OF TABLE I, THIS SHALL BE CAUSE FOR REJECTION OF THE LOT REPRESENTED BY THE SAMPLE."

PG. 10, PARAGRAPH 6.1(B), DELETE AND SUBSTITUTE:

"6.1(B) THE COMPOSITION, FORM TEMPER AND GRADE OF THE MATERIAL REQUIRED."

PG. 10, PARAGRAPH 6.1(P), DELETE.

FOR EACH HEAT OF GRADE 2 MATERIAL SUPPLIED, A MINIMUM OF 2 CHEMICAL AND 2 MECHANICAL TESTS SHALL BE PROVIDED.