

Y1930
Revision Level A
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UT OF K-MONEL HOT FORGED BAR 4.000 OR LARGER

Y1930-19960324

ALL HOT FORGED NICKEL-COPPER-ALUMINUM (K-MONEL, QQ-N-286) BAR 4.000 INCHES OR OVER IN DIAMETER AND ROD 16 SQ INCHES OR OVER IN CROSS SECTIONAL AREA SHALL BE ULTRASONICALLY INSPECTED IN ACCORDANCE WITH THE REQUIREMENTS OF QQ-N-286E AMENDMENT 1. AFTER FINAL HEAT TREATMENT MODIFIED AS FOLLOWS:

PARAGRAPH 4.6.3.4.1.1- CHANGE "LOSS OF BACK REFLECTION....." TO "COMPLETE LOSS OF BACK REFLECTION.....".

PARAGRAPH 4.6.3.2.2- DELETE THE FIRST SENTENCE AND REPLACE WITH THE FOLLOWING TWO SENTENCES: "INSPECTION SHALL BE PERFORMED BY MAKING TWO SCANS, 90 DEG. APART, ALONG THE LENGTH OF THE BAR WITH EACH OF THE TWO PASSES DIRECTED SUCH THAT THE SOUND BEAM PASSES THROUGH THE CENTER OF THE BAR. A PITCH-CATCH TECHNIQUE AS ILLUSTRATED IN FIGURE 2 SHALL BE USED."

PARAGRAPH 4.6.3.2.2.1- LAST SENTENCE- CHANGE "80% TO 90%..." TO "...50% TO 90%...".

PARAGRAPH 4.6.3.4.1.2- FIRST SENTENCE- AFTER "ABRUPT REDUCTIONS IN SIGNAL AMPLITUDE..." ADD "...OF 50% OR MORE...".