

Y2340

Revision Level C001

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SCRIBE LINE ON SOCKET WELD FITTINGS/COMPONENTS

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A SCRIBE LINE FOR WELD INSPECTION PURPOSES SHALL BE MARKED ON ALL FINISHED SOCKET WELD FITTINGS/COMPONENTS AND BELLED END FITTINGS AS FOLLOWS:

- A) THE SCRIBE LINE SHALL BE MARKED AROUND THE ENTIRE OUTSIDE CIRCUMFERENCE (360 DEGREES) OF THE **SOCKET WELD OR BELLED END** FITTING/COMPONENT **WHERE PRACTICABLE**, $1/2 \pm 1/64$ INCH FROM THE SOCKET/**FITTING** FACE. **WHEN THE** FITTING/COMPONENT GEOMETRY DOES NOT PERMIT THE SCRIBE LINE TO BE LOCATED **AT 1/2 INCH** AS SPECIFIED ABOVE, THE SCRIBE LINE SHALL BE **MARKED AROUND THE ENTIRE OUTSIDE CIRCUMFERENCE (360°) OF THE SOCKET WELD OR BELLED END FITTING/COMPONENT, 1/4 ± 1/64 INCH FROM THE SOCKET/FITTING FACE. IF THE SCRIBE LINE CANNOT BE MARKED AROUND THE ENTIRE CIRCUMFERENCE OF THE FITTING, IT SHALL BE APPLIED AROUND AS MUCH OF THE CIRCUMFERENCE AS POSSIBLE. IF THE SCRIBE LINE CANNOT BE LOCATED AT EITHER OF THESE TWO LOCATIONS ON THE FITTING DUE TO PART GEOMETRY, THEN NO SCRIBE LINE SHALL BE APPLIED AND NORTHROP GRUMMAN NEWPORT NEWS SHALL SELECT A SUITABLE SURFACE FOR LOCATING THE SOCKET/FITTING FACE IN LIEU OF A SCRIBE LINE.**
- B) THE SCRIBE LINE SHALL BE APPLIED WITH VIBRO TOOLS OR MADE BY MACHINE TOOL TO A DEPTH OF 0.005/0.010 INCH, BUT SHALL NOT VIOLATE THE MINIMUM WALL THICKNESS REQUIREMENTS OF THE FITTING/COMPONENT AT ANY TIME. VIBRO TOOL MARKING SHALL NOT BE USED ON FITTINGS/COMPONENTS LESS THAN 1/8 INCH THICK. SEE MIL-STD-792 FOR DETAILED MARKING REQUIREMENTS AND MARKING RESTRICTIONS AND LIMITATIONS.
- C) IF THE SCRIBE LINE CANNOT BE APPLIED WITHOUT VIOLATING THE MINIMUM WALL THICKNESS REQUIREMENTS OF THE FITTING/COMPONENT, A LINE NO WIDER THAN 0.015 INCH **SHALL** BE APPLIED BY CHEMICAL, LASER OR ELECTRO-CHEMICAL ETCHING FOR USE AS A SCRIBE LINE.