

MIL-E-19933E(SH)
AMENDMENT 1
29 September 1982

MILITARY SPECIFICATION

ELECTRODES AND RODS - WELDING, BARE, CHROMIUM
AND CHROMIUM - NICKEL STEELS

This amendment forms a part of Military Specification MIL-E-19933E(SH), dated 5 August 1981, and is approved for use by the Naval Sea Systems Command, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

PAGE 1

At bottom of page, beneficial comments statement: Delete and substitute:

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document shall be addressed to: Commander, Naval Sea Systems Command, SEA 5523, Department of the Navy, Washington, DC 20362 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

PAGE 4

3.1, line 4: Delete "6.4" and substitute "6.5".

PAGE 6

3.2.5 Delete and substitute:

"3.2.5 Alloy identity. Each end of rod or wire to be spliced during processing shall be sampled for alloy identity just prior to splicing at the process station (see 4.6.2), except when splicing is done to repair a wire break without removing the wire from the process line. The sample shall be tested for alloy identity prior to release for shipment."

3.2.5.1.1 Delete and substitute:

"3.2.5.1.1 For continuous process operation where rod coil is drawn to finish size, straightened and cut to length without removal from the machine, both ends of each rod coil shall be sampled for alloy identity test immediately prior to the start of the continuous processing operation. The sample shall be tested for alloy identity prior to release for shipment."

FSC 3439

MIL-E-19933E(SH)
AMENDMENT 1

3.2.5.1.2 Delete and substitute:

"3.2.5.1.2 When rod coils are to be spliced during continuous processing operations, each end of each rod coil to be spliced shall be sampled for alloy identity at the process station just prior to splicing. The sample shall be tested for alloy identity prior to release for shipment. In addition, the leading end of the first coil and the tail end of the last coil for each continuous process run shall be alloy identity tested. When alloy identity testing is accomplished in accordance with 3.2.5.1.1 herein, these requirements are satisfied as well."

PAGE 12

6.2(f): Delete.

LAST PAGE

DD 1426, Standardization Document Improvement Proposal: Delete address and substitute:

"COMMANDER
NAVY SEA SYSTEMS COMMAND (SEA 5523)
DEPARTMENT OF THE NAVY
WASHINGTON, DC 20362"

Preparing activity:
Navy - SH
(Project 3439-N446)