

MIL-P-24691/1
 23 September 1987
 SUPERSEDING
 MIL-T-20157C
 22 July 1964
 (See 6.3)

MILITARY SPECIFICATION

PIPE AND TUBE, CARBON STEEL, SEAMLESS

This specification is approved for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers seamless carbon steel pipe and tube for various services such as oil, water, steam and gas for use at temperatures not over 775 degrees Fahrenheit (°F).

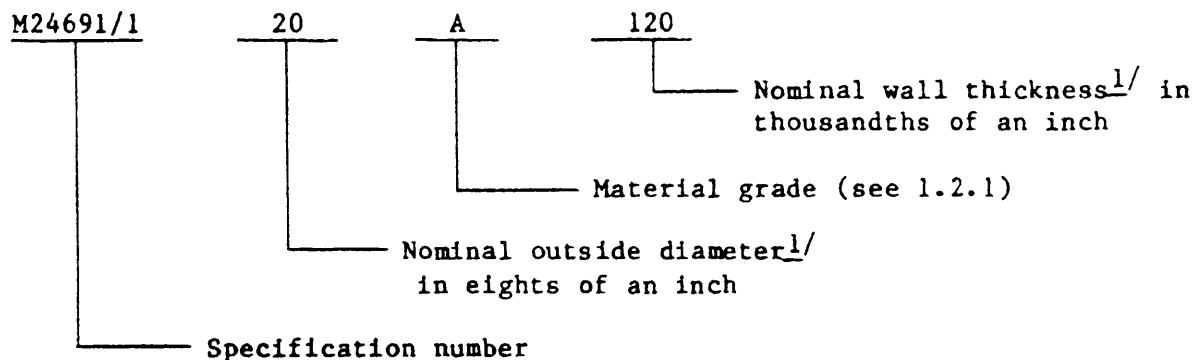
1.2 Classification.

1.2.1 Grades. Pipe and tube covered by this specification shall be one of the following grades identified in ASTM A 106, as specified (see 6.2):

Grade A - Low carbon

Grade B - Medium carbon

1.2.2 Part number.



^{1/} Pipe outside diameters and wall thickness (schedule) shall be selected from those shown in ANSI B36.10.

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, Naval Sea Systems Command, SEA 5523, Department of the Navy, Washington, DC 20362-5101 by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

AMSC N/A

FSC 4710

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2. APPLICABLE DOCUMENTS

2.1 Government document.

2.1.1 Specification. The following specification forms a part of this specification to the extent specified herein. Unless otherwise specified, the issues of this document shall be that listed in the issue of the Department of Defense Index of Specifications and Standards (DoDISS) and the supplement thereto, cited in the solicitation.

SPECIFICATION

MILITARY

MIL-P-24691 - Pipe and Tube, Carbon, Alloy and Stainless Steel, Seamless and Welded, General Specification for.

(Copies of specifications required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting activity.)

2.2 Other publications. The following documents form a part of this specification to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted shall be those listed in the issue of the DoDISS specified in the solicitation. Unless otherwise specified, the issues of documents not listed in the DoDISS shall be the issue of the nongovernment documents which is current on the date of the solicitation.

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

A 106 - Standard Specification for Seamless Carbon Steel Pipe for High-Temperature Service. (DoD adopted)

A 450 - Standard Specification for General Requirements for Carbon, Ferritic Alloy, and Austenitic Alloy Steel Tubes. (DoD adopted)

A 530 - Standard Specification for General Requirements for Specialized Carbon and Alloy Steel Pipe. (DoD adopted)

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

(Nongovernment standards and other publications are normally available from the organizations which prepare or which distribute the documents. These documents also may be available in or through libraries or other informational services.)

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein (except for associated detail specifications, specification sheets or MS standards), the text of this specification shall take precedence. Nothing in this specification, however, shall supersede applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 General. Pipe and tube furnished under this specification shall be acquired to ASTM A 106 with the following additional requirement. The general requirements of MIL-P-24691 and ASTM A 530 form a part of this specification.

3.2 Flaring. When tubing versus piping is ordered, the flaring test of ASTM A 450 shall be performed.

4. QUALITY ASSURANCE PROVISIONS

4.1 The quality assurance provisions shall be in accordance with MIL-P-24691 and as specified herein.

4.2 Quality conformance provisions. Table I shall be used to determine location of quality conformance provisions.

TABLE I. Summary of quality conformance inspections.

Characteristic	Requirement specification	Sampling specification	Examination or test specification
Group A			
Dimensions	MIL-P-24691	MIL-P-24691	MIL-P-24691
Finish	MIL-P-24691	MIL-P-24691	MIL-P-24691
Marking	MIL-P-24691	MIL-P-24691	MIL-P-24691
Workmanship	ASTM A 106	MIL-P-24691	MIL-P-24691
Group B			
Hydrostatic test	ASTM A 106 and ASTM A 530	MIL-P-24691	ASTM A 106
Ultrasonic inspection	MIL-P-24691/1	MIL-P-24691	MIL-P-24691
Group C			
Chemical analysis	ASTM A 106	MIL-P-24691	ASTM A 530
Mechanical properties	ASTM A 106	MIL-P-24691	ASTM A 530
Flattening	ASTM A 106	MIL-P-24691	ASTM A 530
Bending	ASTM A 106	MIL-P-24691	ASTM A 106
Flaring	MIL-P-24691/1	MIL-P-24691	ASTM A 450

5. PACKAGING

5.1 Preservation, packaging, packing and marking shall be in accordance with MIL-P-24691.

6. NOTES

6.1 Intended use. Seamless carbon steel pipe and tube is used as pressure pipe to convey oil, steam, water or gas. Pipe covered by this specification is intended for use at temperatures not over 775°F.

6.2 Ordering data. In addition to the ordering data of MIL-P-24691, acquisition documents should specify the following:

- (a) Grade required (see 1.2).
- (b) Quantity required.

6.3 Supersession. This specification supersedes MIL-T-20157 as follows:

<u>MIL-T-20157, types</u>	<u>MIL-P-24691/1 grades</u>
A, B, C, D	A
E	B

6.4 Subject term (key word) listing.

Flaring
Gas
Oil
Pressure pipe
Steam
Water

Custodians:

Army - ME
Navy - SH

Preparing activity:

Navy - SH
(Project 4710-0849)

Review activities:

Army - GL, MR, AR, EA, MI
Navy - AS
DLA - CS

User activity:

Navy - MC

INSTRUCTIONS: In a continuing effort to make our standardization documents better, the DoD provides this form for use in submitting comments and suggestions for improvements. All users of military standardization documents are invited to provide suggestions. This form may be detached, folded along the lines indicated, taped along the loose edge (*DO NOT STAPLE*), and mailed. In block 5, be as specific as possible about particular problem areas such as wording which required interpretation, was too rigid, restrictive, loose, ambiguous, or was incompatible, and give proposed wording changes which would alleviate the problems. Enter in block 6 any remarks not related to a specific paragraph of the document. If block 7 is filled out, an acknowledgement will be mailed to you within 30 days to let you know that your comments were received and are being considered.

NOTE: This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

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STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL

(See Instructions - Reverse Side)

1. DOCUMENT NUMBER MIL-P-24691/1		2. DOCUMENT TITLE PIPE AND TUBE, CARBON STEEL, SEAMLESS	
3a. NAME OF SUBMITTING ORGANIZATION		4. TYPE OF ORGANIZATION (Mark one)	
b. ADDRESS (Street, City, State, ZIP Code)		<input type="checkbox"/> VENDOR	
		<input type="checkbox"/> USER	
		<input type="checkbox"/> MANUFACTURER	
		<input type="checkbox"/> OTHER (Specify): _____	
5. PROBLEM AREAS			
a. Paragraph Number and Wording:			
b. Recommended Wording:			
c. Reason/Rationale for Recommendation:			
6. REMARKS			
7a. NAME OF SUBMITTER (Last, First, MI) - Optional		b. WORK TELEPHONE NUMBER (Include Area Code) - Optional	
c. MAILING ADDRESS (Street, City, State, ZIP Code) - Optional		8. DATE OF SUBMISSION (YYMMDD)	

(TO DETACH THIS FORM, CUT ALONG THIS LINE.)