

INCH- POUND  
MIL-P-24691  
AMENDMENT 2  
4 February 1991  
SUPERSEDING  
AMENDMENT 1  
16 August 1988

MILITARY SPECIFICATION

PIPE AND TUBE, CARBON, ALLOY AND STAINLESS STEEL,  
SEAMLESS AND WELDED,  
GENERAL SPECIFICATION FOR

This amendment forms a part of MIL-P-24691, dated 23 September 1987, and is approved for use by all Departments and Agencies of the Department of Defense.

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- \* 2.2: Under ASTM, add the following:
- "D 3951 - Standard Practice for Commercial Packaging. (DoD adopted)".

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- \* 2.2: Delete the following:
- "NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT  
National Motor Freight Classification
- (Application for copies should be addressed to the National Motor Freight Traffic Association, Inc., ATA TRAFFIC Dept., 2200 Mill Road, Alexandria, VA 22314.)

UNIFORM CLASSIFICATION COMMITTEE AGENT  
Uniform Freight Classification Ratings, Rules and Regulations

(Application for copies should be addressed to the Uniform Classification Committee Agent, Traffic Publication Officer, Room 1106, 222 South Riverside Plaza, Chicago, IL 60606.)".

AMSC N/A

FSC 4710

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- \* 3.6: Delete and substitute:

"3.6 Cleanliness. Pipe and tube shall be free from heavy oxide or scale. The internal surface of hot finished ferritic steel pipe and tube shall be pickled or blast cleaned to a free of scale condition equivalent to the CSa2 visual standard listed in SSPC - SP6. Cleaning shall be performed in accordance with a written procedure that has been shown to be effective. This procedure shall be available for audit."

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- \* 4.4.1: Delete and substitute:

"4.4.1 Chemical analysis. One sample for chemical analysis shall be selected from each of two tubes or pipes chosen from each lot. The sampling method shall be in accordance with the detail specification."

- \* 4.4.3: Delete and substitute:

"4.4.3 Flattening and flaring test and visual and dimensional inspections. As a minimum, the contractor shall inspect a sample quantity of tube or pipe as follows:

| <u>Lot size (pieces per lot)</u> | <u>Sample size</u> |
|----------------------------------|--------------------|
| 2 to 8                           | Entire lot         |
| 9 to 90                          | 8                  |
| 91 to 150                        | 12                 |
| 151 to 280                       | 19                 |
| 281 to 500                       | 21                 |
| 501 to 1200                      | 27                 |
| 1201 to 3200                     | 35                 |

If one or more defects is found in any sample, the entire lot shall be rejected. The contractor may inspect 100 percent and deliver only conforming material."

- \* 4.4.4: Delete and substitute:

"4.4.4 Hydrostatic and ultrasonic tests. Each tube and pipe shall be tested by the hydrostatic and ultrasonic tests."

- \* 4.5.2, line 3: Delete the following sentence:

"The specified hydrostatic pressure produces in the tube wall a stress not less than 60 percent of the minimum specified yield strength."

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- \* 5.1: Delete and substitute:

"5.1 Preservation. Preservation shall be level A or commercial as specified (see 6.2.1)."

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- \* 5.1.2: Delete and substitute:

"5.1.2 Commercial. Preservation shall be in accordance with ASTM D 3951."

- \* 5.2: Delete "C" and substitute "commercial".

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- \* 5.2.4: Delete and substitute:

"5.2.4 Commercial. Pipe or tube, preserved as specified (see 6.2.1) and in the quantity required (see 5.2.1), shall be packed in accordance with ASTM D 3951."

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- \* 6.2.1: Delete "(f) If pipe or tube is to be used for steam lines (see 3.6)."

6.3: Delete and substitute:

- \* "6.3 Supersession data: This specification supersedes MIL-T-20157, MIL-T-18165 and MIL-P-1144."

The margins of this amendment are marked with an asterisk or vertical lines to indicate where changes (additions, modifications, corrections, deletions) from the previous amendment were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous amendment.

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Army - ME  
Navy - SH

Preparing activity:

Navy - SH  
(Project 4710-1111)

Review activities:

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

User activity:

Navy - MC

