

INCH-POUND

MIL-S-24149/6C(SH)

27 March 1989

SUPERSEDING

MIL-S-24149/6B

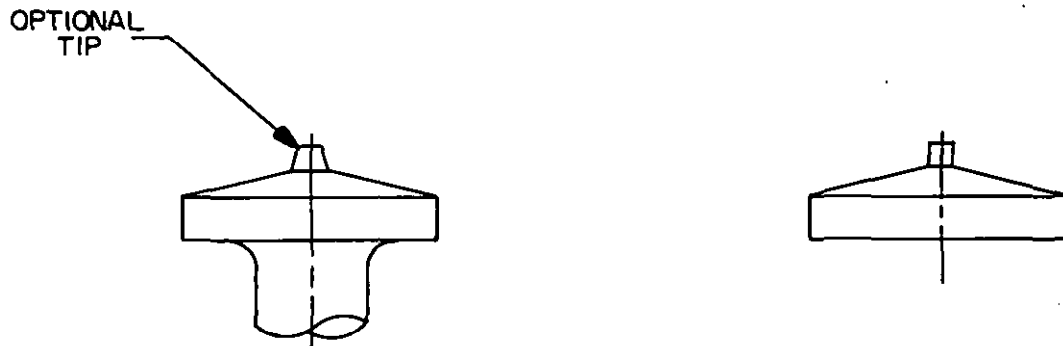
1 June 1981

MILITARY SPECIFICATION SHEET

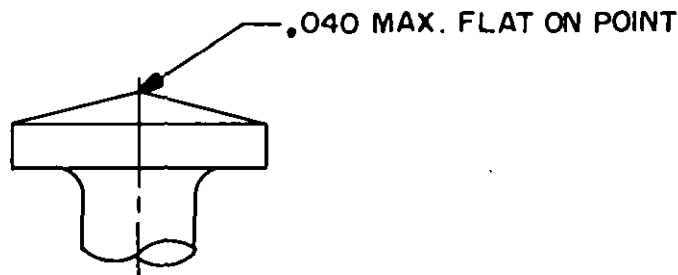
STUDS, WELDING,
 TYPE VIII, CLASS 1,2,3, CORROSION-RESISTANT STEEL FOR
 STORED ENERGY (CAPACITOR DISCHARGE) ARC WELDING

This specification sheet 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.

The requirements for acquiring the product described herein shall consist of this specification sheet and the issue of the following specification listed in that issue of the Department of Defense Index of Specifications and Standards (DoDISS) specified in the solicitation: MIL-S-24149(SH).



CORROSION-RESISTANT STEEL STUDS, TYPE VIII, STYLE A, TIPPED WELD-END.



CORROSION-RESISTANT STEEL STUDS, TYPE VIII, STYLE B, POINTED WELD-END.

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NOTE:

1. The choice of weld-end style shall be based on the type of stored energy welding equipment to be used.

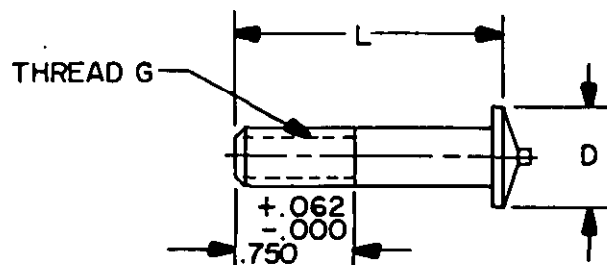
FIGURE 1. Optional weld-end styles.

AMSC N/A

FSC 5307

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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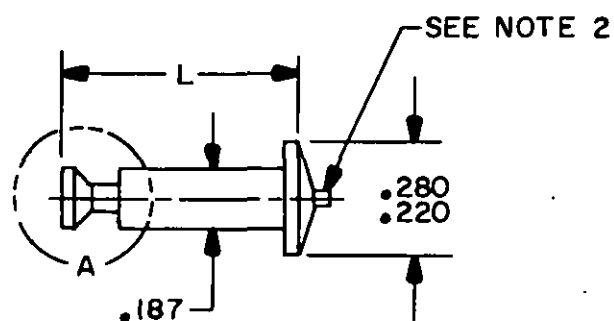
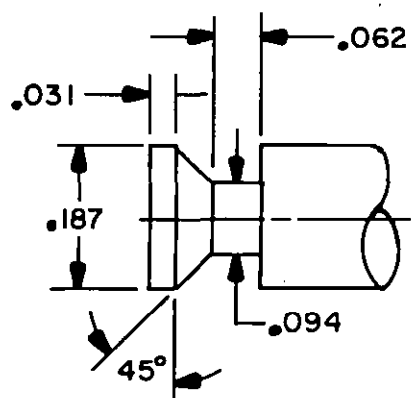
FIGURE 2. Type VIII, class 1, stud with threaded end.TABLE 1. Configuration part numbers.

G	D	L ±0.031	M24149/6 dash no.
0.1900-32UNF-2A	0.280	1.250	-1
		1.375	-2
		1.500	-3
		1.625	-4
		1.750	-5
		1.875	-6
	0.220	2.000	-7
		2.250	-8
		2.500	-9
		2.750	-10
		3.000	-11
		3.250	-12
		3.500	-13
0.2500-20UNC-2A	0.340	1.250	-14
		1.375	-15
		1.500	-16
	0.280	1.625	-17
		1.750	-18
		1.875	-19
		2.000	-20
		2.250	-21
		2.500	-22
		2.750	-23
		3.000	-24
		3.250	-25
		3.500	-26

NOTE:

1. Dimensions are in inches. Unless otherwise specified, tolerance: decimals plus or minus 0.015.

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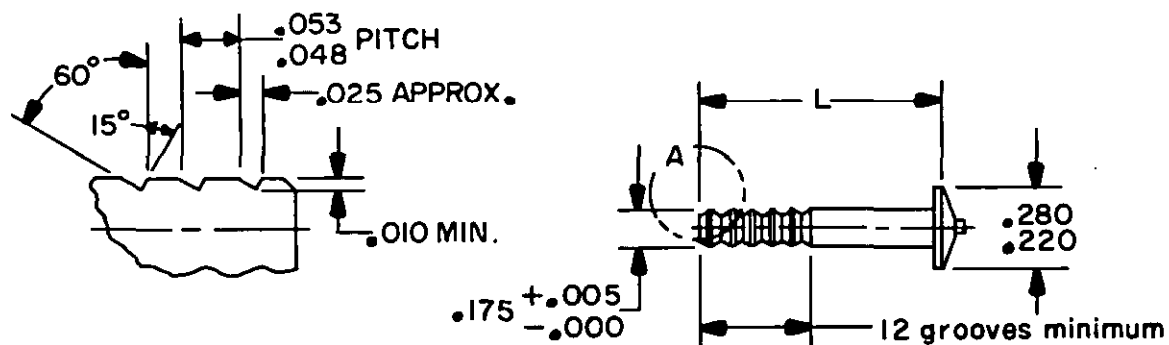
VIEW AFIGURE 3. Type VIII, class 2, stud with notched end.TABLE II. Length part numbers.

L ±0.031	M24149/6 dash no.
0.625	-101
.750	-102
.875	-103
1.000	-104
1.125	-105
1.250	-106
1.375	-107
1.500	-108
1.625	-109
1.750	-110
1.875	-111
2.000	-112
2.250	-113
2.500	-114
2.750	-115
3.000	-116

NOTE:

1. Dimensions are in inches. Unless otherwise specified, tolerances: decimals plus or minus 0.015, angles plus or minus 2 degrees.

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VIEW AFIGURE 4. Type VIII, class 3, stud with grooves (annular rings).TABLE III. Length part numbers.

L +0.031	M24149/6 dash no.
0.625	-201
.750	-202
.875	-203
1.000	-204
1.125	-205
1.250	-206
1.375	-207
1.500	-208
1.625	-209
1.750	-210
1.875	-211
2.000	-212
2.250	-213
2.500	-214
2.750	-215
3.000	-216

NOTE:

1. Dimensions are in inches. Unless otherwise specified, tolerances: decimals plus or minus 0.015, angles plus or minus 1 degree.

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REQUIREMENTS:

1. Material - Corrosion-resistant steel.
2. Tensile strength - 70,000 lb/in², minimum.
3. Chemical composition - Studs shall be of the chemical composition indicated in table IV at the option of the contractor.

TABLE IV. Chemical composition.

UNS No.	Carbon	Manganese	Phosphorus	Sulfur	Silicon	Nickel	Chromium	Other elements
S30400	0.08	2.00	0.045	0.030	1.00	8.00-10.50	18.00-20.00	Cu 3.00-4.00
S30430	.10	2.00	.045	.030	1.00	8.00-10.00	17.00-19.00	
S30500	.12	2.00	.045	.030	1.00	10.50-13.00	17.00-19.00	
S30900	.20	2.00	.045	.030	1.00	12.00-15.00	22.00-24.00	
S31000	.25	2.00	.045	.030	1.00	19.00-22.00	24.00-26.00	
S31600	.08	2.00	.045	.030	1.00	10.00-14.00	16.00-18.00	Mo 2.00-3.00

1/ The chemical compositions listed are standard AISI heat analysis and AISI product tolerances shall apply. Unless a range is shown, values are maximum percentages.

4. Part number - The part number consists of the prefix letter "M" and the specification sheet number plus the applicable dash number.

Example:

M24149/6-7 - Type VIII, class 1 welding stud 0.1900-32 UNF-2A thread, 2.000 inch length.

NOTE:

1. Changes from previous issue - Revision letters are not used to denote changes due to the extensiveness of the changes.

Preparing activity:
Navy - SH
(Project 5307-N029)