

MIL-T-5066B
AMENDMENT-1
5 NOVEMBER 1968

MILITARY SPECIFICATION
**TUBING, CARBON STEEL (1025), SEAMLESS AND
 WELDED (AIRCRAFT QUALITY)**

This amendment forms a part of Military Specification MIL-T-5066B, 22 May 1967, and is mandatory for use by all Departments and Agencies of the Department of Defense.

Page 1,

- (a) In title, delete "SEAMLESS AND WELDED."
- (b) Paragraph 1.2.1: Delete in its entirety.
- (c) Paragraph 1.2.2: Delete, and substitute:

"1.2.1 *Condition.* Tubing shall be supplied in the following conditions, as specified (see 6.2):

- (A) Normalized
- (B) Cold drawn and stress relieved."

Page 2,

- (a) Paragraph 3.1.1: Delete the period at end of paragraph, and add the following: " and shall be reduced by subsequent drawing to refine the microstructure of the weld zone and produce uniform grain size throughout."
- (b) Add as new paragraph:

"3.1.2 Either welded or seamless tubing may be furnished at the option of the vendor."

Page 3, table I: Delete, and substitute:

"Table I. *Chemical composition*¹

Element	Composition limits (percent)	Check analysis tolerance (percent)
Silicon	0.30 (max.)	+ 0.02
Carbon	0.22 - 0.28	± 0.02
Manganese	0.30 - 0.60	± 0.03
Phosphorus	0.025 (max.)	+ 0.008
Sulfur	0.025 (max.)	+ 0.008
Other elements, total	0.75 (max.)	+ 0.02

¹The average of all separate determinations shall be within the limits specified in the composition column. Individual determinations may vary to the extent shown by the tolerance column, except that several determinations of a single element in the samples from a single inspection lot shall not vary both above and below the specified range.

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Page 4,

- (a) Paragraph 3.4.2:
 - (1) In first line, delete "Welded."
 - (2) In second line, delete "in the weld."
- (b) Paragraph 3.6.1: Add "(See 6.2.)" at end of paragraph.
- (c) Paragraph 3.9: Delete last sentence, and substitute the following:

"Tubing may be pickled or otherwise cleaned, as necessary, to meet the surface conditions specified herein."

Page 5,

- (a) Paragraph 3.9.1: Delete, and substitute:

"3.9.1 Defects greater than 1/16-inch in greatest dimension, or of a depth which exceeds wall thickness minimum tolerances, shall be cause for rejection. Discontinuities of depth which do not exceed thickness tolerances shall be removed by polishing or grinding."

- (b) Paragraph 4.1.1:
 - (1) In the third and fourth lines, delete "deep acid etch, and hardenability of each heat in the shipment.", and add "crushing test and mechanical properties."
 - (2) Delete subparagraph (f) in its entirety.
- (c) Paragraph 4.3: In second line, delete "which is essentially homogeneous in all respects,".

Page 7,

- (a) Paragraph 4.8: Delete "(welded tubing only)."
- (b) Paragraph 5.1, second line: Delete "type,".

Page 8, paragraph 6.2:

- (a) In subparagraph (b), delete "type and."
- (b) Subparagraph (d), second line: Delete "(see 3.5.1)" and substitute "(see 3.6.1)."
- (c) In subparagraph (e), delete "(see 3.6.2)" and substitute "(see 3.7.2)."

Custodians:

Army — MR
Navy — AS
Air Force — 11

Preparing activity:

Air Force — 11

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Reviewer activity:

Air Force — 82, 84, 85