NATIONAL STOCK NUMBER	ITEM NAME	REVISION	TECHNICAL CONTACT
1H 4710-01-626-8447 X2	**PIPE,SEAMLESS**	20250821120100	9A28829401/0435

DRAWING PREPARER/MANUFACTURER	MANUFACTURER'S PART NO./DRAWING NO.	RSP
MILITARY SPECIFICATION	**M24691/3P16K160(MOD)**	A

1.0 SCOPE

THIS IRPOD SATISFIES THE REQUIREMENTS FOR

****
* LEVEL I *
****
ORDERING DATA

ADDITIONAL IDENTIFYING INFORMATION:

THE SUBJECT PIPE SHALL BE 2 INCH, SCHEDULE 160 SEAMLESS IN ACCORDANCE WITH MIL-P-24691/3. THE (MOD) SUFFIX PART NUMBER REPRESENT DUAL CERTIFIED TP 316/316L MATERIAL AS SPECIFIED HEREIN.

1.1 THIS IRPOD PROVIDES THE REQUIREMENTS FOR A UNIT REPAIR PART.

2.0 LIST OF APPLICABLE DOCUMENTS

IF A SUPPLIER QUOTES TO A LATER REVISION OF THE DRAWING (OR CATALOG ITEM) THAN SPECIFIED BELOW, SUBMITTAL OF QUOTE SHALL INCLUDE TWO (2) COPIES OF THE REVISED DOCUMENT AND AN EVALUATION OF THE INTERCHANGEABILITY. THE FOLLOWING DOCUMENTS AND CHANGE DATA ARE APPLICABLE TO THE EXTENT SPECIFIED IN THIS IRPOD, THE DRAWINGS, OR OTHER DOCUMENTS INVOKED BY THIS IRPOD. CONTRACTING AGENCY APPROVAL IS REQUIRED TO USE EARLIER SPECIFICATION VERSIONS THAN THOSE LISTED HEREIN, EXCEPT AS IDENTIFIED BELOW. IF NO DOCUMENT VERSION IS LISTED, THEN ANY VERSION OF THE DOCUMENT MAY BE USED.
RAW MATERIAL REQUIRED HEREIN MAY HAVE BEEN PROCESSED OR TESTED (FOR EXAMPLE, HEAT TREATED OR ULTRASONICALLY TESTED) AS REQUIRED BY THE RAW MATERIAL SPECIFICATION PRIOR TO RECEIPT OF THIS ORDER USING PREVIOUS VERSIONS OF PROCESSING OR TESTING SPECIFICATIONS. THIS PROCESSING AND TESTING NEED NOT BE REPEATED IF:

1. IT COMPLIED WITH THE APPLICABLE REQUIREMENTS OF THE PROCESSING/TESTING SPECIFICATION VERSIONS IN EFFECT AT THE TIME OF THE ACTUAL PROCESSING OR TESTING AND;

2. ALL REQUIREMENTS OF THE RAW MATERIAL SPECIFICATION VERSION LISTED HEREIN HAVE BEEN SATISFIED.

SECTION 6.0 IDENTIFIES SPECIAL REQUIREMENTS FOR SUBMITTAL OF THE PROCEDURES USED FOR COMPLETED PROCESSING AND TESTING. ALL PROCESSING AND TESTING PERFORMED AFTER RECEIPT OF THIS ORDER SHALL CONFORM TO THE PROCESSING/TESTING SPECIFICATION VERSIONS LISTED HEREIN.

DOCUMENT NUMBER	VERSION	TITLE
MILITARY SPECIFICATIONS		
MIL-P-24691/3	ORIGINAL	PIPE AND TUBE, CORROSION RESISTANT, STAINLESS STEEL, SEAMLESS OR WELDED

NATIONAL STOCK NUMBER	ITEM NAME	REVISION	TECHNICAL CONTACT
1H 4710-01-626-8447 X2	**PIPE,SEAMLESS**	20250821120100	9A28829401/0435

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MILITARY SPECIFICATION	**M24691/3P16K160(MOD)**	A

MIL-P-24691	ORIGINAL	PIPE AND TUBE, CARBON ALLOY STAINLESS STEEL, SEAMLESS, AND WELDED, GENERAL SPECIFICATION FOR
MIL-P-24691/3	AMD 1	PIPE AND TUBE, CORROSION RESISTANT, STAINLESS STEEL, SEAMLESS OR WELDED
MIL-P-24691	AMD 2	PIPE AND TUBE, CARBON ALLOY STAINLESS STEEL, SEAMLESS, AND WELDED, GENERAL SPECIFICATION FOR

MILITARY STANDARDS

MIL-STD-129	R AND R (CH. 2)	MARKING FOR SHIPMENT AND STORAGE

PUBLICATIONS

STR-ISO 9000 SUPP C	4	SUPPLEMENT C REVISION 4 TO ISO 9000 (ANSI/ISO/ASQ Q9000) QUALITY SYSTEMS FOR BASIC PROCUREMENTS AND COMPLEX PROCUREMENTS.
T9074-AS-GIB-010/271	1, 9/11/2014	NAVSEA TECHNICAL PUBLICATION REQUIREMENTS FOR NON DESTRUCTIVE TESTING METHODS
*+ STR-505	3	SUPPLEMENTARY TECHNICAL REQUIREMENTS; MATERIAL IDENTIFICATION AND CONTROL REQUIREMENTS FOR MANUFACTURERS OF LEVEL I MATERIAL

OTHERS

ANSI/ASQC Q9001	1994	QUALITY SYSTEMS - MODEL FOR QUALITY ASSURANCE IN DESIGN, DEVELOPMENT,PRODUCTION, INSTALLATION, AND SERVICING OR QUALITY MANAGEMENT SYSTEM REQUIREMENTS-ANSI/ISO/ASQ Q9001 VERSION 2000 OR 2008
ANSI/ISO/ASQ Q9002	1994	QUALITY SYSTEMS - MODEL FOR QUALITY ASSURANCE IN PRODUCTION, INSTALLATION, AND SERVICING
ANSI/ISO/ASQ Q9003	1994	QUALITY SYSTEMS - MODEL FOR QUALITY ASSURANCE IN FINAL INSPECTION AND TEST
ASTM A312		STANDARD SPECIFICATION FOR SEAMLESS AND WELDED AUSTHENITIC STAINLESS STEEL PIPES

NATIONAL STOCK NUMBER	ITEM NAME	REVISION	TECHNICAL CONTACT
1H 4710-01-626-8447 X2	**PIPE,SEAMLESS**	20250821120100	9A28829401/0435

DRAWING PREPARER/MANUFACTURER	MANUFACTURER'S PART NO./DRAWING NO.	RSP
MILITARY SPECIFICATION	**M24691/3P16K160(MOD)**	A

* DOCUMENTS IDENTIFIED BY THIS SYMBOL MAY BE OBTAINED FROM CONTRACT ISSUING AGENCY.

\+ LATER VERSIONS (IE: REVISIONS, AMENDMENTS, CHANGE NOTICES AND/OR INTERIM CHANGES) OF DOCUMENTS IDENTIFIED BY THIS SYMBOL MAY BE USED IN THE PERFORMANCE OF THE CONTRACT. WHICHEVER VERSION IS USED MUST BE USED IN ITS ENTIRETY. THE LATER VERSION MAY BE IDENTIFIED AS "MIL-DTL-" OR "MIL-PRF-" AS APPLICABLE, WHICH IS EQUIVALENT TO "MIL-#-" (WHERE # IS AN ALPHA CHARACTER).

3.0 TECHNICAL REOUIREMENTS

PIPE.SEAMLESS M24691/3P16K160(MOD)

THE PIPE SHALL BE PER MIL-P-24691/3 (ASTM A312) GRADE 316/316L, SEAMLESS, 2 INCH NPS, SCHEDULE 160

NON-DEFINITIVE UNIT OF ISSUE

FOOT - 12 INCH

3.1 MATERIAL REOUIREMENTS

PIPE.SEAMLESS M24691/3P16K160(MOD)

MATERIAL IDENTIFICATION AND CONTROL REQUIREMENTS: FOR SPECIAL QUALITY CONTROL, IDENTIFICATION AND MARKING REQUIREMENTS, SEE STR-505. THESE REQUIREMENTS APPLY TO THE ITEM(S) IDENTIFIED BELOW.

LEVEL I ITEM	ITEM NUMBER IDENTIFICATION	MATERIAL SPECIFICATION	MATERIAL DESIGNATOR
PIPE	M24691/3P32K040 (MOD)	MIL-P-24691/3 GR TP 316/316L	SAR

MATERIAL SHALL BE SEAMLESS IN ACCORDANCE WITH MIL-P-24691/3 (ASTM A 312) DUAL QUALIFIED 316/316L (GRADE TP316/TP316L) TO MEET THE CHEMICAL REQUIREMENTS OF 316L MATERIAL AND THE MECHANICAL PROPERTY REQUIREMENTS OF 316.

MATERIAL DESIGN CODE SHALL BE "316/316L" FOR MARKING

IN ADDITION TO THE MARKING REQUIREMENTS SPECIFIED ELSEWHERE IN THE CONTRACT THE NATIONAL STOCK NUMBER (1H 4730-01-626-8447 X2) SHALL BE PART OF THE ITEM MARKING INFORMATION

NATIONAL STOCK NUMBER	ITEM NAME	REVISION	TECHNICAL CONTACT
1H 4710-01-626-8447 X2	**PIPE,SEAMLESS**	20250821120100	9A28829401/0435

DRAWING PREPARER/MANUFACTURER	MANUFACTURER'S PART NO./DRAWING NO.	RSP
MILITARY SPECIFICATION	**M24691/3P16K160(MOD)**	A

THE 316/316L MATERIAL SHALL HAVE A MAXIMUM COBALT COMPOSITION OF 0.2%. IT IS NOTED IF MATERIAL MEETING THE 0.2% MAXIMUM COBALT COMPOSITION IS NOT READILY AVAILABLE, A HIGHER PERCENTAGE (0.5% MAXIMUM) MAY BE CONSIDERED ON A CASE-BY-CASE BASIS, DEPENDING ON NAVY MATERIAL NEED DATES. REQUESTS FOR WAIVER OF THE 0.2% MAXIMUM COBALT COMPOSITION LIMIT SHOULD BE SUBMITTED TO THE PROCURING ACTIVITY FOR APPROVAL WITH JUSTIFICATION SUCH AS ADDITIONAL PROCUREMENT LEAD TIME REQUIRED, EXISTING AVAILABLE MATERIAL, INCREASE IN MATERIAL COSTS, CHEMICAL COMPOSITION DATA (INCLUDING THE HEAT AND LOT NUMBER) OF THE MATERIAL WHICH DOES NOT MEET THE 0.2% MAXIMUM COBALT LIMIT, ETC.

3.2 MANUFACTURING AND PROCESS REOUIREMENTS

PIPE.SEAMLESS M24691/3P16K160(MOD)

CLEANLINESS REQUIREMENTS:
PART(S) SHALL BE CLEANED BY ANY PROCESS OR COMBINATION OF PROCESSES WHICH WILL ACCOMPLISH THOROUGH CLEANING WITHOUT DAMAGE TO THE PART(S). SURFACES SHALL BE EXAMINED VISUALLY TO DETERMINE FREEDOM FROM DIRT, CORROSION, OIL, GREASE OR FOREIGN RESIDUE. PRESERVATIVES SHALL NOT BE USED ON PART(S) WHICH ARE VULNERABLE TO DAMAGE BY CONTACT PRESERVATIVES.

MERCURY CONTAMINATION:THIS ITEM SHALL NOT CONTAIN AND SHALL NOT BE CONTAMINATED BY MERCURY OR MERCURY COMPOUNDS. THIS REQUIREMENT MUST BE PASSED ON TO ALL SUBCONTRACTORS. (FOR PROCURING ACTIVITY USE ONLY,INCLUDE MERCURY CONTROL CLAUSE FROM NAVSEAINST 5100.3 (SERIES)).

4.0 OUALITY ASSURANCE PROVISIONS

PIPE.SEAMLESS M24691/3P16K160(MOD)

PIPE SHALL BE HYDROSTATICALLY PRESSURE TESTED AND ULTRASONIC TESTED IN ACCORDANCE WITH MIL-P-24691

AS A MINIMUM THE SUPPLIER SHALL PROVIDE AND MAINTAIN AN INSPECTION SYSTEM WHICH MEETS THE REQUIREMENTS OF ONE OF THE FOLLOWING:
(A) ISO 9003 (ANSI/ISO/ASQ Q9003) WITH STR-ISO 9000 SUPPLEMENT C. SUPPLEMENTS B OR A ARE ALSO ACCEPTABLE.
(B) ISO 9002 (ANSI/ISO/ASQ Q9002) WITH STR-ISO 9000 SUPPLEMENT C. SUPPLEMENTS B OR A ARE ALSO ACCEPTABLE.
(C) ISO 9001 (ANSI/ISO/ASQ Q9001) WITH STR-ISO 9000 SUPPLEMENT C. SUPPLEMENTS B OR A ARE ALSO ACCEPTABLE.
(D) MIL-I-45208
(E) EXISTING INSPECTION SYSTEMS MEETING THE MORE STRINGENT REQUIREMENTS OF STR-ISO 9000 SUPPLEMENTS A OR B ARE ACCEPTABLE IN LIEU OF SUPPLEMENT C FOR LINES (A), (B) AND (C) ABOVE.

T9074-AS-GIB-010/271 SUPERSEDES MIL-STD-271, WHICH HAS BEEN CANCELLED. ALL REFERENCES TO MIL-STD-271 SHOULD BE REPLACED WITH T9074-AS-GIB-010/271.

5.0 PREPARATION FOR DELIVERY

NATIONAL STOCK NUMBER	ITEM NAME	REVISION	TECHNICAL CONTACT
1H 4710-01-626-8447 X2	**PIPE,SEAMLESS**	20250821120100	9A28829401/0435

DRAWING PREPARER/MANUFACTURER	MANUFACTURER'S PART NO./DRAWING NO.	RSP
MILITARY SPECIFICATION	**M24691/3P16K160(MOD)**	A

PIPE.SEAMLESS M24691/3P16K160(MOD)

MARKING REQUIREMENTS:
MARKING AND LABELING SHALL BE IN ACCORDANCE WITH MIL-STD-129.
BAR CODE MARKING SUITABLE FOR HAND SCANNING IS REQUIRED.
IN ADDITION TO THE STANDARD MARKING REQUIREMENTS OF MIL-STD-129, THE SELLER SHALL INCLUDE THE MANUFACTURER'S COMMERCIAL AND GOVERNMENT ENTITY (CAGE) CODE AND THE MANUFACTURER'S REFERENCE/ PART NUMBER (MFR/PN) ON INTERMEDIATE AND UNIT PACKS.

PACKAGING AND PACKING REQUIREMENTS:PACKAGING CODES FOR MIL-STD-2073-1 SHALL BE AS SPECIFIED ELSEWHERE IN THE CONTRACT.

6.0 CONTRACT DATA REOUIREMENTS

THE SELLER MUST PROVIDE THE CONTRACTING AGENCY WITH ALL OF THE SUBMITTALS LISTED BELOW. SUBMITTALS WHICH ARE REQUIRED BY A SPECIFICATION, BUT WHICH ARE NOT LISTED BELOW, NEED NOT BE SUBMITTED. ONLY THOSE SUBMITTALS LISTED BELOW ARE REQUIRED.

HOWEVER, IF THE SELLER CONSIDERS A REQUIRED SUBMITTAL INAPPLICABLE TO THIS PROCUREMENT, THE SELLER MUST SUBMIT A STATEMENT JUSTIFYING THE EXCLUSION OF THE REQUIRED SUBMITTAL.

REQUESTS FOR APPROVAL OF PROCEDURES USED PRIOR TO RECEIPT OF THIS ORDER SHALL IDENTIFY THE PROCESSING/TESTING SPECIFICATION VERSION APPLICABLE AND STATE THAT THE PROCESSING AND/OR TESTING WAS PERFORMED PRIOR TO RECEIPT OF THE ORDER. IF THE PROCEDURE THAT WAS USED IS NOT COMPLETE, TEST REPORTS, HEAT TREATMENT RECORDS, OR OTHER DOCUMENTATION SHALL BE SUBMITTED WITH THE PROCEDURES TO SUBSTANTIATE THAT ALL SPECIFICATION REQUIREMENTS WERE MET.

@ SUBMITTAL REQUIREMENTS IDENTIFIED BY THIS SYMBOL ARE CONDITIONAL AND ARE REQUIRED ONLY IF APPLICABLE TO THIS PROCUREMENT.

6.1 PROCEDURES AND REPORTS

NATIONAL STOCK NUMBER	ITEM NAME	REVISION	TECHNICAL CONTACT
1H 4710-01-626-8447 X2	**PIPE,SEAMLESS**	20250821120100	9A28829401/0435

DRAWING PREPARER/MANUFACTURER	MANUFACTURER'S PART NO./DRAWING NO.	RSP
MILITARY SPECIFICATION	**M24691/3P16K160(MOD)**	A

THE SELLER SHALL PROVIDE THE FOLLOWING PROCEDURE(S) AND REPORT(S) TO THE PROCURING ACTIVITY. CONTRACTOR PROCEDURE SUBMITTALS REQUIRED BY MATERIAL AND PROCESS SPECIFICATIONS NEED NOT BE RESUBMITTED FOR APPROVAL EACH TIME AN ORDER IS PLACED FOR THE SAME IRPOD ITEM TO THE SAME VERSION (I.E., REVISION, AMENDMENT, CHANGE NOTICE OR INTERIM CHANGE) OF THE SPECIFICATION OR STANDARD INVOKED. THE SELLER NEED ONLY SUBMIT PROOF OF THE PRIOR APPROVAL FOR THAT ITEM AND SPECIFICATION REVISION. ACCEPTABLE PROOF OF PRIOR APPROVAL WILL CONSIST OF A COORDINATED PROCEDURE REVIEW SYSTEM (CPRS) APPROVAL LETTER. CPRS APPROVAL DOES NOT RELIEVE THE SELLER OF THE RESPONSIBILITY TO COMPLY WITH ALL REQUIREMENTS IMPOSED ON ANY CURRENT AND FUTURE PURCHASE ORDERS.

IF FIRST-TIER MANUFACTURER RETESTING OF MATERIAL IS NECESSARY, USE OF BUYER APPROVED PROCEDURES APPLICABLE TO THE SAME VERSION OF THE SPECIFICATION OR STANDARD INVOKED ON THE IRPOD IS ACCEPTABLE IN LIEU OF OBTAINING THE RAW MATERIAL MANUFACTURER OR MATERIAL INSPECTION AND TEST PROCEDURES FOR APPROVAL.

WHERE ALTERNATIVE SPECIFICATIONS ARE SHOWN FOR A GIVEN ITEM, ONLY THE DATA FOR THE SPECIFICATION USED IS REQUIRED. THE SELLER SHALL SPECIFY THE FOLLOWING ON PROCEDURE(S)/REPORT(S) REQUIRING SUBMITTAL, AS APPLICABLE, IN ORDER THAT THE PROCEDURE/REPORT CAN BE READILY REVIEWED AGAINST THE APPROPRIATE ACCEPTANCE CRITERIA: SPECIFICATION AND REVISION, INCLUDING AMENDMENTS, NOTICES, ETC., APPLICABLE PARAGRAPH OF THE SPECIFICATION, THE NAME OF THE SUBMITTAL, THE MATERIAL CONDITIONS (I.E., MATERIAL GRADE, CLASS, TYPE, SIZE, COMPOSITION, ETC.).

6.1.1 PRIOR TO MANUFACTURE, FOR APPROVAL:

PIPE.SEAMLESS M24691/3P16K160(MOD)
COBALT COMPOSITION

@ REQUEST FOR WAIVER OF 0.2 PERCENT MAXIMUM COBALT COMPOSITION (SEE SECTION 3.1)

6.1.3 PER CONTRACT DELIVERY SCHEDULE:

PIPE.SEAMLESS M24691/3P16K160(MOD)
MIL-P-24691

CERTIFICATE OF QUALITY CONFORMANCE

T9074-AS-GIB-010/271

ULTRASONIC TEST REPORT

STR-505

CHEMICAL REQUIREMENTS

MECHANICAL PROPERTIES

NATIONAL STOCK NUMBER	ITEM NAME	REVISION	TECHNICAL CONTACT
1H 4710-01-626-8447 X2	**PIPE,SEAMLESS**	20250821120100	9A28829401/0435

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ASTM A 312

HEAT ANALYSIS

6.2 OTHER CONTRACT DATA REOUIREMENTS

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