ATTACHMENT (1) *CONTRACT No:* N3904026Q5525

TECHNICAL ORDERING DATA (TOD) *ITEM:* PIPE 2 IN SEAMLESS SCH160

SECTION B - SUPPLIES/SERVICES:

NATIONAL STOCK NUMBER (NSN): 1H 4710 01-626-8447 X2

ITEM NAME: 2 INCH SCH 160 MIL-P-24691, TYPE 1

PART NUMBER: M24691/3P16K160 (MOD)

QUANTITY: 440 FEET (5280 INCHES)

SPECIAL CHARACTERISTICS: The (MOD) suffix part number represent dual certified to 316/316L material.

SECTION C - DESCRIPTION/SPECIFICATIONS:

C.1. Manufacture per the attached Individual Repair Part Ordering Data (IRPOD), as modified by this contract.

C.1.1. The order of precedence for any conflicting documentation/requirements shall be as follows:

(a) The contract (including attachments, modifications, amendments, etc.).

(b) The IRPOD.

(c) Drawings (if any) referenced by the IRPOD.

(d) Specifications referenced by the IRPOD or drawing.

C.1.2. Manufacture in accordance with Military Specification MIL-P-24691 Paragraph 6.2 as follows:

(a) Pipe and Tube, Carbon, Alloy and Stainless Steel Seamless and Welded, General Specification for; MIL-P-24691 REV Original with Amendment 2 dated 4 February 1991.

(b) Pipe and Tube, Corrosion-Resistant, Stainless Steel, Seamless or Welded; MIL-P-24691/3 REV Original with Amendment 1 dated 4 February 1991.

(c) Pipe is to be Type 1 (Seamless), Dual Certified as Grade TP316/TP316L. Pipe shall meet chemical requirements of Grade TP316L and mechanical requirements of Grade TP316.

(d) Not Applicable

(e) Pipe is required. Size and Schedule are to be as specified in Section B above.

(f) Deleted

(g) No Applicable.

(h) Each pipe shall be ultrasonically inspected. See C.1.3 for additional UT requirements.

(i) The entire volume of every pipe shall be ultrasonically inspected by shearwave for soundness and be conducted in two opposite circumferential directions.

(j) See section D for Preservation, Packing and Packaging requirements.

(k) Special Marking requirements: see paragraph C.4 for Marking requirements.

C.1.3 Ultrasonically inspect pipe per MIL-DTL-24691 and NAVSEA Technical Publication T9074-AS-GIB-010/211. In addition to the requirements of MIL-P-24691, 100% of each pipe shall be ultrasonically inspected for thickness.

(a) The vendor shall notify the purchasing agent four (4) weeks in advance of ultrasonic testing to allow participation of Portsmouth Nava Shipyard personnel in witnessing the ultrasonic tests.

Notify Code 410_____Phone (207).438_____

C.1.4 Supplemental Technical Requirement (STR) 505 Revision 3 is invoked. STR-505 can be obtained from Portsmouth Naval Shipyard upon request.

C.1.5 COBAL RESTRICTION: The material offered for acceptance shall have a maximum Cobalt content of 0.2%. If material with 0.2% or less Cobalt content is unavailable, Cobalt concentrations up to 0.5% may be permitted on a case basis. The vendor shall submit a waiver request to Portsmouth Code 2305.4 for evaluation. The waiver shall discuss the additional lead time which would be required, any cost increase to the government etc. to justify the increase in Cobalt concentration.

C.1.6 Material Certification Requirements: Certification is required for every test/inspection detailed in applicable specifications. In addition product analysis in accordance with ASTM A312 is required. See C.3 below and Exhibit A.

C.1.7 NAVSEA Technical Publication T9074-AS-GIB-010/271 supersedes MIL-STD-271, which has been cancelled. All references to MIL-STD 271 shall be replaced with T9074-AS-GIB-010/271.

(a) T9074-AS-GIB-010/271 Rev 1 dated 11 September 2014.

C.2. APPLICABLE DOCUMENTS:

C.2.1. Section 2.0 of the IRPOD lists applicable documents to be used (e.g., drawings, specifications, standards, etc.) and their required version level (e.g., revisions, amendments, change notices, interim changes, etc.). The following list of documents and version information takes precedence over version information (including the lack of any version information) identified by the IRPOD:

(a) MIL-STD-792F CH 1; IDENTIFICATION MARKING REQUIREMENTS FOR SPECIAL PURPOSE COMPONENTS
(b) MIL-STD-129R; MARKING FOR SHIPMENT AND STORAGE
(c) ASTM D3951-18; STANDARD PRACTICE FOR COMMERCIAL PACKAGING

C.2.2. If no document version is identified (anywhere in the contract or referenced documents), then use the latest version identified in the Acquisition Streamlining and Standardization Information System (ASSIST) at the time of contract award; ASSIST information is available at the following website: https://quicksearch.dla.mil. If no document version information is available in ASSIST, then any version of the document may be used provided its version is dated 1 November 1969 or later.

C.2.3. In any case, the vendor shall use only one version in its entirety (i.e., the vendor shall not use portions of different versions of a document).

C.3. DATA REQUIREMENTS:

C.3.1. Material Certification; See Exhibit A, Data Item No. A001.

C.3.2. Procedure Approvals; See Exhibit A, Data Item No. A002. The vendor shall provide, and obtain approval for, the procedures identified below prior to their use. If the vendor considers a required submittal inapplicable to this procurement, the vendor shall submit a written statement justifying the exclusion of the required submittal.

C.3.2.1. ULTRASONIC TEST PROCEDURE

a. Procedure (per NAVSEA T9074-AS-GIB-010/271 – for both soundness and thickness), including acceptance criteria (per MIL-P-24691), shall be submitted. Ultrasonic calibration standard certification shall also be submitted for review and approval (this may be submitted no later than two weeks prior to scheduling the ultrasonic inspection witness).

C.4. CLEANLINESS REQUIREMENTS:

C.4.1. Cleanliness requirements shall be per Section 3.2 of the IRPOD and MIL-P-24691.

C.5. MATERIAL MARKING (LEVEL 1 MATERIAL):

C.5.1. Each piece shall be permanently marked at a minimum of twice, once on each end, with the information of (a), (b), (c), (d), (e) and (f) below using the permanent marking methods of MIL-STD-792 or the permanent marking method specified in the material specification. Adhesive labels shall not be used for marking. If any marking specified below cannot be applied due to space limitation, a waiver request shall be submitted to the contracting officer.

(a) The Material Designator/Code "SAR".
(b) The manufacturer's name, trademark, or symbol.
(c) The vendor traceability number traceable to all manufacture test and inspection information and to a unique set of physical, mechanical, and chemical test results which represent the material used to make the piece.
(d) "316/316L"
(e) The National Stock Number **1H 4710 01-626-8447 X2.**
(f) Any information required by the specification or drawing (if applicable) in addition to that required by (a), (b), (c), (d) and (e) above shall be marked either per the specification/drawing or at least once per the permanent marking methods authorized above.

C.5.2. If feasible, consolidate the placement of the permanent marking(s) to accommodate the marking of a nine digit final acceptance marking at Portsmouth Naval Shipyard. Do not compromise the legibility of the permanent markings to meet this request.

C.5.3. The location of the markings shall be on the outer diameter on the end(s) of each piece. Die stamp markings shall not be used for permanently marking pipe or tube per MIL-STD-792. The length is not required to be marked on the material as stated in Paragraph 3.8(d) of MIL-P-24691.

C.6. NAVSEA HQ C-223-H003 Mercury Control.

SECTION D - PRESERVATION/PACKAGING/PACKING:

D.1. Marking requirements for packaging shall be per Section 5.0 of the IRPOD.

D.2. Preservation, Packaging, and Packing shall be in accordance with ASTM D3951, as modified below:

(a) The material shall be shipped in wooden boxes. For 6-inch OD and larger pipe, the wooden boxes shall be constructed of 2-inch thick by 6-inch wide minimum planks nailed or screwed together. The exterior of the boxes shall be banded with metal straps.

D.3. The use of MIL-STD-2073-1 packaging codes are not required for this contract.

SECTION E - INSPECTION ACCEPTANCE:

E.1. Government inspection is required during manufacture and prior to shipment from this facility. Upon receipt of this order, promptly notify the Representative of the Government office who normally serves your facility so that appropriate planning for Government inspection can be accomplished. In the event a Representative of the Government office cannot be located, the purchasing agent should be notified promptly. Provide the location where Procurement Quality Assurance (PQA) of the supplies will be made along with the organization that will be performing PQA.

E.2. All non-conformances to contract requirements affecting product and/or documentation shall require procuring activity waiver approval to accept.

E.2.1. Any request for waivers/deviations should provide written justification for the requested change including an evaluation which demonstrates that the proposed non-conformance will not affect the quality, form, fit, or function of the part.

E.3. FAR 52.246-11, Higher-Level Contract Quality Requirements
Supplemented by:
NAVSEA HQ H-246-H001 Calibration System Requirements (NAVSEA)
NAVSEA HQ E-246-H020 Quality Management System Requirements (NAVSEA)
NAVSEA HQ C-246-H002 Government use of Contractor's Inspection Equipment (NAVSEA)
(MIL-I-45208 or ISO 9001/9002/9003 with STR-ISO 9000 Supplement A or B or C)

E.4. FAR 52.246-2 Inspection of Supplies-Fixed-Price (Aug 1996).