

Quality Clause 244000 - Marking Tube / Pipe (08/24/18)

- 1) All segments to be marked with continuous identification marking per ASTM A106, ASTM A269, or as otherwise required.
- 2) All sections to be hydrostatically tested. As an alternative to the hydrostatic test, each section can be tested with a nondestructive electric test as defined in ASTM A106 ASTM A269 or as otherwise required by other p/n referenced specification.
- 3) The supplier must provide evidence of this testing to Rolls-Royce.
- 4) Inside diameter of tubes to be clean and capped (Rolls-Royce part number shall appear on each cap).
- 5) Ferrous tubing / pipe inside and outside diameters to be clean and coated with 4FVD9 Mobilcut 101, Quaker FERROCOTE 51 MAL HCL 1 (product code 011527-11 03) or FERROCOTE EGL-1 (product code 003385-20).
- 6) Stainless Steel tube / pipe to be annealed and pickled
- 7) Tubing/piping shall be adequately packaged to protect it from damage during shipment
- 8) Mill certification of actual chemical, physical and required testing MUST be emailed to RRNMI.Certs@Rolls-Royce.com with the purchase order and part number referenced in the email subject line in the email subject line in the following format: Documentation for PO XXXXXXXXXX, Part Number YYYYYYYYY. Documentation must be legible and of reproducible quality. Files cannot contain macros or executables.