SECTION B - SUPPLIES/SERVICES:

NATIONAL STOCK NUMBER (NSN): 1H 9510-00-504-4189 X2
ITEM NAME: 3.5" BAR, ROUND, CRES COMPOSITION 304/304L, CONDITION A OR AG, MIL-DTL-23195
PART NUMBER: MIL-DTL-23195COMP304-304L,3.5
QUANTITY: 120 feet
SPECIAL CHARACTERISTICS: 3.5" ROUND BAR

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 MIL-DTL-23195, except as modified herein. Ordering data for paragraph 6.2 of MIL-DTL-23195 is as follows:

(a) See section C.2.1 for specification information.
(b) Composition 304/304L, Type I, II or III, Bar Form, Condition A or AG. The quantity and size to be as specified in Section B of this schedule, except bars shall be furnished in 2-12 foot lengths.
(c) Cobalt limitation (Table I) is not required.
(d) Material shall have an average percent delta ferrite less than or equal to 2.0% with no single specimen value exceeding 2.0% as determined by methods in AMS2315.
(e) Forging dimensions not applicable.
(f) See Section B.
(g) Simulated production heat treatment not applicable.
(h) Not applicable.
(i) Liquid Penetrant Inspection is required.
(j) Transverse mechanical properties are not applicable.

C.1.3. Ultrasonically inspect the bar per MIL-DTL-23195 and MIL-STD-2132.

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

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

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-DTL-23195H; STEEL BARS AND FORGINGS, CORROSION RESISTANT (UNS S30400/S30403, S31600/S31603, S34700, AND S34800)

(b) MIL-STD-2132F; NONDESTRUCTIVE EXAMINATION REQUIREMENTS FOR SPECIAL APPLICATIONS
(c) MIL-STD-129R; MARKING FOR SHIPMENT AND STORAGE
(d) ASTM D3951-18; STANDARD PRACTICE FOR COMMERCIAL PACKAGING
(e) MIL-STD-792F, CH 1; IDENTIFICATION MARKING REQUIREMENTS FOR SPECIAL PURPOSE COMPONENTS

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.'s A002, A003, A004, and A005. 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.

(a) ULTRASONIC TEST PROCEDURE – Procedure (per MIL-STD-2132, including acceptance criteria (per MIL-DTL-23195), 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).

(b) LIQUID PENETRANT TEST PROCEDURE – Procedure (per MIL-STD-2132 including acceptance criteria (per MIL-DTL-23195), shall be submitted for review and approval).

(c) ALLOY IDENTITY PROCEDUURE – Procedure per MIL-STD-2132 shall be submitted for review and approval.

(d) HEAT TREATMENT PROCEDURE – Procedure per MIIL-DTL-23195 shall be submitted for review and approval.

C.4. CLEANLINESS REQUIREMENTS:

C.4.1. Cleanliness requirements shall be per Section 3.2 of the IRPOD and Paragraph 5.1 of MIL-DTL-23195.

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

C.5.1. Each piece shall be permanently marked at a minimum on both ends with the information of (a), (b), (c), and (d) 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 permanent markings. 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 "SAQ".

(b) 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.
(c) The manufacturer's name, trademark, or symbol.
(d) Any information required by the specification or drawing (if applicable) in addition to that required by (a), (b), (c), and (d) above shall be marked either per the specification/drawing or at least once on each end per the permanent marking methods authorized above. Any Material Designator/Code listed in the specification or drawing (if applicable) need not be marked on material, if it is different from that specified by (a) 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 ends of each piece / the ends.

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 section 5 of MIL-DTL-23195. In addition, material shall be shipped in wooden boxes.

D.2. 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).