Quality Clause 244000 - Marking Tube / Pipe (07/01/2025 - Rev A)

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 Bird Johnson Propeller Company.

4) Inside diameter of tubes to be clean and capped (Bird Johnson Propeller Company 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 [BirdJohnsonCerts@fmdefense.com](mailto:BirdJohnsonCerts@fmdefense.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.