
	Material Specification		
	NUMBER AX-123	REV A	SHEET 1 of 3

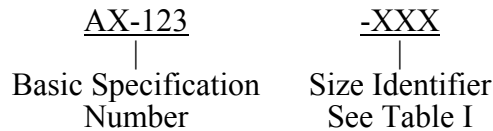
TITLE: Wire, Non-magnetic, Corrosion Resistant, Stainless Steel, Round, Alloy UNS S32100 (Type 321)	WRITTEN BY: J.B. 10/16/89	
	ENG APPROVAL: J.B. 10/16/89	
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<u>Revision</u>	<u>Description</u>	<u>Date</u>	<u>Approved</u>
-	Release to Production	10/16/89	J.B.
A	ECN-H176: Revised to add dash numbers for each size		

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1. SCOPE.

- 1.1 Scope. This specification defines the requirements for round stainless steel wire for use in the production of conduit.
- 1.2 Classification. Part Numbers under this specification are coded as follows:



2. APPLICABLE DOCUMENTS.

This section does not apply to this specification.

3. REQUIREMENTS.

Material shall be 321 stainless steel per UNS S32100 as specified herein.

3.1 Chemical Analysis Requirements:


C:	0.08% max.
Cr:	17.0-19.0% max.
Mn:	2.00% max.
Ni:	9.0-12.0% min.
P:	0.045% max.
S:	0.03% max.
Si:	1.00% max.
Ti:	5xC min.

3.2 Physical Analysis Requirements:

Temper:	Soft
Tensile Strength:	110,000 psi min
Elongation:	To be satisfied by tests on initial lots submitted by suppliers and run on Andrex Inc. braiders. When satisfactory, supplier shall maintain such controls as are necessary to furnish substantially the same material on all future orders.

TABLE I

Size Identifier	Diameter
-008	.0080 ±.0005
-011	.0110 ±.0005
-013	.0130 ±.0005

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3.3 Material Workmanship:

Wire shall be clean, smooth, free from defects or surface imperfections and carefully coiled without kinks.

4. QUALITY ASSURANCE PROVISIONS.

4.1 Quality Assurance shall be responsible for inspection of material upon receipt of each lot for conformance to this specification, or unless otherwise specified by any requirements stated on the lot's specific purchase order.

5. PREPARATION FOR DELIVERY.

5.1 Spooling Requirements:

Vendor shall supply continuous lengths of wire on spools having 1-1/4" I.D. Bore and 8" O.D. Flange. Approximate weight should be 30 lbs. per spool. Spools shall have 10 lbs. min of wire. Spool traverse shall be approximately 6 inches. Spooling shall be such that wire may be unwound under reasonable tension without binding.

5.2 Supplied on our Braider Bobbins

Supply continuous length on Flexco supplied bobbins with minimum weight of 2.0 lbs. per bobbin. Bobbins shall be wound to insure smooth and even unwinding of bobbin.

5.3 Packaging and Marking:

Packing shall be adequate to protect the spools and wire from contamination and physical damage during shipment. Each spool shall be plainly marked with material identification, wire diameter, shipping date, weight and name of manufacturer. Packaging shall be adequate to insure spooling integrity during shipment.

5.4 Certification:

Certificate of Compliance and Analysis Test Reports must accompany each shipment.

6. NOTES.

6.1 Ordering Information: Purchase orders should specify the following:

- a. Part Number including size identifier (see 1.2)
- b. Description
- c. Quantity, total poundage.
- d. Delivery Date