

# ELMET TECHNOLOGIES LLC - SPECIFICATION

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DEPARTMENT: **QUALITY**

PAGE: 1 of 2

SPECIFICATION: **S-22-029** REVISION: **(C)**

TITLE: **ULTRASONIC TESTING OF MOLYBDENUM - FLOWDOWN CLAUSES & STANDARDS**

CONTROLLED COPIES: **NONE**

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## 1. PURPOSE / SCOPE

To provide the testing standard and certification documentation requirements and to ensure specific flowdown clauses, in their entirety or equivalent, are flowed down to all lower tier subcontracts to prevent the inadvertent use of Counterfeit Parts, Material or Work. This specification specifically covers Ultrasonic Testing (UT) of Molybdenum *products (plate, block, rod or bar)*. *Molybdenum alloys are also covered by this specification (e.g., Mola, TZM)*

## 2. TEST STANDARD and DOCUMENTATION

2.1. Unless otherwise specified on the purchase order, each individual *piece* shall be ultrasonically inspected per AMS-STD-2154, Type 1, Class A.

2.2. *A UT standard is required to be prepared from material that is acoustically similar and meets requirements of the UT specification required by the customer order (e.g., AMS-STD-2154). The material for the standard or the standard itself may be supplied by Elmet, with verification and acceptance by the UT inspection service.*

2.3. Testing documentation must specify the following:

- (1) Purchase Order
- (2) Test Standard the *piece* was inspected to (i.e. AMS-STD-2154, Type 1, Class A)
- (3) Type of Test and Procedure
- (4) Material
- (5) The plate, *part number or serial number, as specified on the purchase order* (i.e. 1617246-A-UT for individual plate or 1617246-A-40648-UT-1 for individual parts)
- (6) Total pieces inspected
- (7) Judgement for each individual plate or part number PASS / FAIL
- (8) Pieces rejected
- (9) Reason for rejection

2.4. Reports be *emailed* to:

[quality@elmettech.com](mailto:quality@elmettech.com)

## 3. CLAUSES

3.1 Elmet General Flowdown S-22-100 applies.

## 4. RECORD RETENTION

4.1 All record retention is seven (7) years unless specifically noted in the purchase order.

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## 5. REVISIONS AND APPROVALS

REV	DATE	ORIGINATOR	CHANGES
-	1/3/2017	S. Humphrey	Initial Issue
A	1/4/2017		Specification Title change to add Standards; Paragraph renumbering starting at paragraph 2; Paragraph 2 addition of AMS standard and documentation requirements; Paragraph 4.1 for record retention
B	6/14/18	D. Drinan	Revised title, Scope, 2.1 and 2.3.
C	12/12/2019	D. Drinan	Increased scope of product forms, added 2.2., revised 2.2 (5) and report email address

APPROVER	SIGNATURE
D. Drinan	 Digitally signed by Dan Drinan