

# General Specification

SS 3 Flats R2 – 17-4

All Specifications must be clearly stated on the Mill Test Certificate. Each bundle must be traceable to a single Heat Number. All Chemical and mechanical properties of each Heat Number must be stated as per the Specifications and fall within the parameters allowed by those Specifications. **Except as further modified by the more stringent or restrictive requirements in this document.**

**REQUIREMENTS:** All Incoming Stainless Steel HRAP Flat Bars must meet the following Requirements:

**MARKING:** Heat Number etched or die-stamped at one end. It is preferred that Alloy and Size be included.

**BUNDLES:** Tagged with Size, Grade, Heat Number and Net Weight  
2000 - 2200 LBS bundle weights, 1000 - 1200 LB bundle weights also accepted, 10% allowance for other bundle weights, maximum 2500 lbs.

DELIVERY ALLOWANCE: +/- 10% OF TOTAL WEIGHT ORDERED. OVERAGES ARE SUBJECT TO RETURN OR PRICE RE-NEGOTIATION

## **REQUIRED STATEMENTS ON MILL TEST CERTIFICATES:**

MERCURY FREE

SOLUTION ANNEALING (Time, Temperature and cooling)

GRAIN SIZE PER ASTM E112-88 (state size)

REPORT MELT AND HOT WORKING PRACTICES

DFARS COMPLIANCE

NO WELD REPAIRS

MACRO & MICRO STRUCTURE

COBALT CONTENT WHEN PRESENT

**LENGTHS:** 12' - 14' R.L. 10% Allowance is given for longer bar 14' SS 3 FLATS 17-4 (2)SS 3 FLATS 17-4 (2)given for shorter bars 10' - 12'. Lengths under 10' are not acceptable.

**FINISH:** Hot Rolled Annealed and Pickled (HRAP) - Imperfections shall not exceed ASTM A484  
All bars must be free of surface rust contamination

**SCRATCHES:** The processing and handling of bars must be done in a manner which surface scratching is minimized and no scratches should exceed ASTM A484

**PACKAGING:** Boxing Preferred

**MINIMUM ACCEPTABLE PACKAGING** - Bundles to be fully wrapped and to prevent damage from handling or rust contamination during transportation. Strapping must not make direct contact with bars. Bars shipped on a Less than container load (LCL) bases must be boxed if less than 5/8" thick.

## **DOCUMENTATION:**

Each shipment requires a detailed Packing Slip and Mill Test Certificate. The detailed Packing Slip must state the ESP Purchase Order Number, full product description, individual bundle quantities, Heat Number per bundle and preferably the ESP product code. The Mill Test Certificate must state the ESP Purchase Order Number, full description, Heat number, quantity, Specifications and Requirements as listed in SS3. Only legible copies of the ORIGINAL Mill Test Certificate are acceptable.

Offshore Shipments - Packing slip and Mill Test Certificates must be issued immediately upon shipment to ensure receipt well before delivery.

Local Shipments - Packing Slip and LEGIBLE Mill Test Certificate must accompany shipment.

**SHIPPING ADVICE:**

Offshore shipments - a copy of the packing slip must be faxed directly to ESP purchasing within 7 days of shipping. Faxed copy must indicate date of sailing. Twenty-four hours delivery notice must be given on F.O.B. delivered shipments. The forwarding company must contact ESP receiving for instructions.

Local Shipment - 24-hour delivery notice and copy of the packing slip are required by the ESP receiving department for shipping approval. Shipments without prior notice are subject to refusal at the Vendor's cost.

**TERMS:** Acknowledgment of this order must be returned within 30 days indicating date of shipment.

**ESP HOLDS THE RIGHT;**

- To access the Vendor's premises for the purpose of performing audits, surveys, inspections and verification of the Vendor's quality procedures, as well as compliance with contract requirements.
- To have the same accessibility for ESP's customers relevant to the work performed.
- To reject material that does not meet all Specifications and Requirements. All costs associated to material rejection, including any inbound costs will be at the Vendor's account.
- To charge back to Vendor all costs associated to the rework of substandard material.
- To refuse damaged shipments that were shipped F.O.B. delivered.
- To refuse shipments received 30 days before or after the required delivery date.

Vendor must maintain all quality records that relate to work or services performed for 7 years or for a retention period mutually agreed upon. Quality records must be readily available upon request.

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PURCHASING MANAGER

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DATE