

Ameritube Case Studies

Recent projects completed by Ameritube





Duplex Bundles for Motiva

- 14 U-Bend bundles with difficult testing, bending and annealing requirements:

1. MTR's will be provided for final and raw material.
2. PMI 10% per heat confirmed by Ameritube. PMI equipment model, calibration certificate to be provided with the quote
3. Electric resistance stress relieve of U-Bends + 6" of straight length of rows 1& 2 (39 U's only) @ 1870-2010 degrees F for 15 seconds with water quench or forced air cooling. The tube surface shall be free of heat tint or surface oxides. Clamp areas shall be free of arc is not acceptable.
4. ASTM A923 test method C Ferric Chloride Corrosion test) would be done and meet the given criteria by third party
5. Repair of tube dents is not permitted. Repair welding of tube is not permitted.
6. Eddy current test per SA- 789.
7. Tube hardness shall not exceed rockwell C28.
8. One specimen 1in LG from each lot shall be checked for detrimental intermetallic phases per ASTM A923 test methods A&C.
9. Testing according to ASTM A923 to be done at ISO 17025 certified laboratory. Identical samples to be send via express mail to Ameritube LLC address.
10. Proposal is in conformance with bend schedule and requirements specified in the notes.
11. Quality system to be approved by Ameritube representative
11. Samples and MTRs to be provided as soon as raw material received, after material processed with 2 nd Invoice prior to shipment from Busan, Korea.
12. Raw material MTR to be provided at time of receipt and testing of Korean raw material.
13. NITROGEN CONTENT SHALL BE 0.14% MIN & THE PRE(N) OR PRE(W) TO BE 34 MIN.
14. MAXIMUM SULPHUR SHALL BE 0.010%





SA249 316/316L Bundles for Praxair

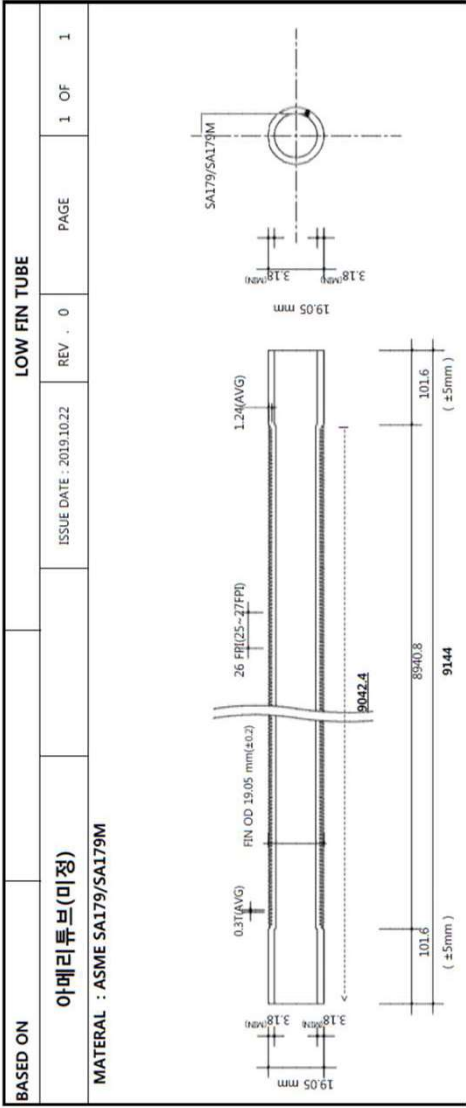


1. U-BENDS PLUS 12" TANGENT SHALL BE SOLUTION ANNEALED AFTER BENDING.
BEND ANNEAL TEMP AT 1950 DEGREES F.
2. TUBES TO MEET SUPPLEMENTAL REQUIREMENTS OF SA-249 S8
3. WELDED TUBES SHALL BE SUPPLIED IN THE SOLUTION ANNEALED CONDITIONS
AND TESTED PER ASTM E426(EDDY CURRENT TESTING) OR SUPPLEMENTAL
REQUIREMENTS SA-249 S9 (ADDITIONAL TESTING OF WELDED TUBING FOR ASME SECTION I).
4. NDE REPORT REQUIRED
5. FOLLOWING TESTING SHALL BE PERFORMED PER HEAT NO. TEST SHALL BE PERFORMED BY TUBE VENDOR PER ASTM 262 PRACTICE A AND EPR METHOD TEST PER ASTM G108. AFTER SAMPLES HAVE PASSED TESTING, VENDOR SHALL SUPPLY TWO(2) 6"LG SECTIONS OF TUBE SAMPLE FROM EACH HEAT NUMBER
6. TUBES TO BE 316L/316 DUAL CERTIFIED
7. NO CHINESE MATERIAL ALLOWED
8. ALL DIMENSIONS ARE +/- 1/16"



SA179 Finned Tubes For Ineos

- 3/4" O.D x 0.109" (AW) UF x 30 feet long - 3,620 pieces
- 19 FPI, 0.049" fin height, 0.012" fin thickness
- 4" bare ends (0.126" thickness at bare ends)
- 100% ECT testing prior to finning
- Material Test Reports according to EN 10204 3.1
- Third Party Inspection by Ameritube representative
- Export standard wooden boxes (included in price)
- Shipped in two 40 foot containers





C71500 CuNi 70/30 for Dominion Energy Nuclear Plant

- The purpose of this process procedure is to summarize the production process for manufacture of seamless tubes at Ameritube, define the documents that are used by Ameritube to provide work instructions, document operating parameters, dimensional and other testing data and facilitate CUSTOMER surveillance at the Ameritube facility in accordance with CUSTOMER'S purchase order requirements.
 - Receiving Inspection Check sheet (HWO-1)
 - Annealing Work Order (HWO-2)
 - Pilgering Work Order (HWO-3)
 - Cutting Work Order (HWO-4)
 - Drawing Work Order (HWO-5)
 - Final Annealing Work Order (HWO-6)
 - Final Inspection Work Order (HWO-7)
 - Hydrostatic Testing Work Order (HWO-8)
 - Air Underwater Testing Work Order (HWO-9)
 - Flattening Test Work Order (HWO-10)
 - Straightening Work Order (HWO-11)
 - Tensile Test Work Order (HWO-12)
 - Expansion Work Order (HWO-13)
 - Micrographic Analysis Work Order (HWO-14)
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- Material Batch/Bundle Allocation/Annealing Batch # Allocation (SOP-301)
 - Receiving Inspection (SOP-1001)
 - Batch/Bundle Annealing (SOP 302)
 - Finishing and Final Inspection (SOP-600)
 - Eddy Current Testing (SOP-100)
 - Hydrostatic Testing (SOP 900)
 - Air Underwater Testing (SOP 902)
 - Tube Cleaning (SOP 903)
 - Boxing and Bundling (SOP-602)
 - Microstructure (Grain Size) (SOP 400)
 - Flattening Test (SOP 401)
 - Expansion Test (SOP 402)
 - Tensile Testing (SOP 403)