

NAVSEA
STANDARD ITEM

FY-15

ITEM NO: 009-55
DATE: 30 JUL 2010
CATEGORY: II

1. SCOPE:

1.1 Title: Regulating/Reducing Valve; repair

2. REFERENCES:

2.1 T9074-AS-GIB-010/271, Requirements for Nondestructive Testing Methods

2.2 MIL-STD-2035, Nondestructive Testing Acceptance Criteria

2.3 S9086-RJ-STM-010/CH-504, Pressure, Temperature and Other Mechanical and Electromechanical Measuring Instruments

3. REQUIREMENTS:

3.1 Matchmark valve parts.

(V) "INSPECT PARTS FOR DEFECTS"

3.2 Disassemble, clean internal and external surfaces free of foreign matter (including paint), and inspect parts for defects.

(I) "LIQUID PENETRANT INSPECT"

3.2.1 Accomplish liquid penetrant inspection of hard-faced metallic seats and discs in accordance with 2.1.

3.2.1.1 Acceptance criteria shall be in accordance with Paragraph 7 of 2.2, except hairline cracks in hard-faced areas of seats and discs are acceptable provided the valve does not show evidence of leakage.

3.3 Repair valve as follows:

3.3.1 Straighten stems and pushrods to within 0.002-inch total indicator reading. Polish stems and pushrods to a 32 Root-Mean-Square finish in way of packing or seal surfaces and remove raised edges and foreign matter.

3.3.2 Chase and tap exposed threaded areas.

3.3.3 Dress and true gasket mating surfaces.

3.3.4 Machine, grind, or lap and spot-in metallic discs to seats to obtain a 360-degree continuous contact.

(V) "INSPECT CONTACT"

3.3.4.1 Inspect contact using blueing method.

3.3.4.2 Transfer line shall not exceed 1/16-inch in width and shall appear within the lower 75 percent of the seating surface.

3.4 Assemble valve, installing new packing, gaskets, diaphragms, springs, and soft seats in accordance with manufacturer's specifications and new fasteners in accordance with Attachment A, or for DDG-51 class, Attachment B.

3.5 Hydrostatically test valve as follows:

3.5.1 Hydrostatic test equipment shall have the following capabilities:

3.5.1.1 Manual overpressure protection release valve.

3.5.1.2 Self-actuated and resetting relief valve with a set point no greater than 100 PSIG above the test pressure or 10 percent above the test pressure, whichever is less.

(V) "GAGE CHECK"

3.5.1.3 Master and backup test gages with gage range and graduation in accordance with Table 504-6-1 of 2.3. The backup gage shall be cross-checked to the master hydrostatic test gage up to the maximum test pressure just prior to start of testing. Master and backup gages shall track within 2 percent of each other.

3.5.1.4 Protection equipment shall be accessible and test gages shall be located where clearly visible and readable to pump operator and inspector.

(I) "SHOP TEST"

3.5.2 Test and set valve in shop.

3.5.2.1 Test shall be applied for a minimum of 3 minutes.

3.6 Attach a metal tag to valve, stamped with the following information:

3.6.1 Ship name and hull number

3.6.2 Valve number or identification

3.6.3 Valve regulation range and set point

3.6.4 Date valve tested and set

3.6.5 Name of repair facility

4. NOTES:

4.1 Test medium and test pressure for valve inlet and regulated pressure/temperature, shall be specified in the invoking Work Item.

4.2 Nitrogen or air may be used for shop test of steam valves.

4.3 Repairs to pilot control will be specified in Work Item.

ATTACHMENT A

VALVE BODY MATERIAL

	^{1/} Alloy Steel	Carbon Steel	^{2/} Nonferrous
^{3/} Studs and Bolts to MIL-DTL-1222	Grade B-16	Grade B-16	Phosphor Bronze - Any Grade Silicon Bronze - Any Grade Nickel Copper - Class A ^{4/}
Nuts to MIL-DTL-1222	Grade 4 or 7	Grade 4 or 7	Phosphor Bronze - Any Grade Silicon Bronze - Any Grade Nickel Copper - Class A or Class B ^{5/}
Socket Head Cap Screws	FF-S-86	FF-S-86	

^{1/} Alloy steel is of Composition A - 2-1/4 percent Chromium, one percent Molybdenum, Composition B - 1-1/4 percent Chromium, 1/2 percent Molybdenum, and Composition C - Carbon Molybdenum.

^{2/} Nonferrous Alloy except Aluminum.

^{3/} Studs shall be Class 2 or 3 fit on the nut end and Class 5 fit on the stud and, except that a Class 3 fit with a thread locking compound may be used where temperatures do not exceed 250 degrees Fahrenheit. The thread locking compound shall conform to ASTM D 5363. Check Class 3 fit stud ends in accordance with SAE-J2270.

^{4/} Fasteners of Nickel Copper Aluminum shall be the only type used on sea chest and hull valves.

^{5/} Nuts of Nickel Copper Alloy, conforming to QQ-N-281 Class A or B, or Nickel Copper Aluminum conforming to QQ-N-286 shall be the only type used on sea chest and hull valves.

ATTACHMENT B

VALVE BODY MATERIAL

	1/ Alloy Steel/Carbon Steel	2/ Nonferrous
<p>3/ Studs and Bolts to MIL-DTL-1222</p>	<p>5/ For services up to and including 650 degrees Fahrenheit; Grade 5 steel</p>	<p>4/ 5/ Phosphor Bronze - Any Grade Silicon Bronze - Any Grade Nickel Copper - Class A</p>
	<p>For services to 775 degrees Fahrenheit; Grade B-7 or B-16</p>	
	<p>For services to 1,000 degrees Fahrenheit; Grade B-16</p>	
	<p>For services in which JP-5 lubricating oil, or inflammable gas or liquid of any kind, regardless of pressure and temperature, which are within 3 feet of hot surfaces (above 650 degrees F) and where steel tubing is required; Grade 2, 5 or 8 steel</p>	
	<p>Bolting subject to seawater corrosion (other than hull integrity bolting; for hull integrity bolting see Note 4) Connections in contact with bilge regions. Where strength requires ferrous bolting and is exposed to the weather; Class A Nickel - Copper alloy to QQ-N-281 or silicon bronze to ASTM B 98 with dimensions of MIL-DTL-1222. Where greater strength is required, use Nickel - Copper - Aluminum alloy QQ-N-286.</p>	
<p>Nuts to MIL-DTL-1222</p>	<p>5/ For services up to and including 650 degrees Fahrenheit; Grade 5 steel</p>	<p>Phosphor Bronze - Any Grade Silicon Bronze - Any Grade Nickel Copper - Class A or Class B</p> <p>4/ 5/</p>
	<p>For service to 775 degrees Fahrenheit; Grade 2H or 4 steel</p>	
	<p>For services to 1,000 degrees Fahrenheit; Grade 4 steel</p>	

ATTACHMENT B
(Con't)

	1/ Alloy Steel/Carbon Steel	2/ Nonferrous
	<p>For services in which JP-5, lubricating oil, or inflammable gas or liquid of any kind, regardless of pressure and temperature which are within 3 feet of hot surfaces (above 650 degrees F) and where steel tubing is required; Grade 5 or 8 steel</p>	
	<p>Nuts subject to seawater corrosion. Connections in the bilge regions. Where strength requires ferrous material and is exposed to the weather; Class A or B Nickel Copper Alloy to QQ-N-281 or Silicon Bronze to ASTM B 98 with dimensions to MIL-DTL-1222</p>	

NOTES

- 1/ Alloy steel is of Composition A - 2-1/4 percent Chromium, one percent Molybdenum, Composition B - 1-1/4 percent Chromium, 1/2 percent Molybdenum, and Composition C - Carbon Molybdenum.
- 2/ Nonferrous Alloy except Aluminum.
- 3/ Studs shall be Class 2 or 3 fit on the nut end and Class 5 fit on the stud end, except that a Class 3 fit with a thread locking compound may be used where temperatures do not exceed 200 degrees Fahrenheit. The thread locking compound shall conform to ASTM D 5363. Check Class 3 fit stud ends in accordance with SAE-J2270.
- 4/ Fasteners of Nickel Copper Aluminum shall be the only type used on sea chest and hull valves.
- 5/ Where these materials would constitute part of a galvanic couple, proposals for alternate materials shall be submitted for approval.