

	Supply Chain Specification		Document #	Revision	DCC #
	Stress Relief Specification for A36 Steel		SCS-002	0	DCC00000106

The Supplier should always follow any Customer flow downs or drawing specific requirements first. When these requirements or drawings do not specify, AIT specifications apply. AIT specifications for multiple types of surface coatings, stress relief, or heat treating for machined and fabricated parts can be found at the link below: https://www.aint.com/about_ait/quality/overview

The latest specification available at the link above applies unless otherwise noted on the PO.

If the Supplier believes there to be a conflict between any requirements, please contact the Buyer.

General Requirements

Material	Heat Treatment	Time / Temperature / Cool	Application
A36 steel	Stress relief	1150°F +/-50°F for 2 hours, plus 15 minutes additional for each 1.0 inch of thickness over 2.0 inch. Oven cool to 600°F then air cool.	Following extensive forming, welding, or machining operation.

Notes

1. Maintain all AIT tags and markings as supplied.
2. Remove all plugs and masking prior to shipping.

Revision History

Rev.	Date	DCC	Comments	Approved By
0	8-8-2023	DCC00000106	Initial release	Robert Chianese