4.2.5.3 Test Methods: Tensile tests shall be conducted in accordance with the tensile test requirements of Method 211.1, Federal Test Method Standard No. 151. The specimens required in Paragraph 4.2.5.1 shall meet the requirements specified in Paragraph 3.10.

4.2.6 Magnetic Inspection

4.2.6.1 Sampling: A slug of sufficient weight shall be cut from intermediate ground billet stock representing the top and bottom of the first and last consumable electrode ingot produced to the requirements of this specification. In cases where an order represents less than a full ingot, recorded data taken from the original ingot approval test may apply.

4.2.6.2 Test Specimen and Procedures: The test material slug shall be ground all over and forged to a 2½ inch thick (minimum) square or octagon. A three-step test bar conforming to the requirements of Figure 1 shall be machined from the forged material. The magnetic inspection test of the bar shall be conducted in accordance with the requirements of MIL-I-6868. The magnetizing current shall be a minimum of 1000 amperes per inch of diameter. The smallest step shall be tested first and each larger step in order of size. All discontinuity indications 1/64 inch and larger shall be as specified in Paragraph 3.6.2.2.

NOTE: As an alternate method the test specimen may conform to the requirements of specification AMS-2300. Inspection procedures, sampling and limitations on indications shall be in accordance with the minimum requirements of this specification.

4.2.6.3 Magnetic Inspection Retests: If the discontinuity indications on any test bar are in excess of the allowable limits specified in Paragraph 3.6.2.2 sufficient ingot cutback shall be made and a new sample shall be tested in the manner described herein.

4.2.7 Rejection and Retest on Production Material:

4.2.7.1 General: Materials failing to meet all the requirements of this specification (except as stated in Paragraph 4.2.7.2) shall be rejected. Where the failure of any lot of