



Designation: A691/A691M – 18a A691/A691M – 19

Standard Specification for Carbon and Alloy Steel Pipe, Electric-Fusion-Welded for High-Pressure Service at High Temperatures¹

This standard is issued under the fixed designation A691/A691M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This specification² covers carbon and alloy steel pipe, electric-fusion-welded with filler metal added, fabricated from pressure-vessel-quality plate of several analyses and strength levels and suitable for high-pressure service at high temperatures. Heat treatment may or may not be required to attain the desired mechanical properties or to comply with applicable code requirements. Supplementary requirements are provided for use when additional testing or examination is desired.

1.2 The specification nominally covers pipe 16 in. [400 mm] in outside diameter and larger with wall thicknesses up to 3 in. [75 mm] inclusive. Pipe having other dimensions may be furnished provided it complies with all other requirements of this specification.

1.3 Several grades and classes of pipe are provided.

1.3.1 *Grade* designates the type of plate used as listed in [Table 1](#).

1.3.2 *Class* designates the type of heat treatment performed in the manufacture of the pipe, whether the weld is radiographically examined, and whether the pipe has been pressure tested as listed in [1.3.3](#).

1.3.3 Class designations are as follows ([Note 1](#)):

Class	Heat Treatment on Pipe	Radiography, see Section	Pressure Test, see Section
10	none	none	none
11	none	9	none
12	none	9	8.3
13	none	none	8.3
20	stress relieved, see 5.3.1	none	none
21	stress relieved, see 5.3.1	9	none
22	stress relieved, see 5.3.1	9	8.3
23	stress relieved, see 5.3.1	none	8.3
30	normalized, see 5.3.2	none	none
31	normalized, see 5.3.2	9	none
32	normalized, see 5.3.2	9	8.3
33	normalized, see 5.3.2	none	8.3
40	normalized and tempered, see 5.3.3	none	none
41	normalized and tempered, see 5.3.3	9	none
42	normalized and tempered, see 5.3.3	9	8.3
43	normalized and tempered, see 5.3.3	none	8.3
50	quenched and tempered, see 5.3.4	none	none
51	quenched and tempered, see 5.3.4	9	none
52	quenched and tempered, see 5.3.4	9	8.3
53	quenched and tempered, see 5.3.4	none	8.3

NOTE 1—Selection of materials should be made with attention to temperature of service. For such guidance, Specification [A20/A20M](#) may be consulted.

1.4 Optional requirements of a supplementary nature are provided, calling for additional tests and control of repair welding, when desired.

1.5 The values stated in either SI units or inch-pound units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system may not be exact equivalents; therefore, each system shall be used

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² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-691 in Section II of that Code.

*A Summary of Changes section appears at the end of this standard



TABLE 1 Plate Materials

Pipe Grade	Type of Steel	ASTM Specification		HB, max ^A
		Number	Grade	
CM-65	carbon-molybdenum steel	A204/A204M	A	201
CM-70	carbon-molybdenum steel	A204/A204M	B	201
CM-75	carbon-molybdenum steel	A204/A204M	C	201
CMSH-70	carbon-manganese-silicon steel, normalized	A537/A537M	1	
CMS-75	carbon-manganese-silicon steel	A299/A299M
CMSH-80	carbon-manganese-silicon steel, quenched and tempered	A537/A537M	2	
½ CR	½ % chromium, ½ % molybdenum steel	A387/A387M	2	201
1CR	1 % chromium, ½ % molybdenum steel	A387/A387M	12	201
1¼ CR	1¼ % chromium, ½ % molybdenum steel	A387/A387M	11	201
2¼ CR	2¼ % chromium, 1 % molybdenum steel	A387/A387M	22	201
3CR	3 % chromium, 1 % molybdenum steel	A387/A387M	21	201
5CR	5 % chromium, ½ % molybdenum steel	A387/A387M	5	225
9CR	9 % chromium, 1 % molybdenum steel	A387/A387M	9	241
91	9 % chromium, 1 % molybdenum, vanadium, niobium ^C	A387/A387M	91 ^B	241

^A Hardness values listed are applicable to S3.

^B Grade 91 shall be designated by Type 1 or Type 2 when required by the prevalent specification.

^C Element 41 has been identified as columbium or niobium. A01 considers them interchangeable and both acceptable. Subcommittee A01.09 has chosen to use niobium.

independently of the other. Combining values from the two systems may result in non-conformance with the standard. The inch-pound units shall apply unless the “M” designation of this specification is specified in the order.

1.6 This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.

2. Referenced Documents

2.1 ASTM Standards:³

A20/A20M Specification for General Requirements for Steel Plates for Pressure Vessels

A204/A204M Specification for Pressure Vessel Plates, Alloy Steel, Molybdenum

A299/A299M Specification for Pressure Vessel Plates, Carbon Steel, Manganese-Silicon

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

A387/A387M Specification for Pressure Vessel Plates, Alloy Steel, Chromium-Molybdenum

A435/A435M Specification for Straight-Beam Ultrasonic Examination of Steel Plates

A530/A530M Specification for General Requirements for Specialized Carbon and Alloy Steel Pipe

A537/A537M Specification for Pressure Vessel Plates, Heat-Treated, Carbon-Manganese-Silicon Steel

E165/E165M Practice for Liquid Penetrant Testing for General Industry

E709 Guide for Magnetic Particle Testing

2.2 ASME Boiler and Pressure Vessel Code:⁴

Section II

Section III

Section VIII

Section IX

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 A lot shall consist of 200 ft [60 m] or fraction thereof of pipe from the same heat of steel.

3.1.1.1 The description of a lot may be further restricted by use of Supplementary Requirement S12.

4. Ordering Information

4.1 The inquiry and order for material under this specification should include the following information:

4.1.1 Quantity (feet, metres, or number of lengths),

4.1.2 Name of the material (steel pipe, electric-fusion-welded),

4.1.3 Plate Specification number, including Grade and Type if applicable,

4.1.4 Pipe Grade and class designations (see 1.3),

³ For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For Annual Book of ASTM Standards volume information, refer to the standard's Document Summary page on the ASTM website.

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, http://www.asme.org.

- 4.1.5 Size (inside or outside diameter, nominal or minimum wall thickness),
- 4.1.6 Length (specific or random),
- 4.1.7 End finish,
- 4.1.8 Purchase options, if any (see 5.2.3, 11.3, 11.4, 13.1), and
- 4.1.9 Supplementary requirements, if any (refer to S1 through S12)-S13).

5. Materials and Manufacture

5.1 *Materials*—The steel plate material shall conform to the requirements of the applicable plate specification for the pipe grade ordered as listed in **Table 1**.

5.2 Welding:

5.2.1 The joints shall be double-welded full-penetration welds made in accordance with procedures and by welders or welding operators qualified in accordance with the ASME Boiler and Pressure Vessel Code, Section IX.

5.2.2 The welds shall be made either manually or automatically by an electric process involving the deposition of filler metal.

5.2.3 The welded joints shall have positive reinforcement at the center of each side of the weld, but no more than 1/8 in. [3 mm]. This reinforcement may be removed at the manufacturer’s option or by agreement between the manufacturer and purchaser. The contour of the reinforcement shall be smooth, and the deposited metal shall be fused smoothly and uniformly into the plate surface.

5.2.4 When radiographic examination in accordance with 9.1 is to be used, the weld reinforcement shall be governed by the more restrictive provisions of UW-51 of Section VIII of the ASME Boiler and Pressure Vessel Code instead of 5.2.3 of this specification.

5.3 *Heat Treatment*—All classes other than 10, 11, 12, and 13 shall be heat treated in a furnace controlled to ± 25 °F [15 °C] and equipped with a recording pyrometer so that heating records are available. Heat treating after forming and welding shall be to one of the following:

5.3.1 Classes 20, 21, 22, and 23 pipe shall be uniformly heated within the post-weld heat-treatment temperature range indicated in **Table 2** for a minimum of 1 h/in. [0.4 hr/cm] of thickness or for 1 h, whichever is greater.

5.3.2 Classes 30, 31, 32, and 33 pipe shall be uniformly heated to a temperature in the austenitizing range and not exceeding the maximum normalizing temperature indicated in **Table 2** and subsequently cooled in air at room temperature.

5.3.3 Classes 40, 41, 42, and 43 pipe shall be normalized in accordance with 5.3.2. After normalizing, the pipe shall be reheated to the tempering temperature indicated in **Table 2** as a minimum and held at temperature for a minimum of 1/2 h/in. [0.2 hr/cm] of thickness or for 1/2 h, whichever is greater, and air cooled.

5.3.4 Classes 50, 51, 52, and 53 pipe shall be uniformly heated to a temperature in the austenitizing range, and not exceeding the maximum quenching temperature indicated in **Table 2** and subsequently quenched in water or oil. After quenching, the pipe shall be reheated to the tempering temperature indicated in **Table 2** as a minimum and held at that temperature for a minimum of 1/2 h/in. [0.2 hr/cm] of thickness or for 1/2 h, whichever is greater, and air cooled.

5.4 Grade 91 shall be produced only to classes 4X and 5X. In addition, post-weld heat treatment is required after weld repair.

TABLE 2 Heat Treatment Parameters^A

Pipe Grade	ASTM Specification	Post-Weld Heat-Treat Temperature Range (Stress Relieving), °F (°C)	Normalizing Temperature, max unless otherwise noted, °F (°C)	Quenching Temperature, max unless otherwise noted, °F (°C)	Tempering Temperature, min, °F (°C)
CM-65	A204/A204M	1100 to 1200 [590 to 650]	1700 [925]
CM-70	A204/A204M	1100 to 1200 [590 to 650]	1700 [925]
CM-75	A204/A204M	1100 to 1200 [590 to 650]	1700 [925]
CMSH-70	A537/A537M	1100 to 1200 [590 to 650]	1700 [925]
CMS-75	A299/A299M	1100 to 1200 [590 to 650]	1700 [925]
CMSH-80	A537/A537M	1100 to 1200 [590 to 650]	1100 to 1200 [590 to 650]	1700 [925]	1100 to 1250 [590 to 675]
1/2 CR	A387/A387M	1100 to 1300 [590 to 705]	1850 [1010]	1700 [925]	1150 to 1375 [620 to 745]
1CR	A387/A387M	1100 to 1350 [590 to 730]	1850 [1010]	1700 [925]	1150 to 1375 [620 to 745]
1 1/4 CR	A387/A387M	1100 to 1375 [590 to 745]	1850 [1010]	1700 [925]	1150 to 1375 [620 to 745]
2 1/4 CR	A387/A387M	1200 to 1400 [650 to 760]	1850 [1010]	1700 [925]	1250 to 1400 [675 to 760]
3CR	A387/A387M	1200 to 1400 [650 to 760]	1850 [1010]	1700 [925]	1250 to 1400 [675 to 760]
5CR	A387/A387M	1200 to 1400 [650 to 760]	1850 [1010]	1650 [900]	1300 to 1400 [705 to 760]
9CR	A387/A387M	1325 to 1375 [715 to 745]	1325 to 1375 [715 to 745]	...	1325 to 1375 [715 to 745]
91	A387/A387M	1350 to 1420 [730 to 770]	1900 to 2000 [1040 to 1095]	1900 min [1040 min]	1350 to 1440 [730 to 780]

^AWhere ellipses (...) appear in the table, there is no requirement.

^B Requires quenching and tempering.

^C 9CR steel is an air-hardenable steel, at times retaining austenite down to near atmospheric temperature. Good practice is to allow the steel to cool to 150 °F or lower before subjecting the steel to a tempering treatment or post-weld heat treatment.

6. General Requirements

6.1 Material furnished to this specification shall conform to the applicable requirements of the current edition of Specification **A530/A530M**, unless otherwise provided herein.

7. Chemical Requirements

7.1 *Product Analysis of Plate*—The pipe manufacturer shall make an analysis of each mill heat of plate material. The product analysis so determined shall meet the requirements of the plate specification to which the material was ordered.

7.2 *Product Analysis of Weld*—The pipe manufacturer shall make an analysis of finished deposited weld metal from each 200 ft [60 m] or fraction thereof. Analysis shall conform to the welding procedure for deposited weld metal.

7.3 Analysis may be taken from the mechanical test specimens. The results of the analyses shall be reported to the purchaser.

7.4 If the analysis of one of these tests specified in 7.1 or 7.2 does not conform to the requirements specified, analyses shall be made on additional pipes of double the original number from the same lot, each of which shall conform to the requirements specified. Nonconforming pipe shall be rejected.

8. Mechanical Requirements

8.1 *Tension Test:*

8.1.1 *Requirements*—Transverse tensile properties of the welded joint shall meet the minimum requirements for ultimate tensile strength of the specified plate material.

8.1.2 *Number of Tests*—One test specimen shall be made to represent each lot of finished pipe.

8.1.3 *Test Specimen Location and Orientation*—The test specimen shall be made transverse to the weld at the end of the finished pipe and may be flattened cold before final machining to size.

8.1.4 *Test Method*—The test specimen shall be made in accordance with QW-150 in Section IX of the ASME Boiler and Pressure Vessel Code. The test specimen shall be tested at room temperature in accordance with Test Methods and Definitions **A370**.

8.2 *Transverse-Guided-Weld-Bend Tests:*

8.2.1 *Requirements*—The bend test shall be acceptable if no cracks or other defects exceeding $\frac{1}{8}$ in. [3 mm] in any direction be present in the weld metal or between the weld and the pipe metal after bending. Cracks that originate along the edges of the specimens during testing, and that are less than $\frac{1}{4}$ in. [6 mm] in any direction shall not be considered.

8.2.2 *Number of Tests*—One test (two specimens) shall be made to represent each lot of finished pipe.

8.2.3 *Test Specimen Location and Orientation*—Two bend test specimens shall be taken transverse to the weld at the end of the finished pipe. As an alternative, by agreement between the purchaser and the manufacturer, the test specimens may be taken from a test plate of the same material as the pipe, the test plate being attached to the end of the cylinder and welded as a prolongation of the pipe longitudinal weld seam.

8.2.4 *Test Method*—Bend tests shall be made in accordance with Test Methods and Definitions **A370**, A 2.5.1.7. For wall thicknesses over $\frac{3}{8}$ in. [10 mm] but less than $\frac{3}{4}$ in. [19 mm] side-bend tests may be made instead of the face and root-bend tests. For wall thicknesses $\frac{3}{4}$ in. [19 mm] and over both specimens shall be subjected to the side-bend test.

8.3 *Pressure Test*—Classes X2 and X3, pipe shall be tested in accordance with Specification **A530/A530M**, Hydrostatic Test Requirements.

9. Radiographic Examination

9.1 The full length of each weld of classes X1 and X2 shall be radiographically examined in accordance with requirements of the ASME Boiler and Pressure Vessel Code, Section VIII, Paragraph UW-51.

9.2 Radiographic examination may be performed prior to heat treatment.

10. Rework

10.1 *Elimination of Surface Imperfections*—Unacceptable surface imperfections shall be removed by grinding or machining. The remaining thickness of the section shall be no less than the minimum specified in Section 11. The depression after grinding or machining shall be blended uniformly into the surrounding surface.

10.2 *Repair of Base Metal Defects by Welding:*

10.2.1 The manufacturer may repair, by welding, base metal where defects have been removed, provided the depth of the repair cavity as prepared for welding does not exceed $\frac{1}{3}$ of the nominal thickness, and the requirements of 10.2.2, 10.2.3, 10.2.4, 10.2.5, and 10.2.6 are met. Base metal defects in excess of these may be repaired with prior approval of the customer.

10.2.2 The defect shall be removed by suitable mechanical or thermal cutting or gouging methods and the cavity prepared for repair welding.

10.2.3 The welding procedure and welders or welding operators are to be qualified in accordance with Section IX of the ASME Boiler and Pressure Vessel Code.