



Designation: B861 – 19

Standard Specification for Titanium and Titanium Alloy Seamless Pipe¹

This standard is issued under the fixed designation B861; 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.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This specification covers the requirements for 34 grades of titanium and titanium alloy seamless pipe intended for general corrosion resisting and elevated temperature service as follows:

- 1.1.1 *Grade 1*—UNS R50250. Unalloyed titanium,
- 1.1.2 *Grade 2*—UNS R50400. Unalloyed titanium,
 - 1.1.2.1 *Grade 2H*—UNS R50400. Unalloyed titanium (Grade 2 with 58 ksi (400 MPa) minimum UTS),
- 1.1.3 *Grade 3*—UNS R50550. Unalloyed titanium,
- 1.1.4 *Grade 5*—UNS R56400. Titanium alloy (6 % aluminum, 4 % vanadium),
- 1.1.5 *Grade 7*—UNS R52400. Unalloyed titanium plus 0.12 to 0.25 % palladium,
 - 1.1.5.1 *Grade 7H*—UNS R52400. Unalloyed titanium plus 0.12 to 0.25 % palladium (Grade 7 with 58 ksi (400 MPa) minimum UTS),
- 1.1.6 *Grade 9*—UNS R56320. Titanium alloy (3 % aluminum, 2.5 % vanadium),
- 1.1.7 *Grade 11*—UNS R52250. Unalloyed titanium plus 0.12 to 0.25 % palladium,
- 1.1.8 *Grade 12*—UNS R53400. Titanium alloy (0.3 % molybdenum, 0.8 % nickel),
- 1.1.9 *Grade 13*—UNS R53413. Titanium alloy (0.5 % nickel, 0.05 % ruthenium),
- 1.1.10 *Grade 14*—UNS R53414. Titanium alloy (0.5 % nickel, 0.05 % ruthenium),
- 1.1.11 *Grade 15*—UNS R53415. Titanium alloy (0.5 % nickel, 0.05 % ruthenium),
- 1.1.12 *Grade 16*—UNS R52402. Unalloyed titanium plus 0.04 to 0.08 % palladium,
 - 1.1.12.1 *Grade 16H*—UNS R52402. Unalloyed titanium plus 0.04 to 0.08 % palladium (Grade 16 with 58 ksi (400 MPa) minimum UTS),
- 1.1.13 *Grade 17*—UNS R52252. Unalloyed titanium plus 0.04 to 0.08 % palladium,

- 1.1.14 *Grade 18*—UNS R56322. Titanium alloy (3 % aluminum, 2.5 % vanadium plus 0.04 to 0.08 % palladium),
- 1.1.15 *Grade 19*—UNS R58640. Titanium alloy (3 % aluminum, 8 % vanadium, 6 % chromium, 4 % zirconium, 4 % molybdenum),
- 1.1.16 *Grade 20*—UNS R58645. Titanium alloy (3 % aluminum, 8 % vanadium, 6 % chromium, 4 % zirconium, 4 % molybdenum) plus 0.04 to 0.08 % palladium,
- 1.1.17 *Grade 21*—UNS R58210. Titanium alloy (15 % molybdenum, 3 % aluminum, 2.7 % niobium, 0.25 % silicon),
- 1.1.18 *Grade 23*—UNS R56407. Titanium alloy (6 % aluminum, 4 % vanadium, extra low interstitial, ELI),
- 1.1.19 *Grade 24*—UNS R56405. Titanium alloy (6 % aluminum, 4 % vanadium) plus 0.04 to 0.08 % palladium,
- 1.1.20 *Grade 25*—UNS R56403. Titanium alloy (6 % aluminum, 4 % vanadium) plus 0.3 to 0.8 % nickel and 0.04 to 0.08 % palladium,
- 1.1.21 *Grade 26*—UNS R52404. Unalloyed titanium plus 0.08 to 0.14 % ruthenium,
 - 1.1.21.1 *Grade 26H*—UNS R52404. Unalloyed titanium plus 0.08 to 0.14 % ruthenium (Grade 26 with 58 ksi (400 MPa) minimum UTS),
- 1.1.22 *Grade 27*—UNS R52254. Unalloyed titanium plus 0.08 to 0.14 % ruthenium,
- 1.1.23 *Grade 28*—UNS R56323. Titanium alloy (3 % aluminum, 2.5 % vanadium plus 0.08 to 0.14 % ruthenium),
- 1.1.24 *Grade 29*—UNS R56404. Titanium alloy (6 % aluminum, 4 % vanadium, extra low interstitial, ELI plus 0.08 to 0.14 % ruthenium),
- 1.1.25 *Grade 33*—UNS R53442. Titanium alloy (0.4 % nickel, 0.015 % palladium, 0.025 % ruthenium, 0.15 % chromium),
- 1.1.26 *Grade 34*—UNS R53445. Titanium alloy (0.4 % nickel, 0.015 % palladium, 0.025 % ruthenium, 0.15 % chromium),
- 1.1.27 *Grade 35*—UNS R56340. Titanium alloy (4.5 % aluminum, 2 % molybdenum, 1.6 % vanadium, 0.5 % iron, 0.3 % silicon),
- 1.1.28 *Grade 36*—UNS R58450. Titanium alloy (45 % niobium),
- 1.1.29 *Grade 37*—UNS R52815. Titanium alloy (1.5 % aluminum), and

¹ This specification is under the jurisdiction of ASTM Committee B10 on Reactive and Refractory Metals and Alloys and is the direct responsibility of Subcommittee B10.01 on Titanium.

Current edition approved Nov. 1, 2019. Published November 2019. Originally approved in 1995. Last previous edition approved in 2014 as B861 – 14. DOI: 10.1520/B0861-19.

1.1.30 *Grade 38*—UNS R54250. Titanium alloy (4 % aluminum, 2.5 % vanadium, 1.5 % iron).

NOTE 1—H grade material is identical to the corresponding numeric grade (that is, Grade 2H = Grade 2) except for the higher guaranteed minimum UTS, and may always be certified as meeting the requirements of its corresponding numeric grade. Grades 2H, 7H, 16H, and 26H are intended primarily for pressure vessel use.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *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:*²

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

B600 Guide for Descaling and Cleaning Titanium and Titanium Alloy Surfaces

E8 Test Methods for Tension Testing of Metallic Materials [Metric] E0008_E0008M

E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E539 Test Method for Analysis of Titanium Alloys by Wavelength Dispersive X-Ray Fluorescence Spectrometry

E1409 Test Method for Determination of Oxygen and Nitrogen in Titanium and Titanium Alloys by Inert Gas Fusion

E1447 Test Method for Determination of Hydrogen in Titanium and Titanium Alloys by Inert Gas Fusion Thermal Conductivity/Infrared Detection Method

E1941 Test Method for Determination of Carbon in Refractory and Reactive Metals and Their Alloys by Combustion Analysis

E2371 Test Method for Analysis of Titanium and Titanium Alloys by Direct Current Plasma and Inductively Coupled Plasma Atomic Emission Spectrometry (Performance-Based Test Methodology)

E2994 Test Method for Analysis of Titanium and Titanium Alloys by Spark Atomic Emission Spectrometry and Glow Discharge Atomic Emission Spectrometry (Performance-Based Method)

2.2 *ANSI/ASME Standards:*³

B.1.20.1 Pipe Threads, General Purpose (Inch)

B 36.10 Carbon, Alloy and Stainless Steel Pipes

B 36.19M-1985 Stainless Steel Pipe

3. Terminology

3.1 *Definitions:*

² 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.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

3.1.1 *lot, n*—a number of pieces of pipe of the same nominal size and wall thickness manufactured by the same process from a single heat of titanium or titanium alloy and heat treated by the same furnace parameters in the same furnace.

3.1.2 *seamless pipe, n*—a hollow tubular product produced with a continuous periphery in all stages of manufacture.

4. Ordering Information

4.1 Orders for materials under this specification shall include the following information as required:

4.1.1 Quantity,

4.1.2 Grade number (Section 1 and Table 1),

4.1.3 Nominal pipe size and schedule (Table 2),

4.1.4 Diameter tolerance (Table 3),

4.1.5 Length tolerance (see 9.3),

4.1.6 Method of manufacture and finish (Sections 5 and 10),

4.1.7 Product analysis, if required (Sections 6 and 7; Table 1 and Table 4),

4.1.8 Mechanical properties, (Sections 8, 14, 15, and 16 and Table 5),

4.1.9 Packaging (Section 23),

4.1.10 Inspection and test reports (Sections 19, 20 and 21), and

4.1.11 Product marking (Section 22).

5. Manufacture

5.1 Seamless pipe may be manufactured by any method that will yield a product meeting the requirements of this specification.

5.2 Unless specified, cold worked pipe shall be heat treated at a temperature of not less than 1000°F (538°C). Hot worked pipe finishing above 1400°F (760°C) need not be further heat treated. The minimum heat treat conditions for Grade 9, 18, and 28 pipe delivered in the stress relieved condition shall be 600°F (316°C) for at least 30 min.

5.2.1 Grade 5, Grade 9, Grade 18, Grade 19, Grade 20, Grade 21, Grade 23, Grade 24, Grade 25, Grade 28, Grade 29, Grade 35, Grade 36, and Grade 38 alloys may be supplied in the following conditions:

5.2.1.1 *Grade 5, Grade 23, Grade 24, Grade 25, Grade 29, Grade 35, or Grade 36*—Annealed or aged condition,

5.2.1.2 *Grade 9, Grade 18, Grade 28, or Grade 38*—Cold-worked and stress-relieved or annealed,

5.2.1.3 *Grade 9, Grade 18, Grade 23, Grade 28, or Grade 29*—Transformed-beta condition, and

5.2.1.4 *Grade 19, Grade 20, or Grade 21*—Solution-treated or solution-treated and aged.

6. Chemical Requirements

6.1 The grades of titanium and titanium alloy metal covered by this specification shall conform to the requirements of the chemical compositions prescribed in Table 1.

6.1.1 The elements listed in Table 1 are intentional alloy additions or elements which are inherent to the manufacture of titanium sponge, ingot or mill product.

6.1.1.1 Elements other than those listed in Table 1 are deemed to be capable of occurring in the grades listed in Table 1 by and only by way of unregulated or unanalyzed scrap

TABLE 1 Chemical Requirements

Composition, Weight Percent^{A,B,C,D,E}

Grade	UNS Number	Carbon, max.	Oxygen, range or max.	Nitrogen, max.	Hydrogen, max.	Iron, range or max.	Aluminum	Vanadium	Palladium	Ruthenium	Nickel	Molybdenum	Chromium	Cobalt	Zirconium	Niobium	Tin	Silicon	Other Elements, max. each	Other Elements, max. total	
1	R50250	0.08	0.18	0.03	0.015	0.20	--	--	--	--	--	--	--	--	--	--	--	--	0.1	0.4	
2/2H	R50400	0.08	0.25	0.03	0.015	0.30	--	--	--	--	--	--	--	--	--	--	--	--	0.1	0.4	
3	R50550	0.08	0.35	0.05	0.015	0.30	--	--	--	--	--	--	--	--	--	--	--	--	0.1	0.4	
4	R50700	0.08	0.40	0.05	0.015	0.50	--	--	--	--	--	--	--	--	--	--	--	--	0.1	0.4	
5	R56400	0.08	0.20	0.05	0.015	0.40	5.5-6.75	3.5-4.5	--	--	--	--	--	--	--	--	--	--	0.1	0.4	
7/7H	R52400	0.08	0.25	0.03	0.015	0.30	--	--	0.12-0.25	--	--	--	--	--	--	--	--	--	--	0.1	0.4
9	R56320	0.08	0.15	0.03	0.015	0.25	2.5-3.0	2.0-3.0	--	--	--	--	--	--	--	--	--	--	0.1	0.4	
11	R52250	0.08	0.18	0.03	0.015	0.20	--	--	0.12-0.25	--	--	--	--	--	--	--	--	--	0.1	0.4	
12	R53400	0.08	0.25	0.03	0.015	0.30	--	--	--	--	0.6-0.9	0.2-0.4	--	--	--	--	--	--	0.1	0.4	
13	R53413	0.08	0.10	0.03	0.015	0.20	--	--	--	0.04-0.06	0.4-0.6	--	--	--	--	--	--	--	0.1	0.4	
14	R53414	0.08	0.15	0.03	0.015	0.30	--	--	--	0.04-0.06	0.4-0.6	--	--	--	--	--	--	--	0.1	0.4	
15	R53415	0.08	0.25	0.05	0.015	0.30	--	--	--	0.04-0.06	0.4-0.6	--	--	--	--	--	--	--	0.1	0.4	
16/16H	R52402	0.08	0.25	0.03	0.015	0.30	--	--	0.04-0.08	--	--	--	--	--	--	--	--	--	0.1	0.4	
17	R52252	0.08	0.18	0.03	0.015	0.20	--	--	0.04-0.08	--	--	--	--	--	--	--	--	--	0.1	0.4	
18	R56322	0.08	0.15	0.03	0.015	0.25	2.5-3.0	2.0-3.0	0.04-0.08	--	--	--	--	--	--	--	--	--	0.1	0.4	
19	R58640	0.05	0.12	0.03	0.02	0.30	3.0-4.0	7.5-8.5	--	--	--	3.5-4.5	5.5-6.5	--	--	--	--	--	0.15	0.4	
20	R58645	0.05	0.12	0.03	0.02	0.30	3.0-4.0	7.5-8.5	0.04-0.08	--	--	3.5-4.5	5.5-6.5	--	--	--	--	--	0.15	0.4	
21	R58210	0.05	0.17	0.03	0.015	0.40	2.5-3.5	--	--	--	--	14.0-16.0	--	--	2.2-3.2	--	0.15-0.25	--	0.1	0.4	
23	R56407	0.08	0.13	0.03	0.0125	0.25	3.5-5.5	3.5-4.5	--	--	--	--	--	--	--	--	--	--	0.1	0.4	
24	R56405	0.08	0.20	0.05	0.015	0.40	5.5-6.75	3.5-4.5	0.04-0.08	--	--	--	--	--	--	--	--	--	0.1	0.4	
25	R56403	0.08	0.20	0.05	0.015	0.40	5.5-6.75	3.5-4.5	0.04-0.08	--	0.3-0.8	--	--	--	--	--	--	--	0.1	0.4	
26/26H	R52404	0.08	0.25	0.03	0.015	0.30	--	--	--	0.08-0.14	--	--	--	--	--	--	--	--	0.1	0.4	
27	R52254	0.08	0.18	0.03	0.015	0.20	--	--	--	0.08-0.14	--	--	--	--	--	--	--	--	0.1	0.4	
28	R56323	0.08	0.15	0.03	0.015	0.25	2.5-3.0	2.0-3.0	--	--	--	--	--	--	--	--	--	--	0.1	0.4	
29	R56404	0.08	0.13	0.03	0.015	0.25	5.5-6.5	3.5-4.5	--	--	--	--	--	--	--	--	--	--	0.1	0.4	
32	R55111	0.08	0.11	0.03	0.015	0.25	4.5-5.5	0.6-1.4	--	--	--	0.6-1.2	--	--	0.6-1.4	--	0.6-1.4	--	0.1	0.4	
33	R53442	0.08	0.25	0.03	0.015	0.30	--	--	0.01-0.02	0.02-0.04	0.35-0.55	--	0.1-0.2	--	--	--	--	--	0.1	0.4	

TABLE 1 Continued

 Composition, Weight Percent^{A,B,C,D,E}

UNS Grade	Carbon max.	Oxygen range or max.	Nitrogen, Hydrogen, max.	Iron range or max.	Aluminum	Vanadium	Palladium	Ruthenium	Nickel	Molybdenum	Chromium	Cobalt	Zirconium	Niobium	Tin	Silicon	Other Elements, max. each	Other Elements, max. total
34	R53445	0.08	0.35	0.015	0.30	--	0.01- 0.02	0.02- 0.04	0.35- 0.55	--	0.1- 0.2	--	--	--	--	--	0.1	0.4
35	R56340	0.08	0.25	0.015	0.20- 0.80	4.0- 5.0	--	--	--	1.5- 2.5	--	--	--	--	0.20- 0.40	0.1	0.1	0.4
36	R58450	0.04	0.16	0.015	0.03	--	--	--	--	--	--	--	42.0- 47.0	--	--	0.1	0.1	0.4
37	R52815	0.08	0.25	0.015	0.30	1.0- 2.0	--	--	--	--	--	--	--	--	--	0.1	0.1	0.4
38	R54250	0.08	0.20- 0.30	0.015	1.2- 1.8	3.5- 4.5	2.0- 3.0	--	--	--	--	--	--	--	--	0.1	0.1	0.4

^A At minimum, the analysis of samples from the top and bottom of the ingot shall be completed and reported for all elements listed for the respective grade in this table.

^B Final product hydrogen shall be reported. Ingot hydrogen need not be reported. Lower hydrogen may be obtained by negotiation with the manufacturer.

^C Single values are maximum. The percentage of titanium is determined by difference.

^D Other elements need not be reported unless the concentration level is greater than 0.1 % each, or 0.4 % total. Other elements may not be added intentionally. Other elements may be present in titanium or titanium alloys in small quantities and are inherent to the manufacturing process. In titanium these elements typically include aluminum, vanadium, tin, chromium, molybdenum, niobium, zirconium, hafnium, bismuth, ruthenium, palladium, yttrium, copper, silicon, cobalt, tantalum, nickel, boron, manganese, and tungsten.

^E The purchaser may, in the written purchase order, request analysis for specific elements not listed in this specification.