



Designation: A554 – 21

Standard Specification for Welded Stainless Steel Mechanical Tubing¹

This standard is issued under the fixed designation A554; 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 specification covers welded austenitic, ferritic, and austenitic-ferritic duplex stainless steel mechanical tubing intended for use in ornamental, structural, exhaust, and other applications where appearance, mechanical properties, or corrosion resistance is needed. The grades covered are listed in [Table 1](#).

1.2 This specification covers as-welded or cold-reduced mechanical tubing in sizes to 16 in. (406.4 mm) outside dimension, and in wall thicknesses 0.020 in. (0.51 mm) and over.

1.3 Tubes shall be furnished in one of the following shapes as specified by the purchaser: round, square, rectangular, or special.

1.4 Supplementary requirements of an optional nature are provided and when desired shall be so stated in the order.

1.5 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.

1.6 *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:*²

[A370 Test Methods and Definitions for Mechanical Testing of Steel Products](#)

[A751 Test Methods and Practices for Chemical Analysis of Steel Products](#)

¹ This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.10 on Stainless and Alloy Steel Tubular Products.

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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.

[A790/A790M Specification for Seamless and Welded Ferritic/Austenitic Stainless Steel Pipe](#)

[A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys](#)

[E527 Practice for Numbering Metals and Alloys in the Unified Numbering System \(UNS\)](#)

2.2 *Military Standards:*

[MIL-STD-129 Marking for Shipment and Storage](#)³

[MIL-STD-163 Steel Mill Products Preparation for Shipment and Storage](#)³

2.3 *Federal Standard:*

[Fed. Std. No. 123 Marking for Shipments \(Civil Agencies\)](#)³

2.4 *SAE Standard:*

[SAE J 1086 Numbering Metals and Alloys](#)⁴

3. Terminology

3.1 *Definitions*—For definitions of terms used in this specification, refer to Terminology [A941](#).

4. Ordering Information

4.1 Orders for material under this specification should include the following, as required, to describe the desired material adequately:

4.1.1 Quantity (feet, mass, or number of pieces),

4.1.2 Name of material (welded stainless steel mechanical tubing),

4.1.3 Form (round, square, rectangular, special, see [1.3](#)),

4.1.4 Dimensions:

4.1.4.1 Round—outside diameter and wall thickness for all conditions (Section [9](#)). Alternatively, for cold-reduced condition, outside diameter and inside diameter or inside diameter and wall dimensions may be specified,

4.1.4.2 Square and rectangular outside dimensions and wall thickness (see [10.1](#)),

4.1.4.3 Special (to be specified),

4.1.5 Length (mill lengths, cut lengths, or multiple lengths (see [9.3](#))),

4.1.6 Grade ([Table 1](#)),

4.1.7 Condition (see [7.1](#)),

³ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

⁴ Available from SAE International (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

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

TABLE 1 Chemical Requirements^A

UNS # ^J	Grade	Composition, %										Copper	Other
		Carbon	Manga- nese,	Phos- phorus	Sulfur	Silicon	Nickel	Chromium	Molybdenum	Titanium	Columbium		
Austenitic													
MT-301		0.15	2.00	0.045	0.030	1.00	6.0–8.0	16.0–18.0
MT-302		0.15	2.00	0.045	0.030	1.00	8.0–10.0	17.0–19.0
MT-304		0.08	2.00	0.045	0.030	1.00	8.0–11.0	18.0–20.0
MT-304L		0.035 ^B	2.00	0.045	0.030	1.00	8.0–13.0	18.0–20.0
MT-305		0.12	2.00	0.045	0.030	1.00	10.0–13.0	17.0–19.0
MT-309S		0.08	2.00	0.045	0.030	1.00	12.0–15.0	22.0–24.0
MT-309S-Cb		0.08	2.00	0.045	0.030	1.00	12.0–15.0	22.0–24.0
MT-310S		0.08	2.00	0.045	0.030	1.00	19.0–22.0	24.0–26.0
MT-316		0.08	2.00	0.045	0.030	1.00	10.0–14.0	16.0–18.0
MT-316L		0.035 ^B	2.00	0.045	0.030	1.00	10.0–15.0	16.0–18.0
...		0.030	2.00	0.045	0.015	1.00	8.0–9.5	19.5–21.5	0.50–1.50
MT-317		0.08	2.00	0.045	0.030	1.00	11.0–14.0	18.0–20.0	3.0–4.0
MT-321		0.08	2.00	0.045	0.030	1.00	9.0–13.0	17.0–20.0
MT-330		0.15	2.00	0.040	0.030	1.00	33.0–36.0	14.0–16.0
MT-347		0.08	2.00	0.045	0.030	1.00	9.0–13.0	17.0–20.0
Ferritic													
MT-429		0.12	1.00	0.040	0.030	1.00	0.50 max	14.0–16.0
MT-430		0.12	1.00	0.040	0.030	1.00	0.50 max	16.0–18.0
MT-430-Ti		0.10	1.00	0.040	0.030	1.00	0.75 max	16.0–19.5	...	5 x C min, 0.75 max
S40900	409 ^F	0.030	1.00	0.040	0.020	1.00	0.50	10.5–11.7	...	Ti 6X (C+N) min, 0.050 max	Cb 0.17	0.030	...
S40920		0.030	1.00	0.040	0.020	1.00	0.50	10.5–11.7	...	Ti 8X (C+N) min, 0.050 max	Cb 0.10	0.030	...
S40930		0.030	1.00	0.040	0.020	1.00	0.50	10.5–11.7	...	Ti 0.15–0.50 (Ti+Cb) [0.08+8 x (C+N)] min, 0.75 max; Ti 0.05 min	...	0.030	...
S43400	434	0.120	1.00	0.040	0.030	1.00	...	16.0–18.0	0.75–1.25	...	Cb 5 x C min
S43600	436	0.120	1.00	0.040	0.030	1.00	...	16.0–18.0	0.75–1.25	...	0.080 max
S43035	439	0.030	1.00	0.040	0.030	1.00	0.50	17.0–19.0	...	Ti [0.20+4(C+N)] min, 1.10 max; Al 0.015	...	0.030	...
S41003	^F	0.030	1.50	0.040	0.030	1.00	1.50	10.5–12.5	0.030	...
S44400	444	0.025	1.00	0.040	0.030	1.00	1.00	17.5–19.5	1.75–2.50	(Ti+Cb) min [0.20+4(C+N)]	...	0.035	...
S41008	410 ^S	0.080	1.00	0.040	0.030	1.00	0.60	11.5–13.5	...	0.80 max
S44100	444	0.030	1.00	0.040	0.030	1.00	1.00	17.5–19.5	...	0.1–0.5	Cb 0.3+ (9x C) min, 0.9 max
Austenitic-Ferritic													
S31803		0.030	2.00	0.030	0.020	1.00	4.5–6.5	21.0–23.0	2.5–3.5	0.08–0.20	...
S32003		0.030	2.00	0.030	0.020	1.00	3.0–4.0	19.5–22.5	1.50–2.00	0.14–0.20	...
S32101		0.040	4.0–6.0	0.040	0.030	1.00	1.35–1.70	21.0–22.0	0.10–0.80	0.20–0.25	0.10–0.80
S32202		0.030	2.00	0.040	0.010	1.00	1.00–2.80	21.5–24.0	0.45 max	0.18–0.26	...

TABLE 1 Continued

UNS # ¹	Grade	Composition, %											
		Carbon	Manga- nese,	Phos- phorus	Sulfur	Silicon	Nickel	Chromium	Molybdenum	Titanium	Columbium	Nitrogen	Copper
S32205	2205 ^K	0.030	2.00	0.030	0.020	1.00	4.5–6.5	22.0–23.0	3.0–3.5	...	0.14–0.20
S32304	2304 ^K	0.030	2.50	0.040	0.040	1.00	3.0–5.5	21.5–24.5	0.05–0.60	...	0.05–0.20	0.05–0.60	...
S32550	255 ^K	0.04	1.50	0.040	0.030	1.00	4.5–6.5	24.0–27.0	2.9–3.9	...	0.10–0.25	1.50–2.50	...
S32750 ^H	2507 ^K	0.030	1.20	0.035	0.020	0.80	6.0–8.0	24.0–26.0	3.0–5.0	...	0.24–0.32	0.5	...
S32760 ^I		0.030	1.00	0.030	0.010	1.00	6.0–8.0	24.0–26.0	3.0–4.0	...	0.20–0.30	0.50–1.00	W 0.50–1.00
S81921		0.030	2.00–4.00	0.040	0.030	1.00	2.00–4.00	19.0–22.0	1.00–2.00	...	0.14–0.20
S82011		0.030	2.0–3.0	0.040	0.020	1.00	1.00–2.00	20.5–23.5	0.10–1.00	...	0.15–0.27	0.50	...
S82441		0.030	2.5–4.0	0.035	0.005	0.70	3.0–4.5	23.0–25.0	1.00–2.00	...	0.20–0.30	0.10–0.80	...

^AMaximum, unless a range or minimum is indicated. Where ellipses (...) appear in this table, there is no minimum and analysis for the element need not be determined or reported.

^BFor small diameter or thin walls, or both, where many drawing passes are required, a carbon content of 0.040 % max is necessary in grades MT-304L and MT-316L. Small outside diameter tubes are defined as those less than 0.500 in. (12.7 mm) in outside diameter and light wall tubes as those less than 0.049 in. (1.24 mm) in average wall thickness.

^CThe columbium content shall be not less than ten times the carbon content and not more than 1.00 %.

^DThe titanium content shall be not less than five times the carbon content and not more than 0.60 %.

^ES40900 (Type 409) has been replaced by S40910, S40920, and S40930. Unless otherwise specified in the ordering information, an order specifying S40900 or Type 409, shall be satisfied by any one of S40910, S40920, or S40930 at the option of the seller. Material meeting the requirements of S40910, S40920, or S40930 may, by agreement between purchaser and manufacturer, be certified as S40900.

^FS41003 chemical composition relates to Type 412, which is not currently an AISI or SAE number.

^GS44100 chemical composition relates to Type 441, which is not currently an AISI or SAE number.

^H% Cr + 3.3 x %Mo + 16 x %N = 41 min.

^I% Cr + 3.3 x %Mo + 16 x %N = 40 min.

^JDesignation established in accordance with Practice E527 and SAE J 1086.

^KCommon name, not a trademark, widely used, not associated with any one producer.

- 4.1.8 Inside diameter bead condition (see 7.2),
- 4.1.9 Surface finish (see Section 12),
- 4.1.10 Report of chemical analysis, if required (Section 8),
- 4.1.11 Individual supplementary requirements, if required,
- 4.1.12 End use,
- 4.1.13 Specification designation,
- 4.1.14 Special requirements,
- 4.1.15 Special marking (Section 15), and
- 4.1.16 Special packing (Section 16).

5. Process

- 5.1 The steel may be made by any process.
- 5.2 If a specific type of melting is required by the purchaser, it shall be stated on the purchase order.
- 5.3 The primary melting may incorporate separate degassing or refining and may be followed by secondary melting, such as electroslag remelting or vacuum-arc remelting. If secondary melting is employed, the heat shall be defined as all of the ingots remelted from a single primary heat.
- 5.4 Steel may be cast in ingots or may be strand cast. When steel of different grades are sequentially strand cast, identification of the resultant transition material is required. The producer shall remove the transition material by an established procedure that positively separates the grades.

6. Materials and Manufacture

- 6.1 The tubes shall be made from flat-rolled steel by an automatic welding process without the addition of filler metal.

7. Condition

- 7.1 The tubes shall be furnished in any of the following conditions as specified:
 - 7.1.1 As welded,
 - 7.1.2 Welded and annealed,
 - 7.1.3 Cold reduced,
 - 7.1.4 Cold reduced and annealed.
- 7.2 The inside diameter bead shall be furnished in any of the following conditions as specified:
 - 7.2.1 Bead not removed,
 - 7.2.2 Bead controlled to 0.005 in. (0.13 mm) or 15 % of the specified wall thickness, whichever is greater, and
 - 7.2.3 Bead removed.
- 7.3 Square and rectangular welded stainless tubing is supplied as cold worked unless otherwise specified.

8. Heat Analysis

- 8.1 An analysis of each heat of steel shall be made by the steel manufacturer to determine the percentages of the elements specified. If secondary melting processes are employed, the heat analysis shall be obtained from one remelted ingot or the product of one remelted ingot of each primary melt. The chemical composition thus determined, or that determined from a product analysis made by the tubular product manufacturer, shall conform to requirements specified. When requested in the order or contract, a report of this analysis shall be furnished to the purchaser. (See Test Methods, Practices, and Terminology A751.)

TABLE 2 Diameter, Wall,^A and Ovality Tolerances (All Conditions Except Tubing with Bead Removed)

NOTE 1—Ovality is the difference between maximum and minimum outside diameters measured at any one cross section. There is no additional tolerance for ovality on tubes having a specified wall thickness of more than 3 % of the outside diameter.

NOTE 2—For sizes up to and including 5-in. (127.0-mm) outside diameter, an ovality tolerance of twice the tabular outside diameter tolerance spread shown is applied one half plus and one half minus to tubes having a specified wall thickness of 3 % or less of the specified outside diameter. The average of the maximum and minimum outside diameter readings should fall within the outside diameter tolerances as shown in this table.

NOTE 3—For sizes over 5-in. (127.0-mm) to and including 16-in. (406.4-mm) outside diameter, when the specified wall thickness is 3 % or less of the outside diameter, the ovality shall not exceed 1.5 % of the specified outside diameter.

OD Size, in. (mm)	Wall Thickness		OD, ±	
	in.	mm	in.	mm
Under ½ (12.7)	0.020 to 0.049	0.51 to 1.24	0.004	0.10
½ to 1 (12.7 to 25.4)	0.020 to 0.065	0.51 to 1.65	0.005	0.13
½ to 1 (12.7 to 25.4)	over 0.065 to 0.134	over 1.65 to 3.40	0.010	0.25
Over 1 to 1 ½ (25.4 to 38.1), incl	0.025 to 0.065	0.64 to 1.65	0.008	0.20
Over 1 to 1 ½ (25.4 to 38.1), incl	over 0.065 to 0.134	over 1.65 to 3.40	0.010	0.25
Over 1 ½ to 2 (38.1 to 50.8), incl	0.025 to 0.049	0.64 to 1.24	0.010	0.25
Over 1 ½ to 2 (38.1 to 50.8), incl	over 0.049 to 0.083	over 1.24 to 2.11	0.011	0.28
Over 1 ½ to 2 (38.1 to 50.8), incl	over 0.083 to 0.149	over 2.11 to 3.78	0.012	0.30
Over 2 to 2 ½ (50.8 to 63.5), incl	0.032 to 0.065	0.81 to 1.65	0.012	0.30
Over 2 to 2 ½ (50.8 to 63.5), incl	over 0.065 to 0.109	over 1.65 to 2.77	0.013	0.33
Over 2 to 2 ½ (50.8 to 63.5), incl	over 0.109 to 0.165	over 2.77 to 4.19	0.014	0.36
Over 2 ½ to 3 ½ (63.5 to 88.9), incl	0.032 to 0.165	0.81 to 4.19	0.014	0.36
Over 2 ½ to 3 ½ (63.5 to 88.9), incl	over 0.165	over 4.19	0.020	0.51
Over 3 ½ to 5 (88.9 to 127.0), incl	0.035 to 0.165	0.89 to 4.19	0.020	0.51
Over 3 ½ to 5 (88.9 to 127.0), incl	over 0.165	over 4.19	0.025	0.64
Over 5 to 7 ½ (127.0 to 190.5), incl	0.049 to 0.250	1.24 to 6.35	0.025	0.64
Over 5 to 7 ½ (127.0 to 190.5), incl	over 0.250	over 6.35	0.030	0.76
Over 7 ½ to 16 (190.5 to 406.4), incl	all	all	0.00125 in./in. or mm/mm of circumference	

^A Wall tolerance ±10 % of specified wall thickness.

9. Permissible Variations in Dimensions—Round Tubing

9.1 For all conditions except tubing with bead removed, Table 2 shall apply.

9.2 For tubing with bead removed, Table 3 shall apply.

9.3 *Lengths*—Tubing is normally furnished in mill lengths 5 ft (1.5 m) and over. Definite cut lengths are furnished when specified, to the length tolerances shown in Table 4. For tubing ordered in multiple lengths, it is common practice to allow a definite amount over for each multiple for the purchaser’s cutting operation. Thus cutting allowance should be specified in the purchase order.

9.4 *Straightness Tolerance*—The straightness tolerance shall be 0.030 in. (0.76 mm) maximum in any 3-ft (0.9-m) length of tubing. The straightness tolerance on shorter lengths and on special requirements shall be agreed upon between the purchaser and producer.

10. Permissible Variations in Dimensions—Square and Rectangular Tubing

10.1 For this tubing, variations in dimensions from those specified shall not exceed the amounts prescribed in Table 5. For lengths, see 9.3. For the measurement of corner radii in Table 5, refer to Fig. 1.

11. Workmanship, Finish, and Appearance

11.1 Finished tubes shall have smooth ends free of burrs. They shall be free of injurious defects and shall have a

TABLE 3 Diameter, Wall,^A and Ovality Tolerances for Tubing with Bead Removed

NOTE 1—Ovality is the difference between maximum and minimum outside diameters measured at any one cross section. There is no additional tolerance for ovality on tubes having a specified wall thickness of more than 3 % of the outside diameter.

NOTE 2—An ovality allowance of twice the outside diameter tolerance, shown in this table, is applied one half plus and one half minus to the outside diameter, for tubes having a specified wall thickness of 3 % or less of the specified outside diameter. The average of the maximum and minimum outside diameter readings should fall within the outside diameter tolerances of this table.

NOTE 3—Tubing may be specified to only two of the three following dimensions—outside diameter, inside diameter, or wall.

OD Size, in. (mm)	OD, ±		ID, ±	
	in.	mm	in.	mm
Up to 3/32 (2.4), excl	0.001	0.03	0.001	0.03
3/32 to 3/16 (2.4 to 4.8), excl	0.0015	0.038	0.0015	0.038
3/16 to 1/2 (4.8 to 12.7), excl	0.003	0.08	0.005	0.13
1/2 to 1 (12.7 to 25.4), excl	0.004	0.10	0.006	0.15
1 to 1 1/2 (25.4 to 38.1), excl	0.005	0.13	0.007	0.18
1 1/2 to 2 (38.1 to 50.8), excl	0.006	0.15	0.008	0.20
2 to 2 1/2 (50.8 to 63.5), excl	0.007	0.18	0.010	0.25
2 1/2 to 3 1/2 (63.5 to 88.9), excl	0.010	0.25	0.014	0.36
3 1/2 to 5 (88.9 to 127.0), incl	0.015	0.38	0.020	0.51
Over 5 to 16 (127.0 to 406.4), incl	0.00125 in./in. or mm/mm of circumference		0.0013 in./in. or mm/mm of circumference	

^A Wall tolerance is ±10 % of specified wall thickness.

TABLE 4 Length Variations—Cut Length Tubes

Length, ft (m)	Outside Diameter, in. (mm)	Permissible Variations in Length, in.		
		Over ^A		Under
		in.	mm	
4 (1.2) and under	up to 2 (50.8), incl over 2 to 4 (50.8 to 101.6), incl over 4 (101.6)	1/16	1.6	0
		3/32	2.4	0
		1/8	3.2	0
Over 4 to 10 (1.2 to 3.0), incl	up to 2 (50.8), incl over 2 (50.8)	3/32	2.4	0
		1/8	3.2	0
Over 10 to 24 (3.0 to 7.3), incl	all sizes	3/16	4.8	0

^A For all diameters in lengths over 24 ft (7.3 m), an additional over tolerance of 1/8 in. (3.2 mm) for each 10 ft (3.0 m) or fraction thereof shall be permissible, up to a tolerance of 1/2 in. (12.7 mm), max.

workmanlike finish. Surface imperfections such as handling marks, straightening marks, light mandrel and die marks, shallow pits, and scale patterns will not be considered as serious defects, provided the imperfections are removable within 10 % of the specified wall or 0.002 in. (0.05 mm), whichever is greater. The removal of surface imperfections is not required, unless special finishes are specified.

12. Surface Finish

12.1 Tubes shall be free of scale.

12.2 If special surface conditioning is required, they shall be stated in the order.

13. Rejection

13.1 Tubing that fails to meet the requirements of this specification shall be set aside and the manufacturer notified.

14. Coating

14.1 Stainless steel tubing is commonly shipped without protective coating. If special protection is needed, details shall be specified in the order.

15. Product Marking

15.1 *Civilian Procurement*—Each box, bundle or lift, and piece (when individual pieces are shipped) shall be identified by a tag or stencil with the manufacturer’s name or brand, specified size, purchaser’s order number, this specification number, and grade. Bar coding is acceptable as a supplementary identification method. Bar coding should be consistent with the Automotive Industry Action Group (AIAG) standard prepared by the Primary Metals Subcommittee of the AIAG Bar Code Project Team.

15.2 *Government Procurement*—When specified in the contract or order, and for direct procurement by or direct shipment to the government, marking for shipment, in addition to requirements specified in the contract or order, shall be in accordance with MIL-STD-129 for Military agencies and in accordance with Fed. Std. No. 123 for civil agencies.