



Designation: **A268/A268M—20 A268/A268M – 22**

Standard Specification for Seamless and Welded Ferritic and Martensitic Stainless Steel Tubing for General Service¹

This standard is issued under the fixed designation A268/A268M; 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 specification² covers a number of grades of nominal-wall-thickness, stainless steel tubing for general corrosion-resisting and high-temperature service. Most of these grades are commonly known as the “straight-chromium” types and are characterized by being ferromagnetic. Two of these grades, TP410 and UNS S 41500 (**Table 1**), are amenable to hardening by heat treatment, and the high-chromium, ferritic alloys are sensitive to notch-brittleness on slow cooling to ordinary temperatures. These features should be recognized in the use of these materials.

1.2 An optional supplementary requirement is provided, and when desired, shall be so stated in the order.

1.3 The values stated in either inch-pound units or SI 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 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.

1.4 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

[A480/A480M Specification for General Requirements for Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet, and Strip](#)

[A763 Practices for Detecting Susceptibility to Intergranular Attack in Ferritic Stainless Steels](#)

[A1016/A1016M Specification for General Requirements for Ferritic Alloy Steel, Austenitic Alloy Steel, and Stainless Steel Tubes](#)

[E213 Practice for Ultrasonic Testing of Metal Pipe and Tubing](#)

[E273 Practice for Ultrasonic Testing of the Weld Zone of Welded Pipe and Tubing](#)

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 ASME Boiler and Pressure Vessel Code applications see related Specification SA-268 in Section II of that Code.

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.

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



3. Terminology

3.1 Lot Definitions:

3.1.1 For flange and flaring requirements, the term lot applies to all tubes, prior to cutting, of the same nominal size and wall thickness that are produced from the same heat of steel. If final heat treatment is in a batch-type furnace, a lot shall include only those tubes of the same size and from the same heat that are heat treated in the same furnace charge. If the final heat treatment is in a continuous furnace, the number of tubes of the same size and from the same heat in a lot shall be determined from the size of the tubes as given in **Table 2**.

3.1.2 For tensile and hardness test requirements, the term lot applies to all tubes, prior to cutting, of the same nominal diameter and wall thickness that are produced from the same heat of steel. If final heat treatment is in a batch-type furnace, a lot shall include only those tubes of the same size and the same heat that are heat treated in the same furnace charge. If the final heat treatment is in a continuous furnace, a lot shall include all tubes of the same size and heat, heat treated in the same furnace at the same temperature, time at heat, and furnace speed.

4. Ordering Information

4.1 It is the responsibility of the purchaser to specify all requirements that are necessary for material ordered under this specification. Such requirements may include, but are not limited to, the following:

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

4.1.2 Name of material (seamless or welded tubes),

4.1.3 Grade (**Table 1**),

4.1.4 Size (outside diameter and nominal wall thickness),

4.1.5 Length (specific or random),

4.1.6 Optional requirements (hydrostatic or nondestructive electric test, **Section 16**),

4.1.7 Test report required (Certification Section of Specification **A1016/A1016M**),

4.1.8 Specification designation,

4.1.9 Intergranular corrosion test, and

4.1.10 Special requirements.

5. General Requirements

5.1 Material furnished under this specification shall conform to the applicable requirements of Specification **A1016/A1016M** unless otherwise provided herein.

TABLE 2 Number of Tubes in a Lot Heat Treated by the Continuous Process

Size of Tube	Size of Lot
2 in. [50.8 mm] and over in outside diameter and 0.200 in. [5.1 mm] and over in wall thickness	not more than 50 tubes
Less than 2 in. [50.8 mm] but over 1 in. [25.4 mm] in outside diameter or over 1 in. [25.4 mm] in outside diameter and under 0.200 in. [5.1 mm] in wall thickness	not more than 75 tubes
1 in. [25.4 mm] or less in outside diameter	not more than 125 tubes



6. Manufacture

6.1 The tubes shall be made by the seamless or welded process with no filler metal added.

7. Heat Treatment

7.1 As a final heat treatment, tubes shall be reheated to a temperature of 1200 °F [650 °C] or higher and cooled (as appropriate for the grade) to meet the requirements of this specification.

7.2 The martensitic grade UNS S 41500 shall be reheated to a temperature of 950 °F [510 °C] or higher and cooled as appropriate to meet the requirements of this specification.

8. Chemical Composition

8.1 The steel shall conform to the chemical requirements prescribed in [Table 1](#).

9. Product Analysis

9.1 An analysis of either one billet or one length of flatrolled stock or one tube shall be made from each heat. The chemical composition thus determined shall conform to the requirements specified.

9.2 The product analysis tolerance of the Chemical Requirements Table of [A480/A480M](#) shall apply. The product analysis tolerance is not applicable to the carbon content for material with a specified maximum carbon of 0.04 % or less.

9.3 If the original test for product analysis fails, retests of two additional billets, lengths of flat-rolled stock or tubes shall be made. Both retests for the elements in question shall meet the requirements of the specification; otherwise all remaining material in the heat or lot shall be rejected or, at the option of the producer, each billet or tube may be individually tested for acceptance. Billets, lengths of flat-rolled stock or tubes which do not meet the requirements of the specification shall be rejected.

10. Tensile Requirements

10.1 The material shall conform to the tensile properties prescribed in [Tables 3 and 4](#).

11. Hardness Requirements

11.1 The tubes shall have a hardness number not to exceed those prescribed in [Table 5](#).

12. Permissible Variations in Dimensions

12.1 Variations in outside diameter, wall thickness, and length from those specified shall not exceed the amounts prescribed in [Table 6](#).

12.2 The permissible variations in outside diameter given in [Table 6](#) are not sufficient to provide for ovality in thin-walled tubes, as defined in the Table. In such tubes, the maximum and minimum diameters at any cross section shall deviate from the nominal diameter by no more than twice the permissible variation in outside diameter given in [Table 6](#); however, the mean diameter at that cross section must still be within the given permissible variation.

12.3 When the specified wall is 2 % or less of the specified outside diameter, the method of measurement is in accordance with the agreement between the purchaser and the manufacturer (see [Note 1](#)).

NOTE 1—Very thin wall tubing may not be stiff enough for the outside diameter to be accurately measured with a point contact test method, such as with the use of a micrometer or caliper. When very thin walls are specified, “go”–“no go” ring gages are commonly used to measure diameters of 1½ in. [38.1 mm] or less. A 0.002-in. [0.05-mm] additional tolerance is usually added on the “go” ring gage to allow clearance for sliding. On larger diameters, measurement is commonly performed with a pi tape. Other test methods such as optical test methods may also be considered.



TABLE 3 Tensile Requirements

Grade and UNS Designation	Tensile strength, min, ksi [MPa]	Yield strength, min, ksi [MPa]	Elongation ^{A,B} in 2 in. or 50 mm, min, %
TP405 S40500	60 [415]	30 [205]	20
TP40800	55 [380]	30 [205]	20
TP410 S41000	60 [415]	30 [205]	20
TP429, TP430, and TP430 Ti S429000, S 43000, and S 43036	60 [415]	35 [240]	20
TP443 S44300	70 [485]	40 [275]	20
TP446-1 S44600	70 [485]	40 [275]	18
TP446-2 S44600	65 [450]	40 [275]	20
TP409 S40900	55 [380]	25 [170]	20
TP439 S43035	60 [415]	30 [205]	20
S43932	60 [415]	30 [205]	20
TP41500	115 [795]	90 [620]	15
TPXM-27 S44627	65 [450]	40 [275]	20
TPXM-33 S44626	68 [470]	45 [310]	20
18Cr-2Mo S44400	60 [415]	40 [275]	20
29-4 and 29-4-2 S44700 and S44800	80 [550]	60 [415]	20
26-3-3 S44660	85 [585]	65 [450]	20
25-4-4 S44635	90 [620]	75 [515]	20
TP44735	75 [515]	60 [415]	18
28-2-3.5 S32803	87 [600]	72 [500]	16
S40977	65 [450]	41 [280]	18
S43940	62 [430]	36 [250]	18
S42035	80 [550]	55 [380]	16
TP468 S46800	60 [415]	30 [205]	22

^A For tubing smaller than 1/2 in. [12.7 mm] in outside diameter, the elongation values given for strip specimens in Table 2 shall apply. Mechanical property requirements do not apply to tubing smaller than 1/8 in. [3.2 mm] in outside diameter or with walls thinner than 0.015 in. [0.4 mm].

^B For longitudinal strip tests a deduction of 0.90 % for TP446-1 and S44735 and 1.00 % for all other grades shall be made from the basic minimum elongation for each 1/32 in. [0.8 mm] decrease in wall thickness below 5/16 in. [8 mm]. The following table gives the computed minimum values:

13. Surface Condition

13.1 All tubes shall be free of excessive mill scale, suitable for inspection. A slight amount of oxidation will not be considered as scale. Any special finish requirements shall be subject to agreement between the manufacturer and the purchaser.

14. Mechanical Tests Required

14.1 *Tension Tests*—One tension test shall be made on a specimen for lots of not more than 50 tubes. Tension tests shall be made on specimens from two tubes for lots of more than 50 tubes.

14.2 *Flaring Test (for Seamless Tubes)*—One test shall be made on specimens from one end of one tube from each lot of finished tubes. The minimum expansion of the inside diameter shall be 10 %. For tubes over 8 in. [203.2 mm] in outside diameter, or tubes with wall thickness 3/8 in. [9.52 mm] and over, the flattening test may be performed instead of the flaring test unless the flaring test is specified in the purchase order.



TABLE 4 Minimum Elongation Values

Wall Thickness		Elongation ^A in 2 in. or 50 mm, min, %		
in.	mm	TP446-1 and S44735		All Other Grades
		S41500		
5/16 [0.312]	8	18	15	20
3/32 [0.281]	7.2	17	14	19
1/4 [0.250]	6.4	16	14	18
7/32 [0.219]	5.6	15	13	17
3/16 [0.188]	4.8	14	12	16
5/32 [0.156]	4	13	11	15
1/8 [0.125]	3.2	13	11	14
3/32 [0.094]	2.4	12	10	13
1/16 [0.062]	1.6	11	9	12
0.062–0.035, excl	1.6–0.9	10	8	12
0.035–0.022, excl	0.9–0.6	10	8	11
0.022–0.015, incl	0.6–0.4	10	8	11

^ACalculated elongation requirements shall be rounded to the nearest whole number.

Note—The above table gives the computed minimum values for each 1/32 in. [0.8 mm] decrease in wall thickness. Where the wall thickness lies between two values shown above, the minimum elongation value shall be determined by the following equation:

Grade	Equation
TP446-1 and S44735	$E = 28.8t + 9.00$ [$E = 1.13t + 9.00$]
S41500	$E = 24t + 7.5$
All other grades	$E = 32t + 10.00$ [$E = 1.25t + 10.00$]

where:

E = elongation in 2 in. or 50 mm, %.
 t = actual thickness of specimen, in. [mm].

TABLE 5 Hardness Requirements.

Grade	UNS Designation	Brinell Hardness, max	Rockwell Hardness, B Scale, max
TP405	S40500	207	95
...	S40800	207	95
TP410	S41000	207	95
TP429, TP430, and TP430 Ti	S42900, S 43000, and S 43036	190	90
TP443	S44300	207	95
TP446-1 and TP446-2	S44600	207	95
TP409	S40900	207	95
TP439	S43035 ^A	190	90
...	S43932	190	90
...	S41500	295 ^B	32
TPXM-33 and TPXM-27	S44626 and S44627	241	100
18CR-2Mo	S44400	217	95
29-4 and 29-4-2	S44700 and S44800	207	100
26-3-3	S44660	265	25 ^B
25-4-4	S44635	270	27 ^B
...	S44735	...	100
28-2-3.5	S32803	240	100
...	S40977	180	88
...	S43940	180	88
...	S42035	180	88

^A Editorially corrected October 2000.

^B Rockwell hardness, C scale.

14.3 Flange Test (for Welded Tubes)—One test shall be made on specimens from one end of one tube from each lot of finished tubes. For tubes over 8 in. [203.2 mm] in outside diameter, or tubes with wall thickness 3/8 in. [9.52 mm] and over, the flattening test may be performed instead of the flange test unless the flange test is specified in the purchase order.