



Designation: A268/A268M – 22

# Standard Specification for Seamless and Welded Ferritic and Martensitic Stainless Steel Tubing for General Service<sup>1</sup>

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 ( $\epsilon$ ) 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<sup>2</sup> 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.*

<sup>1</sup> 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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<sup>2</sup> For ASME Boiler and Pressure Vessel Code applications see related Specification SA-268 in Section II of that Code.

## 2. Referenced Documents

### 2.1 ASTM Standards:<sup>3</sup>

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

## 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

<sup>3</sup> 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



TABLE 1 Chemical Requirements

Grade	TP405	TP410	TP429	TP430	TP443	TP446-1	TP446-2 <sup>A</sup>	...	TP409
UNS Designation	S40500	S41000	S42900	S43000	S44300	S44600	S44600	S40800	S40900
Element	Composition, %								
C, max	0.08	0.15	0.12	0.12	0.20	0.20	0.12	0.08	0.08
Mn, max	1.00	1.00	1.00	1.00	1.00	1.50	1.50	1.00	1.00
P, max	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.045	0.045
S, max	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.045	0.030
Si, max	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
Ni	0.50 max	...	...	...	0.75 max	0.75 max	0.50 max	0.80 max	0.50 max
Cr	11.5-14.5	11.5-13.5	14.0-16.0	16.0-18.0	18.0-23.0	23.0-27.0	23.0-27.0	11.5-13.0	10.5-11.7
Mo	...	...	...	...	...	...	...	...	...
Al	0.10-0.30	...	...	...	0.90-1.25	...	...	...	...
Cu	...	...	...	...	...	0.25	0.25	...	...
N	...	...	...	...	...	...	...	...	...
Ti	...	...	...	...	...	...	...	12 x C min; 1.10 max	6 x C min; 0.75 max



TABLE 1 Continued

Grade UNS Designation	TP439	S43035	S43932	...	TP430 Ti	TP XM-27	TP XM-33 <sup>A</sup>	18Cr-2Ni	S44700	S44800	S44660	25-4-4	...	S43940	S42035	TP468
Element	S43036	S44627	S44626	S44400	S44700	S44800	S44660	S44635	S44735	S32803	S40977	S43940	S42035	S43940	S42035	S46800
Composition, %																
C, max	0.07	0.030	0.030	0.05	0.10	0.010	0.030	0.025	0.010	0.010	0.030	0.025	0.030	0.030	0.030	0.030
Mn, max	1.00	1.00	0.5-1.0	0.5-1.0	1.00	0.30	1.00	1.00	0.30	0.30	1.00	1.00	1.00	1.00	1.00	1.00
P, max	0.040	0.040	0.03	0.03	0.040	0.025	0.040	0.040	0.025	0.025	0.040	0.040	0.040	0.040	0.040	0.040
S, max	0.030	0.030	0.03	0.03	0.030	0.020	0.020	0.030	0.020	0.020	0.030	0.030	0.030	0.030	0.030	0.030
Si, max	1.00	1.00	0.60	0.60	1.00	0.40	0.75	1.00	0.20	0.20	1.00	0.75	1.00	1.00	1.00	1.00
Ni	0.50 max	0.50	3.5-5.5	3.5-5.5	0.75 max	0.5 <sup>D</sup> max	0.50 max	1.00 max	0.15 max	2.0-2.5	1.0-3.50	3.5-4.5	1.00 max	0.30-1.00	1.0-2.5	0.50
Cr	17.00-19.00	17.0-19.0	11.5-14.0	11.5-14.0	16.00-19.00	25.0-27.5	25.0-27.0	17.5-19.5	28.0-30.0	28.0-30.0	25.0-28.0	24.5-26.0	28.00-30.00	10.50-12.50	13.5-15.5	18.00-20.00
Mo	19.00	...	0.5-1.0	0.5-1.0	19.50	0.75-1.50	0.75-1.50	1.75-2.50	3.5-4.2	3.5-4.2	3.0-4.0	3.5-4.5	30.00	...	0.2-1.2	...
Al, max	...	...	...	...	...	...	...	...	...	...	...	...	...	...	...	...
Cu, max	0.15	0.15	...	...	...	0.2	0.20	...	0.15	0.15	...	...	...	...	...	...
N, max	...	...	...	...	...	0.015	0.040	...	0.020 <sup>F</sup>	0.020 <sup>F</sup>	0.040	0.035	0.045	...	...	...
Ti	0.20 + 4 (C + N) min; 1.10 max	0.030	...	...	5 x C min; 0.75 max	...	7 x (C + N) but no less than 0.20 min; 1.00 max	...	...	...	...	...	0.10-0.60	0.030	0.30-0.50	0.07-0.30
Nb <sup>G</sup>	...	...	...	...	...	0.05-0.20	...	...	...	...	...	...	...	...	...	0.10-0.60
Other	...	...	...	...	...	...	...	...	...	0.15-0.50 <sup>F</sup>	...	...	...	...	...	(Ti + Nb) = 0.020 + 4 x (C + N) min.; 0.75 max

<sup>A</sup> For small diameter or thin walls, or both, tubing, where many drawing passes are required, a carbon maximum of 0.015 % is necessary. 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. [1.2 mm] in average wall thickness (0.040 in. [1 mm] in minimum wall thickness).

<sup>B</sup> Plate version of CA6NM.

<sup>D</sup> Carbon plus nitrogen = 0.30 max.

<sup>E</sup> Nickel plus copper.

<sup>F</sup> Carbon plus nitrogen = 0.025 % max.

<sup>G</sup> Nb/(C + N) = 12 min.

<sup>H</sup> The terms Niobium (Nb) and Columbium (Cb) are alternate names for the same element number 41.

**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 and 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

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.

#### 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.

#### 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