



Designation: B 668 – 00

Standard Specification for UNS N08028 Seamless Pipe and Tube¹

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1. Scope

1.1 This specification covers UNS N08028 seamless cold-finished or hot finished pipe and tube intended for general corrosive service. The general requirements are covered in Specification B 829.

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

2. Referenced Documents

2.1 ASTM Standards:

B 829 Specification for General Requirements for Nickel and Nickel Alloy Seamless Pipe and Tube²

3. General Requirement

3.1 Material furnished under this specification shall conform to the applicable requirements of Specification B 829 unless otherwise provided herein.

4. Ordering Information

4.1 Orders for material under this specification shall include the following information:

4.1.1 Alloy name or UNS number,

4.1.2 ASTM designation and year of issue,

4.1.3 *Dimensions*—

4.1.3.1 Outside diameter, minimum or average wall thickness (in inches or millimetres, not gage number), and length,

4.1.3.2 Standard pipe size, schedule and length,

4.1.4 Quantity (feet or metres, or number of pieces),

4.1.5 Optional requirements,

4.1.6 *Certification*— State if certification is required,

4.1.7 *Samples for Product (Check) Analysis*—State whether samples for product (check) analysis should be furnished, and

4.1.8 *Purchaser Inspection*—If the purchaser wishes to witness tests or inspection of material at the place of manufacture, the purchase order must so state, indicating which tests or inspections are to be witnessed.

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.07 on Refined Nickel and Cobalt and Their Alloys.

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² *Annual Book of ASTM Standards*, Vol 02.04.

5. Materials and Manufacture

5.1 Pipe and tube shall be furnished in the solution-annealed condition.

NOTE 1—The recommended heat treatment shall consist of heating the material to a temperature of 1975 to 2100°F (1080 to 1150°C) with subsequent quenching in water or rapidly cooling by other means.

5.2 The scale shall be removed by suitable means. When bright annealed, scale removal operations are not necessary.

6. Chemical Composition

6.1 The material shall conform to the requirement prescribed in Table 1.

TABLE 1 Chemical Requirements

Element	Composition, %
Carbon, max	0.030
Silicon, max	1.0
Manganese, max	2.50
Phosphorus, max	0.030
Sulfur, max	0.030
Chromium	26.0–28.0
Nickel	30.0–34.0
Molybdenum	3.0–4.0
Copper	0.6–1.4
Iron	remainder ^A

^A Determined arithmetically by difference.

6.1.1 A chemical analysis shall be made on each lot of material as described in Specification B 829.

6.2 If a product (check) analysis is performed by the purchaser, the material shall conform to Table 1 subject to the product (check) analysis variations prescribed in Specification B 829.

7. Mechanical Properties and Other Requirements

7.1 The material shall conform to the mechanical properties prescribed in Table 2. One test is required for each lot, as defined in Specification B 829.

7.1.1 One tension test shall be made on each lot of pipe or tube.

7.2 *Flaring Test*— One flaring test shall be made on a specimen from one end of one pipe or tube from each lot of finished tubes.