



Designation: B 829 – 99

Standard Specification for General Requirements for Nickel and Nickel Alloys Seamless Pipe and Tube¹

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1. Scope

1.1 This specification contains various requirements that, with the exception of Sections 5 and 10, are mandatory requirements to the following ASTM nickel and nickel alloy, seamless pipe and tube specifications:

Title of Specification	ASTM Designation ^A
Nickel Seamless Pipe and Tube	B 161
Seamless Nickel and Nickel Alloy, Condenser and Heat Exchanger Tubes	B 163
Nickel-Copper Alloy (UNS N04400) Seamless Pipe and Tube	B 165
Nickel-Chromium-Iron Alloys (UNS N06600, N06601, and N06690) Seamless Pipe and Tube	B 167
Nickel-Iron-Chromium Alloy Seamless Pipe and Tube	B 407
Nickel-Iron-Chromium-Molybdenum-Copper Alloy (UNS N08825 and N08221) Seamless Pipe and Tube	B 423
Nickel-Chromium-Molybdenum-Columbium Alloys (UNS N06625) Pipe and Tube	B 444
Nickel-Chromium-Iron-Columbium-Molybdenum-Tungsten Alloy (UNS N06102) Seamless Pipe and Tube	B 445
Nickel-Iron-Chromium-Silicon Alloys (UNS N08330 and UNS N08332) Seamless Pipe	B 535
Copper-Beryllium Alloy Forgings and Extrusion	B 570 ^B
Seamless Nickel and Nickel-Cobalt Alloy Pipe and Tube	B 622
UNS N08028 Seamless Tubes	B 668
UNS N08904, UNS N08925 and UNS N08926 Seamless Pipe and Tube	B 677
Iron-Nickel-Chromium-Molybdenum Alloys (UNS N08366 and UNS N08367) Seamless Pipe and Tube	B 690
Ni-Cr-Mo-Co-W-Fe-Si Alloy (UNS N06333) Seamless Pipe and Tube	B 722
Seamless UNS N08020, UNS N08026, and UNS N08024 Nickel-Alloy Pipe and Tube	B 729

^AAnnual Book of ASTM Standards, Vol 02.01.

^BAnnual Book of ASTM Standards, Vol 02.04.

1.2 One or more of the test requirements of Section 5 apply only if specifically stated in the product specification or in the purchase order.

1.3 In case of conflict between a requirement of the product specification and a requirement of this general specification, only the requirement of the product specification needs to be satisfied.

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

1.5 The following safety hazards caveat pertains only to the test requirements portion, Section 5, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

- B 880 Specification for General Requirements for Chemical Check Analysis Limits for Nickel, Nickel Alloys and Cobalt Alloys²
- E 8 Test Methods for Tension Testing of Metallic Materials³
- E 18 Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials³
- E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications⁴
- E 39 Methods for Chemical Analysis of Nickel⁵
- E 76 Test Methods for Chemical Analysis of Nickel-Copper Alloys⁵
- E 112 Test Methods for Determining the Average Grain Size³
- E 213 Practice for Ultrasonic Examination of Metal Pipe and Tubing⁶
- E 426 Practice for Electromagnetic (Eddy-Current) Examination of Seamless and Welded Tubular Products, Austenitic Stainless Steel and Similar Alloys⁶
- E 571 Practice for Electromagnetic (Eddy-Current) Examination of Nickel and Nickel Alloy Tubular Products⁶
- E 1473 Test Methods for Chemical Analysis of Nickel,

² Annual Book of ASTM Standards, Vol 02.04.

³ Annual Book of ASTM Standards, Vol 03.01.

⁴ Annual Book of ASTM Standards, Vol 14.02.

⁵ Annual Book of ASTM Standards, Vol 03.05.

⁶ Annual Book of ASTM Standards, Vol 03.03.

¹ This specification is under the jurisdiction of ASTM Committee B-2 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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Cobalt, and High-Temperature Alloys⁷

2.2 ANSI Standards:⁸

B 1.20.1 Pipe Threads

B 36.10 Welded and Seamless Wrought Steel Pipe

B 36.19 Stainless Steel Pipe

3. Terminology

3.1 Definitions:

3.1.1 *average diameter, n*—the average of the maximum and minimum outside diameters, as determined at any one cross section of the pipe or tube.

3.1.2 *nominal wall, n*—a specified wall thickness with a plus or minus tolerance from the specified thickness.

3.1.3 *seamless pipe, n*—a round hollow produced with a continuous periphery in all stages of manufacture, and produced to the particular dimensions commercially known as pipe sizes (NPS).

3.1.4 *seamless tube, n*—a tube produced with a continuous periphery in all stages of the operation.

3.1.5 *thin wall tube, n*—tube with specified wall thickness 3 % or less of the specified outside diameter.

4. Chemical Composition

4.1 In case of disagreement, the chemical composition shall be determined in accordance with the following methods.

UNS No. Prefixes	ASTM Method
N02	E 39
N04	E 76
N06, N08	E 1473

4.2 The ladle analysis of the material shall conform to the chemical requirements prescribed by the individual product specification.

4.3 The product (check) analysis of the material shall meet the requirements for the ladle analysis within the tolerance limits prescribed in B 880.

5. Test Requirements

5.1 *Flare Test*—The flare test shall consist of flaring a test specimen with an expanding tool having an included angle of 60° until the specified outside diameter has been increased by 30 %. The flared specimen shall not exhibit cracking through the wall.

5.2 *Hydrostatic Test*— Each pipe or tube shall be tested by the manufacturer to an internal hydrostatic pressure of 1000 psi (6.9 MPa) provided that the fiber stress, calculated from the following equation, does not exceed the allowable fiber stress for the material:

$$P = 2St/D \quad (1)$$

where:

P = hydrostatic test pressure, psi (MPa),

S = allowable fiber stress, for material in the condition (temper) furnished as specified in the product specification (S is calculated as the lower of $\frac{2}{3}$ of the specified minimum 0.2 % offset yield strength or $\frac{1}{4}$ of the specified minimum ultimate strength for the material),

t = minimum wall thickness permitted, in. (mm), including minus tolerance, if any, and

D = nominal outside diameter of the pipe or tube, in. (mm).

5.2.1 The test pressure must be held for a minimum of 5 s.

NOTE 1—Testing at a pressure greater than 1000 psi may be performed upon agreement between purchaser and manufacturer provided that the allowable fiber stress is not exceeded.

5.2.2 If any pipe or tube shows leaks during hydrostatic testing, it shall be rejected.

5.3 Nondestructive Electric Test:

5.3.1 *Eddy Current Testing*—Testing shall be conducted in accordance with Practices E 426 or E 571. The eddy current examination reference in this specification has the capability of detecting significant discontinuities, especially of the short, abrupt type.

5.3.1.1 Unless otherwise specified by the purchaser, the calibration standard shall contain, at the option of the manufacturer, any one of the following discontinuities to establish a minimum sensitivity level for rejection.

5.3.1.2 *Drill Hole*—A hole not larger than 0.031 in. (0.79 mm) diameter shall be drilled radially and completely through the wall, care being taken to avoid distortion of the material while drilling.

5.3.1.3 *Transverse Tangential Notch*—Using a round file or tool with a $\frac{1}{4}$ in. (6 mm) diameter, a notch shall be filed or milled on the tube or pipe outside diameter tangential to the surface and transverse to the longitudinal axis of the material. Said notch shall have a depth not exceeding 12.5 % of the specified wall thickness of the material, or 0.004 in. (0.10 mm), whichever is greater.

5.3.2 *Ultrasonic Testing*—Testing shall be conducted in accordance with Practice E 213. The ultrasonic examination referred to in this specification is intended to detect longitudinal discontinuities having a reflective area similar to or larger than the calibration reference notches specified in 5.3.2.1. The examination may not detect circumferentially oriented imperfections or short, deep defects.

5.3.2.1 For ultrasonic testing, longitudinal calibration notches shall be machined on the outside and inside diameter surfaces. The depth of the notches shall not exceed 12.5 % of the specified wall thickness or 0.004 in. (0.10 mm), whichever is greater.

5.3.3 *Calibration Frequency*—The frequency of calibration checks shall be as follows:

5.3.3.1 At the beginning of each production run or lot.

5.3.3.2 At least every four hours during testing.

5.3.3.3 At the end of each production run or lot.

5.3.3.4 After any suspected equipment malfunction or work stoppage.

⁷ Annual Book of ASTM Standards, Vol 03.06.

⁸ Available from American National Standards Institute, 11 West 42nd St., 13th Fl., New York, NY 10036.

5.3.3.5 If, during any check, the equipment fails to detect the calibration defects, the instrument must be recalibrated and all material tested since the last satisfactory check shall be retested.

5.3.4 *Acceptance and Rejection*—Material producing a signal equal to or greater than the calibration defect shall be subject to rejection.

5.3.4.1 Test signals produced by imperfections that cannot be identified or produced by cracks or crack-like imperfections shall result in rejection of the pipe or tube, subject to rework and retest.

5.3.4.2 If the imperfection is judged as not fit for use, the tube shall be rejected, but may be reconditioned and retested providing the wall thickness requirements are met. To be accepted, retested material shall meet the original electric test requirements.

5.3.4.3 If the imperfection is explored to the extent that it can be identified, and the pipe or tube is determined to be fit for use, the material may be accepted without further testing, providing the imperfection does not encroach on minimum wall thickness requirements.

5.4 When specified by the purchaser, a nondestructive electric test, in accordance with Practices E 213, E 426, or E 571, may be used for seamless pipe or tube, instead of the hydrostatic test.

5.5 *Tension Test*— Tension testing shall be conducted in accordance with Test Methods E 8.

5.5.1 The material shall conform to the tensile properties prescribed in the individual product specification.

5.6 *Hardness Test*— Hardness testing shall be conducted in accordance with Test Methods E 18.

5.7 *Grain Size*—The measurement of average grain size may be carried out by the planimetric method, the comparison method, or the intercept method described in Test Methods E 112. In case of dispute, the “referee” method for determining average grain size shall be the intercept method.

5.8 For purposes of determining compliance with the specified limits for requirements of the properties listed in the following table, an observed value or a calculated value shall be rounded in accordance with the rounding method of Practice E 29:

Requirements	Rounded Unit for Observed or Calculated Value
Chemical composition and tolerances	nearest unit in the last right-hand place of figures of the specified limit
Tensile strength and yield strength	nearest 1000 psi (7 MPa)
Elongation	nearest 1 %
Grain size	
0.0024 in. (0.060 mm) or larger	nearest multiple of 0.0002 in. (0.005 mm)
Less than 0.0024 in. (0.060 mm)	nearest multiple of 0.0001 in. (0.002 mm)

6. Dimensions and Permissible Variations

6.1 Dimensions of pipe are shown in Table 1.

6.1.1 Permissible variations in outside diameter and wall thickness are shown in Table 2, Table 3, and Table 4.

6.2 *Length*—When material is ordered as cut-to-length, the length shall conform to the permissible variations prescribed in Table 5. When material is ordered to random lengths, the lengths and variations shall be agreed upon between the manufacturer and purchaser.

TABLE 1 Dimensions of Pipe

NOTE 1—The following table is a reprint of Table 1 of ANSI B36.19.

NOTE 2—The decimal thicknesses listed for the respective pipe sizes represent their nominal wall dimensions.

NPS Designator	Outside Diameter		Nominal Wall Thickness							
	in.	mm	Schedule 5S ^A		Schedule 10S ^A		Schedule 40S		Schedule 80S	
			in.	mm	in.	mm	in.	mm	in.	mm
1/8	0.405	10.29	0.049	1.24	0.068	1.73	0.095	2.41
1/4	0.540	13.72	0.065	1.65	0.088	2.24	0.119	3.02
3/8	0.675	17.15	0.065	1.65	0.091	2.31	0.126	3.20
1/2	0.840	21.34	0.065	1.65	0.083	2.11	0.109	2.77	0.147	3.73
3/4	1.050	26.67	0.065	1.65	0.083	2.11	0.113	2.87	0.154	3.91
1.0	1.315	33.40	0.065	1.65	0.109	2.77	0.133	3.38	0.179	4.55
1 1/4	1.660	42.16	0.065	1.65	0.109	2.77	0.140	3.56	0.191	4.85
1 1/2	1.900	48.26	0.065	1.65	0.109	2.77	0.145	3.68	0.200	5.08
2	2.375	60.33	0.065	1.65	0.109	2.77	0.154	3.91	0.218	5.54
2 1/2	2.875	73.03	0.083	2.11	0.120	3.05	0.203	5.16	0.276	7.01
3	3.500	88.90	0.083	2.11	0.120	3.05	0.216	5.49	0.300	7.62
3 1/2	4.000	101.60	0.083	2.11	0.120	3.05	0.226	5.74	0.318	8.08
4	4.500	114.30	0.083	2.11	0.120	3.05	0.237	6.02	0.337	8.56
5	5.563	141.30	0.109	2.77	0.134	3.40	0.258	6.55	0.375	9.52
6	6.625	168.28	0.109	2.77	0.134	3.40	0.280	7.11	0.432	10.97
8	8.625	219.08	0.109	2.77	0.148	3.76	0.322	8.18	0.500	12.70
10	10.750	273.05	0.134	3.40	0.165	4.19	0.365	9.27	0.500 ^B	12.70 ^B
12	12.750	323.85	0.156	3.96	0.180	4.57	0.375 ^B	9.52 ^B	0.500 ^B	12.70 ^B
14	14.000	355.60	0.156	3.96	0.188 ^B	4.78 ^B
16	16.000	406.40	0.165	4.19	0.188 ^B	4.78 ^B
18	18.000	457.20	0.165	4.19	0.188 ^B	4.78 ^B
20	20.000	508.00	0.188	4.78	0.218 ^B	5.54 ^B
22	22.000	558.80	0.188	4.78	0.218 ^B	5.54 ^B
24	24.000	609.60	0.218	5.54	0.250	6.35
30	30.000	762.00	0.250	6.35	0.312	7.92

^ASchedules 5S and 10S wall thicknesses do not permit threading in accordance with ANSI B1.20.1.

^BThese do not conform to ANSI B36.10.