



Standard Specification for Spray-Formed Seamless Austenitic Stainless Steel Pipes¹

This standard is issued under the fixed designation A 943/A 943M; 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 spray-formed seamless austenitic stainless steel pipe intended for high-temperature and general corrosive service.

1.2 Grades TP304H, TP309H, TP309HCb, TP310H, TP310HCb, TP316H, TP321H, TP347H, and TP348H are modifications of Grades TP304, TP309Cb, TP309S, TP310Cb, TP310S, TP316, TP321, TP347, and TP348, and are intended for high-temperature service.

1.3 Optional supplementary requirements are provided for pipe where a greater degree of testing is desired. These supplementary requirements call for additional tests to be made and, when desired, one or more of these may be specified in the order.

1.4 Appendix X1 lists the dimensions of seamless stainless steel pipe as shown in ANSI B36.19. Pipe having other dimensions may be furnished provided such pipe complies with all other requirements of this specification.

1.5 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 are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification. The inch-pound units shall apply unless the “M” designation of this specification is specified in the order.

NOTE 1—The dimensionless designator NPS (nominal pipe size) has been substituted in this standard for such traditional terms as “nominal diameter,” “size,” and “nominal size.”

2. Referenced Documents

2.1 ASTM Standards:

A 262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels²

A 450/A 450M Specification for General Requirements for Carbon, Ferritic Alloy, and Austenitic Alloy Steel Tubes³

A 999/A 999M Specification for General Requirements for Alloy and Stainless Steel Pipe³

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 *Annual Book of ASTM Standards*, Vol 01.03.

³ *Annual Book of ASTM Standards*, Vol 01.01.

E 112 Test Methods for Determining the Average Grain Size⁴

E 381 Method of Macroetch Testing Steel Bars, Billets, Blooms, and Forgings⁴

E 527 Practice for Numbering Metals and Alloys (UNS)³

2.2 *ANSI/ASME Standards*.⁵

B1.20.1 Pipe Threads, General Purpose

B36.10 Welded and Seamless Wrought Steel Pipe

B36.19 Stainless Steel Pipe

2.3 *Other Standard*.⁶

SAE J1086 Practice for Numbering Metals and Alloys (UNS)

3. Ordering Information

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

3.1.1 Quantity (feet, centimetres, or number of lengths),

3.1.2 Name of material (austenitic steel pipe),

3.1.3 Grade (Table 1),

3.1.4 Size (NPS or outside diameter and schedule number or average wall thickness or other),

3.1.5 Length (specific or random) (Section 10),

3.1.6 End finish (Section on Ends of Specification A 999/A 999M),

3.1.7 Optional requirements (Section 7),

3.1.8 Test report required (Certification Section of Specification A 999/A 999M),

3.1.9 Specification number, and

3.1.10 Special requirements or any supplementary requirements selected, or both.

4. General Requirements

4.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification A 999/A 999M unless otherwise provided herein.

5. Materials and Manufacture

5.1 *Melting*—The steel shall be made by the electric-furnace process or by other similar processes. The primary

⁴ *Annual Book of ASTM Standards*, Vol 03.01.

⁵ Available from American National Standards Institute, 11 West 42nd St., 13th Floor, New York, NY 10036.

⁶ Available from Society of Automotive Engineers, 400 Commonwealth Drive, Warrendale, PA 15096.

TABLE 1 Chemical Requirements

Grade	UNS Designation ^A	Composition, %										Composition, %				
		Carbon, max ^B	Manganese, max ^B	Phosphorus, max	Sulfur, max	Silicon, max ^B	Nickel	Chromium	Molybdenum	Titanium	Columbium plus Tantalum	Tantalum, max	Nitrogen ^C	Vanadium	Copper	Cerium
TP304	S30400	0.08	2.00	0.040	0.030	0.75	8.00–11.0	18.0–20.0
TP304H	S30409	0.04–0.10	2.00	0.040	0.030	0.75	8.00–11.0	18.0–20.0
TP304L	S30403	0.030	2.00	0.040	0.030	0.75	8.00–13.0	18.0–20.0
TP304N	S30451	0.08	2.00	0.040	0.030	0.75	8.00–11.0	18.0–20.0	0.10–0.16
TP304LN	S30453	0.030	2.00	0.040	0.030	0.75	8.00–11.0	18.0–20.0	0.10–0.16
TP309Cb	S30940	0.08	2.00	0.045	0.030	0.75	12.0–16.0	22.0–24.0	0.75 max	...	10 × C min 1.10 max
TP309H	S30909	0.04–0.10	2.00	0.040	0.030	0.75	12.0–15.0	22.0–24.0
TP309HCb	S30941	0.04–0.10	2.00	0.045	0.030	0.75	12.0–16.0	22.0–24.0	0.75 max	...	10 × C min 1.10 max
TP309S	S30908	0.08	2.00	0.045	0.030	0.75	12.0–15.0	22.0–24.0	0.75 max
TP310Cb	S31040	0.08	2.00	0.045	0.030	0.75	19.0–22.0	24.0–26.0	0.75 max	...	10 × C min 1.10 max
TP310H	S31009	0.04–0.10	2.00	0.040	0.030	0.75	19.0–22.0	24.0–26.0
TP310HCb	S31041	0.04–0.10	2.00	0.045	0.030	0.75	19.0–22.0	24.0–26.0	0.75 max	...	10 × C min 1.10 max
TP310S	S31008	0.08	2.00	0.045	0.030	0.75	19.0–22.0	24.0–26.0	0.75 max
...	S31272 ^D	0.08–0.12	1.5–2.00	0.030	0.015	0.3–0.7	14.0–16.0	14.0–16.0	1.0–14.0	0.3–0.6
TP316	S31600	0.08	2.00	0.040	0.030	0.75	11.0–14.0	16.0–18.0	2.00–3.00
TP316H	S31609	0.04–0.10	2.00	0.040	0.030	0.75	11.0–14.0	16.0–18.0	2.00–3.00
TP316L	S31603	0.030	2.00	0.040	0.030	0.75	10.0–15.0	16.0–18.0	2.00–3.00
TP316N	S31651	0.08	2.00	0.040	0.030	0.75	11.0–14.0	16.0–18.0	2.00–3.00	0.10–0.16
TP316LN	S31653	0.030	2.00	0.040	0.030	0.75	11.0–14.0	16.0–18.0	2.00–3.00	0.10–0.16
TP317	S31700	0.08	2.00	0.040	0.030	0.75	11.0–14.0	18.0–20.0	3.00–4.00
TP317L	S31703	0.030	2.00	0.040	0.030	0.75	11.0–15.0	18.0–20.0	3.00–4.00
TP321	S32100	0.08	2.00	0.040	0.030	0.75	9.00–13.0	17.0–20.0
TP321H	S32109	0.04–0.10	2.00	0.040	0.030	0.75	9.00–13.0	17.0–20.0
TP347	S34700	0.08	2.00	0.040	0.030	0.75	9.00–13.0	17.0–20.0
TP347H	S34709	0.04–0.10	2.00	0.040	0.030	0.75	9.00–13.0	17.0–20.0
TP348	S34800	0.08	2.00	0.040	0.030	0.75	9.00–13.0	17.0–20.0
TP348H	S34809	0.04–0.10	2.00	0.040	0.030	0.75	9.00–13.0	17.0–20.0	0.10
TPXM-10	S21900	0.08	8.00–10.00	0.040	0.030	1.00	5.50–7.50	19.0–21.5	0.15–0.40
TPXM-11	S21903	0.04	8.00–10.00	0.040	0.030	1.00	5.50–7.50	19.0–21.5	0.15–0.40
TPXM-15	S38100	0.08	2.00	0.030	0.030	1.50–2.50	17.5–18.5	17.0–19.0
TPXM-19	S20910	0.060	4.00–6.00	0.040	0.030	1.00	11.5–13.5	20.5–23.5	1.50–3.00	...	0.10–0.30	0.20–0.40	0.10–0.30
TPXM-29	S24000	0.080	11.5–14.5	0.060	0.030	1.00	2.25–3.75	17.0–19.0	0.20–0.40
...	S31254	0.020	1.00	0.030	0.010	0.80	17.5–18.5	19.5–20.5	6.00–6.50	0.18–0.22	...	0.50–1.00
...	S30815	0.05–0.10	0.80	0.040	0.030	1.40–2.00	10.0–12.0	20.0–22.0	0.14–0.20	0.03–0.08	...
...	S31050	0.25	2.00	0.020	0.015	0.4	20.5–23.5	24.0–26.0	1.6–2.6	0.09–0.15
...	S30600	0.018	2.00	0.02	0.02	3.7–4.3	14.0–15.5	17.0–18.5	0.20 max	0.50 max
...	S31725	0.03	2.00	0.040	0.030	0.75	13.5–17.5	18.0–20.0	4.0–5.0	0.10 max	...	0.75 max
...	S31726	0.03	2.00	0.040	0.030	0.75	13.5–17.5	17.0–20.0	4.0–5.0	0.10–0.20	...	0.75 max
...	S32615	0.07	2.00	0.045	0.030	4.8–6.0	19.0–22.0	16.5–19.5	0.3–1.5	1.5–2.5
...	S34565	0.03	5.0–7.0	0.030	0.010	1.00	16.0–18.0	23.0–25.0	4.0–5.0	...	0.1 max	0.4–0.6

^A New designation established in accordance with Practice E 527 and SAE J1086, Practice for Numbering Metals and Alloys (UNS).

^B Maximum, unless otherwise indicated.

^C The method of analysis for nitrogen shall be a matter of agreement between the purchaser and manufacturer.

^D The boron content shall be in the range 0.004–0.008.

^E The titanium content shall be not less than five times the carbon content and not more than 0.70 %.

^F The titanium content shall be not less than four times the carbon content and not more than 0.60 %.

^G The columbium (niobium) plus tantalum content shall be not less than ten times the carbon content and not more than 1.00 %.

^H The columbium (niobium) plus tantalum content shall be not less than eight times the carbon content and not more than 1.0 %.

melting may incorporate separate degassing or refining and may be followed by secondary melting, using electros slag 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.

5.1.1 If a specified type of melting is required by the purchaser, it shall be stated on the purchase order.

5.1.2 When specified on the purchase order, or when a specific type of melting has been specified, the material manufacturer shall include with the report required by the Heat Analysis section of this specification or the Certification section of Specification A 999/A 999M the type of melting used to produce the material.

5.2 Pipe Manufacture:

5.2.1 The pipe shall be made by the spray forming process using the steel from the electric steel process or other similar processes as in 5.1.

5.2.2 The pipe shall be made by spraying the melt on to a thin-walled collector tube. The as-spray formed pipe shall be machined on both the inner and outer surfaces. The remaining metal shall be homogeneous, sound, and meet the requirements of Section 10.

5.2.3 Unless specified by the purchaser, pipe may be furnished as-spray formed or as-spray formed and cold finished.

5.2.4 All pipe shall be furnished in the descaled condition and be free of contaminating iron particles. Pickling, blasting or surface finishing is not mandatory when pipe is bright annealed. The purchaser may request that a passivating treatment be applied.

5.3 Heat Treatment:

5.3.1 All pipe shall be furnished in the heat-treated condition. The heat-treatment procedure, except for “H” grades, S30815 and S31254, shall consist of heating the pipe to a minimum temperature of 1900°F [1040°C] and quenching in water or rapidly cooling by other means.

5.3.2 All H grades shall be furnished in the solution-treated condition. If cold working is involved in processing, the minimum solution treating temperature for Grades TP321H, TP347H, and TP348H shall be 2000°F [1100°C] and for Grades TP304H, and TP316H, 1900°F [1040°C]. If the H Grade is furnished in the spray-formed condition only, the minimum solution treating temperatures for Grades TP321H, TP347H, and TP348H shall be 1925°F [1050°C], and for Grades TP304H, and TP316H, 1900°F [1040°C]. The minimum solution treating temperature for S30815 shall be 1920°F [1050°C]. The minimum solution treating temperature for TP309H, TP309HCb, TP310H, and TP310HCb shall be 1900°F [1040°C].

5.3.3 The heat-treatment procedure for S31254 shall consist of heating the pipe to a minimum temperature of 2100°F [1150°C] and quenching in water or rapidly cooling by other means.

5.3.4 A solution annealing temperature above 1950°F [1065°C] may impair the resistance to intergranular corrosion after subsequent exposure to sensitizing conditions in TP309HCb, TP310HCb, TP321, TP321H, TP347, TP347H, TP348, and TP348H. When specified by the purchaser, a lower temperature stabilization or re-solution anneal shall be used subsequent to the initial high temperature solution anneal (see Supplementary Requirement S6).

5.4 Grain Size:

5.4.1 The grain size of TP304H, TP316H, TP321H, TP347H and TP348H, as determined in accordance with Test Methods E 112, shall be ASTM No. 7 or coarser.

5.4.2 The grain size of TP309H, TP309HCb, TP310H and TP310HCb, shall be ASTM No. 6 or coarser.

6. Chemical Composition

6.1 The steel shall conform to the requirements as to chemical composition prescribed in Table 1.

7. Product Analysis

7.1 At the request of the purchaser, an analysis of two pipes

from each lot shall be made by the manufacturer. A lot of pipe shall consist of the following number of lengths of the same size and wall thickness from any one heat of stainless steel:

NPS Designator	Lengths of Pipe in Lot
Under 2	200 or fraction thereof
2 to 5	100 or fraction thereof
6 and over	

7.2 The results of these analyses shall be reported to the purchaser or the purchaser’s representative, and shall conform to the requirements specified in Section 6.

7.3 If the analysis of one of the tests specified in 7.1 does not conform to the requirements specified in Section 6, an analysis of each pipe from the same heat or lot may be made, and all pipes conforming to the requirements shall be accepted.

8. Tensile Requirements

8.1 The tensile properties of the material shall conform to the requirements prescribed in Table 2.

9. Mechanical Tests and Grain Size Determinations Required

9.1 *Transverse or Longitudinal Tension Test*—One tension test shall be made on a specimen for lots of not more than 100 pipes. Tension tests shall be made on specimens from two tubes for lots of more than 100 pipes.

NOTE 2—The term “lot,” for mechanical tests, applies to all pipe of the same diameter and wall thickness (or schedule) that are produced from the same heat of steel and subjected to the same finishing treatment: (1) in a continuous heat treatment furnace, or (2) in a batch-type heat treatment furnace, equipped with recording pyrometers and automatically controlled within a 50°F [30°C] range, the larger of: (a) each 200 ft [60°C] or fraction thereof or (b) that pipe heat treated in the same batch furnace charge.

9.2 *Flattening Test*—For material heat treated in a batch-typed furnace, flattening tests shall be made on 5 % of the pipe from each heat-treated lot. For material heat treated by the continuous process, this test shall be made on a sufficient number of pipe to constitute 5 % of the lot, but in no case less than two lengths of pipe.

9.3 Hydrostatic Test:

9.3.1 Each length of finished pipe shall be subjected to the hydrostatic test in accordance with Specification A 530/A 530M, unless specifically exempted under the provisions of 9.3.2.

9.3.2 For pipe whose dimensions are equal to or exceed NPS 10, the purchaser with the agreement of the manufacturer may waive the hydrostatic test requirement when in lieu of such test the purchaser performs a system test. Each length of pipe furnished without the completed manufacturer’s hydrostatic test shall include with the mandatory markings the letters “NH”.

9.3.3 When specified by the purchaser, a non-destructive electric test in accordance with Specification A 450/A 450M may be used instead of, or in addition to, the hydrostatic test.

9.4 *Grain Size*—Grain size determination, when required, shall be made on the same number of tubes as prescribed in 9.2.