



Designation: A 530/A 530M – 02

Standard Specification for General Requirements for Specialized Carbon and Alloy Steel Pipe¹

This standard is issued under the fixed designation A 530/A 530M; 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 Department of Defense.

1. Scope*

1.1 This specification² covers a group of requirements which, with the exceptions of Section 4.3, Section 12, Section 19, and Section 20, are mandatory requirements to the ASTM pipe product specifications noted below unless the product specification specifies different requirements, in which case the requirement of the product specification shall prevail.

1.2 Sections 4.3 or 19 are mandatory if the product specification has a requirement for product analysis or flattening tests.

1.3 Section 20 is mandatory if the product specification has a hydrostatic test requirement without defining the test parameters.

1.4 Section 12 is for information only.

1.5 In case of conflict between a requirement of the product specification and a requirement of this general requirement specification, only the requirement of the product specification need be satisfied.

Carbon and Alloy Steel Pipe, Electric-Fusion-Welded for High-Pressure Service at High Temperatures	A 691
Centrifugally Cast Ferritic/Austenitic Stainless Steel Pipe for Corrosive Environments	A 872

^A These designations refer to the latest issue of the respective specifications.

1.6 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 (SI) of the product 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 370 Test Methods and Definitions for Mechanical Testing of Steel Products³

A 450/A 450M Specification for General Requirements for Carbon, Ferritic Alloy, and Austenitic Alloy Steel Tubes⁴

A 700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Domestic Shipment⁵

A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products³

D 3951 Practice for Commercial Packaging⁶

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications⁷

2.2 ANSI Standards:

B 36.10 Welded and Seamless Wrought Steel Pipe⁸

B 36.19 Stainless Steel Pipe⁸

2.3 Military Standards:

³ Annual Book of ASTM Standards, Vol 01.03.

⁴ Annual Book of ASTM Standards, Vol 01.01.

⁵ Annual Book of ASTM Standards, Vol 01.05.

⁶ Annual Book of ASTM Standards, Vol 15.09.

⁷ Annual Book of ASTM Standards, Vol 14.02.

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

Title of Specification	ASTM Designation ^A
Seamless Carbon Steel Pipe for High-Temperature Service	A 106
Metal-Arc-Welded Steel Pipe for Use With High-Pressure Transmission Systems	A 381
Centrifugally Cast Ferritic Alloy Steel Pipe for High-Temperature Service	A 426
Centrifugally Cast Austenitic Steel Pipe for High-Temperature Service	A 451
Seamless Carbon Steel Pipe for Atmospheric and Lower Temperatures	A 524
Centrifugally Cast Iron-Chromium-Nickel High-Alloy Tubing for Pressure Application at High Temperatures	A 608
Centrifugally Cast Carbon Steel Pipe for High-Temperature Service	A 660
Electric-Fusion-Welded Steel Pipe for Atmospheric and Lower Temperatures	A 671
Electric-Fusion-Welded Steel Pipe for High-Pressure Service at Moderate Temperatures	A 672

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 A01.09 on Carbon Steel Tubular Products.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-530 in Section II of that Code.

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

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MIL-STD-163 Steel Mill Products Preparation for Shipment and Storage⁹

MIL-STD-271 Nondestructive Testing Requirements for Metals⁹

MIL-STD-792 Identification Marking Requirements for Special Purpose Components⁹

2.4 Federal Standards:

Fed. Std. No. 183 Continuous Identification Marking of Iron and Steel Products⁹

2.5 Steel Structures Painting Council:

SSPC-SP 6 Surface Preparation Specification No. 6 Commercial Blast Cleaning¹⁰

3. Process

3.1 The steel shall be made from any process.

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

3.3 The primary melting may incorporate separate degassing or refining and may be followed by secondary melting, using electroslag remelting or vacuum remelting. If secondary melting is employed, the heat shall be defined as all of the ingots remelted from a single primary heat.

3.4 Steel may be cast in ingots or may be strand cast. When steel of different grades is sequentially strand cast, identification of the resultant transition material is required. The producer shall remove the transition material by an established procedure that positively separates the grades.

4. Chemical Composition

4.1 *Chemical Analysis*—Samples for chemical analysis and method of analysis shall be in accordance with Test Methods, Practices, and Terminology A 751.

4.2 *Heat Analysis*—An analysis of each heat of steel shall be made by the steel manufacturer to determine the percentages of the elements specified. If secondary melting processes are employed, the heat analysis shall be obtained from one remelted ingot or the product of one remelted ingot of each primary melt. The chemical composition thus determined, or that determined from a product analysis made by the tubular product manufacturer shall conform to the requirements specified.

4.2.1 For stainless steels ordered under product specifications referencing this specification of general requirements, the steel shall not contain an unspecified element, other than nitrogen, for the ordered grade to the extent that the steel conforms to the requirements of another grade for which that element is a specified element having a required minimum content. For this requirement, a grade is defined as an alloy described individually and identified by its own UNS designation in a table of chemical requirements within any specification listed within the scope as being covered by this specification.

4.3 *Product Analysis*—Product analysis requirements and options, if any, are contained in the product specification.

5. Mechanical Requirements

5.1 *Method of Mechanical Tests*—The specimens and the mechanical tests required shall be in accordance with Test Methods and Definitions A 370, especially Annex A2 thereof.

5.2 Specimens shall be tested at room temperature.

5.3 Small or subsize specimens as described in Test Methods and Definitions A 370 may be used only when there is insufficient material to prepare one of the standard specimens. When using small or subsize specimens, the largest one possible shall be used.

6. Tensile Requirements

6.1 The material shall conform to the requirements as to tensile properties prescribed in the individual specifications.

6.2 The yield strength corresponding to a permanent offset of 0.2 % of the gage length or to a total extension of 0.5 % of the gage length under load shall be determined.

6.3 If the percentage of elongation of any test specimen is less than that specified and any part of the fracture is more than 3/4 in. [19.0 mm] from the center of the gage length, as indicated by scribe marks on the specimen before testing, a retest shall be allowed.

7. Permissible Variation in Weight

7.1 The weight of any length of pipe NPS 12 and under shall not vary more than 10 % over or 3.5 % under that specified. For sizes over NPS 12, the weight of any length of pipe shall not vary more than 10 % over or 5 % under that specified. Unless otherwise specified, pipe of NPS 4 and smaller may be weighed in convenient lots; pipe in sizes larger than NPS 4 shall be weighed separately.

8. Permissible Variations in Wall Thickness

8.1 *Seamless and Welded (no filler metal added)*—The minimum wall thickness at any point shall be within the tolerances specified in Table 1, except that for welded pipe the weld area shall not be limited by the over tolerance. The minimum wall thickness on inspection for – 12.5 % is shown in Table X1.1.

8.2 *Forged and Bored*—The wall thickness shall not vary over that specified by more than 1/8 in. [3.2 mm]. There shall be no variation under the specified wall thickness.

8.3 *Cast*—The wall thickness shall not vary over that specified by more than 1/16 in. [1.6 mm]. There shall be no variation under the specified wall thickness.

TABLE 1 Permissible Variations in Wall Thickness

NPS Designator	Tolerance, % from Nominal	
	Over	Under
1/8 to 2 1/2, incl., all $t/D^{A,B}$ ratios	20.0	12.5
3 to 18 incl., t/D up to 5 % incl.	22.5	12.5
3 to 18 incl., $t/D > 5$ %	15.0	12.5
20 and larger, welded, all t/D ratios	17.5	12.5
20 and larger, seamless, t/D up to 5 % incl.	22.5	12.5
20 and larger, seamless, $t/D > 5$ %	15.0	12.5

^A t = Nominal wall thickness.

^B D = Ordered outside diameter.

⁹ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

¹⁰ Available from Steel Structures Painting Council, 4400 Fifth Ave., Pittsburgh, PA 15213.

9. Permissible Variations in Inside Diameter

9.1 *Forged and Bored, and Cast*—The inside diameter shall not vary under that specified by more than 1/16 in. [1.6 mm]. There shall be no variation over the specified inside diameter.

10. Permissible Variations in Outside Diameter

10.1 Variations in outside diameter, unless otherwise specified, shall not exceed the limits prescribed in Table 2. The tolerances on outside diameter include ovality except as provided for in 10.2 and 10.2.1.

10.2 Thin-wall pipe usually develops significant ovality (out-of-roundness) during final annealing, straightening, or both. Thin-wall pipes are defined as having a wall thickness of 3 % or less of the outside diameter.

10.2.1 The diameter tolerances of Table 2 are not sufficient to provide for additional ovality expected in thin-wall pipe and are applicable only to the mean of the extreme (maximum and minimum) outside diameter readings in any one cross-section. However, for thin-wall pipe the difference in extreme outside diameter readings (ovality) in any one cross-section shall not exceed 1.5 % of the specified outside diameter.

11. Permissible Variations in Length

11.1 *Seamless and Welded (no filler metal added)*—If definite cut lengths are ordered, no length of pipe shall be under the length specified and not more than 1/4 in. [6 mm] over that specified.

11.2 *Forged and Bored, Cast, and Cast Cold-Wrought*—If definite cut lengths are ordered, no length of pipe shall be under the length specified and not more than 1/8 in. [3 mm] over that specified.

11.3 For pipe ordered to random lengths, the lengths and variations shall be agreed upon between the manufacturer and purchaser.

11.4 No jointers are permitted unless otherwise agreed upon.

12. Standard Weight

12.1 A system of standard pipe sizes has been approved by the American National Standards Institute as ANSI B 36.10 and B 36.19. These standard sizes do not prohibit the production and use of other sizes of pipe produced to the various specifications referenced to this Specification.

12.2 For nonstandard sizes of pipe, the calculated weight per foot, shall be determined from the following equation:

$$W = C(D - t)t \tag{1}$$

where:

C = 10.69 [0.0246615],

W = weight, lb/ft [kg/m],

D = specified or calculated (from specified inside diameter and wall thickness) outside diameter, in. [mm], and

t = specified wall thickness, in. (to 3 decimal places) [mm to 2 decimal places].

NOTE 2—The weights given in the American National Standards and the calculated weights given by Eq 1 are based on the weights for carbon steel pipe. The weight of pipe made of ferritic stainless steels may be about 5 % less, and that made of austenitic stainless steel about 2 % greater than the values given.

13. Ends

13.1 Unless otherwise specified, the pipe shall be furnished with plain ends. All burrs at the ends of the pipe shall be removed.

14. Straightness

14.1 The finished pipe shall be reasonably straight.

14.2 For metal-arc welded pipe, the maximum deviation from a 10-ft [3.0-m] straightedge placed so that both ends are in contact with the pipe shall be 1/8 in. [3.2 mm]. For metal-arc welded pipe with lengths shorter than 10 ft [3.0 m], this maximum deviation shall be pro-rated with respect to the ratio of the actual length to 10 ft [3.0 m].

15. Repair by Welding

15.1 Repair by welding of defects in seamless pipe (including centrifugally cast and forged and bored) and of plate defects in welded pipe and, when specifically stated by the product specification weld seam defects in welded pipe, shall be permitted subject to the approval of the purchaser and with the further understanding that the composition of the deposited filler metal shall be suitable for the composition being welded. Defects shall be thoroughly chipped or ground out before welding and each repaired length shall be reheat treated or stress relieved as required by the applicable specification. Each length of repaired pipe shall be tested hydrostatically as required by the product specification.

15.2 Repair welding shall be performed using procedures and welders or welding operators that have been qualified in accordance with the ASME Boiler and Pressure Vessel Code, Section IX.

16. Retests

16.1 If the results of the mechanical tests of any group or lot do not conform to the requirements specified in the individual specification, retests may be made on additional lengths of pipe of double the original number from the same group or lot, each of which shall conform to the requirements specified. Only one retest of any group or lot will be permitted. Nonconformance will be cause for the rejection of the group or lot.

16.2 Any individual length of pipe that meets the test requirements is acceptable. Individual lengths that do not conform to the test requirements may be resubmitted for test provided the reason for nonconformance is established and the nonconforming portion removed.

TABLE 2 Permissible Variations in Outside Diameter

NPS Designator	Permissible Variations In Outside Diameter			
	Over		Under	
	in.	mm	in.	mm
1/8 to 1 1/2, incl	1/64 (0.015)	0.4	1/32 (0.031)	0.8
Over 1 1/2 to 4, incl	1/32 (0.031)	0.8	1/32 (0.031)	0.8
Over 4 to 8, incl	1/16 (0.062)	1.6	1/32 (0.031)	0.8
Over 8 to 18, incl	3/32 (0.093)	2.4	1/32 (0.031)	0.8
Over 18 to 26, incl	1/8 (0.125)	3.2	1/32 (0.031)	0.8
Over 26 to 34, incl	5/32 (0.156)	4.0	1/32 (0.031)	0.8
Over 34	3/16 (0.187)	4.8	1/32 (0.031)	0.8

17. Retreatment

17.1 If individual lengths of pipe selected to represent any group or lot fail to conform to the test requirements, the group or lot represented may be reheat treated and resubmitted for test. The manufacturer may reheat treat the pipe, but not more than twice, except with the approval of the purchaser on the basis of satisfactory metallurgical evidence that the cause of failure of the test is curable and the quality of the material is satisfactory.

18. Test Specimens

18.1 Test specimens shall be taken from the ends of finished pipe prior to any forming operations, or being cut to length. They shall be smooth on the ends and free from burrs and flaws, except for specimens for the flattening test when made from crop ends.

18.2 Specimens cut either longitudinally or transversely shall be acceptable for the tension test.

18.3 If any test specimen shows flaws or defective machining, the specimen may be discarded and another substituted.

19. Flattening Test Requirements

19.1 *Seamless and Centrifugally Cast Pipe*—A section of pipe not less than 2½ in. [63 mm] in length shall be flattened cold between parallel plates in two steps. During the first step, which is a test for ductility, no cracks or breaks on the inside, outside, or end surfaces, except as provided for in 19.3.4, shall occur until the distance between the plates is less than the value of H calculated as follows:

$$H = (1 + e)t/(e+t/D) \quad (2)$$

where:

H = distance between flattening plates, in. [mm],

t = specified wall thickness, in. [mm],

D = specified or calculated (from the specified inside diameter and wall thickness) outside diameter, in. [mm], and

e = deformation per unit length (constant for a given grade of steel; 0.07 for medium carbon steel (maximum specified carbon 0.19 % or greater), 0.08 for ferritic alloy steel, 0.09 for austenitic steel, and 0.09 for low-carbon steel (maximum specified carbon 0.18 % or less)).

During the second step, which is a test for soundness, the flattening shall be continued until the specimen breaks or the opposite walls of the pipe meet.

19.2 *Welded Pipe*—A section of welded pipe not less than 4 in. [100 mm] in length shall be flattened cold between parallel plates in two steps. The weld shall be placed 90° from the direction of the applied force (at the point of maximum bending). During the first step, which is a test for ductility, no cracks or breaks on the inside or outside surfaces, except as provided for in 19.3.4, shall occur until the distance between the plates is less than the value of H calculated by Eq 2. During the second step, which is a test for soundness, the flattening shall be continued until the specimen breaks or the opposite walls of the pipe meet.

19.3 *Seamless, Centrifugally Cast, and Welded Pipe:*

19.3.1 Evidence of laminated or defective material or weld that is revealed during the entire flattening test shall be cause for rejection.

19.3.2 Surface imperfections not evident in the test specimen before flattening, but revealed during the first step of the flattening test, shall be judged in accordance with the finish requirements.

19.3.3 Superficial ruptures resulting from surface imperfections shall not be a cause for rejection.

19.3.4 When low D -to- t ratio tubular products are tested, because the strain imposed due to geometry is unreasonably high on the inside surface at the six and twelve o'clock locations, cracks at these locations shall not be cause for rejection if the D to t ratio is less than 10.

20. Hydrostatic Test Requirements

20.1 Except as provided in 20.2 and 20.3, each length of pipe shall be tested by the manufacturer to a hydrostatic pressure which will produce in the pipe wall a stress not less than 60 % of the minimum specified yield strength for carbon and ferritic alloy steel pipe, or 50 % of the specified minimum yield strength for austenitic alloy steel pipe. The test pressure or stress shall be determined by the following equation:

$$P = 2St/D \text{ or } S = PD/2t \quad (3)$$

where:

P = hydrostatic test pressure in psi or MPa,

S = pipe wall stress in psi or MPa,

t = specified nominal wall thickness, nominal wall thickness corresponding to specified ANSI schedule number, or 1.143 times the specified minimal wall thickness, in. [mm], and

D = specified outside diameter, outside diameter corresponding to specified ANSI pipe size, or outside diameter calculated by adding $2t$ (as defined above) to the specified inside diameter, in. [mm].

20.1.1 The hydrostatic test pressure determined by the equation shall be rounded to the nearest 50 psi [0.5 MPa] for pressures below 1000 psi [7 MPa], and to the nearest 100 psi [1 MPa] for pressures 1000 psi [7 MPa] and above. The hydrostatic test may be performed prior to cutting to final length, or prior to upsetting, swaging, expanding, bending, or other forming operations.

20.2 Regardless of pipe-wall stress-level determined by Eq 3, the minimum hydrostatic test pressure required to satisfy these requirements need not exceed 2500 psi [17.0 MPa] for outside diameters (see D in 20.1) of 3.5 in. [88.9 mm] or less, nor 2800 psi [19.0 MPa] for outside diameters over 3.5 in. [88.9 mm]. This does not prohibit testing at higher pressures at the manufacturer's option or as provided in 20.3.

20.3 With concurrence of the manufacturer, a minimum hydrostatic test pressure in excess of the requirements of 20.2 or 20.1, or both, may be stated on the order.

20.4 The test pressure shall be held for a minimum of 5 s, without resultant leakage through the pipe wall. For welded pipe, the test pressure shall be held for a time sufficient to permit the inspector to examine the entire length of the welded seam.