



Standard Specification for Electric-Fusion-Welded Austenitic Chromium-Nickel Alloy Steel Pipe for High-Temperature Service¹

This standard is issued under the fixed designation A 358/A 358M; 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 specification² covers electric-fusion-welded austenitic chromium-nickel alloy steel pipe suitable for corrosive or high-temperature service, or both.

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.”

1.2 This specification covers nineteen grades of alloy steel as indicated in Table 1. The selection of the proper alloy and requirements for heat treatment shall be at the discretion of the purchaser, dependent on the service conditions to be encountered.

1.3 Five classes of pipe are covered as follows:

1.3.1 *Class 1*—Pipe shall be double welded by processes employing filler metal in all passes and shall be completely radiographed.

1.3.2 *Class 2*—Pipe shall be double welded by processes employing filler metal in all passes. No radiography is required.

1.3.3 *Class 3*—Pipe shall be single welded by processes employing filler metal in all passes and shall be completely radiographed.

1.3.4 *Class 4*—Same as Class 3 except that the weld pass exposed to the inside pipe surface may be made without the addition of filler metal (see 6.2.2.1 and 6.2.2.2).

1.3.5 *Class 5*—Pipe shall be double welded by processes employing filler metal in all passes and shall be spot radiographed.

1.4 Supplementary requirements covering provisions ranging from additional testing to formalized procedures for manufacturing practice are provided. Supplementary Requirements S1 through S6 are included as options to be specified when desired.

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.

2. Referenced Documents

2.1 ASTM Standards:

A 240/A 240M Specification for Heat-Resisting Chromium and Chromium-Nickel Stainless Steel Plate, Sheet, and Strip for Pressure Vessels³

A 262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels³

A 480/A 480M Specification for General Requirements for Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet, and Strip³

A 941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys⁴

A 999/A 999M Specification for General Requirements for Alloy and Stainless Steel Pipe⁴

E 527 Practice for Numbering Metals and Alloys (UNS)⁴

2.2 ASME Boiler and Pressure Vessel Code: a358m-01
Section I, Welding and Brazing Qualifications⁵
Section IX, Welding Qualifications⁵

2.3 AWS Specifications:⁶

A 5.22 Flux Cored Arc Welding

A 5.30 Consumable Weld Inserts for Gas Tungsten Arc Welding

A 5.4 Corrosion-Resisting Chromium and Chromium-Nickel Steel Covered Welding Electrodes

A 5.9 Corrosion-Resisting Chromium and Chromium-Nickel Steel Welding Rods and Bare Electrodes

A 5.11 Nickel and Nickel-Alloy Covered Welding Electrodes

A 5.14 Nickel and Nickel-Alloy Bare Welding Rods and Electrodes

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 For ASME Boiler and Pressure Vessel Code applications see related Specifications SA-358 in Section II of that Code.

³ *Annual Book of ASTM Standards*, Vol 01.03.

⁴ *Annual Book of ASTM Standards*, Vol 01.01.

⁵ Available from ASME International, Three Park Avenue, New York, NY 10016-5990.

⁶ American Welding Society, 550 LeJeune Road, P.O. Box 351040, Miami, FL 33135.

TABLE 1 Plate and Filler Metal Specifications

Grade	UNS Designation	Material Type	ASTM Plate Specification No. and Grade	Filler Metal Classification and UNS Designation ^A for Applicable ^B AWS Specification											
				A5.4		A5.9		A5.11		A5.14		A5.22		A5.30	
				Class.	UNS	Class.	UNS	Class.	UNS	Class.	UNS	Class.	UNS	Class.	UNS
304	S30400	304	A 240 Type 304	E308	W30810	ER308	S30880 W30840	E308T	W30831	IN308	S30880
304L	S30403	304L	A 240 Type 304	E308L	W30813	ER308L	S30883 W30843	E308LT	W30835	IN308L	S30883
304N	S30451	304N	A 240 Type 304N	E308	W30810	ER308	S30880 W30840	E308T	W30831	IN308	S30880
304LN	S30453	304LN	A 240 Type 304LN	E308L	W30813	ER308L	S30883 W30843	W308LT	W30835	IN308L	S30883
304H	S30409	304H	A 240 Type 304H	E308H	W30810	ER308	S30880 W30840	E308T	W30831	IN308	S30880
309Cb	S30940	309Cb	A 240, Type 309Cb	E309Cb
309S	S30908	309S	A 240, Type 309S
310Cb	S31040	310Cb	A 240, Type 310Cb	E310Cb
310S	S31008	310S	A 240, Type 310S
316	S31600	316	A 240 Type 316	E316	W31610	ER316	S31680 W31640	E316T	W31631	IN316	S31680
316L	S31603	316L	A 240 Type 316L	E316L	W31613	ER316L	S31683 W31643	E316LT	W31635	IN316L	S31683
316N	S31651	316N	A 240 Type 316N	E316	W31610	ER316	S31680 W31640	E316T	W31631	IN316	S31680
316LN	S31653	316LN	A 240 Type 316LN	E316L	W31613	ER316L	S31683 W31643	E316LT	W31635	IN316L	S31683
316H	S31609	316H	A 240 Type 316H	E316H	W31610	ER316H	S31680 W31640	E316T	W31631	IN316	S31680
321	S32100	321	A 240 Type 321	E347	W34710	ER321 ER347	S32180 W32140 S34780 W34740	E347T	W34733	IN348	S34780
347	S34700	347	A 240 Type 347	E347	W34710	ER347	S34780 W34740	E347T	W34733	IN348	S34780
348	S34800	348	A 240 Type 348	E347	W34710	ER347	S34780 W34740	E347T	W34733	IN348	S34780
XM-19	S22100	XM-19	A 240 Type XM-19	E209	W32210	ER209	S20980 W32240
XM-29	S28300	XM-29	A 240 Type XM-29	E240	W32410	ER240	S23980 W32440
...	S31254	...	A 240 S31254	ENiCrMo-3	W86112	ERNiCrMo-3	N06625
...	S30815	...	A 240 S30815
...	S31725	...	A 240 S31725	ENiCrMo-3	W86112	ERNiCrMo-3	N06625
...	S31726	...	A 240 S31726	ENiCrMo-3	W86112	ERNiCrMo-3	N06625
...	S30600 ^C	...	A 240 S30600 ^C
...	S24565	...	A 240 S24565
...	S30415	...	A 240 S30415
...	S32654	...	A 240 S32654
...	S31266	...	A 240 S31266	ENiCrMo-13	W86059	ERNiCrMo-13	N06059
...	S31266	...	A 240 S31266	ENiCrMo-10	W86022	ERNiCrMo-10	N06022
...	S32050	...	A 240 S32050
...	N08367	...	A 240 N08367	ENiCrMo-3	W86112	ERNiCrMo-3	N06625
...	N08904	...	A 240 N08904
...	N08926	...	A 240 N08926	ENiCrMo-3	W86112	ERNiCrMo-3	N06625
...	N08800	...	A 240 N08800
...	N08810	...	A 240 N08810
...	N08020	...	A 240 N08020
...	S20400	...	A 240 S20400	E 209	W32210	ER209	S20980 W32240

^A New designation established in accordance with ASTM E 527 and SAE J 1086.
^B Choice of American Welding Society specification depends on the welding process used.
^C In previous editions, S30600 was incorrectly shown as S01815.

2.4 *Other Standard:*
 SAE J1086 Practice for Numbering Metals and Alloys (UNS)⁷

3. Terminology

3.1 *Definitions:*

3.1.1 The definitions in Specification A 999/A 999M and Terminology A 941 are applicable to this specification.

4. Ordering Information

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

- 4.1.1 Quantity (feet, metres, or number of lengths),
- 4.1.2 Name of material (electric-fusion-welded pipe),

⁷ Available from Society of Automotive Engineers, 400 Commonwealth Drive, Warrendale, PA 15096.

- 4.1.3 Grade (Table 1),
- 4.1.4 Class (see 1.3),
- 4.1.5 Size (outside diameter and nominal wall thickness),
- 4.1.6 Length (specific or random),
- 4.1.7 End finish (Section on Ends of Specification A 999/A 999M),
- 4.1.8 Authorization for repair of plate defects by welding and subsequent heat treatment without prior approval if such is intended (see 9.3),
- 4.1.9 Specification designation,
- 4.1.10 Special requirements,
- 4.1.11 Statement invoking requirements of 16.4 if such is intended.
- 4.1.12 Circumferential weld permissibility (see Section 16),
- 4.1.13 Supplementary Requirements (S1 through S6),
- 4.1.14 Applicable ASME Code if known,
- 4.1.15 For ASME Code Section III applications, the service classification intended, and
- 4.1.16 Certification requirements (see Section on Certification of Specification A 999/A 999M).

5. General Requirements

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

6. Materials and Manufacture

6.1 Materials:

6.1.1 The steel plate material shall conform to the requirements of one of the grades of Specification A 240/A 240M, listed in Table 1, except as provided in 6.3.2.3.

6.2 Welding:

6.2.1 The joints shall be full penetration double-welded or single-welded butt joints employing fusion welding processes as defined under “Definitions,” ASME Boiler and Pressure Vessel Code, Section IX. This specification makes no provision for any difference in weld quality requirements regardless of the weld joint type employed (single or double) in making the weld. Where backing rings or strips are employed, the ring or strip material shall be of the same P-Number (Table QW-422 of Section IX) as the plate being joined. Backing rings or strips shall be completely removed after welding, prior to any required radiography, and the exposed weld surface shall be examined visually for conformance to the requirements of 6.2.3. Welds made by procedures employing backing strips or rings which remain in place are prohibited. Welding procedures, and welding operators shall be qualified in accordance with ASME Boiler and Pressure Vessel Code, Section IX.

6.2.2 Except as provided in 6.2.2.1 and 6.2.2.2, welds shall be made in their entirety by processes involving the deposition of filler metal.

6.2.2.1 For Class 4 pipe employing multiple passes, the root-pass may be without the addition of filler metal.

6.2.2.2 For Class 4 pipe, the weld surface exposed inside the pipe may result from a single pass made from the inside of the pipe without the addition of filler metal.

6.2.2.3 All single-welded pipe shall be completely radiographed.

6.2.3 The weld surface on either side of the weld may be flush with the base plate or may have a reasonably uniform crown, not to exceed $\frac{1}{8}$ in. [3 mm]. Any weld reinforcement may be removed at the manufacturer’s option or by agreement between the manufacturer and purchaser. The contour of the reinforcement should be reasonably smooth and free from irregularities. The deposited metal shall be fused uniformly into the plate surface. No concavity of contour is permitted unless the resulting thickness of weld metal is equal to or greater than the minimum thickness of the adjacent base metal.

6.2.4 Weld defects shall be repaired by removal to sound metal and rewelding. Subsequent heat treatment and examination (that is, visual, radiographic, and dye penetrant) shall be as required on the original welds.

6.3 Heat Treatment:

6.3.1 Unless otherwise stated in the order, heat-treatment shall consist of heating the material to a minimum temperature of 1900°F [1040°C] except for S31266, S31254, S32654, S32050, and S30815 which shall be heated to a minimum temperature of 2100°F [1150°C], and 1920°F [1050°C] respectively, S24565 which shall be heated to a minimum temperature of 2050°F [1120°C], N08367 which shall be heated to a minimum temperature of 2025°F [1107°C], and N08926 which shall be heat treated to a minimum temperature of 2010°F [1100°C], all treatments being followed by quenching in water or rapidly cooling by other means. N08904 shall be heat treated to a minimum temperature of 2000°F [1095°C] and cooled rapidly. UNS N08810 shall be heated to a minimum temperature of 2050°F [1120°C] and cooled rapidly. UNS N08020 shall be heated in the range from 1800 to 1850°F [982 to 1010°C] and cooled rapidly.

6.3.2 The purchase order shall specify one of the following conditions if the heat-treated condition specified in 6.3.1 is not desired by the purchaser:

6.3.2.1 *A final heat-treatment temperature under 1900°F [1040°C]*—Each pipe supplied under this requirement shall be stenciled with the final heat-treatment temperature in degrees Fahrenheit or degrees Celsius after the suffix “HT”. Controlled structural or special service characteristics may be specified as a guide for the most suitable heat treatment.

6.3.2.2 *No final heat treatment of pipe fabricated of plate that has been solution heat treated at temperatures required by this specification*—Each pipe supplied under this requirement shall be stenciled with the suffix “HT-O”.

6.3.2.3 *No final heat treatment of pipe fabricated of plate that has not been solution heat treated*—Each pipe supplied under this requirement shall be stenciled with the suffix “HT-SO”.

6.4 A solution annealing temperature above 1950°F [1065°C] may impair the resistance to intergranular corrosion after subsequent exposure to sensitizing conditions in Grades 321, 347, and 348. 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 S5).