
**Petroleum and natural gas industries —
Materials for use in H₂S-containing
environments in oil and gas
production —**

Part 3:

**Cracking-resistant CRAs (corrosion-
resistant alloys) and other alloys**

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*Industries du pétrole et du gaz naturel — Matériaux pour utilisation
dans des environnements contenant de l'hydrogène sulfuré (H₂S) dans
la production de pétrole et de gaz —*

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*Partie 3: ARC (alliages résistants à la corrosion) et autres alliages
résistants à la fissuration*



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Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 15156-3 was prepared by Technical Committee ISO/TC 67, *Materials, equipment and offshore structures for petroleum and natural gas industries*.

ISO 15156 consists of the following parts, under the general title *Petroleum and natural gas industries — Materials for use in H₂S-containing environments in oil and gas production*:

- Part 1: *General principles for selection of cracking-resistant materials*
- Part 2: *Cracking-resistant carbon and low alloy steels, and the use of cast irons*
- Part 3: *Cracking-resistant CRAs (corrosion-resistant alloys) and other alloys*

Introduction

The consequences of sudden failures of metallic oil and gas field components, associated with their exposure to H₂S-containing production fluids, led to the preparation of the first edition of NACE MR0175, which was published in 1975 by the National Association of Corrosion Engineers, now known as NACE International.

The original and subsequent editions of NACE MR0175 established limits of H₂S partial pressure above which precautions against sulfide stress-cracking (SSC) were always considered necessary. They also provided guidance for the selection and specification of SSC-resistant materials when the H₂S thresholds were exceeded. In more recent editions, NACE MR0175 has also provided application limits for some corrosion-resistant alloys, in terms of environmental composition and pH, temperature and H₂S partial pressures. NACE MR0175 is complemented by NACE TM0177-96 and NACE TM0284 test methods.

In separate developments, the European Federation of Corrosion issued EFC Publication Number 16 in 1995 and EFC Publication Number 17 in 1996. These documents are generally complementary to those of NACE, though they differ in scope and detail.

This part of ISO 15156 utilises the above sources to provide requirements and recommendations for materials qualification and selection for application in environments containing wet H₂S in oil and gas production systems.

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Changes will be incorporated into this International Standard by amendments or revisions in accordance with *Interpretation and maintenance of ISO 15156* by ISO/TC 67/WG 7, copies of which can be obtained from the ISO/TC 67 Secretariat. Experts from both NACE and EFC are members of ISO/TC 67/WG 7.

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Petroleum and natural gas industries — Materials for use in H₂S-containing environments in oil and gas production —

Part 3: Cracking-resistant CRAs (corrosion-resistant alloys) and other alloys

WARNING — CRAs (corrosion-resistant alloys) and other alloys selected using this part of ISO 15156 are resistant to cracking in defined H₂S-containing environments in oil and gas production but not necessarily immune to cracking under all service conditions. It is the equipment user's responsibility to select the CRAs and other alloys suitable for the intended service.

1 Scope

This part of ISO 15156 gives requirements and recommendations for the selection and qualification of CRAs (corrosion-resistant alloys) and other alloys for service in equipment, used in oil and natural gas production and natural gas treatment plants in H₂S-containing environments, whose failure could pose a risk to the health and safety of the public and personnel or to the environment. It can be applied to help to avoid costly corrosion damage to the equipment itself. It supplements, but does not replace, the materials' requirements of the appropriate design codes, standards or regulations.

This part of ISO 15156 addresses the resistance of these materials to damage that may be caused by sulfide stress-cracking (SSC), stress-corrosion cracking (SCC) and galvanically-induced hydrogen stress-cracking (GHSC).

This part of ISO 15156 is only concerned with cracking. Loss of material by general (mass loss) or localized corrosion is not addressed.

Table 1 provides a non-exhaustive list of equipment to which this part of ISO 15156 is applicable, including permitted exclusions.

This part of ISO 15156 applies to the qualification and selection of materials for equipment designed and constructed using conventional elastic design criteria. For designs utilizing plastic criteria (e.g. strain-based and limit-state designs), see ISO 15156-1:2001, Clause 5.

This part of ISO 15156 is not necessarily suitable for application to equipment used in refining or downstream processes and equipment.

Table 1 — List of equipment

ISO 15156 is applicable to materials used for the following equipment	Permitted exclusions
Drilling, well construction and well-servicing equipment	Equipment only exposed to drilling fluids of controlled composition ^a Drill bits Blowout Preventer (BOP) shear blades ^b Drilling riser systems Work strings Wireline and wireline equipment ^c Surface and intermediate casing
Wells, including subsurface equipment, gas lift equipment, wellheads and christmas trees	Sucker rod pumps and sucker rods ^d Electric submersible pumps Other artificial lift equipment Slips
Flow-lines, gathering lines, field facilities and field processing plants	Crude oil storage and handling facilities operating at a total absolute pressure below 0,45 MPa (65 psi)
Water-handling equipment	Water-handling facilities operating at a total absolute pressure below 0,45 MPa (65 psi)
Natural gas treatment plants	
Transportation pipelines for liquids, gases and multiphase fluids	Lines handling gas prepared for general commercial and domestic use
For all equipment above	Components loaded only in compression
<p>^a See ISO 15156-2:2003, A.2.3.2.3 for more information.</p> <p>^b See ISO 15156-2:2003, A.2.3.2.1 for more information.</p> <p>^c Wireline lubricators and lubricator connecting devices are not permitted exclusions.</p> <p>^d For sucker rod pumps and sucker rods, reference can be made to NACE MR0176.</p>	

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 6507-1, *Metallic materials — Vickers hardness test — Part 1: Test method*

ISO 6508-1, *Metallic materials — Rockwell hardness test — Test method (scales A, B, C, D, E, F, G, H, K, N, T)*

ISO 6892, *Metallic materials — Tensile testing at ambient temperature*

ISO 10423, *Petroleum and natural gas industries — Drilling and production equipment — Wellhead and christmas tree equipment*

ISO 11960, *Petroleum and natural gas industries — Steel pipes for use as casing or tubing for wells*

ISO 15156-1:2001, *Petroleum and natural gas industries — Materials for use in H₂S-containing environments in oil and gas production — Part 1: General principles for selection of cracking-resistant materials*

ISO 15156-2:2003, *Petroleum and natural gas industries — Materials for use in H₂S-containing environments in oil and gas production — Part 2: Cracking-resistant carbon and low alloy steels, and the use of cast irons*

ASTM A 747/A 747M¹⁾, *Standard specification for steel castings, stainless, precipitation hardening*

EFC Publications Number 17²⁾, *Corrosion resistant alloys for oil and gas production: guidelines on general requirements and test methods for H₂S in service*

NACE CORROSION/95³⁾, Paper 47, (Houston), 1995, *Test methodology for elemental sulfur-resistant advanced materials for oil and gas field equipment*, by G. Steinbeck, W. Bruckhoff, M. Köhler, H. Schlerkmann, G. Schmitt

NACE TM0177-96, *Laboratory testing of metals for resistance to sulfide stress cracking and stress corrosion cracking in H₂S environments*

SAE⁴⁾ – ASTM, *Metals and alloys in the Unified Numbering System*, ISBN 0-7680-04074

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 15156-1 and ISO 15156-2 and the following apply.

3.1 ageing

change in metallurgical properties that generally occurs slowly at room temperature (natural ageing) and more rapidly at higher temperature (artificial ageing)

3.2 anneal

heat to and hold at a temperature appropriate to the specific material and then cool at a suitable rate, for such purposes as reducing hardness, improving machineability, or obtaining desired properties

3.3 austenite

face-centred cubic crystalline phase of iron-base alloys

3.4 duplex stainless steel

austenitic/ferritic stainless steel

stainless steel whose microstructure at room temperature consists primarily of a mixture of austenite and ferrite

3.5 ferrite

body-centred cubic crystalline phase of iron-base alloys

1) ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, USA

2) European Federation for Corrosion, available from The Institute of Materials, 1 Carlton House Terrace, London SW1Y 5DB, UK [ISBN 0-901716-95-2]

3) NACE International, P.O. Box 2183140, Houston, TX 77218-8340, USA

4) Society of Automotive Engineers (SAE), 400 Commonwealth Drive, Warrendale, PA 15096-0001 USA

- 3.6**
ferritic stainless steel
stainless steel whose microstructure, at room temperature, consists predominantly of ferrite
- 3.7**
galvanically-induced hydrogen stress-cracking
GHSC
cracking that results due to the presence of hydrogen in a metal, induced in the cathode of a galvanic couple, and tensile stress (residual and/or applied)
- 3.8**
martensite
hard, supersaturated solid solution of carbon in iron characterized by an acicular (needle-like) microstructure
- 3.9**
martensitic steel
steel in which a microstructure of martensite can be attained by quenching at a cooling rate fast enough to avoid the formation of other microstructures
- 3.10**
pitting resistance equivalent number
PREN
 F_{PREN}
number, developed to reflect and predict the pitting resistance of a CRA, based upon the proportions of Cr, Mo, W and N in the chemical composition of the alloy
- NOTE See 6.3 for further information.
- 3.11**
solid solution
single crystalline phase containing two or more elements
- 3.12**
stainless steel
steel containing 10,5 % or more chromium, possibly with other elements added to secure special properties

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4 Symbols and abbreviated terms

For the purposes of this document, the symbols and abbreviated terms shown in ISO 15156-1 and ISO 15156-2 apply, some of which are repeated for the purpose of convenience, together with the following:

- AYS actual yield strength
- CRA corrosion-resistant alloy
- HBW Brinell hardness
- HRB Rockwell hardness (scale B)
- HRC Rockwell hardness (scale C)
- p_{CO_2} partial pressure of CO₂
- p_{H_2S} partial pressure of H₂S
- PWHT post-weld heat treatment

S ⁰	elemental sulfur
RSRT	rippled strain rate test
SSRT	slow strain rate test
UNS	unified (alloy) numbering system

5 Factors affecting the cracking resistance of CRAs and other alloys in H₂S-containing environments

The cracking behavior of CRAs and other alloys in H₂S-containing environments can be affected by complex interactions of parameters, including the following:

- chemical composition, strength, heat treatment, microstructure, method of manufacture and finished condition of the material;
- H₂S partial pressure or equivalent dissolved concentration in the water phase;
- acidity (*in situ* pH) of the water phase;
- chloride or other halide ion concentration;
- presence of oxygen, sulfur or other oxidants;
- exposure temperature;
- pitting resistance of the material in the service environment;
- galvanic effects;
- total tensile stress (applied plus residual);
- exposure time.

These factors shall be considered when using this part of ISO 15156 for the selection of materials suitable for environments containing H₂S in oil and gas production systems.

6 Qualification and selection of CRAs and other alloys with respect to SSC, SCC and GHSC in H₂S-containing environments

6.1 General

CRAs and other alloys shall be selected for their resistance to SSC, SCC and/or GHSC as required by the intended service.

Compliance of a CRA or other alloy with this part of ISO 15156 implies cracking resistance within defined environmental service limits. These limits are dependent on the material type or the individual alloy.

To enable qualification and/or selection of CRAs and other alloys, the equipment purchaser may be required to provide information on the proposed conditions of exposure to the equipment supplier.

In defining the severity of H₂S-containing environments, exposures that might occur during system upsets or shutdowns, etc. shall also be considered. Such exposures can include unbuffered, low pH, condensed water

and acids used for well stimulation. In the case of stimulation acids, conditions occurring during backflow shall be considered.

CRA and other alloys shall be selected using Annex A or following qualification by successful laboratory testing in accordance with Annex B. Qualification based on satisfactory field experience is also acceptable. Such qualification shall comply with ISO 15156-1.

In Annex A, materials are identified by materials groups. Within each group alloys are identified by materials type (within compositional limits) or as individual alloys. Acceptable metallurgical conditions and environmental limits are given, for which alloys are expected to resist cracking. Environmental limits are given for H₂S partial pressure, temperature, chloride concentration and elemental sulfur.

A CRA or other alloy may be qualified by testing for use under operating conditions that are more severe than the environmental limits given in Annex A. Similarly, a CRA or other alloy may be qualified for use in different metallurgical conditions (higher strength, alternative heat treatment, etc.) to those given in Annex A.

The documentation of qualifications performed in accordance with Annex B shall meet the requirements in Clause 9 of ISO 15156-1:2001.

The equipment user shall verify qualifications (see B.2.2) and retain documentation supporting the materials selections made.

6.2 Evaluation of materials properties

6.2.1 Hardness of parent metals

If hardness measurements on parent metal are specified, sufficient hardness tests shall be made to establish the actual hardness of the CRA or other alloy being examined. Individual HRC readings exceeding the value permitted by this part of ISO 15156 may be considered acceptable if the average of several readings taken within close proximity does not exceed the value permitted by this part of ISO 15156 and no individual reading is greater than 2 HRC above the specified value. Equivalent requirements shall apply to other methods of hardness measurement when specified in this part of ISO 15156 or referenced in a manufacturing specification.

The conversion of hardness readings to or from other scales is material-dependent; the user may establish the required conversion tables.

NOTE The number and location of hardness tests on parent metal are not specified in ISO 15156.

6.2.2 Cracking-resistance properties of welds

6.2.2.1 General

The metallurgical changes that occur when welding CRAs and other alloys can affect their susceptibility to SSC, SCC and/or GHSC. Welded joints may have a greater susceptibility to cracking than the parent material(s) joined.

The equipment user may allow the cracking susceptibility of weldments to govern the limits of safe service conditions for a fabricated system.

Processes and consumables used in welding should be selected in accordance with good practice and to achieve the required corrosion and cracking resistances.

Welding shall be carried out in compliance with appropriate codes and standards as agreed between the supplier and the purchaser. Welding procedure specifications (WPSs) and procedure qualification records (PQRs) shall be available for inspection by the equipment user.

Welding PQRs shall include documented evidence demonstrating satisfactory cracking resistance under conditions at least as severe as those of the proposed application. Such evidence shall be based upon one or more of the following:

- compliance with the requirements and recommendations for the specific materials group of Annex A (6.2.2.2 and 6.2.2.3);
- weld cracking-resistance qualification testing in accordance with Annex B;
- documented field experience, modelled upon that specified for parent materials in ISO 15156-1.

The requirements and recommendations given in Annex A may not be appropriate for all combinations of parent and weld metals used in the fabrication of equipment and components. The equipment user may require evidence of successful cracking-resistance testing, as part of the welding procedure qualification, to ensure the weldment produced provides adequate resistance to SSC, SCC and GHSC for the application.

6.2.2.2 Qualification of welding procedures in accordance with Annex A, based upon hardness

6.2.2.2.1 General

The qualification of welding procedures for sour service shall, if specified in Annex A, include hardness testing in accordance with 6.2.2.2.2, 6.2.2.2.3 and 6.2.2.2.4.

6.2.2.2.2 Hardness testing methods for welding procedure qualification

Hardness testing for welding procedure qualification shall be carried out using Vickers HV 10 or HV 5 methods in accordance with ISO 6507-1 or the Rockwell 15N method in accordance with ISO 6508-1.

The use of other methods shall require explicit user approval.

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6.2.2.2.3 Hardness surveys for welding procedure qualification

Hardness surveys for butt welds, fillet welds, and repair and partial penetration welds shall be carried out as described in 7.3.3.3 of ISO 15156-2:2003.

6.2.2.2.4 Hardness acceptance criteria for welds

Weld hardness acceptance criteria for CRAs or other alloys given in Annex A shall apply to alloys selected using Annex A.

Hardness acceptance criteria may also be established from successful cracking-resistance testing of welded samples. Testing shall be in accordance with Annex B.

6.2.2.3 Qualification of welding procedures in accordance with Annex A, by other means of testing

Where appropriate, requirements and recommendations to ensure adequate cracking-resistance of welds, using other means of testing, are provided in the materials groups of Annex A.

6.2.3 Cracking-resistance properties associated with other fabrication methods

For CRAs and other alloys that are subject to metallurgical changes caused by fabrication methods other than welding, cracking-resistance qualification testing of the material affected by fabrication shall be specified as part of the qualification of the fabrication process.

Qualification testing shall be specified as part of the qualification of burning and cutting processes if any HAZ remains in the final product.

The requirements and acceptance criteria of 6.2.2 shall apply to the qualification testing of both fabrication methods and burning/cutting processes, subject to the suitable interpretation of the hardness survey requirements of 6.2.2.2.3 for the fabrication method or burning/cutting process.

The form and location of the samples used for evaluation and testing shall be acceptable to the equipment user.

6.3 PREN

The PREN (F_{PREN}) shall be calculated as follows:

$$F_{\text{PREN}} = w_{\text{Cr}} + 3,3(w_{\text{Mo}} + 0,5w_{\text{W}}) + 16w_{\text{N}}$$

where

w_{Cr} is the mass fraction of chromium in the alloy, expressed as a percentage of the total composition;

w_{Mo} is the mass fraction of molybdenum in the alloy, expressed as a percentage of the total composition;

w_{W} is the mass fraction of tungsten in the alloy, expressed as a percentage of the total composition;

w_{N} is the mass fraction of nitrogen in the alloy, expressed as a percentage of the total composition.

NOTE There are several variations of the PREN. All were developed to reflect and predict the pitting resistance of Fe/Ni/Cr/Mo CRAs in the presence of dissolved chlorides and oxygen, e.g. in sea water. Though useful, these indices are not directly indicative of corrosion resistance in H₂S-containing oil field environments.

7 Purchasing information and marking

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7.1 Information to be supplied for material purchasing

7.1.1 The preparation of material purchasing specifications might require co-operation and exchange of data between the equipment user, the equipment supplier and the material manufacturer to ensure that the material purchased complies with ISO 15156-1 and this part of ISO 15156.

7.1.2 The following information shall be provided:

- preferred materials types and/or grades (if known);
- equipment type (if known);
- reference to this part of ISO 15156;
- acceptable bases for selection of materials for cracking resistance (see Clause 6).

7.1.3 The equipment user and the equipment supplier/material manufacturer may agree that CRAs and other alloys other than those described and or listed in Annex A may be selected subject to suitable qualification testing.

If the purchaser intends to make use of such agreements, extensions and qualifications, the appropriate additional information shall be clearly indicated in the materials purchasing specification. This information includes:

- requirements for SSC, SCC and/or GHSC testing (see Clause 6 and Annex B);
- service conditions for the specific sour service application.

7.1.4 The information required for material purchasing shall be entered on suitable data sheets. Suggested formats are given in Annex C.

7.2 Marking

Materials complying with this part of ISO 15156 shall be made traceable, preferably by marking, before delivery. Suitable labelling or documentation is also acceptable.

For materials qualified and selected for a special application in accordance with Annex B, traceability shall include reference to the environmental conditions of the special application.

The tables in Annex C provide designations that may be used to identify materials.

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