



Designation: A 554 – 03

Standard Specification for Welded Stainless Steel Mechanical Tubing¹

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This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This specification covers welded stainless steel tubing for mechanical applications where appearance, mechanical properties, or corrosion resistance is needed. The grades covered are listed in Table 1.

1.2 This specification covers as-welded or cold-reduced mechanical tubing in sizes to 16 in. (406.4 mm) outside dimension, and in wall thicknesses 0.020 in. (0.51 mm) and over.

1.3 Tubes shall be furnished in one of the following shapes as specified by the purchaser: round, square, rectangular, or special.

1.4 Supplementary requirements of an optional nature are provided and when desired shall be so stated in the order.

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

2. Referenced Documents

2.1 ASTM Standards:²

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products

E 30 Test Methods for Chemical Analysis of Steel, Cast Iron, Open-Hearth Iron, and Wrought Iron³

E 59 Practice for Sampling Steel and Iron for Determination of Chemical Composition³

2.2 Military Standards:

MIL-STD-129 Marking for Shipment and Storage⁴

MIL-STD-163 Steel Mill Products Preparation for Shipment and Storage⁴

2.3 Federal Standard:

Fed. Std. No. 123 Marking for Shipments (Civil Agencies)⁴

3. Ordering Information

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

3.1.1 Quantity (feet, mass, or number of pieces),

3.1.2 Name of material (welded stainless steel mechanical tubing),

3.1.3 Form (round, square, rectangular, special, see 1.3),

3.1.4 Dimensions:

3.1.4.1 Round-outside diameter and wall thickness for all conditions (Section 8). Alternatively, for cold-reduced condition, outside diameter and inside diameter or inside diameter and wall dimensions may be specified,

3.1.4.2 Square and rectangular outside dimensions and wall thickness (see 9.1),

3.1.4.3 Special (to be specified),

3.1.5 Length (mill lengths, cut lengths, or multiple lengths (see 8.3)),

3.1.6 Grade (Table 1),

3.1.7 Condition (see 6.1),

3.1.8 Inside diameter bead condition (see 6.2),

3.1.9 Surface finish (see Section 11),

3.1.10 Report of chemical analysis, if required (Section 7),

3.1.11 Individual supplementary requirements, if required,

3.1.12 End use,

3.1.13 Specification designation,

3.1.14 Special requirements,

3.1.15 Special marking (Section 14), and

3.1.16 Special packing (Section 15).

4. Process

4.1 The steel may be made by any process.

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

4.3 The primary melting may incorporate separate degassing or refining and may be followed by secondary melting, such as electroslag 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.

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 Tubing.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Withdrawn

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

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

TABLE 1 Chemical Requirements

Grade	Composition, %									
	Carbon, max	Manganese, max	Phosphorus, max	Sulfur, max	Silicon, max	Nickel	Chromium	Molybdenum	Titanium	Columbium + Tantalum
Austenitic										
MT-301	0.15	2.00	0.040	0.030	1.00	6.0–8.0	16.0–18.0
MT-302	0.15	2.00	0.040	0.030	1.00	8.0–10.0	17.0–19.0
MT-304	0.08	2.00	0.040	0.030	1.00	8.0–11.0	18.0–20.0
MT-304L	0.035 ^A	2.00	0.040	0.030	1.00	8.0–13.0	18.0–20.0
MT-305	0.12	2.00	0.040	0.030	1.00	10.0–13.0	17.0–19.0
MT-309S	0.08	2.00	0.040	0.030	1.00	12.0–15.0	22.0–24.0
MT-309S-Cb	0.08	2.00	0.040	0.030	1.00	12.0–15.0	22.0–24.0	^B
MT-310S	0.08	2.00	0.040	0.030	1.00	19.0–22.0	24.0–26.0
MT-316	0.08	2.00	0.040	0.030	1.00	10.0–14.0	16.0–18.0	2.0–3.0
MT-316L	0.035 ^A	2.00	0.040	0.030	1.00	10.0–15.0	16.0–18.0	2.0–3.0
MT-317	0.08	2.00	0.040	0.030	1.00	11.0–14.0	18.0–20.0	3.0–4.0
MT-321	0.08	2.00	0.040	0.030	1.00	9.0–13.0	17.0–20.0	...	^C	...
MT-330	0.15	2.00	0.040	0.030	1.00	33.0–36.0	14.0–16.0
MT-347	0.08	2.00	0.040	0.030	1.00	9.0–13.0	17.0–20.0	^B
Ferritic										
MT-429	0.12	1.00	0.040	0.030	1.00	0.50 max	14.0–16.0
MT-430	0.12	1.00	0.040	0.030	1.00	0.50 max	16.0–18.0
MT-430-Ti	0.10	1.00	0.040	0.030	1.00	0.075 max	16.0–19.5	...	5 × C min, 0.75 max	...

^A For small diameter or thin walls, or both, where many drawing passes are required, a carbon content of 0.040 % max is necessary in grades MT-304L and MT-316L. Small outside diameter tubes are defined as those less than 0.500 in. (12.7 mm) in outside diameter and light wall tubes as those less than 0.049 in. (1.24 mm) in average wall thickness.

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

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

4.4 Steel may be cast in ingots or may be strand cast. When steel of different grades are 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.

5. Materials and Manufacture

5.1 The tubes shall be made from flat-rolled steel by an automatic welding process without the addition of filler metal.

6. Condition

6.1 The tubes shall be furnished in any of the following conditions as specified:

- 6.1.1 As welded,
- 6.1.2 Welded and annealed,
- 6.1.3 Cold reduced,
- 6.1.4 Cold reduced and annealed.

6.2 The inside diameter bead shall be furnished in any of the following conditions as specified:

- 6.2.1 Bead not removed,
- 6.2.2 Bead controlled to 0.005 in. (0.13 mm) or 15 % of the specified wall thickness, whichever is greater, and
- 6.2.3 Bead removed.

7. Heat Analysis

7.1 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 requirements specified. When requested in the order or contract, a report of this analysis shall be furnished to the purchaser. (See Test Methods E 30 and Practice E 59.)

8. Permissible Variations in Dimensions—Round Tubing

8.1 For all conditions except tubing with bead removed, Table 2 shall apply.

8.2 For tubing with bead removed, Table 3 shall apply.

8.3 *Lengths*—Tubing is normally furnished in mill lengths 5 ft (1.5 m) and over. Definite cut lengths are furnished when specified, to the length tolerances shown in Table 4. For tubing ordered in multiple lengths, it is common practice to allow a definite amount over for each multiple for the purchaser's cutting operation. Thus cutting allowance should be specified in the purchase order.

8.4 *Straightness Tolerance*—The straightness tolerance shall be 0.030 in. (0.76 mm) maximum in any 3-ft (0.9-m) length of tubing. The straightness tolerance on shorter lengths and on special requirements shall be agreed upon between the purchaser and producer.

9. Permissible Variations in Dimensions—Square and Rectangular Tubing

9.1 Square and rectangular welded stainless mechanical tubing is supplied as cold worked unless otherwise specified. For this tubing, variations in dimensions from those specified shall not exceed the amounts prescribed in Table 5. For lengths, see 8.3.

10. Workmanship, Finish, and Appearance

10.1 Finished tubes shall have smooth ends free of burrs. They shall be free of injurious defects and shall have a

TABLE 2 Diameter, Wall,^A and Ovality Tolerances (All Conditions Except Tubing with Bead Removed)

NOTE 1—Ovality is the difference between maximum and minimum outside diameters measured at any one cross section. There is no additional tolerance for ovality on tubes having a specified wall thickness of more than 3 % of the outside diameter.

NOTE 2—For sizes up to and including 5-in. (127.0-mm) outside diameter, an ovality tolerance of twice the tabular outside diameter tolerance spread shown is applied one half plus and one half minus to tubes having a specified wall thickness of 3 % or less of the specified outside diameter. The average of the maximum and minimum outside diameter readings should fall within the outside diameter tolerances as shown in this table.

NOTE 3—For sizes over 5-in. (127.0-mm) to and including 16-in. (406.4-mm) outside diameter, when the specified wall thickness is 3 % or less of the outside diameter, the ovality shall not exceed 1.5 % of the specified outside diameter.

OD Size, in. (mm)	Wall Thickness		OD, ±	
	in.	mm	in.	mm
Under ½ (12.7)	0.020 to 0.049	0.51 to 1.24	0.004	0.10
½ to 1 (12.7 to 25.4)	0.020 to 0.065	0.51 to 1.65	0.005	0.13
½ to 1 (12.7 to 25.4)	over 0.065 to 0.134	over 1.65 to 3.40	0.010	0.25
Over 1 to 1 ½ (25.4 to 38.1), incl	0.025 to 0.065	0.64 to 1.65	0.008	0.20
Over 1 to 1 ½ (25.4 to 38.1), incl	over 0.065 to 0.134	over 1.65 to 3.40	0.010	0.25
Over 1 ½ to 2 (38.1 to 50.8), incl	0.025 to 0.049	0.64 to 1.24	0.010	0.25
Over 1 ½ to 2 (38.1 to 50.8), incl	over 0.049 to 0.083	over 1.24 to 2.11	0.011	0.28
Over 1 ½ to 2 (38.1 to 50.8), incl	over 0.083 to 0.149	over 2.11 to 3.78	0.012	0.30
Over 2 to 2 ½ (50.8 to 63.5), incl	0.032 to 0.065	0.81 to 1.65	0.012	0.30
Over 2 to 2 ½ (50.8 to 63.5), incl	over 0.065 to 0.109	over 1.65 to 2.77	0.013	0.33
Over 2 to 2 ½ (50.8 to 63.5), incl	over 0.109 to 0.165	over 2.77 to 4.19	0.014	0.36
Over 2 ½ to 3 ½ (63.5 to 88.9), incl	0.032 to 0.165	0.81 to 4.19	0.014	0.36
Over 2 ½ to 3 ½ (63.5 to 88.9), incl	over 0.165	over 4.19	0.020	0.51
Over 3 ½ to 5 (88.9 to 127.0), incl	0.035 to 0.165	0.89 to 4.19	0.020	0.51
Over 3 ½ to 5 (88.9 to 127.0), incl	over 0.165	over 4.19	0.025	0.64
Over 5 to 7 ½ (127.0 to 190.5), incl	0.049 to 0.250	1.24 to 6.35	0.025	0.64
Over 5 to 7 ½ (127.0 to 190.5), incl	over 0.250	over 6.35	0.030	0.76
Over 7 ½ to 16 (190.5 to 406.4), incl	all	all	0.00125 in./in. or mm/mm of circumference	

^A Wall tolerance ±10 % of specified wall thickness.

workmanlike finish. Surface imperfections such as handling marks, straightening marks, light mandrel and die marks, shallow pits, and scale patterns will not be considered as serious defects, provided the imperfections are removable within 10 % of the specified wall or 0.002 in. (0.05 mm), whichever is greater. The removal of surface imperfections is not required, unless special finishes are specified.

11. Surface Finish

11.1 Tubes shall be free of scale.

11.2 If special surface conditioning is required, they shall be stated in the order.

12. Rejection

12.1 Tubing that fails to meet the requirements of this specification shall be set aside and the manufacturer notified.

13. Coating

13.1 Stainless steel tubing is commonly shipped without protective coating. If special protection is needed, details shall be specified in the order.

TABLE 3 Diameter, Wall,^A and Ovality Tolerances for Tubing with Bead Removed

NOTE 1—Ovality is the difference between maximum and minimum outside diameters measured at any one cross section. There is no additional tolerance for ovality on tubes having a specified wall thickness of more than 3 % of the outside diameter.

NOTE 2—An ovality allowance of twice the outside diameter tolerance, shown in this table, is applied one half plus and one half minus to the outside diameter, for tubes having a specified wall thickness of 3 % or less of the specified outside diameter. The average of the maximum and minimum outside diameter readings should fall within the outside diameter tolerances of this table.

NOTE 3—Tubing may be specified to only two of the three following dimensions—outside diameter, inside diameter, or wall.

OD Size, in. (mm)	OD, ±		ID, ±	
	in.	mm	in.	mm
Up to ⅜ (2.4), excl	0.001	0.03	0.001	0.03
⅜ to ⅜ (2.4 to 4.8), excl	0.0015	0.038	0.0015	0.038
⅜ to ½ (4.8 to 12.7), excl	0.003	0.08	0.005	0.13
½ to 1 (12.7 to 25.4), excl	0.004	0.10	0.006	0.15
1 to 1 ½ (25.4 to 38.1), excl	0.005	0.13	0.007	0.18
1 ½ to 2 (38.1 to 50.8), excl	0.006	0.15	0.008	0.20
2 to 2 ½ (50.8 to 63.5), excl	0.007	0.18	0.010	0.25
2 ½ to 3 ½ (63.5 to 88.9), excl	0.010	0.25	0.014	0.36
3 ½ to 5 (88.9 to 127.0), incl	0.015	0.38	0.020	0.51
Over 5 to 16 (127.0 to 406.4), incl	0.00125 in./in. or mm/mm of circumference		0.0013 in./in. or mm/mm of circumference	

^A Wall tolerance is ±10 % of specified wall thickness.