



Standard Specification for Welded Austenitic Steel Boiler, Superheater, Heat- Exchanger, and Condenser Tubes¹

This standard is issued under the fixed designation A 249/A 249M; 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 nominal-wall-thickness welded tubes made from the austenitic steels listed in Table 1, with various grades intended for such use as boiler, superheater, heat exchanger, or condenser tubes.

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

1.3 The tubing sizes and thicknesses usually furnished to this specification are 1/8 in. [3.2 mm] in inside diameter to 5 in. [127 mm] in outside diameter and 0.015 to 0.320 in. [0.4 to 8.1 mm], inclusive, in wall thickness. Tubing having other dimensions may be furnished, provided such tubes comply with all other requirements of this specification.

1.4 Mechanical property requirements do not apply to tubing smaller than 1/8 in. [3.2 mm] in inside diameter or 0.015 in. [0.4 mm] in thickness.

1.5 Optional supplementary requirements are provided and, when one or more of these are desired, each shall be so stated in the order.

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 of this specification is specified in the order.

1.7 The following safety hazards caveat pertains only to the test method described in the Supplementary Requirements of this specification. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the*

responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use. A specific warning statement is given in Supplementary Requirement S7, Note S7.1.

2. Referenced Documents

2.1 ASTM Standards:³

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

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

A 1016/A 1016M Specification for General Requirements for Ferritic Alloy Steel, Austenitic Alloy Steel, and Stainless Steel Tubes

E 112 Test Methods for Determining Average Grain Size

E 213 Practice for Ultrasonic Examination of Metal Pipe and Tubing

E 273 Practice for Ultrasonic Examination of the Weld Zone of Welded Pipe and Tubing

E 527 Practice for Numbering Metals and Alloys (UNS)

3. Ordering Information

3.1 It is the responsibility of the purchaser to specify all requirements that are necessary for material ordered under this specification. Such requirements may include, but are not limited to, the following:

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

3.1.2 Name of material (welded tubes),

3.1.3 Grade (Table 1),

3.1.4 Size (outside diameter and nominal wall thickness),

3.1.5 Length (specific or random),

3.1.6 Optional requirements (13.6),

3.1.7 Test report required (see Certification Section of Specification A 1016/A 1016M),

3.1.8 Specification designation, and

3.1.9 Special requirements and any supplementary requirements selected.

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 Specification SA-249 in Section II of that Code.

³ 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.

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

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TABLE 1 Chemical Requirements, %^A

Grade	UNS Designation ^B	Composition, %										
		Carbon	Manganese	Phosphorous	Sulfur	Silicon	Chromium	Nickel	Molybdenum	Nitrogen ^C	Copper	Other
TP 201	S20100	0.15	5.50–7.5	0.060	0.030	1.00	16.0–18.0	3.5–5.5	...	0.25
TP 202	S20200	0.15	7.5–10.0	0.060	0.030	1.00	17.0–19.0	4.0–6.0	...	0.25
TPXM-19	S20910	0.06	4.0–6.0	0.045	0.030	1.00	20.5–23.5	11.5–13.5	1.50–3.00	0.20–0.40	...	Cb 0.10–0.30 V 0.10–0.30
TPXM-29	S24000	0.08	11.5–14.5	0.060	0.030	1.00	17.0–19.0	2.3–3.7	...	0.20–0.40
TP304	S30400	0.08	2.00	0.045	0.030	1.00	18.0–20.0	8.0–11.0
TP304L ^D	S30403	0.030	2.00	0.045	0.030	1.00	18.0–20.0	8.0–12.0
TP304H	S30409	0.04–0.10	2.00	0.045	0.030	1.00	18.0–20.0	8.0–11.0
...	S30415	0.04–0.06	0.80	0.045	0.030	1.00–2.00	18.0–19.0	9.0–10.	...	0.12–0.18	...	Ce 0.03–0.08
TP304N	S30451	0.08	2.00	0.045	0.030	1.00	18.0–20.0	8.0–11.0	...	0.10–0.16
TP304LN ^D	S30453	0.030	2.00	0.045	0.030	1.00	18.0	20.0	8.0–11.0	0.10–0.16
TP305	S30500	0.12	2.00	0.045	0.030	1.00	17.0–19.0	11.0–13.0
...	S30615	0.16–0.24	2.00	0.030	0.030	3.2–4.0	17.0–19.5	13.5–16.0
...	S30815	0.05–0.10	0.80	0.040	0.030	1.40–2.00	20.0–22.0	10.0–12.0	...	0.14–0.20	...	Ce 0.03–0.08
TP309S	S30908	0.08	2.00	0.045	0.030	1.00	22.0–24.0	12.0–15.0
TP309H	S30909	0.04–0.10	2.00	0.045	0.030	1.00	22.0–24.0	12.0–15.0

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TABLE 1 Continued

Grade	UNS Designation ^e	Composition, %										Other
		Carbon	Manganese	Phosphorous	Sulfur	Silicon	Chromium	Nickel	Molybdenum	Nitrogen ^c	Copper	
TP309Cb	S30940	0.08	2.00	0.045	0.030	1.00	22.0–24.0	12.0–16.0	Cb 10x C-1.10
TP309HCb	S30941	0.04–0.10	2.00	0.045	0.030	1.00	22.0–24.0	12.0–16.0	Cb 10x C-1.10
TP310S	S31008	0.08	2.00	0.045	0.030	1.00	24.0–26.0	19.0–22.0
TP310H	S31009	0.04–0.10	2.00	0.045	0.030	1.00	24.0–26.0	19.0–22.0
TP310Cb	S31040	0.08	2.00	0.045	0.030	1.00	14.0–26.0	18.0–22.0
TP310HCb	S31041	0.04–0.10	2.00	0.045	0.030	1.00	24.0–26.0	19.0–22.0	Cb 10x C-1.10
...	S31050	0.030	2.00	0.030	0.015	0.40	24.0–26.0	21.0–23.0	2.00–3.00	0.10–0.16
...	S31254	0.020	1.00	0.030	0.010	0.80	19.5–20.5	17.5–18.5	6.0–6.5	0.18–0.25	0.50–1.00	...
TP316	S31600	0.08	2.00	0.045	0.030	1.00	16.0–18.0	10.0–14.0	2.00–3.00
TP316L ^d	S31603	0.030	2.00	0.045	0.030	1.00	16.0–18.0	10.0–14.0	2.00–3.00
TP316H	S31609	0.04–0.10	2.00	0.045	0.030	1.00	16.0–18.0	10.0–14.0	2.00–3.00
TP316N	S31651	0.08	2.00	0.045	0.030	1.00	16.0–18.0	10.0–13.0	2.00–3.00	0.10–0.16
TP316LN ^d	S31653	0.030	2.00	0.045	0.030	1.00	16.0–18.0	10.0–13.0	2.00–3.00	0.10–0.16
TP317	S31700	0.08	2.00	0.045	0.030	1.00	18.0–20.0	11.0–15.0	3.0–4.0
TP317L	S31703	0.030	2.00	0.045	0.030	1.00	18.0–20.0	11.0–15.0	3.0–4.0

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TABLE 1 Continued

Grade	UNS Designation ^a	Composition, %										
		Carbon	Manganese	Phosphorous	Sulfur	Silicon	Chromium	Nickel	Molybdenum	Nitrogen ^c	Copper	Other
...	S31725	0.030	2.00	0.045	0.030	1.00	18.0-20.0	13.5-17.5	4.0-5.0	0.20
...	S31726	0.030	2.00	0.045	0.030	1.00	17.0-20.0	14.5-17.5	4.0-5.0	0.10-0.20
...	S32050	0.030	1.50	0.035	0.020	1.00	22.0-24.0	20.0-23.0	6.0-6.8	0.21-0.32	0.40	...
TP321	S32100	0.08	2.00	0.045	0.030	1.00	17.0-19.0	9.0-12.0	...	0.10	...	Ti 5(C+N)-0.70
TP321H	S32109	0.04-0.10	2.00	0.045	0.030	1.00	17.0-19.0	9.0-12.0	...	0.10	...	Ti 5(C+N)-0.70
...	S32654	0.020	2.0-4.0	0.030	0.005	0.50	24.0-25.0	21.0-23.0	7.0-8.0	0.45-0.55	0.30-0.60	...
...	S33228	0.04-0.08	1.00	0.020	0.015	0.30	26.0-28.0	31.0-333.0	Cb 0.60-1.00 Ce 0.05-0.10 Al0.025 Cb 0.10 Cb 10xC-1.10 Cb 8xC-1.10 (Cb+Ta) 10xC-1.10 Ta 0.10 Co 0.20 (Cb+Ta) 8xC-1.10 Ta 0.10 Co 0.20
...	S34565	0.030	5.0-7.0	0.030	0.010	1.00	23.0-25.0	16.0-18.0	4.0-5.0	0.40-0.60
TP347	S34700	0.08	2.00	0.045	0.030	1.00	17.0-19.0	9.0-12.0
TP347H	S34709	0.04-0.10	2.00	0.045	0.030	1.00	17.0-19.0	9.0-12.0
TP348	S34800	0.08	2.00	0.045	0.030	1.00	17.0-19.0	9.0-12.0
TP348H	S34809	0.04-0.10	2.00	0.045	0.030	1.00	17.0-19.0	9.0-12.0
TPXM-15	S38100	0.08	2.00	0.030	0.030	1.50-2.50	17.0-19.0	17.5-18.5
...	N08367	0.030	2.00	0.040	0.030	1.00	20.0-22.0	23.5-25.5	6.0-7.0	0.18-0.25	0.75	...
...	N08926	0.020	2.00	0.030	0.010	0.50	19.0-21.0	24.0-26.0	6.0-7.0	0.15-0.25	0.50-1.50	...
...	N08904	0.020	2.00	0.040	0.030	1.00	19.0-23.0	23.0-28.0	4.0-5.0	0.10	1.00-2.00	...

^A Maximum, unless otherwise indicated.

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

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

^D For small diameter or thin walls, or both, where many drawing passes are required, a carbon maximum of 0.040 % is necessary in Grades TP 304L and TP 316L. Small outside diameter tubes are defined as those less than 0.500 in. [12.7 mm] in outside diameter and light wall are those less than 0.049 in. [1.2 mm] in minimum wall thickness.