



Standard Specification for Wrought Austenitic Stainless Steel Piping Fittings¹

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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 wrought stainless steel fittings for pressure piping applications.²

1.2 Several grades of austenitic stainless steel alloys are included in this specification Grades are designated with a prefix, WP or CR, based on the applicable ASME or MSS dimensional and rating standards, respectively.

1.3 For each of the WP stainless grades, several classes of fittings are covered, to indicate whether seamless or welded construction was utilized. Class designations are also utilized to indicate the nondestructive test method and extent of nondestructive examination (NDE). **Table 1** is a general summary of the fitting classes applicable to all WP grades of stainless steel covered by this specification. There are no classes for the CR grades. Specific requirements are covered elsewhere.

1.4 This specification is expressed in both inch-pound units and in SI units. However, unless the order specifies the applicable “M” specification designation (SI units), the material shall be furnished to inch-pound units.

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.

1.6 This specification does not apply to cast steel fittings. Austenitic stainless steel castings are covered in Specifications A 351/A 351M, A 351/A 351MA 351/A 351M, A 743/A 743M, A 743/A 743MA 743/A 743M, and A 744/A 744M, A 744/A 744MA 744/A 744M.

2. Referenced Documents

2.1 ASTM Standards:

A 262 Practices for Detecting Susceptibility to Intergranular

TABLE 1 Fitting Classes for WP Grades

Class	Construction	Nondestructive Examination
S	Seamless	None
W	Welded	Radiography or Ultrasonic
WX	Welded	Radiography
WU	Welded	Ultrasonic

lar Attack in Austenitic Stainless Steels³

A 351/A 351M Specification for Castings, Austenitic, Austenitic-Ferritic (Duplex), for Pressure-Containing Parts⁴

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products³

A 388/A 388M Practice for Ultrasonic Examination of Heavy Steel Forgings⁵

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

A 743/A 743M Specification for Castings, Iron-Chromium, Iron-Chromium-Nickel, Corrosion-Resistant, for General Application⁴

A 744/A 744M Specification for Castings, Iron-Chromium-Nickel, Corrosion-Resistant, for Severe Service⁴

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

A 960 Specification for Common Requirements for Wrought Steel Piping Fittings⁶

E 112 Test Methods for Determining Average Grain Size⁷

E 165 Test Method for Liquid Penetrant Examination⁸

E 213 Practice for Ultrasonic Examination of Metal Pipe and Tubing⁷

2.2 ASME Standards:

ASME B16.9 Factory-Made Wrought Steel Butt-Welding Fittings⁹

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 A01.22 on Steel Forgings and Wrought Fittings for Piping Applications and Bolting Materials for Piping and Special Purpose Applications.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-403 in Section II of that Code.

³ Annual Book of ASTM Standards, Vol 01.03.

⁴ Annual Book of ASTM Standards, Vol 01.02.

⁵ Annual Book of ASTM Standards, Vol 01.05.

⁶ Annual Book of ASTM Standards, Vol 01.01.

⁷ Annual Book of ASTM Standards, Vol 03.01.

⁸ Annual Book of ASTM Standards, Vol 03.03.

⁹ Available from ASME International, Three Park Avenue, New York, NY 10016-5990.

ASME B16.11 Forged Steel Fittings, Socket-Welding and Threaded⁹

ASME B16.28 Wrought Steel Butt-Welding Short Radius Elbows and Returns⁹

2.3 *MSS Standards:*

MSS SP-25 Standard Marking System for Valves, Fittings, Flanges, and Unions¹⁰

MSS SP-43 Standard Practice for Light Weight Stainless Steel Butt-Welding Fittings¹⁰

MSS SP-79 Socket-Welding Reducer Inserts¹⁰

MSS SP-95 Swaged(d) Nipples and Bull Plugs¹⁰

2.4 *ASME Boiler and Pressure Vessel Code:*

Section VIII Division I, Pressure Vessels¹¹

Section IX, Welding Qualifications¹¹

2.5 *AWS Standards:*

A 5.4 Specification for Corrosion-Resisting Chromium and Chromium-Nickel Steel Covered Welding Electrodes¹²

A 5.9 Specification for Corrosion-Resisting Chromium and Chromium-Nickel Steel Welding Rods and Bare Electrodes¹²

2.6 *ASNT:*

SNT-TC-1A(1984) Recommended Practice for Nondestructive Testing Personnel Qualification and Certification¹³

3. Common Requirements and Ordering Information

3.1 Material furnished to this specification shall conform to the requirements of Specification A 960A 960 including any supplementary requirements that are indicated in the purchase order. Failure to comply with the common requirements of Specification A 960A 960 constitutes nonconformance with this specification. In case of conflict between this specification and Specification A 960A 960, this specification shall prevail.

3.2 Specification A 960A 960 identifies the ordering information that should be complied with when purchasing material to this specification.

4. Material

4.1 The material for fittings shall consist of forgings, bars, plates, or seamless or welded tubular products that conform to the chemical requirements in Table 2. See Table 3 for a list of common names.

4.2 The steel shall be melted by one of the following processes:

4.2.1 Electric furnace (with separate degassing and refining optional),

4.2.2 Vacuum furnace, or

4.2.3 One of the former followed by vacuum or electroslag-consumable remelting.

4.3 If secondary melting is employed, the heat shall be defined as all ingots remelted from a primary heat.

5. Manufacture

5.1 *Forming*—Forging or shaping operations may be performed by hammering, pressing, piercing, extruding, upsetting, rolling, bending, fusion welding, machining, or by a combination of two or more of these operations. The forming procedure shall be so applied that it will not produce injurious defects in the fittings.

5.2 All fittings shall be heat treated in accordance with Section 6.

5.3 Grade WP fittings ordered as Class S shall be of seamless construction and shall meet all requirements of ASME B16.9, B16.28, or MSS SP-79.

5.4 Grade WP fittings ordered as Class W shall meet the requirements of ASME B16.9 or B16.28 and:

5.4.1 Shall have all pipe welds made by mill or the fitting manufacturer with the addition of filler metal radiographically examined throughout the entire length in accordance with the Code requirements stated in 5.5, and,

5.4.2 Radiographic inspection is not required on single longitudinal seam welds made by the starting pipe manufacturer if made without the addition of filler metal; and

5.4.3 Radiographic inspection is not required on longitudinal seam fusion welds made by the fitting manufacturer when all of the following conditions have been met:

5.4.3.1 no addition of filler metal,

5.4.3.2 only one welding pass per weld seam, and,

5.4.3.3 fusion welding from one side only.

5.4.4 In place of radiographic examination, welds made by the fitting manufacturer may be ultrasonically examined in accordance with the Code requirements stated in 5.6.

5.5 Grade WP fittings ordered as Class WX shall meet the requirements of ASME B16.9 or B16.28 and shall have all welds, whether made by the fitting manufacturer or the starting material manufacturer, radiographically examined throughout their entire length in accordance with Paragraph UW-51 of Section VIII, Division I, of the ASME Boiler and Pressure Vessel Code.

5.6 Grade WP fittings ordered as Class WU shall meet the requirements of ASME B16.9 or B16.28 and shall have all welds, whether made by the fitting manufacturer or the starting material manufacturer, ultrasonically examined throughout their entire length in accordance with Appendix 12 of Section VIII, Division 1 of ASME Boiler and Pressure Vessel Code.

5.7 The radiography or ultrasonic examination of welds for this class of fittings may be done at the option of the manufacturer, either prior to or after forming.

5.8 Personnel performing NDE examinations shall be qualified in accordance with SNT-TC-1A.

5.9 Grade CR fittings shall meet the requirements of MSS SP-43 and do not require nondestructive examination.

5.10 All fittings shall have the welders, welding operators, and welding procedures qualified under the provisions of Section IX of the ASME Boiler and Pressure Vessel Code except that starting pipe welds made without the addition of filler metal do not require such qualification.

⁹ Available from Manufacturers' Standardization Society of the Valve and Fittings Industry, 127 Park St., Northeast, Vienna, VA 22180.

¹⁰ Available from ASME International, Three Park Avenue, New York, NY 10016-5990.

¹² Available from American Welding Society, 550 LeJeune Rd., P.O. Box 351040, Miami, FL 33135.

¹³ Available from American Society for Nondestructive Testing, 4153 Arlington Plaza, Columbus, OH 43228-0518.

TABLE 2 Chemical Requirements

NOTE 1—Where an ellipsis (...) appears in this table, there is no requirement.

Grade ^A			Composition, %											
Grade WP	Grade CR	UNS Designation	C ^B	Mn ^B	P ^B	S ^B	Si ^B	Ni	Cr	Mo	Ti	N ₂ C ^C	Others	
WPXM-19	CRXM-19	S20910	0.06	4.0–6.0	0.045	0.030	1.00	11.5–13.5	20.5–23.5	1.50–3.00	...	0.20–0.40	^D	
WP304	CR304	S30400	0.08	2.00	0.045	0.030	1.00	8.0–11.0	18.0–20.0	
WP304L	CR304L	S30403	0.030 ^E	2.00	0.045	0.030	1.00	8.0–12.0	18.0–20.0	
WP304H	CR304H	S30409	0.04–0.10	2.00	0.045	0.030	1.00	8.0–11.0	18.0–20.0	
WP304N	CR304N	S30451	0.08	2.00	0.045	0.030	1.00	8.0–11.0	18.0–20.0	0.10–0.16	...	
WP304LN	CR304LN	S30453	0.030	2.00	0.045	0.030	1.00	8.0–11.0	18.0–20.0	0.10–0.16	...	
WP309	CR309	S30900	0.20	2.00	0.045	0.030	1.00	12.0–15.0	22.0–24.0	
WP310S	CR310S	S31008	0.08	2.00	0.045	0.030	1.00	19.0–22.0	24.0–26.0	
WPS31254	CRS31254	S31254	0.020	1.00	0.030	0.010	0.80	17.5–18.5	19.5–20.5	6.0–6.5	...	0.18–0.22	Cu 0.50–1.00	
WP316	CR316	S31600	0.08	2.00	0.045	0.030	1.00	10.0–14.0	16.0–18.0	2.00–3.00	
WP316L	CR316L	S31603	0.030 ^E	2.00	0.045	0.030	1.00	10.0–14.0 ^F	16.0–18.0	2.00–3.00	
WP316H	CR316H	S31609	0.04–0.10	2.00	0.045	0.030	1.00	10.0–14.0	16.0–18.0	2.00–3.00	
WP316N	CR316N	S31651	0.08	2.00	0.045	0.030	1.00	10.0–13.0	16.0–18.0	2.00–3.00	...	0.10–0.16	...	
WP316LN	CR316LN	S31653	0.030	2.00	0.045	0.030	1.00	10.0–13.0	16.0–18.0	2.00–3.00	...	0.10–0.16	...	
WP317	CR317	S31700	0.08	2.00	0.045	0.030	1.00	11.0–15.0	18.0–20.0	3.0–4.0	
WP317L	CR317L	S31703	0.030	2.00	0.045	0.030	1.00	11.0–15.0	18.0–20.0	3.0–4.0	
WPS31725	CRS31725	S31725	0.030	2.00	0.045	0.030	1.00	13.5–17.5	18.0–20.0	4.0–5.0	...	0.20	...	
WPS31726	CRS31726	S31726	0.030	2.00	0.045	0.030	1.00	13.5–17.5	17.0–20.0	4.0–5.0	...	0.10–0.20	...	
WP321	CR321	S32100	0.08	2.00	0.045	0.030	1.00	9.0–12.0	17.0–19.0	...	^G	
WP321H	CR321H	S32109	0.04–0.10	2.00	0.045	0.030	1.00	9.0–12.0	17.0–19.0	...	^H	
WPS33228	CRS33228	S33228	0.04–0.08	1.00	0.020	0.015	0.30	31.0–33.0	26.0–28.0	Ce 0.05–0.10 Al 0.025 Cb 0.6–1.0	
WPS34565	CRS34565	S34565	0.030	5.0–7.0	0.030	0.010	1.00	16.0–18.0	23.0–25.0	4.0–5.0	...	0.40–0.60	Cb 0.10	
WP347	CR347	S34700	0.08	2.00	0.045	0.030	1.00	9.0–12.0	17.0–19.0	^I	
WP347H	CR347H	S34709	0.04–0.10	2.00	0.045	0.030	1.00	9.0–12.0	17.0–19.0	^J	
WP348	CR348	S34800	0.08	2.00	0.045	0.030	1.00	9.0–12.0	17.0–19.0	Cb+Ta=10×(C)–1.10 Ta 0.10 Co 0.20	
WP348H	CR348H	S34809	0.04–0.10	2.00	0.045	0.030	1.00	9.0–12.0	17.0–19.0	Cb+Ta=8×(C)–1.10 Ta 0.10 Co 0.20	

^A See Section 15 for marking requirements.

^B Maximum, unless otherwise indicated.

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

^D Columbium 0.10–0.30 %; Vanadium, 0.10–0.30 %.

^E For small diameter or thin walls, or both, where many drawing passes are required, a carbon maximum of 0.040 % is necessary in grades TP304L and TP316L. 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.

^F On pierced tubing, the nickel may be 11.0–16.0 %.

^G 5X(C+N₂)–0.70.

^H 4X(C+N₂)–0.70.

^I The columbium content shall be not less than ten times the carbon content and not more than 1.10 %.

^J The columbium content shall be not less than eight times the carbon content and not more than 1.10 %.

5.11 All joints welded with filler metal shall be finished in accordance with the requirements of Paragraph UW-35 (a) of Section VIII, Division I, of the ASME Boiler and Pressure Vessel Code.

5.12 Fittings machined from bar shall be restricted to NPS 4 or smaller. Elbows, return bends, tees, and header tees shall not be machined directly from bar stock.

5.12.1 All caps machined from bar shall be examined by liquid penetrant in accordance with Supplementary Requirement S7.

5.13 Weld buildup is permitted to dimensionally correct unfilled areas produced during cold forming of stub ends. Radiographic examination of the weld buildup shall not be required provided that all the following steps are adhered to:

5.13.1 The weld procedure and welders or welding operators meet the requirements of 5.10.

5.13.2 Annealing is performed after welding and prior to machining.

5.13.3 All weld surfaces are liquid penetrant examined in accordance with Appendix 8 of Section VIII, Division 1 of the ASME Boiler and Pressure Vessel Code.

5.13.4 Repair of areas in the weld is permitted, but 5.13.1, 5.13.2, and 5.13.3 must be repeated.

5.14 Stub ends may be produced with the entire lap added as weld metal to a straight pipe section provided the welding satisfies the requirements of 5.10 for qualifications and 6.3 post weld heat treatment.

5.14.1 *Grade WP Class W*—Radiographic inspection of the weld is required. See 5.4.

5.14.2 *Grade WP Class WX*—Radiographic inspection of all welds is required. See 5.5.

5.14.3 *Grade WP Class WU*—Ultrasonic inspection of all welds is required. See 5.6.

5.14.4 *Grade CR*—Nondestructive examination is not required. See 5.12.1.

TABLE 3 Common Names

Grade WP ^A	Grade CR ^A	UNS Designation	Type ^B
WPXM-19	CRXM-19	S20910	XM-19 ^C
WP304	CR304	S30400	304
WP304L	CR304L	S30403	304L
WP304H	CR304H	S30409	304H
WP304N	CR304N	S30451	304N
WP304LN	CR304LN	S30453	304LN
WP309	CR309	S30900	309
WP310S	CR310S	S31008	310S
WPS31254	CRS31254	S31254	...
WP316	CR316	S31600	316
WP316L	CR316L	S31603	316L
WP316H	CR316H	S31609	316H
WP316N	CR316N	S31651	316N
WP316LN	CR316LN	S31653	316LN
WP317	CR317	S31700	317
WP317L	CR317L	S31703	317L
WPS31725	CRS31725	S31725	317LM ^C
WPS31726	CRS31726	S31726	317LMN ^C
WP321	CR321	S32100	321
WP321H	CR321H	S32109	321H
WPS33228	CRS33228	S33228	...
WPS34565	CRS34565	S34565	...
WP347	CR347	S34700	347
WP347H	CR347H	S34709	347H
WP348	CR348	S34800	348
WP348H	CR348H	S34809	348H

^ANaming system developed and applied by ASTM.

^BUnless otherwise indicated, a grade designation originally assigned by the American Iron and Steel Institute (AISI).

^CCommon name, not a trademark widely used, not associated with any one producer.

5.15 Stub ends may be produced with the entire lap added by the welding of a ring, made from plate or bar of the same alloy grade and composition, to the outside of a straight section of pipe, provided the weld is double welded, is a full penetration joint, satisfies the requirements of 5.10 for qualifications and 6.2 for post weld heat treatment.

5.15.1 *Class WP-W*—Radiographic inspection of the welds, made with the addition of filler metal, is required (see 5.4).

5.15.2 *Class WP-WX*— Radiographic inspection of all welds, made with or without the addition of filler metal, is required (see 5.5).

5.15.3 *Class WP-WU*— Ultrasonic inspection of all welds, made with or without the addition of filler metal, is required (see 5.6).

5.15.4 Class CR nondestructive examination is not required (see 5.9).

5.16 After final heat treatment, all “H-Grade” steel fittings shall have a grain size of 7 or coarser in accordance with Test Methods E 112E 112.

6. Heat Treatment

6.1 All fittings shall be furnished in the heat-treated condition. The heat-treat procedure shall consist of solution annealing the fittings at the temperatures specified in Table 4 until the chromium carbides go into solution, and then cooling at a sufficient rate to prevent reprecipitation.

6.2 A solution annealing temperature above 1950°F [1065°C] may impair the resistance to intergranular corrosion after subsequent exposure to sensitizing conditions in 321, 321H, 347, and 347H. When specified by the purchaser, a lower temperature stabilization or resolution anneal shall be

TABLE 4 Heat Treatment

Grade	Solution Annealing Temperature, °F [°C], min, Unless Range Specified
All except those listed below	1900 [1040]
348H	1925 [1050]
S31254	2100 [1150]
S33228	2050 [1120]
S34565	2050-2140 [1120-1170]
321, 347	1900-2100 [1040-1150]
321H, 347H	1925-2100 [1050-1150]

used subsequent to the initial high-temperature solution anneal (see Supplementary Requirement S10).

6.3 All welding shall be done prior to heat treatment.

6.4 Fittings machined directly from solution-annealed forgings and bar stock need not be resolution annealed.

7. Chemical Composition

7.1 The chemical composition of each cast or heat used shall be determined and shall conform to the requirements of the chemical composition for the respective grades of materials listed in Table 2. The ranges as shown have been expanded to include variations of the chemical analysis requirements that are listed in the various specifications for starting materials (pipe, tube, plate, bar, and forgings) normally used in the manufacturing of fittings to this specification. Methods and practices relating to chemical analyses required by this specification shall be in accordance with Test Methods, Practices, and Terminology A 751A 751. Product analysis tolerances in accordance with Specification A 480/A 480M A 480/A 480M are applicable.

7.2 The steel shall not contain any unspecified elements for the ordered grade to the extent that it conforms to the requirements of another grade for which that element is a specified element having a required minimum content.

7.3 In fittings of welded construction, the alloy content (carbon, chromium, nickel, molybdenum, columbium, and tantalum) of the deposited weld metal shall conform to that required of the base metal or for equivalent weld metal as given in the AWS filler metal specification A 5.4 or A 5.9 (Type 348 weld metal is listed in AWS A 5.9 but not in AWS A 5.4). Exceptions are when welding on Types 304L and 304 base metals, the deposited weld metal shall correspond, respectively, to AWS E308L(ER308L) and E308 (ER308), when welding on Type 321 base metal, the weld metal shall correspond to AWS Type E347 (ER347 or ER321); and, when welding on S31725, S31726, S31254 or S33228 osited weld metal shall correspond either to the alloy content of the base metal or to AWS A5.11 E NiCrMo-3 (UNS W86112) (AWS A5.14 Ni Cr Mo-3 (UNS N06625)).

7.3.1 Supplementary Requirement S8 may be specified where 16-8-2 filler metal is required for joining thick sections of Types 316, 321, or 347 and has adequate corrosion resistance for the intended service.

8. Tensile Properties

8.1 The tensile properties of the fitting material shall conform to the requirements of Table 5. The testing and reporting