



Designation: B 546 – 04

Standard Specification for Electric Fusion-Welded Ni-Cr-Co-Mo Alloy (UNS N06617), Ni-Fe-Cr-Si Alloys (UNS N08330 and UNS N08332), Ni-Cr- Fe-Al Alloy (UNS N06603), Ni-Cr-Fe Alloy (UNS N06025), and Ni-Cr-Fe-Si Alloy (UNS N06045) Pipe¹

This standard is issued under the fixed designation B 546; 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.

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

1. Scope

1.1 This specification covers electric fusion-welded nickel-chromium-cobalt-molybdenum alloy UNS N06617, nickel-iron-chromium-silicon alloys UNS N08330 and UNS N08332, Ni-Cr-Fe-Al Alloy (UNS N06603), Ni-Cr-Fe Alloy UNS N06025, and Ni-Cr-Fe-Si Alloy UNS N06045 pipe intended for heat resisting applications and general corrosive service.

1.2 This specification covers pipe in sizes 3 in. (76.2 mm) nominal diameter and larger and possessing a minimum wall thickness of 0.083 in. (2.11 mm).

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

1.4 *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 become familiar with all hazards including those identified in the appropriate Material Safety Data Sheet for this product/material as provided by the manufacturer, to establish appropriate safety and health practices, and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

B 168 Specification for Nickel-Chromium-Iron Alloys (UNS N06600, N06601, N06603, N06690, N06693, N06025, and N06045) and Nickel-Chromium-Cobalt-Molybdenum Alloy (UNS N06617) Plate, Sheet, and Strip

B 536 Specification for Nickel-Iron-Chromium-Silicon Alloys (UNS N08330 and N08332) Plate, Sheet, and Strip

B 775 Specification for General Requirements for Nickel and Nickel Alloy Welded Pipe

B 899 Terminology Relating to Non-ferrous Metals and Alloys

E 10 Test Method for Brinell Hardness of Metallic Materials

E 140 Hardness Conversion Tables for Metals (Relationship Between Brinell Hardness, Vickers Hardness, Rockwell Hardness, Rockwell Superficial Hardness, and Knoop Hardness)

E 1473 Test Methods for Chemical Analysis of Nickel, Cobalt, and High-Temperature Alloys

2.2 ASME Standards:

Boiler and Pressure Vessel Code, Section VIII, Paragraph UW-51³

Boiler and Pressure Vessel Code, Section IX³

3. Terminology

3.1 Definitions:

3.1.1 Definitions for terms defined in Terminology **B 899** shall apply unless otherwise defined by the requirements of this document.

4. General Requirement

4.1 Material furnished in accordance with this specification shall conform to the applicable requirements of the current edition of Specification **B 775** unless otherwise provided herein.

5. Classification

5.1 Two classes of pipe are covered as follows:

5.1.1 *Class 1*—All welded joints to be 100 % inspected by radiography.

³ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990.

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.07 on Refined Nickel and Cobalt and Their Alloys.

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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.

5.1.2 *Class 2*—No radiographic examination is required.

6. Ordering Information

6.1 It is the responsibility of the purchaser to specify all requirements that are necessary for the safe and satisfactory performance of material ordered under this specification. Examples of such requirements include, but are not limited to, the following:

- 6.1.1 Alloy (**Table 1**),
- 6.1.2 ASTM designation and year of issue,
- 6.1.3 Class (See **5.1**),
- 6.1.4 Dimensions (standard pipe size and schedule),
- 6.1.5 Length (specific or random),
- 6.1.6 Quantity (feet or number of pieces),
- 6.1.7 Certification—State if certification is required,
- 6.1.8 Whether type of filler metal and deposited composition is required (see **8.3**),
- 6.1.9 *Samples for Product (Check) Analysis*—State whether samples for product (check) analysis should be furnished, and
- 6.1.10 Purchaser Inspection—If purchaser wishes to witness tests or inspection of material at place of manufacture, the purchase order must so state indicating which tests or inspections are to be witnessed.

7. Materials and Manufacture

7.1 *Materials*—The UNS N08330 and UNS N08332 alloy plate material shall conform to the requirements of Specification **B 536**. The UNS N06617, UNS N06603, UNS N06025, and UNS N06045 alloy plate material shall conform to the requirements of Specification **B 168**.

7.2 Welding:

7.2.1 The joints shall be double-welded, full-penetration welds made by qualified operators in accordance with procedures in the ASME **Boiler and Pressure Vessel Code, Section IX**.

7.2.2 The weld shall be made either manually or automatically by an electric process involving the deposition of filler metal.

7.2.3 The joint shall be reinforced at the center of the weld on each side of the formed plate by a weld bead at least $\frac{1}{16}$ in. (1.6 mm) but not more than $\frac{1}{8}$ in. (3.2 mm). This reinforcement (weld bead) may be removed at the manufacturer's option or by agreement between the manufacturer and the purchaser. The contour of the reinforcement (weld bead) shall be smooth, with no valley or groove along the edge or in the center of the weld, and the deposited metal shall be fused smoothly and uniformly into the formed-plate surface. The finish of the welded joint shall be reasonably smooth and free of irregularities, grooves, or depressions.

7.2.4 Weld defects shall be repaired by removal to sound metal and rewelding. Subsequent heat treatment and inspection shall be as required on the original welds.

7.3 *Heat Treatment*—All pipe shall be furnished in the annealed condition.

7.4 *Surface Finish*—The pipe shall be free from scale. When bright annealing is used, descaling is not necessary.

8. Chemical Composition

8.1 The material shall conform to the composition limits specified in **Table 1**. One test is required for each lot as defined in Specification **B 775**.

8.2 If a product analysis is performed, it shall meet the chemistry limits prescribed in **Table 1**, subject to the analysis tolerances specified in **Table 1** of Specification **B 775**.

8.3 The chromium and nickel content of the deposited weld metal shall conform to the minimum chromium and nickel contents required for the base metal. Note that the composition of the deposited weld metal may not be the same as the base metal. The user should establish suitability for his particular application. When specified in the purchase order (see section **6.1.8**), the manufacturer shall report the type of filler metal used along with a chemical analysis of the deposited weld metal.

9. Mechanical and Other Requirements

9.1 Tensile Properties:

TABLE 1 Chemical Requirements

Element	Composition Limits, %					
	N08330	N08332	N06603	N06617	N06025	N06045
Carbon	0.08 max	0.05–0.10	0.20–0.40	0.05–0.15	0.15–0.25	0.05–0.12
Manganese	2.00 max	2.00 max	0.15 max	1.0 max	0.15 max	1.0 max
Phosphorus	0.03 max	0.03 max	0.20 max	...	0.02 max	0.02 max
Sulfur	0.03 max	0.03 max	0.10 max	0.015 max	0.010 max	0.010 max
Silicon	0.75 to 1.50	0.75 to 1.50	0.50 max	1.0 max	0.5 max	2.5–3.0
Chromium	17.0 to 20.0	17.0 to 20.0	0.24–0.26	20.0–24.0	24.0–26.0	26.0–29.0
Nickel	34.0 to 37.0	34.0 to 37.0	Bal	remainder	Bal	45.0 min
Copper	1.00 max	1.00 max	0.50 max	0.5 max	0.1 max	0.3 max
Lead	0.005 max	0.005 max
Tin	0.025 max	0.025 max
Iron	remainder ^A	remainder	8.0–11.0	3.0 max	8.0–11.0	21.0–25.0
Aluminum	2.4–3.0	0.8–1.5	1.8–2.4	...
Cobalt	10.0–15.0
Molybdenum	8.0–10.0
Zirconium	0.01–0.10	...	0.01–0.10	...
Yttrium	0.01–0.15	...	0.05–0.12	...
Cerium	0.3–0.09
Titanium	0.010–0.025

^A Element shall be determined arithmetically by difference.