



Designation: A 595 – 04

Standard Specification for Steel Tubes, Low-Carbon or High-Strength Low-Alloy, Tapered for Structural Use¹

This standard is issued under the fixed designation A 595; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope*

1.1 This specification covers three grades of seam-welded, round, tapered steel tubes for structural use. Grades A and B are of low-carbon steel or high-strength low-alloy steel composition and Grade C is of weather-resistant steel composition.

1.2 This tubing is produced in welded sizes in a range of diameters from 2 $\frac{3}{8}$ to 30 in. (63.5 to 762.0 mm) inclusive. Wall thicknesses range from 0.1046 to 0.375 in. (2.66 to 9.53 mm). Tapers are subject to agreement with the manufacturer.

1.3 The values stated in inch-pound units are to be regarded as the standard.

2. Referenced Documents

2.1 ASTM Standards:²

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

A 588/A 588M Specification for High-Strength Low-Alloy Structural Steel with 50 ksi [345 MPa] Minimum Yield Point to 4-in. [100-mm] Thick

A 606 Specification for Steel, Sheet and Strip, High-Strength, Low-Alloy, Hot-Rolled and Cold-Rolled, with Improved Atmospheric Corrosion Resistance

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

G 101 Guide for Estimating the Atmospheric Corrosion Resistance of Low-Alloy Steels

3. Ordering Information

3.1 The inquiry and order should indicate the following:

3.1.1 Large and small diameters (in.), length (ft), wall thickness (in.), and taper (in./ft);

3.1.2 (see Table 1 and Table 2);

3.1.3 Extra test material requirements, if any; and

3.1.4 Supplementary requirements, if any.

4. General Requirements for Delivery

4.1 Required date of shipment or date of receipt, and

4.2 Special shipping instructions, if any.

5. Manufacture

5.1 Tube steel shall be hot-rolled aluminum-semikilled or fine-grained killed sheet or plate manufactured by one or more of the following processes: open-hearth, basic-oxygen, or electric-furnace.

5.2 Tubes shall be made from trapezoidal sheet or plate that is preformed and then seam welded. Tubes shall be brought to final size and properties by roll compressing cold on a hardened mandrel.

6. Chemical Composition

6.1 Steel shall conform to the requirements for chemical composition as prescribed in Table 1 and chemical analysis shall be in accordance with Test Methods, Practices, and Terminology A 751.

6.2 For Grade C material, the atmospheric corrosion-resistance index, calculated on the basis of the chemical composition of the steel, as described in Guide G 101, shall be 6.0 or higher.

NOTE 1—The user is cautioned that the Guide G 101 predictive equation for calculation of an atmospheric corrosion-resistance index has been verified only for the composition limits stated in that guide.

6.3 When required by the purchase order, the manufacturer shall supply guidance concerning corrosion resistance that is satisfactory to the purchaser.

7. Mechanical Properties

7.1 Tension Test:

7.1.1 *Requirements*—The material as represented by the test specimens shall conform to the requirements as to tensile properties as prescribed in Table 2.

7.1.2 Number of Tests:

7.1.2.1 For coil—One or more tension tests as defined in Table 2 shall be made from the large end of one tube produced from each coil when the trapezoidal sheets are made from coil.

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 A01.09 on Carbon Steel Tubular Products.

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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.

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