



Designation: A 333/A 333M – 04a

Standard Specification for Seamless and Welded Steel Pipe for Low-Temperature Service¹

This standard is issued under the fixed designation A 333/A 333M; 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.

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

1. Scope*

1.1 This specification² covers nominal (average) wall seamless and welded carbon and alloy steel pipe intended for use at low temperatures. Several grades of ferritic steel are included as listed in **Table 1**. Some product sizes may not be available under this specification because heavier wall thicknesses have an adverse affect on low-temperature impact properties.

1.2 Supplementary Requirement S1 of an optional nature is provided. This shall apply only when specified by the purchaser.

1.3 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.

NOTE 1—The dimensionless designator NPS (nominal pipe size) has been substituted in this standard for such traditional terms as “nominal diameter,” “size,” and “nominal size.”

2. Referenced Documents

2.1 ASTM Standards:³

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

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-333 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 999/A 999M Specification for General Requirements for Alloy and Stainless Steel Pipe

A 671 Specification for Electric-Fusion-Welded Steel Pipe for Atmospheric and Lower Temperatures

E 23 Test Methods for Notched Bar Impact Testing of Metallic Materials

3. Ordering Information

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

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

3.1.2 Name of material (seamless or welded pipe),

3.1.3 Grade (**Table 1**),

3.1.4 Size (NPS or outside diameter and schedule number of average wall thickness),

3.1.5 Lengths (specific or random) (Section 9), (see the Permissible Variations in Length section of Specification A 999/A 999M **A 999/A 999M**),

3.1.6 End finish (see the Ends section of Specification A 999/A 999M **A 999/A 999M**),

3.1.7 Optional requirements, (see the Heat Analysis requirement in the Chemical Composition section of A 999/A 999M **A 999/A 999M**, the Repair by Welding section, and the section on Nondestructive Test Requirements),

3.1.8 Test report required, (see the Certification section of Specification A 999/A 999M **A 999/A 999M**),

3.1.9 Specification designation, and

3.1.10 Special requirements or exceptions to this specification.

4. Materials and Manufacture

4.1 *Manufacture*—The pipe shall be made by the seamless or welding process with the addition of no filler metal in the welding operation. Grade 4 shall be made by the seamless process.

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

TABLE 1 Chemical Requirements

Element	Composition, %								
	Grade 1 ^A	Grade 3	Grade 4	Grade 6 ^A	Grade 7	Grade 8	Grade 9	Grade 10	Grade 11
Carbon, max	0.30	0.19	0.12	0.30	0.19	0.13	0.20	0.20	0.10
Manganese	0.40–1.06	0.31–0.64	0.50–1.05	0.29–1.06	0.90 max	0.90 max	0.40–1.06	1.15–1.50	0.60 max
Phosphorus, max	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.035	0.025
Sulfur, max	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.015	0.025
Silicon	...	0.18–0.37	0.08–0.37	0.10 min	0.13–0.32	0.13–0.32	...	0.10–0.35	0.35 max
Nickel	...	3.18–3.82	0.47–0.98	...	2.03–2.57	8.40–9.60	1.60–2.24	0.25 max	35.0–37.0
Chromium	0.44–1.01	0.15 max	0.50 max
Copper	0.40–0.75	0.75–1.25	0.15 max	...
Aluminum	0.04–0.30	0.06 max	...
Vanadium, max	0.12	...
Columbium, max	0.05	...
Molybdenum, max	0.05	0.50 max
Cobalt	0.50 max

^A For each reduction of 0.01 % carbon below 0.30 %, an increase of 0.05 % manganese above 1.06 % would be permitted to a maximum of 1.35 % manganese.

NOTE 2—For electric-fusion-welded pipe, with filler metal added, see Specification A 671A 671.

4.2 Heat Treatment:

4.2.1 All seamless and welded pipe, other than Grades 8 and 11, shall be treated to control their microstructure in accordance with one of the following methods:

4.2.1.1 Normalize by heating to a uniform temperature of not less than 1500°F [815°C] and cool in air or in the cooling chamber of an atmosphere controlled furnace.

4.2.1.2 Normalize as in 4.2.1.1, and, at the discretion of the manufacturer, reheat to a suitable tempering temperature.

4.2.1.3 For the seamless process only, reheat and control hot working and the temperature of the hot-finishing operation to a finishing temperature range from 1550 to 1750°F [845 to 945°C] and cool in air or in a controlled atmosphere furnace from an initial temperature of not less than 1550°F [845°C].

4.2.1.4 Treat as in 4.2.1.3 and, at the discretion of the manufacturer, reheat to a suitable tempering temperature.

4.2.1.5 Seamless pipe of Grades 1, 6, and 10 may be heat treated by heating to a uniform temperature of not less than 1500°F [815°C], followed by quenching in liquid and reheating to a suitable tempering temperature, in place of any of the other heat treatments provided for in 4.2.1.

4.2.2 Grade 8 pipe shall be heat treated by the manufacturer by either of the following methods:

4.2.2.1 *Quenched and Tempered*—Heat to a uniform temperature of 1475 ± 25°F [800 ± 15°C]; hold at this temperature for a minimum time in the ratio of 1 h/in. [2 min/mm] of thickness, but in no case less than 15 min; quench by immersion in circulating water. Reheat until the pipe attains a uniform temperature within the range from 1050 to 1125°F [565 to 605°C]; hold at this temperature for a minimum time in the ratio of 1 h/in. [2 min/mm] of thickness, but in no case less than 15 min; cool in air or water quench at a rate not less than 300°F [165°C]/h.

4.2.2.2 *Double Normalized and Tempered*—Heat to a uniform temperature of 1650 ± 25°F [900 ± 15°C]; hold at this temperature for a minimum time in the ratio of 1 h/in. [2 min/mm] of thickness, but in no case less than 15 min; cool in air. Reheat until the pipe attains a uniform temperature of 1450 ± 25°F [790 ± 15°C]; hold at this temperature for a minimum time in the ratio of 1 h/in. [2 min/mm] of thickness, but in no case less than 15 min; cool in air. Reheat to a uniform

temperature within the range from 1050 to 1125°F [565 to 605°C]; hold at this temperature for a minimum time of 1 h/in. [2 min/mm] of thickness but in no case less than 15 min; cool in air or water quench at a rate not less than 300°F [165°C]/h.

4.2.3 Whether to anneal Grade 11 pipe is per agreement between purchaser and supplier. When Grade 11 pipe is annealed, it shall be normalized in the range of 1400 to 1600°F [760 to 870°C].

4.2.4 Material from which test specimens are obtained shall be in the same condition of heat treatment as the pipe furnished. Material from which specimens are to be taken shall be heat treated prior to preparation of the specimens.

4.2.5 When specified in the order the test specimens shall be taken from full thickness test pieces which have been stress relieved after having been removed from the heat-treated pipe. The test pieces shall be gradually and uniformly heated to the prescribed temperature, held at that temperature for a period of time in accordance with Table 2, and then furnace cooled at a temperature not exceeding 600°F [315°C]. Grade 8 shall be cooled at a minimum rate of 300°F [165°C]/h in air or water to a temperature not exceeding 600°F [315°C].

5. Chemical Composition

5.1 The steel shall conform to the requirements as to chemical composition prescribed in Table 1.

5.2 When Grades 1, 6, or 10 are ordered under this specification, supplying an alloy grade that specifically requires the addition of any element other than those listed for

TABLE 2 Stress Relieving of Test Pieces

Metal Temperature ^{A,B}				Minimum Holding Time, h/in. [min/mm] of Thickness
Grades 1, 3, 6, 7, and 10		Grade 4 ^C		
°F	°C	°F	°C	
1100	600	1150	620	1 [2.4]
1050	565	1100	600	2 [4.7]
1000	540	1050	565	3 [7.1]

^A For intermediate temperatures, the holding time shall be determined by straight-line interpolation.

^B Grade 8 shall be stress relieved at 1025 to 1085°F, [550 to 585°C], held for a minimum time of 2 h for thickness up to 1.0 in. [25.4 mm], plus a minimum of 1 h for each additional inch [25.4 mm] of thickness and cooled at a minimum rate of 300°F [165°C]/h in air or water to a temperature not exceeding 600°F [315°C].

^C Unless otherwise specified, Grade 4 shall be stress relieved at 1150°F [620°C].

the ordered grade in [Table 1](#) is not permitted. However, the addition of elements required for the deoxidation of the steel is permitted.

6. Product Analysis

6.1 At the request of the purchaser, an analysis of one billet or two samples of flat-rolled stock from each heat or of two pipes from each lot shall be made by the manufacturer. A lot of pipe shall consist of the following:

NPS Designator	Length of Pipe in Lot
Under 2	400 or fraction thereof
2 to 6	200 or fraction thereof
Over 6	100 or fraction thereof

6.2 The results of these analyses shall be reported to the purchaser or the purchaser's representative and shall conform to the requirements specified.

6.3 If the analysis of one of the tests specified in [6.1](#) does not conform to the requirements specified, an analysis of each billet or pipe from the same heat or lot may be made, and all billets or pipe conforming to the requirements shall be accepted.

7. Tensile Requirements

7.1 The material shall conform to the requirements as to tensile properties prescribed in [Table 3](#).

8. Impact Requirements

8.1 For Grades 1, 3, 4, 6, 7, 9, and 10, the notched-bar impact properties of each set of three impact specimens, including specimens for the welded joint in welded pipe with wall thicknesses of 0.120 in. [3 mm] and larger, when tested at temperatures in conformance with [14.1](#) shall be not less than the values prescribed in [Table 4](#). The impact test is not required for Grade 11.

8.1.1 If the impact value of one specimen is below the minimum value, or the impact values of two specimens are less than the minimum average value but not below the minimum value permitted on a single specimen, a retest shall be allowed. The retest shall consist of breaking three additional specimens and each specimen must equal or exceed the required average value. When an erratic result is caused by a defective specimen, or there is uncertainty in test procedures, a retest will be allowed.

8.2 For Grade 8 each of the notched bar impact specimens shall display a lateral expansion opposite the notch of not less than 0.015 in. [0.38 mm].

8.2.1 When the average lateral expansion value for the three impact specimens equals or exceeds 0.015 in. [0.38 mm] and the value for one specimen is below 0.015 in. [0.38 mm] but not below 0.010 in. [0.25 mm], a retest of three additional specimens may be made. The lateral expansion of each of the retest specimens must equal or exceed 0.015 in. [0.38 mm].

8.2.2 Lateral expansion values shall be determined by the procedure in Test Methods and Definitions [A 370A 370](#).

8.2.3 The values of absorbed energy in foot-pounds and the fracture appearance in percentage shear shall be recorded for information. A record of these values shall be retained for a period of at least 2 years.

9. Lengths

9.1 If definite lengths are not required, pipe may be ordered in single random lengths of 16 to 22 ft ([Note 3](#)) with 5 % 12 to 16 ft ([Note 3](#)), or in double random lengths with a minimum average of 35 ft ([Note 3](#)) and a minimum length of 22 ft ([Note 3](#)) with 5 % 16 to 22 ft ([Note 3](#)).

NOTE 3—This value(s) applies when the inch-pound designation of this specification is the basis of purchase. When the "M" designation of this specification is the basis of purchase, the corresponding metric value(s) shall be agreed upon between the manufacturer and purchaser.

10. Workmanship, Finish and Appearance

10.1 The pipe manufacturer shall explore a sufficient number of visual surface imperfections to provide reasonable assurance that they have been properly evaluated with respect to depth. Exploration of all surface imperfections is not required but may be necessary to ensure compliance with [10.2](#).

10.2 Surface imperfections that penetrate more than 1½ % of the nominal wall thickness or encroach on the minimum wall thickness shall be considered defects. Pipe with such defects shall be given one of the following dispositions:

10.2.1 The defect may be removed by grinding provided that the remaining wall thickness is within specified limits.

10.2.2 Repaired in accordance with the repair welding provisions of [10.5](#).

10.2.3 The section of pipe containing the defect may be cut off within the limits of requirements on length.

10.2.4 The defective pipe may be rejected.

10.3 To provide a workmanlike finish and basis for evaluating conformance with [10.2](#), the pipe manufacturer shall remove by grinding the following:

10.3.1 Mechanical marks, abrasions and pits, any of which imperfections are deeper than ¼ in. [1.6 mm], and

10.3.2 Visual imperfections commonly referred to as scabs, seams, laps, tears, or slivers found by exploration in accordance with [10.1](#) to be deeper than 5 % of the nominal wall thickness.

10.4 At the purchaser's discretion, pipe shall be subject to rejection if surface imperfections acceptable under [10.2](#) are not scattered, but appear over a large area in excess of what is considered a workmanlike finish. Disposition of such pipe shall be a matter of agreement between the manufacturer and the purchaser.

10.5 When imperfections or defects are removed by grinding, a smooth curved surface shall be maintained, and the wall thickness shall not be decreased below that permitted by this specification. The outside diameter at the point of grinding may be reduced by the amount so removed.

10.5.1 Wall thickness measurements shall be made with a mechanical caliper or with a properly calibrated nondestructive testing device of appropriate accuracy. In case of dispute, the measurement determined by use of the mechanical caliper shall govern.

10.6 Weld repair shall be permitted only subject to the approval of the purchaser and in accordance with Specification [A 999/A 999M](#) [A 999/A 999M](#).

10.7 The finished pipe shall be reasonably straight.