



Designation: B 366 – 04b

Standard Specification for Factory-Made Wrought Nickel and Nickel Alloy Fittings¹

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1. Scope*

1.1 This specification covers wrought welding fittings for pressure piping, factory-made from nickel and nickel alloys. Threaded fittings as covered in ASME B16.11 are also covered by this specification. The term welding applies to butt-welding or socket-welding parts such as 45 and 90° elbows, 180° bends, caps, tees, reducers, lap-joint stub ends, and other types, as covered by ASME B16.9, ASME B16.11, MSS SP-43, MSS SP-95, and MSS SP-97.

1.1.1 Several grades of nickel and nickel 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.

1.1.2 Class WP fittings are those manufactured to the requirements of ASME B16.9, B16.11.

1.1.3 For each of the WP nickel and nickel alloy 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 general summary of the fitting classes applicable to all WP grades of nickel and nickel alloys covered by this specification. There are no classes for the CR grades. Specific requirements are covered elsewhere.

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 |

1.2 This specification does not apply to cast welding fittings.

1.3 Optional supplementary requirements are provided for fittings where a greater degree of examination is desired. These supplementary requirements call for additional tests. When desired, one or more of these may be specified in the order.

¹This 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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1.4 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.5 *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 127 Specification for Nickel-Copper Alloy (UNS N04400) Plate, Sheet, and Strip
- B 160 Specification for Nickel Rod and Bar
- B 161 Specification for Nickel Seamless Pipe and Tube
- B 162 Specification for Nickel Plate, Sheet, and Strip
- B 163 Specification for Seamless Nickel and Nickel Alloy Condenser and Heat-Exchanger Tubes
- B 164 Specification for Nickel-Copper Alloy Rod, Bar, and Wire
- B 165 Specification for Nickel-Copper Alloy (UNS N04400) Seamless Pipe and Tube
- B 166 Specification for Nickel-Chromium-Iron Alloys (UNS N06600, N06601, N06603, N06690, N06025, and N06045) and Nickel-Chromium-Cobalt-Molybdenum Alloy (UNS N06617) Rod, Bar, and Wire
- B 167 Specification for Nickel-Chromium-Iron Alloys (UNS N06600, N06601, N06603, N06690, N06693, N06025, and N06045) and Nickel-Chromium-Cobalt-Molybdenum Alloy (UNS N06617) Seamless Pipe and Tube
- 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 333 Specification for Nickel-Molybdenum Alloy Plate, Sheet, and Strip

²For 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.

- B 335 Specification for Nickel-Molybdenum Alloy Rod
- B 407 Specification for Nickel-Iron-Chromium Alloy Seamless Pipe and Tube
- B 408 Specification for Nickel-Iron-Chromium Alloy Rod and Bar
- B 409 Specification for Nickel-Iron-Chromium Alloy Plate, Sheet, and Strip
- B 423 Specification for Nickel-Iron-Chromium-Molybdenum-Copper Alloy (UNS N08825 and N08221) Seamless Pipe and Tube
- B 424 Specification for Ni-Fe-Cr-Mo-Cu Alloy (UNS N08825 and UNS N08221) Plate, Sheet, and Strip
- B 425 Specification for Ni-Fe-Cr-Mo-Cu Alloy (UNS N08825 and UNS N08221) Rod and Bar
- B 434 Specification for Nickel-Molybdenum-Chromium-Iron Alloys (UNS N10003, UNS N10242) Plate, Sheet, and Strip
- B 435 Specification for UNS N06002, UNS N06230, UNS N12160, and UNS R30556 Plate, Sheet, and Strip
- B 443 Specification for Nickel-Chromium-Molybdenum-Columbium Alloy (UNS N06625) and Nickel-Chromium-Molybdenum-Silicon Alloy (UNS N06219) Plate, Sheet, and Strip
- B 444 Specification for Nickel-Chromium-Molybdenum-Columbium Alloy (UNS N06625) and Nickel-Chromium-Molybdenum-Silicon Alloy (UNS N06219) Pipe and Tube
- B 446 Specification for Nickel-Chromium-Molybdenum-Columbium Alloy (UNS N06625), Nickel-Chromium-Molybdenum-Silicon Alloy (UNS N06219), and Nickel-Chromium-Molybdenum-Tungsten Alloy (UNS N06650) Rod and Bar
- B 462 Specification for Forged or Rolled UNS N06030, UNS N06022, UNS N06035, UNS N06200, UNS N06059, UNS N06686, UNS N08020, UNS N08024, UNS N08026, UNS N08367, UNS N10276, UNS N10665, UNS N10675, UNS N10629, UNS N08031, UNS N06045, UNS N06025, and UNS R20033 Alloy Pipe Flanges, Forged Fittings, and Valves and Parts for Corrosive High-Temperature Service
- B 463 Specification for UNS N08020, UNS N08026, and UNS N08024 Alloy Plate, Sheet, and Strip
- B 464 Specification for Welded UNS N08020, N08024, and N08026 Alloy Pipe
- B 468 Specification for Welded UNS N08020, N08024, and N08026 Alloy Tubes
- B 472 Specification for Nickel Alloy Billets and Bars for Reforging
- B 473 Specification for UNS N08020, UNS N08024, and UNS N08026 Nickel Alloy Bar and Wire
- B 511 Specification for Nickel-Iron-Chromium-Silicon Alloy Bars and Shapes
- B 512 Specification for Nickel-Chromium-Silicon Alloy (UNS N08330) Billets and Bars
- B 514 Specification for Welded Nickel-Iron-Chromium Alloy Pipe
- B 515 Specification for Welded UNS N08120, UNS N08800, UNS N08810, and UNS N08811 Alloy Tubes
- B 516 Specification for Welded Nickel-Chromium-Iron Alloy (UNS N06600, UNS N06603, UNS N06025, and UNS N06045) Tubes
- B 517 Specification for Welded Nickel-Chromium-Iron Alloy (UNS N06600, UNS N06603, UNS N06025, and UNS N06045) Pipe
- B 535 Specification for Nickel-Iron-Chromium-Silicon Alloys (UNS N08330 and UNS N08332) Seamless Pipe and Tube
- B 536 Specification for Nickel-Iron-Chromium-Silicon Alloys (UNS N08330 and N08332) Plate, Sheet, and Strip
- B 564 Specification for Nickel Alloy Forgings
- B 572 Specification for UNS N06002, UNS N06230, UNS N12160, and UNS R30556 Rod
- B 573 Specification for Nickel-Molybdenum-Chromium-Iron Alloy (UNS N10003, UNS N10242) Rod
- B 574 Specification for Low-Carbon Nickel-Molybdenum-Chromium, Low-Carbon Nickel-Chromium-Molybdenum, Low-Carbon Nickel-Molybdenum-Chromium-Tantalum, Low-Carbon Nickel-Chromium-Molybdenum-Copper, and Low-Carbon Nickel-Chromium-Molybdenum-Tungsten Alloy Rod
- B 575 Specification for Low-Carbon Nickel-Molybdenum-Chromium, Low-Carbon Nickel-Chromium-Molybdenum, Low-Carbon Nickel-Chromium-Molybdenum-Copper, Low-Carbon Nickel-Chromium-Molybdenum-Tantalum, and Low-Carbon Nickel-Chromium-Molybdenum-Tungsten Alloy Plate, Sheet, and Strip
- B 581 Specification for Nickel-Chromium-Iron-Molybdenum-Copper Alloy Rod
- B 582 Specification for Nickel-Chromium-Iron-Molybdenum-Copper Alloy Plate, Sheet, and Strip
- B 619 Specification for Welded Nickel and Nickel-Cobalt Alloy Pipe
- B 622 Specification for Seamless Nickel and Nickel-Cobalt Alloy Pipe and Tube
- B 625 Specification for UNS N08904, UNS N08925, UNS N08031, UNS N08932, UNS N08926, and UNS R20033 Plate, Sheet, and Strip
- B 626 Specification for Welded Nickel and Nickel-Cobalt Alloy Tube
- B 649 Specification for Ni-Fe-Cr-Mo-Cu Low-Carbon Alloy (UNS N08904), Ni-Fe-Cr-Mo-Cu-N Low-Carbon Alloys (UNS N08925, UNS N08031, and UNS N08926), and Cr-Ni-Fe-N Low Carbon Alloy (UNS R20033) Bar and Wire
- B 673 Specification for UNS N08904, N08925, and N08926 Welded Pipe
- B 674 Specification for UNS N08904, N08925, and N08926 Welded Tube
- B 675 Specification for UNS N08367 Welded Pipe
- B 676 Specification for UNS N08367 Welded Tube
- B 677 Specification for UNS N08904, N08925, and N08926 Seamless Pipe and Tube
- B 688 Specification for Chromium-Nickel-Molybdenum-Iron (UNS N08366 and UNS N08367) Plate, Sheet, and Strip

- B 690 Specification for Iron-Nickel-Chromium-Molybdenum Alloys (UNS N08366 and UNS N08367) Seamless Pipe and Tube
- B 691 Specification for Iron-Nickel-Chromium-Molybdenum Alloys (UNS N08366 and UNS N08367) Rod, Bar, and Wire
- B 704 Specification for Welded UNS N06625, N06219, and UNS N08825 Alloy Tubes
- B 705 Specification for Nickel-Alloy (UNS N06625, N06219, and N08825) Welded Pipe
- B 710 Specification for Nickel-Iron-Chromium-Silicon Alloy Welded Pipe
- B 880 Specification for General Requirements for Chemical Check Analysis Limits for Nickel, Nickel Alloys and Cobalt Alloys
- B 899 Terminology Relating to Non-ferrous Metals and Alloys
- E 165 Test Method for Liquid Penetrant Examination
- E 1916 Guide for Identification and/or Segregation of Mixed Lots of Metals
- 2.2 *ASME Standards:*
- B16.9 Wrought Steel Butt Welding Fittings³
- B16.11 Forged Steel Fittings, Socket-Welding and Threaded³
- H34.1 Nickel Seamless Pipe and Tubing³
- H34.2 Nickel-Copper Alloy Seamless Pipe and Tubing³
- H34.3 Nickel-Chromium-Iron Alloy Seamless Pipe and Tubing³
- 2.3 *Manufacturers Standardization Society of the Valve and Fittings Industry Standards:*
- MSS SP-25 Standard Marking Systems for Valves, Fittings, Flanges, and Unions⁴
- MSS SP-43 Standard Practice for Light Weight Stainless Steel Butt Welding Fittings⁴
- MSS SP-95 Sewage (D) Nipples and Bull Plugs⁴
- MSS SP-97 Forged Carbon Steel Branch Outlet Fittings—Socket Welding, Threaded and Butt Welding Ends⁴
- Boiler and Pressure Vessel Code, Section VIII, Division 1, Pressure Vessels and Section IX, Welding Qualifications³
- 2.5 *AWS Standards:*
- A5.11 Specification for Nickel and Nickel Alloy Covered Welding Electrodes⁵
- A5.14 Specification for Nickel and Nickel-Alloy Bare Welding Rods and Electrodes⁵

3. Terminology

3.1 Terms defined in Terminology B 899 shall apply unless otherwise defined in this standard.

4. Ordering Information

4.1 It is the responsibility of the purchaser to specify all requirements that are necessary for material ordered under this

specification. Examples of such requirements include, but are not limited to, the following:

- 4.1.1 Quantity, number of fittings of each kind,
- 4.1.2 Description of Fitting and Nominal Dimensions (standard or special),
- 4.1.3 Alloy Composition,
- 4.1.4 Condition (temper) if applicable.
- 4.1.5 If neither grade of N06625 is specified, Grade 1 will be supplied.
- 4.1.6 For each Grade of WP fittings ordered, a Class should also be indicated.
 - 4.1.6.1 Grade **CR** fittings shall not be substituted for fittings ordered to Grade **WP**, but Grade **WP** may be substituted for Grade **CR**.
 - 4.1.6.2 For all Classes of WP fittings, unless S, W, WX, or WU is specified by the purchaser, any class may be furnished at the option of the supplier.
- 4.1.7 *Purchaser Inspection*—State which tests or inspections are to be witnessed (Section 10),
- 4.1.8 *Samples for Product (Check) Analysis*—State whether samples should be furnished (6.3),
- 4.1.9 Test reports (Section 12), and
- 4.1.10 Supplementary requirements, if any.

5. Materials and Manufacture

5.1 *Material*—The material for wrought welding fittings may consist of forgings, rods, bars, plates, sheets, and seamless or welded pipe that conform to all the requirements of the ASTM specifications for the particular product and alloy referred to in Table 2.

5.2 *Manufacture:*

5.2.1 Forging or shaping operations may be performed by hammering, pressing, piercing, extruding, upsetting, rolling, bending, or fusion welding, 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.

5.2.2 Grade WP fittings ordered as Class S shall be of seamless construction and shall meet all requirements of ASME B16.9 or B16.11.

5.2.3 All classes of 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.

5.2.4 Grade WP fittings ordered as Class W shall meet the requirements of ASME B16.9 and shall have all pipe welds made by the starting material manufacturer or the fitting manufacturer with the addition of filler radiographically examined throughout the entire length in accordance with Paragraph UW-51 of Section VIII, Division 1, of the ASME Boiler and Pressure Vessel Code, except as exempt by 5.2.4.1, and 5.2.4.2.

5.2.4.1 The weld in the starting pipe, made to one of the pipe or tube product specifications listed in Table 2, shall not require radiography, provided that no filler metal is used in making the weld.

5.2.4.2 Instead of the radiographic examination, and at the option of the manufacturer, welds made by the fitting manufacturer may be ultrasonically examined in accordance with the Code requirements stated in 5.2.6.

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

⁴ Available from Manufacturers Standardization Society of the Valve and Fittings Industry (MSS), 127 Park St., NE, Vienna, VA 22180-4602.

⁵ Available from The American Welding Society (AWS), 550 NW LeJeune Rd., Miami, FL 33126.

TABLE 2 Permissible Raw Materials

| Marking ^A | | | | Product and ASTM Designation ^B | | |
|------------------------------|------------------------|------------------------------|-----------------|---|------------------------|-------------------------------|
| Corrosion-Resistant Fittings | ASME Pressure Fittings | Alloy | UNS Designation | Pipe or Tube | Plate, Sheet, or Strip | Bar Forging and Forging Stock |
| CRN | WPN | Ni | N02200 | B 161 | B 162 | B 160, B 564 |
| CRNL | WPNL | Ni, Low C | N02201 | B 161 | B 162 | B 160 |
| CRNC ^C | WPNC ^C | Ni-Cu | N04400 | B 165 | B 127 | B 164, B 564 |
| CR HX | WPHX | Ni-Cr-Mo-Fe | N06002 | B 619, B 622, B 626 | B 435 | B 572 |
| CR HG | WPHG | Ni-Cr-Fe-Mo-Cu | N06007 | B 619, B 622, B 626 | B 582 | B 581 |
| CR HC 22 | WPHC22 | Low C-Ni-Mo-Cr | N06022 | B 619, B 622, B 626 | B 575 | B 574, B 564, B 462, B 472 |
| CRV602 | WPV602 | Ni-Cr-Fe | N06025 | B 163, B 167 | B 168 | B 166, B 462, B 472 |
| CR HG 30 | WPHG30 | Ni-Cr-Fe-Mo-Cu | N06030 | B 619, B 622, B 626 | B 582 | B 581, B 462, B 472 |
| CRHG35 | WPHG35 | Ni-Cr-Mo | N06035 | B 619, B 622, B 626 | B 575 | B 574, B 564, B 462, B 472 |
| CRV45TM | WPV45TM | Ni-Cr-Fe | N06045 | B 163, B 167 | B 168 | B 166, B 462, B 472 |
| CR2120 | WP2120 | Ni-Cr-Mo low C | N06058 | B 619, B 622, B 626 | B 575 | B 564, B 574 |
| CR5923 | WP5923 | Low C-Ni-Cr-Mo | N06059 | B 619, B 622, B 626 | B 575 | B 564, B 574, B 462, B 472 |
| CR HC 2000 | WPHC2000 | Low C-Ni-Cr-Mo-Cu | N06200 | B 619, B 622, B 626 | B 575 | B 564, B 574, B 462, B 472 |
| CRM21 | WPM21 | Low C-Ni-Cr-Mo-Ta | N06210 | B 619, B 622, B 626 | B 575 | B 564, B 574 |
| CRH230 | WPH230 | Ni-Cr-W-Mo | N06230 | B 619, B 622, B 626 | B 435 | B 572, B 564 |
| CR HC 4 | WPHC4 | Low C-Ni-Mo-Cr | N06455 | B 619, B 622, B 626 | B 575 | B 574 |
| CRNCI | WPNCI | Ni-Cr-Fe | N06600 | B 167, B 516, B 517 | B 168 | B 166, B 564 |
| CR603GT | WP603GT | Ni-Cr-Fe-Al | N06603 | B 163, B 167, B 516, B 517 | B 168 | B 166, B 564 |
| CRNCMC | WPNCMC | Ni-Cr-Mo-Cb | N06625 | B 444, B 704, B 705 | B 443 | B 446, B 564 |
| CRIN686 | WPIN686 | Low C-Ni-Cr-Mo | N06686 | B 163, B 619, B 622, B 626 | B 575 | B 564, B 574, B 462, B 472 |
| CR626Si | WP626Si | Ni-Cr-Mo-Si | N06219 | B 444, B 704, B 705 | B 443 | B 446, B 564 |
| CR HG3 | WPHG3 | Ni-Cr-Fe-Mo-Cu | N06985 | B 619, B 622, B 626 | B 582 | B 581 |
| CR20CB | WP20CB | Cr-Ni-Fe-Mo-Cu-Cb stabilized | N08020 | B 464, B 468, B 729 | B 463 | B 472, B 473, B 462 |
| CR3127 | WP3127 | Low C-Ni-Fe-Cr-Mo-Cu | N08031 | B 619, B 622, B 626 | B 625 | B 564, B 649, B 462, B 472 |
| CRH120 | WPH120 | Ni-Cr-Fe | N08120 | B 407, B 514, B 515 | B 409 | B 408, B 564 |
| CR330 | WP330 | Ni-Fe-Cr-Si | N08330 | B 535, B 710 | B 536 | B 511, B 512 |
| CR6XN | WP6XN | Fe-Ni-Cr-Mo-N | N08367 | B 675, B 676, B 690 | B 688 | B 472, B 564, B 691, B 462 |
| CRNIC | WPNIC | Ni-Fe-Cr | N08800 | B 407, B 514, B 515 | B 409 | B 408, B 564 |
| CRNIC10 | WPNIC10 | Ni-Fe-Cr | N08810 | B 407, B 514, B 515 | B 409 | B 408, B 564 |
| CRNIC11 | WPNIC11 | Ni-Fe-Cr | N08811 | B 407 | B 409 | B 408, B 564 |
| CRNICMC | WPNICMC | Ni-Fe-Cr-Mo-Cu | N08825 | B 423, B 704, B 705 | B 424 | B 425, B 564 |
| CR904L | WP904L | Low C-Ni-Fe-Cr-Mo-Cu | N08904 | B 673, B 674, B 677 | B 625 | B 649 |
| CR1925 | WP1925 | Low C-Ni-Fe-Cr-Mo-Cu | N08925 | B 673, B 674, B 677 | B 625 | B 649 |
| CR1925N | WP1925N | Low C-Ni-Fe-Cr-Mo-Cu-N | N08926 | B 673, B 674, B 677 | B 625 | B 649 |
| CR HB | WPHB | Ni-Mo | N10001 | B 619, B 622, B 626 | B 333 | B 335 |
| CR HN | WPHN | Ni-Mo-Cr-Fe | N10003 | | B 434 | B 573 |
| CR H242 | WPH242 | Ni-Mo-Cr-Fe | N10242 | B 619, B 622, B 626 | B 434 | B 573, B 564 |
| CR HC 276 | WPHC276 | Low C-Ni-Mo-Cr | N10276 | B 619, B 622, B 626 | B 575 | B 574, B 564, B 462, B 472 |
| CRB10 | WPB10 | Low C-Ni-Mo-Cr-Fe | N10624 | B 619, B 622, B 626 | B 333 | B 335, B 564 |
| CRVB4 | WPVB4 | Ni-Mo | N10629 | B 619, B 622, B 626 | B 333 | B 335, B 564, B 462, B 472 |
| CR HB2 | WPHB-2 | Ni-Mo | N10665 | B 619, B 622, B 626 | B 333 | B 335, B 564, B 462, B 472 |
| CR HB3 | WPHB-3 | Ni-Mo | N10675 | B 619, B 622, B 626 | B 333 | B 335, B 564, B 462, B 472 |
| CRH160 | WPH160 | Ni-Co-Cr-Si | N12160 | B 619, B 622, B 626 | B 435 | B 564, B 572 |
| CR3033 | WP3033 | Low C-Cr-Ni-Fe-N | R20033 | B 619, B 622, B 626 | B 625 | B 564, B 649, B 472, B 462 |
| CRH556 | WPH556 | Ni-Fe-Cr-Co | R30556 | B 619, B 622, B 626 | B 435 | B 572 |

^A When WP fittings are of welded construction or made from welded pipe, the symbol shall be supplemented with W or WX as applicable. If ultrasonic examination in accordance with 5.2.4.2 or 5.2.5.1 is used, the symbol shall be supplemented with WU or WXU as applicable.

^B See 2.1 and 5.1.

^C Yield strength shall be 25 000 psi (172 MPa) min, for all hot-formed, annealed fittings made from WPNC material.