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Standard Specification for Nickel-Chromium-Molybdenum-Columbium Alloys (~~UNS N06625~~) and Nickel-Chromium-Molybdenum-Silicon Alloy (~~UNS N06219~~)* Pipe and Tube (~~UNS N06625~~ and ~~UNS N06852~~) and Nickel-Chromium-Molybdenum-Silicon Alloy (~~UNS N06219~~) Pipe and Tube¹

This standard is issued under the fixed designation B 444; 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 specification² covers nickel-chromium-molybdenum-columbium alloys (~~UNS N06625~~ and ~~UNS N06852~~) and nickel-chromium-molybdenum-silicon alloy (~~UNS N06219~~)* in the form of cold-worked seamless pipe and tube. The general requirements for pipe and tube are covered by Specification B 829.

1.1.1 UNS N06625 products are furnished in two grades of different heat-treated conditions:

1.1.1.1 *Grade 1 (annealed)*—Material is normally employed in service temperatures up to 1100°F (593°C).

1.1.1.2 *Grade 2 (solution annealed)*—Material is normally employed in service temperatures above 1100°F (593°C) when resistance to creep and rupture is required.

NOTE 1—Hot-working or reannealing may change properties significantly, depending on working history and temperatures.

~~1.1.2 Alloy UNS N06219 is supplied in solution annealed condition only.~~

1.1.2 Alloys UNS N06219 and UNS N06852 are supplied in the solution annealed condition only.

1.2 The following precautionary caveat pertains only to the test methods portion, Section 9, of this specification: *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 establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards*:³

B 829 Specification for General Requirements for Nickel and Nickel Alloy Seamless Pipe and Tube—Specification for General Requirements for Nickel and Nickel Alloy Seamless Pipe and Tube

E 527 Practice for Numbering Metals and Alloys (UNS)

3. General Requirement

3.1 Material furnished under this specification shall conform to the applicable requirements of Specification B 829 unless otherwise provided herein.

4. Ordering Information

4.1 Orders for material to this specification shall include information with respect to the following:

4.1.1 Alloy name or UNS number,

4.1.2 ASTM designation,

4.1.3 Condition (temper) (see 1.1.1, 1.1.2, Section 6, and Appendix X1 and Appendix X2),

4.1.3.1 If neither grade of N06625 is specified, Grade 1 will be supplied.

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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* New designation established in accordance with Practice E 527 and SAE J 1086, Practice for Numbering Metals and Alloys (UNS).

² For ASME Boiler and Pressure Vessel Code applications see related Specification SB-444 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*, Vol ~~02.04~~ volume information, refer to the standard's Document Summary page on the ASTM website.

- 4.1.4 Finish (See Appendix X2),
- 4.1.5 *Dimensions*:
 - 4.1.5.1 *Tube*—Specify outside diameter and nominal or minimum wall,
 - 4.1.5.2 *Pipe*—Specify standard pipe size and schedule,
 - 4.1.5.3 *Length*—Cut to length or random,
- 4.1.6 *Quantity*—Feet (or metres) or number of pieces,
- 4.1.7 *Hydrostatic Pressure Requirements*—Specify test pressure if other than required by 9.1.1,
- 4.1.8 *Certification*— State if certification is required,
- 4.1.9 *Samples for Product (Check) Analysis*—State whether samples for product (check) analysis should be furnished (see 5.2),
- 4.1.10 *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, and
- 4.1.11 *Small-Diameter and Light-Wall Tube (Converter Sizes)*—See Appendix X1 and Table 1.

5. Chemical Composition

5.1 The material shall conform to the composition limits specified in Table 2. One test is required for each lot as defined in Specification B 829.

5.2 If a product (check) analysis is performed by the purchaser, the material shall conform to the product (check) analysis variations in Table 2 of Specification B 829.

6. Mechanical Properties and Other Requirements

6.1 *Tension Test*— The material shall conform to the tensile properties specified in Table 1. The sampling and specimen preparation are as covered in Specification B 829.

6.2 *Hydrostatic Test*— If any pipe or tube shows leaks during hydrostatic testing, it shall be rejected.

7. Dimensions and Permissible Variations

7.1 Permissible variations for material specified as small-diameter and light-wall tube (converter size) shall conform to the permissible variations prescribed in Table X1.1 and Table X1.2.

8. Number of Tests

- 8.1 *Chemical Analysis*—One test per lot.
- 8.2 *Tension*—One test per lot.
- 8.3 *Hydrostatic*— Each piece in each lot.

9. Test Methods

9.1 *Hydrostatic Test*— Each pipe or tube with an outside diameter 1/8 in. (3 mm) and larger and with wall thickness of 0.015 in. (0.38 mm) and over shall be tested in accordance with Specification B 829. The allowable fiber stress for material in the condition furnished, is as follows:

N06625:

TABLE 1 Room Temperature Tensile Properties and Heat Treatment Including Small Diameter and Light-Wall Tubing (Converter Sizes)^{AB}

Condition	Tensile Strength, min, ksi (MPa) ^C	Yield Strength (0.2 % offset), min, ksi (MPa) ^C	Elongation in 2 in. or 50.8 mm (or 4D), min, %
Alloy N06625			
Grade 1 (annealed) ^D	120 (827)	60 (414)	30
Grade 2 (solution annealed) ^E	100 (690)	40 (276)	30
Alloy N06219			
All (solution annealed)	96 (660)	39 (270)	30
Alloy N06852			
All (solution annealed)	85 (586)	35 (241)	30

^ANot applicable to outside diameters under 1/8 in. (3.2 mm) and to wall thicknesses under 0.015 in. (0.38 mm).

^BHot forming quality pipe and tubing is furnished to chemical requirements and surface inspection only. No tensile properties are required.

^CThe minimum strength values apply only to tubing in straight lengths.

^DAnnealed at 1600°F (871°C) minimum.

^ESolution annealed at 2000°F (1093°C) minimum, with or without subsequent stabilization anneal at 1800°F (982°C) minimum to increase resistance to sensitization.