



Designation: ~~A426/A 426M-02~~ Designation: A 426/A 426M - 05

Standard Specification for Centrifugally Cast Ferritic Alloy Steel Pipe for High- Temperature Service¹

This standard is issued under the fixed designation A 426/A 426M; 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.

1. Scope*

- 1.1 This specification² covers centrifugally cast alloy steel pipe intended for use in high-temperature, high-pressure service.
- 1.2 Several grades of ferritic steels are covered. Their compositions are given in Table 1.
- 1.3 Supplementary Requirements S1 through S12 are provided. The supplementary requirements provide for additional tests of an optional nature and when desired shall be so stated in the order (Section 4).
- 1.4 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 each other. Combining values from the two systems may result in nonconformance with the specification.

2. Referenced Documents

2.1 *ASTM Standards:*³

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products ~~A530/A 530M Specification for General Requirements for Specialized Carbon and Alloy Steel Pipe~~

A 609/A 609M Practice for Castings, Carbon, Low-Alloy, and Martensitic Stainless Steel, Ultrasonic Examination Thereof
A 941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys

~~E44 Definitions of Terms Relating to Heat Treatment of Metals~~⁵ A 999/A 999M Specification for General Requirements for Alloy and Stainless Steel Pipe

E 94 Guide for Radiographic Examination

E 165 Test Method for Liquid Penetrant Examination

E 186 Reference Radiographs for Heavy-Walled (2 to 4½-in. [51 to 114-mm]) Steel Castings

E 208 Test Method for Conducting Drop-Weight Test to Determine Nil-Ductility Transition Temperature of Ferritic Steels

E 280 Reference Radiographs for Heavy-Walled (4½ to 12-in. [114 to 305-mm]) Steel Castings

E 446 Reference Radiographs for Steel Castings Up to 2 in. [51 mm] in Thickness

E 709 Practice for Magnetic Particle Examination

2.2 *ANSI Standard:*

~~B46.1 Surface Texture~~ ANSI Standard:⁴

B46.1 Surface Texture

2.3 *ASME Boiler and Pressure Vessel Code:*⁵

Section IX Welding Qualifications

3. Ordering Information

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

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 A01.18 on Castings.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-426 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 01-03 volume information, refer to the standard's Document Summary page on the ASTM website.

⁴ *Annual Book of ASTM Standards*, Vol 01.01.

⁴ Available from American National Standards Institute, 25 W. 43rd St., 4th Floor, New York, NY 10036.

⁵ *Annual Book of ASTM Standards*, Vol 01.02.

⁵ Available from American Society of Mechanical Engineers (ASME), Three Park Ave., New York, NY 10016-5990.

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

TABLE 1 Chemical Requirements

Composition, %							
Grade	Carbon	Manganese	Phosphorus, max	Sulfur, max	Silicon	Chromium	Molybdenum
GP1	0.25 max	0.30–0.80	0.040	0.045	0.10–0.50	...	0.44–0.65
CP1	0.25 max	0.30–0.80	0.040	0.045	0.10–0.50	...	0.44–0.65
GP2	0.10–0.20	0.30–0.61	0.040	0.045	0.10–0.50	0.50–0.81	0.44–0.65
CP2	0.10–0.20	0.30–0.61	0.040	0.045	0.10–0.50	0.50–0.81	0.44–0.65
GP5	0.20 max	0.30–0.70	0.040	0.045	0.75 max	4.00–6.50	0.45–0.65
CP5	0.20 max	0.30–0.70	0.040	0.045	0.75 max	4.00–6.50	0.45–0.65
GP5b	0.15 max	0.30–0.60	0.040	0.045	1.00–2.00	4.00–6.00	0.45–0.65
CP5b	0.15 max	0.30–0.60	0.040	0.045	1.00–2.00	4.00–6.00	0.45–0.65
GP9	0.20 max	0.30–0.65	0.040	0.045	0.25–1.00	8.00–10.00	0.90–1.20
CP9	0.20 max	0.30–0.65	0.040	0.045	0.25–1.00	8.00–10.00	0.90–1.20
GP11	0.05–0.20	0.30–0.80	0.040	0.045	0.60 max	1.00–1.50	0.44–0.65
CP11	0.05–0.20	0.30–0.80	0.040	0.045	0.60 max	1.00–1.50	0.44–0.65
GP12	0.05–0.15	0.30–0.61	0.040	0.045	0.50 max	0.80–1.25	0.44–0.65
CP12	0.05–0.15	0.30–0.61	0.040	0.045	0.50 max	0.80–1.25	0.44–0.65
GP15	0.15 max	0.30–0.60	0.040	0.045	0.15–1.65	...	0.44–0.65
CP15	0.15 max	0.30–0.60	0.040	0.045	0.15–1.65	...	0.44–0.65
GP21	0.05–0.15	0.30–0.60	0.040	0.045	0.50 max	2.65–3.35	0.80–1.06
CP21	0.05–0.15	0.30–0.60	0.040	0.045	0.50 max	2.65–3.35	0.80–1.06
GP22	0.05–0.15	0.30–0.70	0.040	0.045	0.60 max	2.00–2.75	0.90–1.20
CP22	0.05–0.15	0.30–0.70	0.040	0.045	0.60 max	2.00–2.75	0.90–1.20
CPCA15	0.15 max	1.00 max	0.040	0.040	1.50 max	11.5–14.0	0.50 max
CPCA15	0.15 max	1.00 max	0.040	0.040	1.50 max	11.5–14.0	0.50 max

- 3.1.1 Quantity (feet, centimetres, or number of lengths),
- 3.1.2 Name of material (centrifugally cast pipe),
- 3.1.3 Specification number,
- 3.1.4 Grade (Table 1),
- 3.1.5 Size (outside or inside diameter and minimum wall thickness),
- 3.1.6 Length (specific or random) (Section on Permissible Variations in Length of Specification A530A 999/A 999M/A530M),
- 3.1.7 End finish (Section on Ends of Specification A530A 999/A 999M/A530M),
- 3.1.8 Optional Requirements S1 through S12 and Section 14.1,
- 3.1.9 Test report required (Section on Certification of Specification A530/A530M),
- 3.1.9 Test report required (Section on Certified Test Report of Specification A 999/A 999M),
- 3.1.10 Service temperature if over 1000°F [540°C] (Note 1), and
- 3.1.11 Special requirements or additions to specification.

4. General Requirements for Delivery

4.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification A530A 999/A 999M/A530M unless otherwise provided herein.

5. Materials and Manufacture

5.1 *Heat Treatment*—The pipe shall be furnished in the normalized and tempered or liquid-quenched and tempered condition (Note 1). The temperature for tempering shall not be less than 1250°F [675°C] except for Grades CP1, CP2, CP11, CP12, and CP15 for which the temperature for tempering shall not be less than 1100°F [595°C].

5.1.1 Heat treatment shall be performed after the pipe has been allowed to cool below the transformation range. Definition of heat-treatment terms shall be as given in Definitions E44 Terminology A 941.

NOTE 1—It is recommended that the temperature for tempering should be at least 100°F [55°C] above the intended service temperature. The purchaser shall advise the manufacturer of the service temperature when it is over 1000°F [540°C].

5.2 *Machining*—The pipe shall be machined on the inner and outer surfaces to a roughness value no greater than 250 μ in. [6.35 μm] arithmetical average deviation (AA) from the mean line unless otherwise specified as in ANSI B46.1.

6. Chemical Analysis

6.1 *Heat Analysis*—An analysis of each heat shall be made by the manufacturer to determine the percentages of elements specified in Table 1. The analysis shall be made on a test sample taken preferable during the pouring of the heat. The chemical composition thus determined shall conform to the requirements specified in Table 1.

6.2 *Product Analysis*—A product analysis may be made by the purchaser. The sample for analysis shall be selected so as to be representative of the pipe being analyzed. The chemical composition thus determined shall conform to the requirements of Table 1.

7. Tensile and Hardness Requirements

7.1 Steel used for the castings shall conform to the tensile and hardness requirements specified in Table 2.

8. Permissible Variations in Dimensions

8.1 *Thickness*—The wall thickness shall not vary over that specified by more than 1/8 in. [3 mm]. There shall be no variation under the specified wall thickness.

9. Number of Tests

9.1 One tension and one hardness test shall be made from each heat.

9.2 If a specimen is machined improperly or if flaws are revealed by machining or during testing, the specimen may be discarded and another substituted from the same heat.

10. Retests

10.1 If the results of the mechanical tests for any heat do not conform to the requirements specified, the castings may be reheat-treated and retested, but may not be re-austenitized more than twice.

11. Test Specimens

11.1 Test coupons from which tension test specimens are prepared shall be removed from heat-treated casting prolongations.

11.2 When agreed upon between the manufacturer and the purchaser, test coupons from which test specimens are prepared shall be cast attached to separate blocks from the same heat as the casting represented. The test blocks shall be heat treated in the same manner as the casting represented.

TABLE 2 Tensile Properties and Hardness Requirements

Tensile strength, min, psi—[MPa]:	
—Grade CP4	65 000 [450]
Grade CP1	65 000 [450]
—Grades CP11, CP22	70 000 [485]
Grades CP11, CP22	70 000 [485]
—Grades CP5, CP9, CPCA15	90 000 [620]
Grades CP5, CP9, CPCA15	90 000 [620]
—All other grades	60 000 [415]
All other grades	60 000 [415]
Yield strength, min, psi [MPa]:	
Yield strength, min, psi [MPa]:	
—Grade CP4	35 000 [240]
Grade CP1	35 000 [240]
—Grades CP11, CP22	40 000 [275]
Grades CP11, CP22	40 000 [275]
—Grades CP5, CP9	60 000 [415]
Grades CP5, CP9	60 000 [415]
—Grade CPCA15	65 000 [450]
Grade CPCA15	65 000 [450]
—All other grades	30 000 [205]
All other grades	30 000 [205]
Elongation, min, %: ^A	
Elongation, min, %: ^A	
—Grade CP4	24—
Grade CP1	24
—Grades CP11, CP22	20—
Grades CP11, CP22	20
—Grades CP5, CP9, CPCA15	18—
Grades CP5, CP9, CPCA15	18
—All other grades	22—
All other grades	22
Reduction of area, min, %:	
Reduction of area, min, %:	
Grades CP1, CP2, CP11, CP12, CP15, CP21, CP22, CP5, CP5b, CP7, CP9	35—
Grades CP1, CP2, CP11, CP12, CP15, CP21, CP22, CP5, CP5b, CP7, CP9	35
—Grade CPCA15	30—
Grade CPCA15	30
Hardness, max, HB:	
Hardness, max, HB:	
—Grades CP5, CP5b, CP9, CPCA15	225—
Grades CP5, CP5b, CP9, CPCA15	225
—All other grades	201—
All other grades	201

^AElongation in 2 in.—[50 mm] using a standard round specimen, in either the transverse or longitudinal direction.