



Designation: E235 – 06

Standard Specification for Thermocouples, Sheathed, Type K and Type N, for Nuclear or for Other High-Reliability Applications¹

This standard is issued under the fixed designation E235; 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 specification covers the requirements for sheathed, Type K and N thermocouples for nuclear service. Depending on size, these thermocouples are normally suitable for operating temperatures to 1652 °F (900 °C); special conditions of environment and life expectancy may permit their use at temperatures in excess of 2012 °F (1100 °C). This specification was prepared specifically to detail requirements for using this type of sheathed thermocouple in nuclear environments. This specification can be used for sheathed thermocouples which are required for laboratory or general commercial applications where the environmental conditions exceed normal service requirements. The intended use of a sheathed thermocouple in a specific nuclear application will require evaluation by the purchaser of the compatibility of the thermocouple, including the effect of the temperature, atmosphere, and integrated neutron flux on the materials and accuracy of the thermoelements in the proposed application. This specification does not attempt to include all possible specifications, standards, etc., for materials that may be used as sheathing, insulation, and thermocouple wires for sheathed-type construction. The requirements of this specification include only the austenitic stainless steels and other alloys as allowed with Specification E585/E585M for sheathing, magnesium oxide or aluminum oxide as insulation, and Type K and N thermocouple wires for thermoelements (see Note 1).

1.2 *General Design*—Nominal sizes of the finished thermocouples shall be 0.0400 in. (1.016 mm), 0.0625 in. (1.588 mm), 0.125 in. (3.175 mm), 0.1875 in. (4.763 mm), or 0.250 in. (6.350 mm). Sheath dimensions and tolerances for each nominal size shall be in accordance with Table 1 and Figs. 1 and 2. The measuring junction styles for thermocouples covered by this specification are as follows:

1.2.1 *Style G² (grounded)*—Measuring junction electrically connected to conductive sheaths, and

1.2.2 *Style U² (ungrounded)*—Measuring junctions are electrically isolated from conductive sheaths and from reference ground.

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

1.4 *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

- A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels
- E3 Guide for Preparation of Metallographic Specimens
- E45 Test Methods for Determining the Inclusion Content of Steel
- E94 Guide for Radiographic Examination
- E112 Test Methods for Determining Average Grain Size
- E165 Practice for Liquid Penetrant Examination for General Industry
- E220 Test Method for Calibration of Thermocouples By Comparison Techniques
- E230 Specification and Temperature-Electromotive Force (EMF) Tables for Standardized Thermocouples
- E344 Terminology Relating to Thermometry and Hydrometry
- E585/E585M Specification for Compacted Mineral-Insulated, Metal-Sheathed, Base Metal Thermocouple Cable
- E780 Test Method for Measuring the Insulation Resistance of Mineral-Insulated, Metal-Sheathed Thermocouples and Thermocouple Cable at Room Temperature
- E839 Test Methods for Sheathed Thermocouples and Sheathed Thermocouple Material
- E883 Guide for Reflected-Light Photomicrography

¹ This specification is under the jurisdiction of ASTM Committee E20 on Temperature Measurement and is the direct responsibility of Subcommittee E20.04 on Thermocouples.

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² Style G and Style U measuring junctions were previously termed Class 1 and Class 2 measuring junctions respectively.

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.

TABLE 1 Dimensions for Style G and U Measuring Junctions

Sheath Outside Diameter, A			Minimum Sheath Wall, B	Minimum Insulation Thickness, C	Minimum Wire Diameter, D	E, Tolerance		F, Tolerance	
Nominal	Tolerance					min	max	min	max
	min	max							
Inches									
0.0400	0.0390	0.0415	0.006	0.004	0.005	0.006	0.020	0.004	0.021
0.0625	0.0615	0.0640	0.009	0.005	0.010	0.009	0.032	0.005	0.032
0.1250	0.1240	0.1265	0.012	0.012	0.020	0.012	0.062	0.012	0.063
0.1875	0.1865	0.1890	0.020	0.022	0.031	0.020	0.093	0.022	0.095
0.2500	0.2480	0.2520	0.030	0.024	0.040	0.030	0.125	0.024	0.125
Millimetres									
1.016	0.991	1.054	0.15	0.10	0.13	0.15	0.51	0.10	0.53
1.588	1.562	1.626	0.23	0.13	0.25	0.23	0.81	0.13	0.81
3.175	3.150	3.213	0.30	0.30	0.51	0.30	1.57	0.30	1.60
4.763	4.737	4.801	0.51	0.56	0.79	0.51	2.36	0.56	2.41
6.350	6.299	6.401	0.76	0.61	1.02	0.76	3.18	0.61	3.18

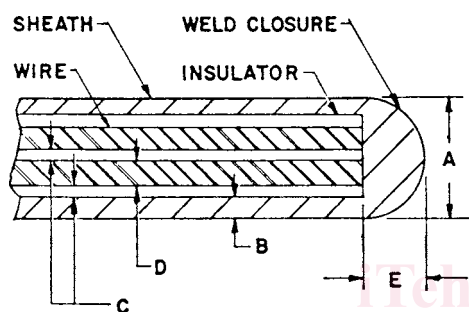


FIG. 1 Grounded Measuring Junction, Style G

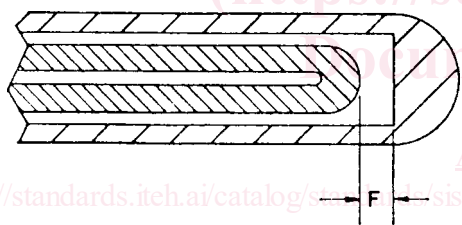


FIG. 2 Ungrounded Measuring Junction, Style U

E1652 Specification for Magnesium Oxide and Aluminum Oxide Powder and Crushable Insulators Used in the Manufacture of Metal-Sheathed Platinum Resistance Thermometers, Base Metal Thermocouples, and Noble Metal Thermocouples

2.2 ANSI Standard:

B46.1 Surface Texture⁴

2.3 American Welding Society Standard:

A5.9 Specification for Corrosion-Resisting Chromium and Chromium-Nickel Steel-Welding Rods and Bare Electrodes⁵

3. Terminology

3.1 The definitions given in Terminology E344 shall apply to this specification.

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁵ Available from American Welding Society (AWS), 550 NW LeJeune Rd., Miami, FL 33126, <http://www.aws.org>.

4. Ordering Information and Basis of Purchase

4.1 The purchase order documents shall specify the following information:

4.1.1 The quantity, length, and nominal diameter of the sheathed thermocouple,

4.1.2 The thermocouple type and tolerance on initial values of emf versus temperature, if other than standard (see Specification E230),

4.1.3 The type of ceramic insulation required, either alumina (Al₂O₃) or magnesia (MgO),

4.1.4 The type of sheath material and other information required (see 5.1.1),

4.1.5 The style of thermocouple measuring junction,

4.1.6 The type of dye-penetrant inspection procedure to be used, and

4.1.7 Any deviations from this specification or the referenced specifications.

5. Materials and Manufacture

5.1 All materials used shall be in accordance with the following requirements:

5.1.1 *Sheath Materials*—The sheath material used for the thermocouples described in this specification must meet the requirements of Specification E585/E585M. The purchaser of the thermocouples shall specify only the name of the material (seamless or welded), grade, optional requirements, test report required, and ASTM designation.

5.1.1.1 The inclusion level of the tubing shall be determined by mounting a 1-in. minimum length of a longitudinal section of the tubing using Test Methods E45, Microscopical Method A, for examination. The inclusion level shall be less than 3 A through D, thin or heavy.

5.1.1.2 The grain size of the tubing shall be determined by a specimen taken in accordance with Test Methods E112. Grain size shall be as specified in Table 2, or finer, as determined by the Comparison Procedure of Test Methods E112.

5.1.1.3 Each lot of tubing used shall be sampled using Practices A262 as follows. Samples shall be tested by Practice A, and further tested as outlined by Table 1 in Practices A262, where screening tests so indicate. Acceptance levels for these tests shall be agreed upon between the purchaser and the producer.