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Standard Specification for Cold-Worked Welded Austenitic Stainless Steel Pipe¹

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1. Scope*

1.1 This specification covers two classes of flanged and cold-bending quality cold-worked straight-seam single or double welded austenitic steel pipe intended for high-temperature and general corrosive services.

NOTE 1—When the impact test criterion for a low-temperature service would be 15 ft-lbf [20 J] energy absorption or 15 mils [0.38 mm] lateral expansion, some of the austenitic stainless steel grades covered by this specification are accepted by certain pressure vessel or piping codes without the necessity of making the actual test. For example, Grades 304, 304L, and 347 are accepted by the ASME Pressure Vessel Code, Section VIII Division 1, and by the Chemical Plant and Refinery Piping Code, ANSI B31.3 for service at temperatures as low as -425°F [-250°C] without qualification by impact tests. Other AISI stainless steel grades are usually accepted for service temperatures as low as -325°F [-200°C] without impact testing. Impact testing may, under certain circumstances, be required. For example, materials with chromium or nickel content outside the AISI ranges, and for material with carbon content exceeding 0.10 %, are required to be impact tested under the rules of ASME Section VIII Division 1 when service temperatures are lower than -50°F [-45°C].

1.2 Grades TP304H, TP304N, TP316H, TP316N, TP321H, TP347H, and TP348H are modifications of Grades TP304, TP316, TP321, TP347, and TP348, and are intended for high-temperature service.

1.3 Two classes of pipe are covered as follows:

1.3.1 *Class SW*—Pipe, single-welded with no addition of filler metal and

1.3.2 *Class DW*—Pipe, double-welded with no addition of filler metal.

1.4 Optional supplementary requirements are provided for pipe where a greater degree of testing is desired. These supplementary requirements call for additional tests to be made and, when desired, one or more of these may be specified in the order.

1.5 Table 1 lists the dimensions of cold-worked single- or double-welded stainless steel pipe. Pipe having other dimensions may be furnished provided such pipe complies with all other requirements of this specification.

1.6 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.

2. Referenced Documents

2.1 *ASTM Standards*:²

A262 [Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels](#)

A370 [Test Methods and Definitions for Mechanical Testing of Steel Products](#)

A480/A480M [Specification for General Requirements for Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet, and Strip](#)

A999/A999M [Specification for General Requirements for Alloy and Stainless Steel Pipe](#)

E112 [Test Methods for Determining Average Grain Size](#)

E381 [Method of Macroetch Testing Steel Bars, Billets, Blooms, and Forgings](#)

E527 [Practice for Numbering Metals and Alloys in the Unified Numbering System \(UNS\)](#)

2.2 *ASME Boiler and Pressure Vessel Code*:³

Section VIII Division 1, Pressure Vessels

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 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.

³ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

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

TABLE 1 Pipe Dimensions^A

NOTE 1—For pipe sizes not listed and for pipe ordered to the “M” designation of this specification, the dimensions and tolerances shall be by agreement between the purchaser and producer.

NPS No.	Outside Diameter	Outside Diameter Tolerance	Schedule	Wall	
				Thickness	Tolerance
1/8	0.405	+0.004 -0.002	10	0.049	±0.004
			40	0.068	±0.005
			80	0.095	±0.006
1/4	0.540	+0.005 -0.003	10	0.065	±0.005
			40	0.088	±0.006
			80	0.119	±0.009
3/8	0.675	+0.006 -0.004	10	0.065	±0.005
			40	0.091	±0.006
			80	0.126	±0.010
1/2	0.840	+0.007 -0.005	5	0.065	±0.005
			10	0.083	±0.006
			40	0.109	±0.009
3/4	1.060	+0.010 -0.007	80	0.147	±0.011
			5	0.065	±0.005
			10	0.083	±0.006
1	1.315	+0.010 -0.007	40	0.113	±0.009
			80	0.154	±0.011
			5	0.065	±0.005
1 1/4	1.660	+0.012 -0.0080	10	0.109	±0.009
			40	0.133	±0.011
			80	0.179	±0.014
1 1/2	1.900	+0.015 -0.008	5	0.065	±0.005
			10	0.065	±0.005
			40	0.109	±0.009
2	2.375	+0.018 -0.008	80	0.145	±0.011
			5	0.065	±0.005
			10	0.109	±0.009
2 1/2	2.875	+0.020 -0.009	40	0.154	±0.011
			80	0.218	±0.015
			5	0.065	±0.005
3	3.500	+0.025 -0.010	10	0.120	±0.010
			40	0.203	±0.015
			80	0.276	±0.020
3 1/2	4.000	+0.025 -0.010	5	0.083	±0.006
			10	0.120	±0.010
			40	0.226	±0.018
4	4.500	+0.025 -0.010	80	0.318	±0.020
			5	0.083	±0.006
			10	0.120	±0.010
			40	0.237	±0.019
			80	0.337	±0.020

^A All dimensions in inches.

2.3 SAE Standard:⁴

SAE J 1086 Practice for Numbering Metals and Alloys (UNS)

3. Ordering Information

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

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

3.1.2 Name of material (austenitic steel pipe),

3.1.3 Class (1.3). If not specified by the purchaser, the producer shall have the option to furnish either single-welded (SW) or double-welded (DW) pipe,

⁴ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

- 3.1.4 Grade (Table 2),
- 3.1.5 Size (NPS or outside diameter and schedule number or average wall thickness),
- 3.1.6 Length (specific or random) (Section 10),
- 3.1.7 End finish (Section on Ends of Specification ~~A 999/A 999M~~A999/A999M),
- 3.1.8 Optional requirements (Section 9), (Supplementary Requirements S1 to S8),
- 3.1.9 Test report required (Section on Certification of Specification ~~A 999/A 999M~~A999/A999M),
- 3.1.10 Specification designation, and
- 3.1.11 Special requirements or exceptions to the specification.

4. Materials and Manufacture

4.1 *Manufacture:*

4.1.1 The pipe shall be made by a machine-welding or an automatic-welding process, welding from one or both sides and producing full penetration welds with no addition of filler metal in the welding operation.

4.1.2 Weld repairs, with the addition of compatible filler metal, may be made to the weld joint in accordance with the requirements of the section on Repair by Welding of Specification ~~A 999/A 999M~~A999/A999M.

4.1.3 Prior to final heat treatment of the pipe, the weld bead must be cold-worked by methods such as forging, planishing, drawing, swaging or bead rolling so as to obtain a flush condition on the inside and outside of the pipe. Undercuts shall be limited to shallow rounded depressions of less than 0.005 in. [0.127 mm] deep on either the inside or outside surface of the pipe with no encroachment of the minimum permitted wall thickness.

4.1.4 The pipe shall be pickled free of scale. When bright annealing is used, pickling is not necessary.

4.2 *Heat Treatment:*

4.2.1 All pipe shall be furnished in the heat-treated condition. The heat-treatment procedure, except for H grades, S30815, N 08367 and S 31254, shall consist of heating the pipe to a minimum temperature of 1900 °F [1040 °C] and quenching in water or rapidly cooling by other means.

4.2.2 All H grades and S30815 shall be furnished in the solution-treated condition. The minimum solution treating temperature for Grades TP321H, TP347H, and TP348H shall be 2000 °F [1100 °C] and for Grades TP304H and TP316H, 1900 °F [1040 °C]. The minimum temperature for S30815 shall be 1920 °F [1050 °C].

4.2.3 The heat-treatment procedure for S 31254 shall consist of heating the pipe to a minimum temperature of 2100 °F [1150 °C] and quenching in water or rapidly cooling by other means.

4.2.4 The heat-treatment procedure for S31727 and S32053 shall consist of heating the pipe to a minimum temperature of 1975 to 2155 °F [1080 to 1180 °C] and quenching in water or rapidly cooling by other means.

4.2.5 UNS N 08367 shall be solution annealed from 2025 °F minimum followed by rapid quenching.

4.3 H grades and S30815 shall have a minimum grain size of 7 or coarser when measured in accordance with Test Methods E H2E112.

5. Chemical Composition

5.1 The steel shall conform to the chemical composition prescribed in Table 2.

5.2 When specified on the purchase order, a product analysis shall be supplied from one tube or coil of steel per heat. The product analysis tolerance of Specification ~~A 480/A 480M~~A480/A480M shall apply.

6. Tensile Requirements

6.1 The tensile properties of the material shall conform to the requirements prescribed in Table 3.

7. Permissible Variations in Dimensions

7.1 *Specified Diameter*—The diameter at any point in each length of pipe shall be within the tolerance specified in Table 1.

7.2 *Alignment (Camber)*—Using a 3-ft [1.0-m] straightedge placed so that both ends are in contact with the pipe, the camber shall not be more than 0.030-in. [0.8-mm].

7.3 *Thickness*—The wall thickness at any point in the pipe shall be within the thickness tolerance specified in Table 3, except that for pipe in which the wall thickness exceeds 0.188-in. [4.8-mm] a weld reinforcement of up to 0.015-in. [0.38-mm] is permitted on the inside of the pipe.

8. Lengths

8.1 Pipe lengths shall be in accordance with the following regular practice.

8.1.1 Unless otherwise agreed upon, all sizes up to and including NPS 4 are available in a length up to 24 ft (Note 2) with the permissible range of 15 of 24 ft (Note 2).

NOTE 2—The 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.

8.1.2 If definite cut lengths are desired, the lengths required shall be specified in the order. No pipe shall be under the specified length and not more than ¼ in. [6 mm] over that specified.

TABLE 2 Chemical Requirements

Grade	UNS Designation ^A	Composition, %														
		Carbon, max ^B	Manganese, max ^B	Phosphorus, max	Sulfur, max	Silicon	Nickel	Chromium	Molybdenum	Titanium	Columbium plus Tantalum	Tantalum, max	Nitrogen ^C	Vanadium	Copper	Cerium
TP 201	S20100	0.15	5.5–7.5	0.060	0.030	1.00	3.5–5.5	16.0–18.0	0.25
TP 201LN	S20153	0.03	6.4–7.5	0.045	0.015	0.75	4.0–5.0	16.0–17.5	0.10–0.25	...	1.00	...
TP 304	S30400	0.08	2.00	0.045	0.030	1.00 max	8.0–11.0	18.0–20.0
TP 304H	S30409	0.04–0.10	2.00	0.045	0.030	1.00 max	8.0–11.0	18.0–20.0
TP 304L	S30403	0.030 ^D	2.00	0.045	0.030	1.00 max	8.0–13.0	18.0–20.0
TP 304N	S30451	0.08	2.00	0.045	0.030	1.00 max	8.0–11.0	18.0–20.0	0.10–0.16
TP 304LN	S30453	0.030	2.00	0.045	0.030	1.00 max	8.0–11.0	18.0–20.0	0.10–0.16
TP 309Cb	S30940	0.08	2.00	0.045	0.030	1.00 max	12.0–16.0	22.0–24.0	10 × C min, 1.10 max
TP309S	S30908	0.08	2.00	0.045	0.030	1.00 max	12.0–15.0	22.0–24.0
TP 310Cb	S31040	0.08	2.00	0.045	0.030	1.00 max	19.0–22.0	24.0–26.0	10 × C min, 1.10 max
TP 310S	S31008	0.08	2.00	0.045	0.030	1.00 max	19.0–22.0	24.0–26.0	0.75 max
TP 316	S31600	0.08	2.00	0.045	0.030	1.00 max	10.0–14.0	16.0–18.0	2.00–3.00
TP 316H	S31609	0.04–0.10	2.00	0.045	0.030	1.00 max	10.0–14.0	16.0–18.0	2.00–3.00
TP 316L	S31603	0.030 ^D	2.00	0.045	0.030	1.00 max	10.0–14.0	16.0–18.0	2.00–3.00
TP 316N	S31651	0.08	2.00	0.045	0.030	1.00 max	10.0–14.0	16.0–18.0	2.00–3.00	0.10–0.16
TP 316LN	S31653	0.030	2.00	0.045	0.030	1.00 max	10.0–14.0	16.0–18.0	2.00–3.00	0.10–0.16
TP 317	S31700	0.08	2.00	0.045	0.030	1.00 max	11.0–14.0	18.0–20.0	3.0–4.0
TP 317L	S31703	0.030	2.00	0.045	0.030	1.00 max	11.0–15.0	18.0–20.0	3.0–4.0
...	S31727	0.030	1.00	0.030	0.030	1.00	14.5–16.5	17.5–19.0	3.8–4.5	0.15–0.21	...	2.8–4.0	...
...	S32053	0.030	1.00	0.030	0.010	1.00	24.0–26.0	22.0–24.0	5.0–6.0	0.17–0.22
TP 321	S32100	0.08	2.00	0.045	0.030	1.00 max	9.00–13.0	17.0–19.0	E
TP 321H	S32109	0.04–0.10	2.00	0.045	0.030	1.00 max	9.00–13.0	17.0–19.0	F
TP 347	S34700	0.08	2.00	0.045	0.030	1.00 max	9.00–13.0	17.0–19.0	G
TP347H	S34709	0.04–0.10	2.00	0.045	0.030	1.00 max	9.00–13.0	17.0–19.0	H
TP 348	S34800	0.08	2.00	0.045	0.030	1.00 max	9.00–13.0	17.0–19.0	G	0.10
TP 348H	S34809	0.04–0.10	2.00	0.045	0.030	1.00 max	9.00–13.0	17.0–19.0	H	0.10
TP XM-10	S21900	0.08	8.0–10.0	0.045	0.030	1.00 max	5.5–7.5	19.0–21.5	0.15–0.40
TP XM-11	S21903	0.04	8.0–10.0	0.045	0.030	1.00 max	5.5–7.5	19.0–21.5	0.15–0.40
TP XM-15	S38100	0.08	2.00	0.030	0.030	1.50–2.50	17.5–18.5	17.0–19.0
TP XM-19	S20910	0.06	4.0–6.0	0.045	0.030	1.00 max	11.5–13.5	20.5–23.5	1.50–3.00	...	0.10–0.30	...	0.20–0.40	0.10–0.30
TP XM-29	S24000	0.08	11.5–14.5	0.060	0.030	1.00 max	2.3–3.7	17.0–19.0	0.20–0.40
...	S31254	0.020	1.00	0.030	0.010	0.80 max	17.5–18.5	19.5–20.5	6.0–6.5	0.18–0.22	...	0.50–1.00	...
...	S30815	0.05–0.10	0.80	0.040	0.030	1.40–2.00	10.0–12.0	20.0–22.0	0.14–0.20	0.03–0.08
...	N08367	0.030	2.00	0.040	0.030	1.00 max	23.5–25.5	20.0–22.0	6.0–7.0	0.18–0.25	...	0.75 max	...