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Standard Specification for Common Requirements for Wrought Steel Piping Fittings¹

This standard is issued under the fixed designation A 960/A 960M; 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 a group of common requirements that shall apply to wrought steel piping fittings covered in any of the following individual product specifications or any other ASTM specification that invokes this specification or portions thereof:

Title of Specification	ASTM Designation
Specification for Piping Fittings of Wrought Carbon Steel and Alloy Steel for Moderate and Elevated Temperatures	A 234/A 234M A234/A234M
Specification for Wrought Austenitic Stainless Steel Piping Fittings	A 403/A 403M A403/A403M
Specification for Piping Fittings of Wrought Carbon Steel and Alloy Steel for Low-Temperature Service	A 420/A 420M A420/A420M
Specification for Butt-Welding, Wrought-Carbon Steel, Piping Fittings with Improved Notch Toughness	A 758/A 758M A758/A758M
Specification for As-Welded Wrought Austenitic Stainless Steel Fittings for General Corrosive Service at Low and Moderate Temperatures	A 774/A 774M A774/A774M
Specification for Wrought Ferritic, Ferritic/Austenitic, and Martensitic Stainless Steel Piping Fittings	A 815/A 815M A815/A815M
Specification for Heat-Treated Carbon Steel Fittings for Low-Temperature and Corrosive Service	A 858/A 858M A858/A858M
Specification for Wrought High-Strength Low-Alloy Steel Butt-Welded Fittings	A 860/A 860M A860/A860M

1.2 In case of conflict between a requirement of the individual product specification and a requirement of this general requirement specification, the requirements of the individual product specification shall prevail over those of this specification.

1.3 By mutual agreement between the purchaser and the supplier, additional requirements may be specified (See 4.1.7). The acceptance of any such additional requirements shall be dependent on negotiations with the supplier and must be included in the order as agreed upon by the purchaser and supplier.

1.4 The values stated in either inch-pound units or SI units [metric] are to be regarded separately as standard. Within the text and the tables, 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 [SI] of the product specification is specified in the order.

2. Referenced Documents

2.1 ASTM Standards:²

- A29/A29M Specification for Steel Bars, Carbon and Alloy, Hot-Wrought, General Requirements for
- A234/A234M Specification for Piping Fittings of Wrought Carbon Steel and Alloy Steel for Moderate and High Temperature Service
- A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels
- A370 Test Methods and Definitions for Mechanical Testing of Steel Products
- A388/A388M Practice for Ultrasonic Examination of Steel Forgings
- A403/A403M Specification for Wrought Austenitic Stainless Steel Piping Fittings
- A420/A420M Specification for Piping Fittings of Wrought Carbon Steel and Alloy Steel for Low-Temperature Service

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 A01.22 on Steel Forgings and Wrought Fittings for Piping Applications and Bolting Materials for Piping and Special Purpose Applications.

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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.

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



A700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Shipment
A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products
A758/A758M Specification for Wrought-Carbon Steel Butt-Welding Piping Fittings with Improved Notch Toughness
A763 Practices for Detecting Susceptibility to Intergranular Attack in Ferritic Stainless Steels
A774/A774M Specification for As-Welded Wrought Austenitic Stainless Steel Fittings for General Corrosive Service at Low and Moderate Temperatures
A815/A815M Specification for Wrought Ferritic, Ferritic/Austenitic, and Martensitic Stainless Steel Piping Fittings
A858/A858M Specification for Heat-Treated Carbon Steel Fittings for Low-Temperature and Corrosive Service
A860/A860M Specification for Wrought High-Strength Ferritic Steel Butt-Welding Fittings
A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys
A967 Specification for Chemical Passivation Treatments for Stainless Steel Parts
E165 Practice for Liquid Penetrant Examination for General Industry
E213 Practice for Ultrasonic Testing of Metal Pipe and Tubing
E709 Guide for Magnetic Particle Testing
E1916 Guide for Identification of Mixed Lots of Metals

2.2 ~~Military Standard:~~

~~MIL-STD-163 Steel Mill Products, Preparation for Shipment and Storage~~

2.3 ~~Manufacturer's Standardization Society Standards:~~³

~~MSS-SP-25 The Standard Marking System of Valves, Fittings, Flanges and Unions
MSS-SP-43 Standard Practice for Light Weight Stainless Steel Butt-Welding Fittings
MSS-SP-75 Specification for High Test Wrought Butt-Welding Fittings
MSS-SP-79 Socket Welding Reducer Inserts
MSS-SP-95 Swage(d) Nipples and Bull Plugs~~

2.4

2.3 ~~American Society of Nondestructive Testing:~~⁴

~~SNT-TC-1A Recommended Practice for Nondestructive Testing Personnel Qualification and Certification~~

2.5

2.4 ~~ASME Standards:~~⁵

~~B16.9 Steel Butt-Welding Fittings
B16.11 Forged Steel Fittings, Socket Welding and Threaded
Section IX Welding Qualifications~~

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *bar*—a solid section that is long in relationship to its cross sectional dimensions, with a relatively constant cross section throughout its length. (See Specification A 29/A 29MA29/A29M for definitions relating to the production of hot wrought and cold finished bars.)

3.1.2 *certifying organization*—the company or association responsible for the conformance of, the marking of, and the certification of the product to the specification requirements.

3.1.3 *fitting*—a component for non-bolted joints used in piping systems and pressure vessels.

3.1.4 *flange*—a component for bolted joints used in piping systems and pressure vessels.

3.1.5 *forging*—the product of a substantially compressive hot or cold plastic working operation that consolidates the material and produces the required shape.

3.1.6 *Discussion*—The plastic working must be performed by a forging machine, such as a hammer, press, or ring rolling machine and must deform the material to produce an essentially wrought structure throughout the material cross section.

3.2 *Definitions*—For definitions of other terms used in this specification, refer to Terminology A 941A941.

4. Ordering Information

4.1 It is the purchaser's responsibility to specify in the purchase order all ordering information necessary to purchase the needed material. Examples of such information include but are not limited to the following:

³ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098.

³ Available from Manufacturers Standardization Society of the Valve and Fittings Industry (MSS), 127 Park St., NE, Vienna, VA 22180-4602, <http://www.mss-hq.com>.

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

⁴ Available from American Society for Nondestructive Testing (ASNT), P.O. Box 28518, 1711 Arlingate Ln., Columbus, OH 43228-0518, <http://www.asnt.org>.

⁵ Available from The American Society for Nondestructive Testing (ASNT), P.O. Box 28518, 1711 Arlingate Ln., Columbus, OH 43228-0518.

⁵ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.