



Designation: ~~A270-03a~~ Designation: A 270 – 03a (Reapproved 2008)^{ε1}

Standard Specification for Seamless and Welded Austenitic and Ferritic/Austenitic Stainless Steel Sanitary Tubing¹

This standard is issued under the fixed designation A 270; 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.

^{ε1} NOTE—The units statement in 1.3 was corrected editorially in October 2008.

1. Scope *

1.1 This specification covers grades of seamless, welded, and heavily cold worked welded austenitic and ferritic/austenitic stainless steel sanitary tubing intended for use in the dairy and food industry and having special surface finishes. Pharmaceutical quality may be requested, as a supplementary requirement.

1.2 This specification covers tubes in sizes up to and including 12 in. (304.8 mm) in outside diameter.

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1.3 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.4 Optional supplementary requirements are provided, and when one or more of these are desired, each shall be so stated in the order.

2. Referenced Documents

2.1 ASTM Standards:²

A 262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels

A 480/A 480M Specification for General Requirements for Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet, and Strip

A 923 Test Methods for Detecting Detrimental Intermetallic Phase in Wrought Duplex Austenitic/Ferritic Stainless Steels

A 967 Specification for Chemical Passivation Treatments for Stainless Steel Parts

A 1016/A 1016M Specification for General Requirements for Ferritic Alloy Steel, Austenitic Alloy Steel, and Stainless Steel Tubes

E 527 Practice for Numbering Metals and Alloys (UNS) Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

2.2 ASME Standard:

B46.1 Surface Texture (Surface Roughness, Waviness, and Lay)³

2.3 ASME Boiler and Pressure Vessel Code:

Section VIII Pressure Vessels³

2.4 Other Standard:

SAE J1086 Practice for Numbering Metals and Alloys (UNS)⁴

3. Terminology

3.1 Definition:

3.1.1 roughness average, R_a , n —arithmetic average surface roughness normally reported in microinches or microns; a

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 ASME International, Three Park Avenue, New York, NY 10016-5990.

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

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

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

measurement of surface roughness usually performed by moving a stylus in a straight line along the surface, although other methods may be used.

4. Ordering Information

4.1 It is the responsibility of the purchaser to specify all requirements that are necessary for material ordered under this specification. Such requirements may include, but are not limited to, the following:

- 4.1.1 Quantity (feet, metres, or number of lengths),
 - 4.1.2 Name of material (austenitic steel tube),
 - 4.1.3 Process seamless (SML), welded (WLD), or heavily cold worked (HCW),
 - 4.1.4 Size (outside diameter and average wall thickness),
 - 4.1.5 Length (specific or random),
 - 4.1.6 Surface finish (Section 13),
 - 4.1.7 Optional requirements (product analysis, see Section 9; hydrostatic or nondestructive electric test, see Section 11),
 - 4.1.8 Test report required (Certification Section of Specification A 1016/A 1016M),
 - 4.1.9 Specification designation,
 - 4.1.10 Special requirements, and
- 4.2 Any supplementary requirements.

5. General Requirements

5.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification A 1016/A 1016M, unless otherwise provided herein.

6. Manufacture

6.1 The tubes shall be manufactured by one of the following processes:

- 6.1.1 Seamless (SML) tubes shall be made by a process that does not involve welding at any stage.
- 6.1.2 Welded (WLD) tubes shall be made using an automated welding process with no addition of filler metal during the welding process.
- 6.1.3 Heavily cold worked (HCW) tubes shall be made by applying cold working of not less than 35 % reduction of thickness of both wall and weld to a welded tube prior to the final anneal. No filler shall be used in making the weld. Prior to cold working, the weld shall be 100 % radiographically inspected in accordance with the requirements of ASME Boiler and Pressure Vessel Code Section VIII, Division 1, latest revision, Paragraph UW 51.

6.2 At the manufacturer's option, tubing may be furnished either hot finished or cold finished.

7. Heat Treatment

7.1 All material shall be furnished in the heat-treated condition. The heat treatment procedure, except for S31803, S32003, S32205, S32750, N08926 and N08367, shall consist of heating the material to a minimum temperature of 1900 °F (1040 °C) and quenching in water or rapid cooling by other means.

7.2 N08926 shall be heat-treated to a minimum temperature of ~~2010°F [1100°C]~~ 2010 °F (1100 °C) followed by quenching in water or rapidly cooling by other means. UNS N08367 should be solution annealed from ~~2025°F [1107°C]~~ 2025 °F (1107 °C) minimum followed by rapid quenching.

7.3 S31803 and S32205 shall be heat-treated in a temperature range of ~~1870°F [1020°C]~~ 1870 °F (1020 °C) to ~~2010°F [1100°C]~~ 2010 °F (1100 °C) followed by quenching in water or rapidly cooling by other means.

7.4 S32750 shall be heat-treated in a temperature range of ~~1880°F [1025°C]~~ 1880 °F (1025 °C) to ~~2060°F [1125°C]~~ 2060 °F (1125 °C) followed by quenching in water or rapidly cooling by other means.

7.5 S32003 shall be heat-treated in a temperature range of 1850 °F (1010 °C) to 2010 °F (1100 °C).

8. Chemical Composition

8.1 An analysis of either one length of flat-rolled stock or one tube shall be made for each heat. The chemical composition thus determined shall conform to the requirements given in Table 1.

9. Product Analysis

9.1 When requested by the purchaser, product analysis tolerance in Specification A 480/A 480M shall apply. The product analysis tolerance is not applicable to the carbon content for material with a specified maximum carbon of 0.04 % or less.

9.2 If the original test for product analysis fails, retests of two additional lengths of flat-rolled stock or tubes shall be made. Both retests for the elements in question shall meet the requirements of the specification; otherwise all remaining material in the heat or lot (Note 1) shall be rejected or, at the option of the producer, each length of flat-rolled stock or tube may be individually tested for acceptance. Lengths of flat rolled stock or tubes that do not meet the requirements of the specification shall be rejected.

10. Mechanical Tests Required

10.1 *Reverse Flattening Test*—For welded tubes, one reverse flattening test shall be made on a specimen from each 1500 ft (457 m) of finished tubing.



TABLE 1 Chemical Requirements

Element	TP 304		TP 304L		TP 316		TP 316L		S32205		S32750		2003	
	Grade	UNS	Grade	UNS	Grade	UNS	Grade	UNS	Grade	UNS	Grade	UNS	Grade	UNS
Carbon, max	0.08	0.035 ^B	0.08	0.035 ^B	0.08	0.035 ^B	0.020	0.030	0.030	0.030	0.030	0.030	0.030	0.030 max
Manganese, max	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00 max
Phosphorus, max	0.045	0.045	0.045	0.045	0.045	0.045	0.030	0.040	0.030	0.030	0.030	0.030	0.030	0.030
Sulfur, max	0.030	0.030	0.030	0.030	0.030	0.030	0.010	0.030	0.020	0.020	0.020	0.020	0.020	0.020 max
Silicon, max	1.00	1.00	1.00	1.00	1.00	1.00	0.50	1.00	1.00	1.00	1.00	1.00	1.00	1.00 max
Nickel	8.0–11.0	8.0–12.0	17.5–18.5	10.0–14.0	10.0–14.0	10.0–14.0	24.0–26.0	23.5–25.5	4.5–6.5	4.5–6.5	4.5–6.5	6.0–8.0	6.0–8.0	3.0–4.0
Chromium	18.0–20.0	18.0–20.0	19.5–20.5	16.0–18.0	16.0–18.0	16.0–18.0	19.0–21.0	20.0–22.0	21.0–23.0	22.0–23.0	22.0–23.0	24.0–26.0	24.0–26.0	19.5–22.5
Molybdenum	6.0–6.5	2.00–3.00	2.00–3.00	2.00–3.00	6.0–7.0	6.0–7.0	2.5–3.5	3.0–3.5	3.0–3.5	3.0–5.0	3.0–5.0	1.5–2.0
Nitrogen ^C	0.18–0.22	0.15–0.25	0.18–0.25	0.08–0.20	0.14–0.20	0.14–0.20	0.24–0.32	0.24–0.32	0.14–0.20
Copper	0.50–1.00	0.50–1.5	0.75 max	0.50 max	0.50 max	...

^A New designation established in accordance with Practice E 527 and SAE J 1086.

^B For small diameter or thin walls or both, where many drawing passes are required, a carbon maximum of 0.040 % is necessary in grades TP304L and TP316L. Small outside diameter tubes are defined as those less than 0.500 in. (12.7 mm) in outside diameter and light wall tubes as those less than 0.049 in. (1.24 mm) in average wall thickness (0.044 in. (1.12 mm) in minimum wall thickness).

^C The method of analysis for nitrogen shall be a matter of agreement between the purchaser and manufacturer.