



Designation: A 847 – 99a

Standard Specification for Cold-Formed Welded and Seamless High-Strength, Low- Alloy Structural Tubing with Improved Atmospheric Corrosion Resistance¹

This standard is issued under the fixed designation A 847; 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 cold-formed welded and seamless high-strength, low-alloy round, square, rectangular, or special shaped structural tubing for welded, riveted, or bolted construction of bridges and buildings and for general structural purposes where high strength and enhanced atmospheric corrosion resistance are required (Note 1). The atmospheric corrosion resistance of this steel in most environments is substantially better than carbon steel with or without copper addition (Note 2). When properly exposed to the atmosphere, this steel can be used bare (unpainted) for many applications. When this steel is used in welded construction, the welding procedure shall be suitable for the steel and the intended service.

1.2 This tubing is produced in welded sizes with a maximum periphery of 64 in. (1626 mm) and a maximum wall of 0.625 in. (15.88 mm), and in seamless with a maximum periphery of 32 in. (813 mm) and a maximum wall of 0.500 in. (12.70 mm). Tubing having other dimensions may be furnished provided such tubing complies with all other requirements of this specification.

1.3 The values stated in inch-pound units are to be regarded as the standard.

NOTE 1—Products manufactured to this specification may not be suitable for those applications where low temperature notch toughness properties may be important, such as dynamically loaded elements in welded structures, etc.

NOTE 2—For methods of estimating the atmospheric corrosion resistance of low alloy steels see Guide G 101 or actual data.

2. Referenced Documents

2.1 ASTM Standards:

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products²

A 700 Practices for Packaging, Marking, and Loading

¹ This specification is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.09 on Carbon Steel Tubular Products.

Current edition approved June 10, 1999. Published July 1999. Originally published as A 847 – 85. Last previous edition A 847 – 99.

² Annual Book of ASTM Standards, Vol 01.03.

Methods for Steel Products for Domestic Shipment³
A 751 Test Methods, Practices, and Terminology for
Chemical Analysis of Steel Products²
G 101 Guide For Estimating the Atmospheric Corrosion
Resistance of Low-Alloy Steels⁴

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 ASTM specification number,
- 3.1.2 Quantity (feet, metres, or number of lengths),
- 3.1.3 Name of material (cold-formed tubing),
- 3.1.4 Method of manufacture (welded or seamless),
- 3.1.5 Size (outside diameter and nominal wall thickness for round tubing and the outside dimensions and nominal wall thickness for square and rectangular tubing),
- 3.1.6 Length (specific or random, see 10.3),
- 3.1.7 End condition (see 14.2),
- 3.1.8 Burr removal (see 14.2),
- 3.1.9 Certification (see Section 17),
- 3.1.10 End use, and
- 3.1.11 Special requirements.

4. Process

4.1 The steel shall be made by one or more of the following processes: open hearth, basic oxygen, or electric furnace.

5. Manufacture

5.1 The tubing shall be made by a welded or seamless process.

5.2 Welded tubing shall be made from flat-rolled steel by the electric-resistance welding or electric-fusion welding process. The longitudinal butt joint shall be welded across its thickness in such a manner that the structural design strength of the tubing section is assured.

5.2.1 Structural tubing welded by the electric-resistance method is normally furnished without removal of inside flash.

³ Annual Book of ASTM Standards, Vol 01.05.

⁴ Annual Book of ASTM Standards, Vol 03.02.

5.3 The tubing may be stress relieved or annealed, as is considered necessary by the tubing manufacturer, to conform to the requirements of this specification.

6. Chemical Composition

6.1 The choice and use of alloying elements combined with carbon, manganese, phosphorus, sulphur, and copper shall be within the limits prescribed in Section 7 to give the mechanical properties prescribed in Table 1 and to provide the atmospheric corrosion resistance of 1.1. The choice and use of these elements shall be made by the manufacturer and included and reported in the heat analysis to identify the type of steel applied. Elements commonly added include chromium, nickel, silicon, vanadium, titanium, and zirconium. For Specification A 847 material, the atmospheric corrosion-resistance index, calculated on the basis of the chemical composition of the steel as described in Guide G 101, shall be 6.0 or higher.

NOTE 3—The user is cautioned that the Guide G 101 predictive equation for calculation of an atmospheric corrosion-resistance index has been verified only for the composition limits stated in that guide.

7. Heat Analysis

7.1 Each heat analysis shall conform to the requirements specified in Table 2 for heat analysis.

8. Product Analysis

8.1 The tubing shall be capable of conforming to the requirements specified in Table 2 for product analysis.

8.2 If product analyses are made, they shall be made using test specimens taken from two lengths of tubing from each lot of 500 lengths, or a fraction thereof, or two pieces of flat-rolled stock from each lot of a corresponding quantity of flat-rolled stock. Methods and practices relating to chemical analysis shall be in accordance with Test Methods, Practices, and Terminology A 751. Such product analyses shall conform to the requirements specified in Table 2 for product analysis.

8.3 If both product analyses representing a lot fail to conform to the specified requirements, the lot shall be rejected.

8.4 If only one product analysis representing a lot fails to conform to the specified requirements, product analyses shall be made using two additional test specimens taken from the lot. Both additional product analyses shall conform to the specified requirements or the lot shall be rejected.

9. Tensile Requirements

9.1 The material, as represented by the test specimen, shall conform to the tensile property requirements prescribed in Table 1.

10. Permissible Variations and Dimensions

10.1 Outside Dimensions:

TABLE 1 Tensile Requirements for Round and Shaped Tubing

Tensile strength, min, psi (MPa)	70 000 (483)
Yield strength, min, psi (MPa)	50 000 (345)
Elongation in 2 in. (50.8 mm) min, %	19 ^A

^A Applies to specified wall thicknesses 0.120 in. (3.05 mm) and over. For lighter wall thicknesses, elongation shall be by agreement with the manufacturer.

TABLE 2 Chemical Requirements

Elements	Heat Analysis	Product Analysis
Carbon, max	0.20	0.24
Manganese, max	1.35	1.40
Phosphorus, max	0.15	^A
Sulphur, max	0.05	0.06
Copper, min	0.20 ^B	0.18 ^B

^A Because of the degree to which phosphorus segregates, product analysis for this element is not technologically appropriate for rephosphorized steels unless misapplication is clearly indicated.

^B If chromium and silicon contents are each 0.50 minimum, then the copper minimums do not apply.

10.1.1 *Round Structural Tubing*—The outside diameter shall not vary more than $\pm 0.5\%$, rounded to the nearest 0.005 in. (0.13 mm), of the nominal outside diameter size specified for nominal outside diameters 1.900 in. (48.26 mm) and smaller; $\pm 0.75\%$, rounded to the nearest 0.005 in., for nominal outside diameters 2 in. (50.8 mm) and larger. The outside diameter measurements shall be made at positions at least 2 in. (50.8 mm) from either end of the tubing.

10.1.2 *Square and Rectangular Structural Tubing*—The specified dimensions, measured across the flats at a position at least 2 in. (50.8 mm) from either end of the tubing and including an allowance for convexity or concavity, shall not exceed the plus and minus tolerances shown in Table 3.

10.2 *Wall Thickness*—The minimum wall thickness at any point of measurement on the tubing shall be not more than 10 % less than the nominal wall thickness specified. The maximum wall thickness, excluding the weld seam of welded tubing, shall be not more than 10 % greater than the nominal wall thickness specified. The wall thickness on square and rectangular tubing is to be measured at the center of the flat.

10.3 *Length*—Structural tubing is normally produced in random mill lengths 5 ft (1.5 m) and over, in multiple lengths, and in specified mill lengths (see Section 3). When specified mill lengths are ordered, the length tolerance shall be in accordance with Table 4.

10.4 *Straightness*—The permissible variation for straightness of structural tubing shall be $\frac{1}{8}$ in. times the number of feet (10.4 mm times the number of metres) of total length divided by 5.

10.5 *Squareness of Sides*—For square and rectangular structural tubing, adjacent sides may deviate from 90° by a tolerance of $\pm 2^\circ$ maximum.

10.6 *Radius of Corners*—For square or rectangular structural tubing, the radius of any outside corner of the section shall not exceed three times the specified wall thickness.

TABLE 3 Outside Dimension Tolerances for Square and Rectangular Tubing

Largest outside dimension across flats, in. (mm)	Tolerance, \pm in. (mm) ^A
2½ (63.5) and under	0.020 (0.51)
Over 2½ to 3½ (63.5 to 88.9), incl	0.025 (0.64)
Over 3½ to 5½ (88.9 to 139.7), incl	0.030 (0.76)
Over 5½ (139.7)	1 %

^A Tolerances include allowance for convexity or concavity. For rectangular sections, the tolerance calculated for the larger flat dimension shall also apply to the smaller flat dimension. This tolerance may be increased 50 % when applied to the smaller dimension if the ratio of the external sides is in the range of 1.5 to 3, inclusive; the tolerance may be increased 100 % when the ratio exceeds 3.