



Designation: A 860/A 860M – 00

# Standard Specification for Wrought High-Strength Low-Alloy Steel Butt-Welding Fittings<sup>1</sup>

This standard is issued under the fixed designation A 860/A 860M; 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 wrought high-strength low-alloy steel butt-welding fittings of seamless and electric fusion-welded construction covered by the latest revisions of ANSI B16.9, ANSI 16.28, and MSS-SP-75. Butt-welding fittings differing from these ASME and MSS standards shall be furnished in accordance with Supplementary Requirement S58 of Specification A 960. These fittings are for use in high-pressure gas and oil transmission and distribution systems.

1.2 Optional supplementary requirements are provided for fittings when a greater degree of examination is desired. One or more of the supplementary requirements may be specified in the order.

1.3 This specification does not cover cast-welding fittings or fittings machined from castings.

1.4 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 this specification. Unless the order specifies the applicable “M” specification designation (SI units), the material shall be furnished to inch-pound units.

## 2. Referenced Documents

### 2.1 ASTM Standards:

A 530/A 530M Specification for General Requirements for Specialized Carbon and Alloy Steel Pipe<sup>2</sup>

A 960 Specification for Common Requirements for Wrought Steel Piping Fittings<sup>2</sup>

### 2.2 AWS Standard:

AWS 5.18 Specification for Carbon Steel Metals for Gas Shielded Arc Welding<sup>3</sup>

2.3 ASME Boiler and Pressure Vessel Code:<sup>4</sup>  
Section V, Nondestructive Examination  
Section VIII, Division 1, Pressure Vessels

## 3. Ordering Information

3.1 In addition to the requirements of Specification A 960, the following ordering information applies:

3.1.1 Grade Symbol,

3.1.2 Requirements for certification of test report.

## 4. General Requirements

4.1 Product furnished to this specification shall conform to the requirements of Specification A 960, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification A 960 constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A 960, this specification shall prevail.

## 5. Materials and Manufacture

5.1 The material for fittings shall be fully killed fine-grain material made by a melting process that is intended to produce rounded, well dispersed, fine sulphide inclusions, that promote good notch toughness, assists in the resistance to hydrogen induced cracking, and for weldability suitable for field welding.

5.2 Starting materials shall consist of plate, sheet, forgings, forging quality bar, and seamless or fusion-welded tubular products with filler metal added. The chemical composition shall conform to Table 1.

5.3 A starting material that specifically requires the addition of any element beyond those listed in Table 1 is not permitted. This does not preclude the use of deoxidizers.

<sup>1</sup> 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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<sup>2</sup> Annual Book of ASTM Standards, Vol 01.01.

<sup>3</sup> Available from American Welding Society, 550 N. W. Lajeune Rd., Miami, FL 33135.

<sup>4</sup> Available from American Society of Mechanical Engineers, 345 E. 47th St., New York, NY 10017.

**TABLE 1 Chemical Requirements**

	Composition %	
	Heat Analysis	
Carbon	0.20 <sup>A</sup>	
Manganese	1.00–1.45	All values are maximum unless a range is stated
Phosphorus	0.030	
Sulfur	0.010	
Silicon	0.15–0.40 <sup>B</sup>	
Nickel	0.50 <sup>C</sup>	
Chromium	0.30 <sup>C</sup>	
Molybdenum	0.25 <sup>C</sup>	
Copper	0.35 <sup>C</sup>	
Titanium	0.05	
Vanadium	0.10	
Columbium	0.04	
Vanadium plus Columbium	0.12	
Aluminum	0.06	

<sup>A</sup> The carbon equivalent, as calculated by the following formula, shall not exceed 0.42 %:

$$CE = C + \frac{Mn}{6} + \frac{Cr + Mo + V}{5} + \frac{Ni + Cu}{15}$$

<sup>B</sup> If vacuum carbon deoxidation is used, silicon shall not exceed 0.10 % by heat analysis and 0.12 % by product analysis.

<sup>C</sup> The sum of Ni + Cr + Mo + Cu shall not exceed 1.0 %.

5.4 Starting material shall not require a preheat for field welding provided that the restrictions of ASME Boiler and Pressure Vessel Code, Section VIII, Paragraph UW-30 are complied with.

5.5 Forging or shaping operations may be performed by hammering, pressing, piercing, extruding, upsetting, rolling, bending, fusion, welding, machining, or by a combination of these operations.

5.6 All welds including welds in tubular products from which the fittings are made shall be:

5.6.1 Made by welders, welding operators, and welding procedures qualified under the provisions of ASME Boiler and Pressure Vessel Code, Section IX,

5.6.2 Heat treated in accordance with Section 6 of this specification, and

5.6.3 Radiographically examined throughout the entire length of each weld in accordance with Articles 1 and 2 of ASME Boiler and Pressure Vessel Code, Section V with acceptance limits in accordance with Paragraph UW-51 of ASME Boiler and Pressure Vessel Code, Section VIII.

5.7 The welded joints of the fittings shall be furnished in accordance with the requirements of Paragraph UW-35(a) of ASME Boiler and Pressure Vessel Code, Section VIII.

5.8 All butt-weld tees manufactured by cold-forming methods shall be liquid penetrant or magnetic particle examined by one of the methods specified in Supplementary Requirements S69 or S70 of Specification A 960. This examination shall be performed in accordance with a written procedure and shall be performed after final heat treatment. Only the side wall area of the tees need be examined. This area is defined by a circle that covers the area from the weld bevel of the branch outlet to the center line of the body or run. Internal and external surfaces shall be examined when size permits accessibility. No cracks shall be permitted. Other imperfections shall be treated in accordance with Section 12.1 on finish. After the removal of any cracks, the tees shall be re-examined by the original

method. Acceptable tees shall be marked with the symbol PT or MT, as applicable, to indicate compliance. NDE personnel shall be qualified in accordance with SNT-TC-1A.

5.9 All caps machined from bar stock shall be examined by liquid penetrant or magnetic particle in accordance with Supplementary Requirements S69 or S70 of Specification A 960, and with personnel qualifications, acceptance criteria, and marking as in 5.8.

## 6. Heat Treatment

6.1 All fittings shall be furnished in the heat-treated condition. Fittings formed above the transformation temperature or upon which welding is performed, shall be cooled to below the lower critical temperature prior to heat treatment. Fittings shall subsequently be heat treated by normalizing, quenching, and tempering or stress relieving in accordance with Specification A 960.

## 7. Chemical Composition

7.1 The chemical composition of the steel shall conform to the requirements prescribed in Table 1.

7.2 The steel shall not contain any unspecified elements for the ordered grade to the extent that it conforms to the requirements of another grade for which that element is a specified element having a required minimum content.

7.3 Analysis of each heat of steel shall be made from a sample taken preferably during the pouring of the heat. The results shall conform to Table 1 for either heat or Specification A 960 for product analysis limits as applicable.

7.4 The fittings manufacturer shall make a product analysis per heat from either the starting material or from a fitting. The chemical composition thus determined shall conform to Table 1. The product analysis shall be the basis for rejection. For referee purposes, Methods, Practices, and Terminology A 751 shall apply.

7.5 The carbon equivalent of the base metal, as determined by the following formula, shall not exceed 0.42 % for the product analysis:

$$CE = C + \frac{Mn}{6} + \frac{Cr + Mo + V}{5} + \frac{Ni + Cu}{15}$$

7.6 Weld metal used in the construction of the fittings shall conform to the tensile and impact requirements of 9.4 and 8.1 after heat treatment in accordance with Section 6. A chemical analysis shall be performed on deposited weld metal for each heat of filler metal or, for submerged arc welding, each heat of filler metal and batch of flux. The weld metal shall be deposited in accordance with the qualified weld procedure.

7.7 Only the carbon content of the deposited weld-metal composition need comply with the requirements of Table 1. The nickel content of the deposited weld metal shall not exceed 1.0 %.

## 8. Notch Toughness Properties

8.1 The notch toughness properties of the fittings shall conform to the requirements listed in Table 2. The testing shall be performed in accordance with Test Methods and Definitions A 370. Full size Charpy, V-notch specimens shall be used whenever possible. Small size specimens shall be used only