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Standard Specification for Electric-Fusion-Welded Steel Pipe for High-Pressure Service at Moderate Temperatures¹

This standard is issued under the fixed designation A672/A672M; 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 specification² covers steel pipe: electric-fusion-welded with filler metal added, fabricated from pressure-vessel quality plate of any of several analyses and strength levels and suitable for high-pressure service at moderate temperatures. Heat treatment may or may not be required to attain the desired properties or to comply with applicable code requirements. Supplementary requirements are provided for use when additional testing or examination is desired.

1.2 The specification nominally covers pipe 16 in. (~~405 mm~~)[400 mm] in outside diameter or larger with wall thicknesses up to 3 in. (~~75 mm~~)[75 mm], inclusive. Pipe having other dimensions may be furnished provided it complies with all other requirements of this specification.

1.3 Several grades and classes of pipe are provided.

1.3.1 *Grade* designates the type of plate used.

1.3.2 *Class* designates the type of heat treatment performed during manufacture of the pipe, whether the weld is radiographically examined, and whether the pipe has been pressure tested as listed in 1.3.3.

1.3.3 Class designations are as follows (Note 1):

Class	Heat Treatment on Pipe	Radiography, see Section	Pressure Test, see Section
10	none	none	none
11	none	9	none
12	none	9	8.3
13	none	none	8.3
20	stress relieved, see 5.3.1	none	none
21	stress relieved, see 5.3.1	9	none
22	stress relieved, see 5.3.1	9	8.3
23	stress relieved, see 5.3.1	none	8.3
30	normalized, see 5.3.2	none	none
31	normalized, see 5.3.2	9	none
32	normalized, see 5.3.2	9	8.3
33	normalized, see 5.3.2	none	8.3
40	normalized and tempered, see 5.3.3	none	none
41	normalized and tempered, see 5.3.3	9	none
42	normalized and tempered, see 5.3.3	9	8.3
43	normalized and tempered, see 5.3.3	none	8.3
50	quenched and tempered, see 5.3.4	none	none
51	quenched and tempered, see 5.3.4	9	none
52	quenched and tempered, see 5.3.4	9	8.3
53	quenched and tempered, see 5.3.4	none	8.3

NOTE 1—Selection of materials should be made with attention to temperature of service. For such guidance, Specification A20/A20M may be consulted.

~~1.4 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 The values stated in either SI units or inch-pound units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard. The inch-pound units shall apply unless the “M” designation of this specification is specified in the order.

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 A01.09 on Carbon Steel Tubular Products.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-672 in Section II of that Code.

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

2. Referenced Documents

2.1 ASTM Standards:³

- A20/A20M [Specification for General Requirements for Steel Plates for Pressure Vessels](#)
- A370 [Test Methods and Definitions for Mechanical Testing of Steel Products](#)
- A435/A435M [Specification for Straight-Beam Ultrasonic Examination of Steel Plates](#)
- A530/A530M [Specification for General Requirements for Specialized Carbon and Alloy Steel Pipe](#)
- A577/A577M [Specification for Ultrasonic Angle-Beam Examination of Steel Plates](#)
- A578/A578M [Specification for Straight-Beam Ultrasonic Examination of Rolled Steel Plates for Special Applications](#) ⁴
- E109 [Method for Dry Powder Magnetic Particle Inspection](#)⁴—Discontinued 1981; Method for Dry Powder Magnetic Particle Inspection; Replaced by E709 ⁴
- E138 [Method for Wet Magnetic Particle Inspection](#)⁴—Discontinued 1981; Method for Wet Magnetic Particle Inspection; Replaced by E709
- E110 [Test Method for Indentation Hardness of Metallic Materials by Portable Hardness Testers](#)
- E165 [Practice for Liquid Penetrant Examination for General Industry](#)
- E709 [Guide for Magnetic Particle Testing](#)
- 2.1.1 [Plate Steel Specifications \(Table 1\)](#) ⁴
- A202/A202M [Specification for Pressure Vessel Plates, Alloy Steel, Chromium-Manganese-Silicon](#)
- A204/A204M [Specification for Pressure Vessel Plates, Alloy Steel, Molybdenum](#)
- A285/A285M [Specification for Pressure Vessel Plates, Carbon Steel, Low- and Intermediate-Tensile Strength](#)
- A299/A299M [Specification for Pressure Vessel Plates, Carbon Steel, Manganese-Silicon](#)
- A302/A302M [Specification for Pressure Vessel Plates, Alloy Steel, Manganese-Molybdenum and Manganese-Molybdenum-Nickel](#)
- A515/A515M [Specification for Pressure Vessel Plates, Carbon Steel, for Intermediate- and Higher-Temperature Service](#)
- A516/A516M [Specification for Pressure Vessel Plates, Carbon Steel, for Moderate- and Lower-Temperature Service](#)
- A533/A533M [Specification for Pressure Vessel Plates, Alloy Steel, Quenched and Tempered, Manganese-Molybdenum and Manganese-Molybdenum-Nickel](#)
- A537/A537M [Specification for Pressure Vessel Plates, Heat-Treated, Carbon-Manganese-Silicon Steel](#)

2.2 ASME Boiler and Pressure Vessel Code:⁵

- Section II, Material Specifications
- Section III, Nuclear Vessels
- Section VIII, Unfired Pressure Vessels
- Section IX, Welding Qualifications

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

- 3.1.1 A lot shall consist of 200 ft (61 m)[60 m] or fraction thereof of pipe from the same heat of steel.
- 3.1.2 The description of a lot may be further restricted by use of Supplementary Requirement S14.

4. Ordering Information

- 4.1 The inquiry and order for material under this specification should include the following information:
- 4.1.1 Quantity (feet, metres, or number of lengths),
- 4.1.2 Name of material (steel pipe, electric-fusionwelded),
- 4.1.3 Specification number,
- 4.1.4 Grade and class designations (see 1.3),
- 4.1.5 Size (inside or outside diameter, nominal or minimum wall thickness),
- 4.1.6 Length (specific or random),
- 4.1.7 End finish (11.4),
- 4.1.8 Purchase options, if any (see 5.2.3, 11.3, 14.1 and Sections 16, 20.1, 21, 22 of Specification A530/A530M), and
- 4.1.9 Supplementary requirements, if any, (refer to S1 through S14).

5. Materials and Manufacture

5.1 *Materials*—The steel plate material shall conform to the requirements of the applicable plate specification for pipe grade ordered as listed in Table 1.

³ 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.

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

⁵ Withdrawn.

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

5.2 Welding:

5.2.1 The joints shall be double-welded, full-penetration welds made in accordance with procedures and by welders or welding operators qualified in accordance with the ASME Boiler and Pressure Vessel Code, Section IX.

5.2.2 The welds shall be made either manually or automatically by an electric process involving the deposition of filler metal.

5.2.3 The welded joint shall have positive reinforcement at the center of each side of the weld, but not more than $\frac{1}{8}$ in. (~~3.2 mm~~)[3 mm]. This reinforcement may be removed at the manufacturer's option or by agreement between the manufacturer and purchaser. The contour of the reinforcement shall be smooth, and the deposited metal shall be fused smoothly and uniformly into the plate surface.

5.2.4 When radiographic examination in accordance with 9.1 is to be used, the weld reinforcement shall be governed by the more restrictive provisions of UW-51 of Section VIII of the ASME Boiler and Pressure Vessel Code instead of 5.2.3 of this specification.

TABLE 1 Plate Specification

Pipe Grade	Type of Steel	ASTM Specification	
		No.	Grade
A 45	plain carbon	A285/A285M	A
A 50	plain carbon	A285/A285M	B
A 55	plain carbon	A285/A285M	C
B 60	plain carbon, killed	A515/A515M	60
B 65	plain carbon, killed	A515/A515M	65
B 70	plain carbon, killed	A515/A515M	70
C 55	plain carbon, killed, fine grain	A516/A516M	55
C 60	plain carbon, killed, fine grain	A516/A516M	60
C 65	plain carbon, killed, fine grain	A516/A516M	65
C 70	plain carbon, killed, fine grain	A516/A516M	70
D 70	manganese-silicon— normalized	A537/A537M	1
D80	manganese-silicon—Q&T ^A	A537/A537M	2
H 75	manganese-molybdenum— normalized	A302/A302M	A
H 80	manganese-molybdenum— normalized	A302/A302M	B, C or D
J 80	manganese-molybdenum— Q&T ^A	A533/A533M	Cl-1 ^B
J 90	manganese-molybdenum— Q&T ^A	A533/A533M	Cl-2 ^B
J 100	manganese-molybdenum— Q&T ^A	A533/A533M	Cl-3 ^B
K 75	chromium-manganese-silicon	A202/A202M	A
K 85	chromium-manganese-silicon	A202/A202M	B
L 65	molybdenum	A204/A204M	A
L 70	molybdenum	A204/A204M	B
L 75	molybdenum	A204/A204M	C
N 75	manganese-silicon	A299/A299M	...

^A Q&T = quenched and tempered.

^B Any grade may be furnished.

5.3 Heat Treatment—All classes other than 10, 11, 12 and 13 shall be heat treated in furnace controlled to ± 25 °F (14 °C)[15 °C] and equipped with a recording pyrometer so that heating records are available. Heat treating after forming and welding shall be to one of the following:

5.3.1 Classes 20, 21, 22, and 23 pipe shall be uniformly heated within the post-weld heat-treatment temperature range indicated in Table 2 for a minimum of 1 h/in. [0.4 hr/cm] of thickness or 1 h, whichever is greater.

5.3.2 Classes 30, 31, 32, and 33 pipe shall be uniformly heated to a temperature in the austenitizing range and not exceeding the maximum normalizing temperature indicated in Table 2 and subsequently cooled in air at room temperature.

5.3.3 Classes 40, 41, 42, and 43 pipe shall be normalized in accordance with 5.3.2. After normalizing, the pipe shall be reheated to the tempering temperature indicated in Table 2 as a minimum and held at temperature for a minimum of $\frac{1}{2}$ h/in. of thickness or $\frac{1}{2}$ h/in. [0.2 hr/cm] of thickness or $\frac{1}{2}$ h, whichever is greater, and air cooled.

5.3.4 Classes 50, 51, 52, and 53 pipe shall be uniformly heated to a temperature in the austenitizing range, and not exceeding the maximum quenching temperature indicated in Table 2 and subsequently quenched in water or oil. After quenching the pipe

shall be reheated to the tempering temperature indicated in Table 2 as a minimum and held at temperature for a minimum of $\frac{1}{2}$ h/in. of thickness or $\frac{1}{2}$ h/in. [0.2 hr/cm] of thickness or $\frac{1}{2}$ h, whichever is greater, and air cooled.

6. General Requirements

6.1 Material furnished to this specification shall conform to the applicable requirements of the current edition of Specification A530/A530M unless otherwise provided herein.

7. Chemical Composition

7.1 *Product Analysis of Plate*—The pipe manufacturer shall make an analysis of each mill heat of plate material. The product analysis so determined shall meet the requirements of the plate specification to which the material was ordered.

7.2 *Product Analysis of Weld*—The pipe manufacturer shall make an analysis of the finished deposited weld material from each 500 ft (152 m) [150 m] or fraction thereof. Analysis shall conform to the welding procedure for deposited weld metal.

7.3 Analysis may be taken from the mechanical test specimens. The results of the analyses shall be reported to the purchaser.

7.4 If the analysis of one of the tests specified in 7.1 or 7.2 does not conform to the requirements specified, analyses shall be made on additional pipes of double the original number from the same lot, each of which shall conform to the requirements specified. Nonconforming pipe shall be rejected.

8. Mechanical Properties

8.1 Tension Test:

8.1.1 *Requirements*—Transverse tensile properties of the welded joint shall meet the minimum requirements for ultimate tensile strength of the specified plate material. In addition for Grades Dxx, Hxx, Jxx, and Nxx in Classes 3x, 4x, and 5x transverse tensile properties of the base plate, shall be determined on specimens cut from the heat-treated pipe. These properties shall meet the mechanical test requirements of the plate specification.

8.1.2 *Number of Tests*—One test specimen shall be made to represent each lot of finished pipe.

8.1.3 *Test Specimen Location and Orientation*—The test specimens shall be taken transverse to the weld at the end of the finished pipe and may be flattened cold before final machining to size.

8.1.4 *Test Method*—The test specimen shall be made in accordance with QW-150 in Section IX of the ASME Boiler and Pressure Vessel Code. The test specimen shall be tested at room temperature in accordance with Test Methods and Definitions A370.

8.2 Transverse-Guided-Weld-Bend Tests:

8.2.1 *Requirements*—The bend test shall be acceptable if no cracks or other defects exceeding $\frac{1}{8}$ in. (3.2 mm) [3 mm] in any direction are present in the weld metal or between the weld and the base metal after bending. Cracks that originate along the edges of the specimen during testing, and that are less than

$\frac{1}{4}$ in. (6.4 mm) [6 mm] measured in any direction shall not be considered.

8.2.2 *Number of Tests*—One test (two specimens) shall be made to represent each lot of finished pipe.

8.2.3 *Test Specimen Location and Orientation*—Two bend test specimens shall be taken transverse to the weld at the end of the finished pipe. As an alternative by agreement between the purchaser and the manufacturer, the test specimens may be taken from a test plate of the same material as the pipe, the test plate being attached to the end of the cylinder and welded as a prolongation of the pipe longitudinal seam.

8.2.4 *Test Method*—The test requirements of Test Methods and Definitions A370, paragraph A2.5.1.7 shall be met. For wall thickness over $\frac{3}{8}$ in. (9.5 mm) [10 mm] but less than $\frac{3}{4}$ in. (19.0 mm) [19 mm] side-bend tests may be made instead of the face and root-bend tests. For wall thicknesses $\frac{3}{4}$ in. [19 mm] and over both specimens shall be subjected to the side-bend test.

8.3 *Pressure Test*—Classes X2 and X3 pipe shall be tested in accordance with Specification A530/A530M, Section 20.

9. Radiographic Examination

9.1 The full length of each weld of Classes X1 and X2 shall be radiographically examined in accordance with and meet the requirements of the ASME Boiler and Pressure Vessel Code, Section VIII, paragraph UW-51.

9.2 Radiographic examination may be performed prior to heat treatment.

10. Rework

10.1 *Elimination of Surface Imperfections*—Unacceptable surface imperfections shall be removed by grinding or machining. The remaining thickness of the section shall be no less than the minimum specified in Section 11. The depression after grinding or machining shall be blended uniformly into the surrounding surface.

10.2 Repair of Base Metal Defects by Welding:

10.2.1 The manufacturer may repair, by welding, base metal where defects have been removed, provided the depth of the repair cavity as prepared for welding does not exceed $\frac{1}{3}$ of the nominal thickness and the requirements of 10.2.2-10.2.6 are met. Base metal defects in excess of these may be repaired with proper approval of the customer.

10.2.2 The defect shall be removed by suitable mechanical or thermal cutting or gouging methods and the cavity prepared for repair welding.