



**Designation: A250/A250M-05 Designation: A250/A250M – 05 (Reapproved 2009)**

## Standard Specification for Electric-Resistance-Welded Ferritic Alloy-Steel Boiler and Superheater Tubes<sup>1</sup>

This standard is issued under the fixed designation A250/A250M; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

### 1. Scope <sup>\*</sup>

1.1 This specification<sup>2</sup> covers several grades, designated T1, T1a, T1b, T2, T11, T12 and T22, of minimum-wall-thickness, electric-resistance-welded, carbon-molybdenum and chromium-molybdenum alloy-steel, boiler and superheater tubes.

1.2 The tubing sizes and thicknesses usually furnished to this specification are ½ to 5 in. [12.7 to 127 mm] in outside diameter and 0.035 to 0.320 in. [0.9 to 8.1 mm], inclusive, in minimum wall thickness. Tubing having other dimensions may be furnished, provided such tubes comply with all other requirements of this specification.

1.3 Mechanical property requirements do not apply to tubing smaller than ⅛ in. [3.2 mm] in inside diameter or 0.015 in. [0.4 mm] in thickness.

1.4 An optional supplementary requirement is provided for non-destructive examination for certain ASME applications.

1.5 The values stated in either ~~inch-pound~~SI units or ~~SI~~inch-pound units are to be ~~regarded~~regarded separately as ~~the~~standard. ~~Within the text, the SI units are shown in brackets. The values stated in each system are~~may not be exact equivalents; therefore, each system ~~must~~shall be used independently of the other. Combining values from the two systems may result in non-conformance with the ~~specification. The standard.~~

1.5.1 Within the text, the SI units are shown in brackets.

1.5.2 The inch-pound units shall apply unless the “M” designation of this specification is specified in the order.

### 2. Referenced Documents

2.1 *ASTM Standards:*<sup>3</sup>

A1016/A1016M Specification for General Requirements for Ferritic Alloy Steel, Austenitic Alloy Steel, and Stainless Steel Tubes

E213 Practice for Ultrasonic Testing of Metal Pipe and Tubing

E273 Practice for Ultrasonic Testing of the Weld Zone of Welded Pipe and Tubing

### 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 Quantity (feet, metres, or number of lengths),

3.1.2 Name of material (electric-resistance-welded tubes),

3.1.3 Grade (Table 1),

3.1.4 Size (outside diameter or minimum wall thickness),

3.1.5 Length (specific or random),

3.1.6 Optional requirement (7.3.6),

3.1.7 Test report required (see Certification Section of Specification A1016/A1016M),

3.1.8 Specification designation, and

3.1.9 Special requirements and any supplementary requirements selected.

### 4. General Requirements

4.1 Product furnished under this specification shall conform to the applicable requirements of Specification A1016/A1016M,

<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 A01.10 on Stainless and Alloy Steel Tubular Products.

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<sup>2</sup> For ASME Boiler and Pressure Vessel Code applications see related Specification SA-250 in Section II of that Code.

<sup>3</sup> 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.

**TABLE 1 Chemical Requirements**

Element	Composition, %						
	Grade T1	Grade T1a	Grade T1b	Grade T2	Grade T11	Grade T12	Grade T22
Carbon	0.10–0.20	0.15–0.25	0.14 max	0.10–0.20	0.05–0.15	0.05–0.15	0.15 max
Manganese	0.30–0.80	0.30–0.80	0.30–0.80	0.30–0.61	0.30–0.60	0.30–0.61	0.30–0.60
Phosphorus, max	0.025	0.025	0.025	0.025	0.025	0.030	0.025
Sulfur, max	0.025	0.025	0.025	0.020	0.020	0.020	0.020
Silicon	0.10–0.50	0.10–0.50	0.10–0.50	0.10–0.30	0.50–1.00	0.50 max	0.50 max
Molybdenum	0.44–0.65	0.44–0.65	0.44–0.65	0.44–0.65	0.44–0.65	0.44–0.65	0.87–1.13
Chromium	...	...	...	0.50–0.81	1.00–1.50	0.80–1.25	1.90–2.60

including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification A1016/A1016M constitutes nonconformance with this specification. In case of conflicts with the requirements of this specification and Specification A1016/A1016M, this specification shall prevail.

## 5. Materials and Manufacture

5.1 The steel shall be killed.

5.2 The tubes shall be made by electric-resistance welding.

### 5.3 Heat Treatment

5.3.1 After welding, or when cold finished, after the final cold-drawing pass, all tubes shall be heat treated and, except as provided in 5.3.2, furnished in the full annealed, isothermal annealed, normalized, or normalized and tempered condition at the option of the manufacturer. If furnished in the normalized and tempered condition, the minimum tempering temperature shall be 1200 °F [650 °C], except T22 shall be tempered at 1250 °F [676 °C] minimum.

5.3.2 When grades T1, T1a, T1b, and T2 are cold finished, the tubes may, at the option of the manufacturer, be heat treated after the final cold-drawing pass at a temperature of 1200 °F or higher, provided one of the heat treatments specified in 5.3.1 was applied after welding.

## 6. Chemical Composition

6.1 The steel shall conform to the requirements given in Table 1.

### 6.2 Product Analysis

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

6.2.2 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 (See 8.1) 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.

## 7. Mechanical Requirements

### 7.1 Tensile Requirements

7.1.1 The material shall conform to the requirements as to tensile properties given in Table 2.

7.1.2 Table 3 gives the computed minimum elongation values for each 1/32-in. [0.8-mm] decrease in wall thickness. Where the wall thickness lies between two values given in Table 3, the minimum elongation value shall be determined by the following equation:

$$E = 48t + 15.00 \quad [E = 1.87t + 15.00]$$

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where:

$E$  = elongation in 2 in. [50 mm] %, and

$t$  = actual thickness of specimen, in.[mm].

**TABLE 2 Tensile Requirements**

Grade	T1	T1a	T1b	T2	T11	T12	T22
Tensile strength, min, ksi [MPa]	55 [380]	60 [415]	53 [365]	60 [415]	60 [415]	60 [415]	60 [415]
Yield strength, min, ksi [MPa]	30 [205]	32 [220]	28 [195]	30 [205]	30 [205]	32 [220]	30 [205]
Elongation in 2 in. or 50 mm, min, %	30	30	30	30	30	30	30
For longitudinal strip tests a deduction shall be made for each 1/32-in. [0.8-mm] decrease in wall thickness below 5/16 in. [8 mm] from the basic minimum elongation of the following percentage points	1.50 <sup>A</sup>	1.50 <sup>A</sup>	1.50 <sup>A</sup>	1.50 <sup>A</sup>	1.50 <sup>A</sup>	1.50 <sup>A</sup>	1.50 <sup>A</sup>

<sup>A</sup> See Table 3 for the computed minimum values.