



Designation: A671/A671M – 10

Standard Specification for Electric-Fusion-Welded Steel Pipe for Atmospheric and Lower Temperatures¹

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1. Scope*

1.1 This specification² covers electric-fusion-welded steel pipe with filler metal added, fabricated from pressure vessel quality plate of several analyses and strength levels and suitable for high-pressure service at atmospheric and lower 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. [400 mm] in outside diameter or larger and of 1/4 in. [6 mm] wall thickness or greater. 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 as listed in 5.1.

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:
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

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-671 in Section II of that Code.

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
60	normalized and precipitation heat treated	none	none
61	normalized and precipitation heat treated	9	none
62	normalized and precipitation heat treated	9	8.3
63	normalized and precipitation heat treated	none	8.3
70	quenched and precipitation heat treated	none	none
71	quenched and precipitation heat treated	9	none
72	quenched and precipitation heat treated	9	8.3
73	quenched and precipitation heat treated	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 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.

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](#)

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.

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

- [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
- [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

2.2 Plate Steels:

- [A203/A203M](#) Specification for Pressure Vessel Plates, Alloy Steel, Nickel
- [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
- [A353/A353M](#) Specification for Pressure Vessel Plates, Alloy Steel, Double-Normalized and Tempered 9 % 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
- [A517/A517M](#) Specification for Pressure Vessel Plates, Alloy Steel, High-Strength, Quenched and Tempered
- [A537/A537M](#) Specification for Pressure Vessel Plates, Heat-Treated, Carbon-Manganese-Silicon Steel
- [A553/A553M](#) Specification for Pressure Vessel Plates, Alloy Steel, Quenched and Tempered 8 and 9 % Nickel
- [A736/A736M](#) Specification for Pressure Vessel Plates, Low-Carbon Age-Hardening Nickel-Copper-Chromium-Molybdenum-Columbium and Nickel-Copper-Manganese-Molybdenum-Columbium Alloy Steel

2.3 ASME Boiler and Pressure Vessel Code:⁴

- 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 *lot*—a lot shall consist of 200 ft [60 m] or fraction thereof of pipe from the same heat of steel.

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 and 11.3 of this specification. See also Specification [A530/A530M](#)),
- 4.1.9 Supplementary requirements, if any.

5. Materials and Manufacture

5.1 *Materials*—The steel plate material shall conform to the requirement of the applicable plate specification for the pipe grade ordered as listed in [Table 1](#).

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 As welded, the welded joint shall have positive reinforcement at the center of each side of the weld, but no more than 1/8 in. [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.

TABLE 1 Plate Specifications

Pipe Grade	Type of Steel	ASTM Specification	
		No.	Grade
CA 55	plain carbon	A285/A285M	C
CB 60	plain carbon, killed	A515/A515M	60
CB 65	plain carbon, killed	A515/A515M	65
CB 70	plain carbon, killed	A515/A515M	70
CC 60	plain carbon, killed, fine grain	A516/A516M	60
CC 65	plain carbon, killed, fine grain	A516/A516M	65
CC 70	plain carbon, killed, fine grain	A516/A516M	70
CD 70	manganese-silicon, normalized	A537/A537M	1
CD 80	manganese-silicon, quenched and tempered	A537/A537M	2
CF 65	nickel steel	A203/A203M	A
CF 70	nickel steel	A203/A203M	B
CF 66	nickel steel	A203/A203M	D
CF 71	nickel steel	A203/A203M	E
CG 100	9 % nickel	A353/A353M	
CH 100	9 % nickel	A553/A553M	1
CJ 101	alloy steel, quenched and tempered	A517/A517M	A
CJ 102	alloy steel, quenched and tempered	A517/A517M	B
CJ 103	alloy steel, quenched and tempered	A517/A517M	C
CJ 104	alloy steel, quenched and tempered	A517/A517M	D
CJ 105	alloy steel, quenched and tempered	A517/A517M	E
CJ 106	alloy steel, quenched and tempered	A517/A517M	F
CJ 107	alloy steel, quenched and tempered	A517/A517M	G
CJ 108	alloy steel, quenched and tempered	A517/A517M	H
CJ 109	alloy steel, quenched and tempered	A517/A517M	J
CJ 110	alloy steel, quenched and tempered	A517/A517M	K
CJ 111	alloy steel, quenched and tempered	A517/A517M	L
CJ 112	alloy steel, quenched and tempered	A517/A517M	M
CJ 113	alloy steel, quenched and tempered	A517/A517M	P
CK 75	carbon-manganese-silicon	A299/A299M	
CP65	alloy steel, age hardening, normalized and precipitation heat treated	A736/A736M	2
CP75	alloy steel, age hardening, quenched and precipitation heat treated	A736/A736M	3

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

5.3 *Heat Treatment*—All classes other than 10, 11, 12, and 13 shall be heat treated in furnace controlled to $\pm 25^\circ\text{F}$ [$\pm 15^\circ\text{C}$] 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 h/cm] of thickness or for 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 ½ h/in. [0.2 h/cm] of thickness or for ½ 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 that temperature for a minimum of ½ h/in. [0.2 h/cm] of thickness or for ½ h, whichever is greater, and air cooled.

5.3.5 Classes 60, 61, 62, and 63 pipe shall be normalized in accordance with 5.3.2. After normalizing, the pipe shall be precipitation heat treated in the range shown in **Table 2** for a time to be determined by the manufacturer.

5.3.6 Classes 70, 71, 72, and 73 pipe shall be uniformly heated to a temperature in the austenitizing range, not exceeding the maximum quenching temperature indicated in **Table 2**, and subsequently quenched in water or oil. After quenching the pipe shall be reheated into the precipitation heat treating range indicated in **Table 2** for a time to be determined by the manufacturer.

TABLE 2 Heat Treatment Parameters^A

Pipe Grade ^B	ASTM Specification and Grade	Post-Weld Heat-Treatment Temperature Range °F [°C]	Normalizing Temperature, max, °F [°C]	Quenching Temperature, max, °F [°C]	Tempering Temperature, min, °F [°C]	Precipitation Heat Treatment Temperature Range °F [°C]
CA 55	A285/A285M (C)	1100–1250 [590–680]	1700 [925]
CB 60	A515/A515M (60)	1100–1250 [590–680]	1750 [950]
CB 65	A515/A515M (65)	1100–1250 [590–680]	1750 [950]
CB 70	A515/A515M	1100–1250 [590–680]	1750 [950]
CC 60	A516/A516M (60)	1100–1250 [590–680] ^C	1700 [925]	1650 [900]	1200 [650] ^D	...
CC 65	A516/A516M (65)	1100–1250 [590–680] ^C	1700 [925]	1650 [900]	1200 [650]	...
CC 70	A516/A516M (70)	1100–1250 [590–680] ^C	1700 [925]	1650 [900]	1200 [650]	...
CD 70	A537/A537M (1)	1100–1250 [590–680]	1700 [925]
CD 80	A537/A537M (2)	1100–1250 [590–680] ^C	...	1650 [900]	1100 [590]	...
CF 65	A203/A203M (A)	1100–1175 [590–635]	1750 [950]
CF 70	A203/A203M (B)	1100–1175 [590–635]	1750 [950]
CF 66	A203/A203M (D)	1100–1175 [590–635]	1750 [950]
CF 71	A203/A203M (E)	1100–1175 [590–635]	1750 [950]
CG 100	A353/A353M	1025–1085 [550–580]	1650 [900]	...	1050 [560]	...
CH 100	A553/A553M	1025–1085 [550–580]	1650 [900]	1700 [925]	1050 [560]	...
CJ 101	A517/A517M (A)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CJ 102	A517/A517M (B)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CJ 103	A517/A517M (C)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CJ 104	A517/A517M (D)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CJ 105	A517/A517M (E)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CJ 106	A517/A517M (F)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CJ 107	A517/A517M (G)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CJ 108	A517/A517M (H)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CJ 109	A517/A517M (J)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CJ 110	A517/A517M (K)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CJ 111	A517/A517M (L)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CJ 112	A517/A517M (M)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CJ 113	A517/A517M (P)	1000–1100 [540–590]	...	1725 [940] ^E	1150 [620]	...
CK 75	A299/A299M	1100–1250 [590–680]	1700 [925]
CP65	A736/A736M (2)	1000–1175 [540–635]	1725 [940]	1000–1200 [540–650]
CP75	A736/A736M (3)	1000–1175 [540–635]	...	1725 [940]	...	1000–1225 [540–665]

^AWhere ellipses (...) appear in this table, there is no requirement.

^BNumbers indicate minimum tensile strength in ksi.

^CIn no case shall the post-weld heat-treatment temperature exceed the mill tempering temperature.

^DTempering range 1100 to 1300 [590 to 705], if accelerated cooling utilized per Specification A516/A516M.

^EPer ASME Section VIII Specification A517/A517M specified 1650 [900] minimum quenching temperature.