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Standard Specification for General Requirements for Ferritic Alloy Steel, Austenitic Alloy Steel, and Stainless Steel Tubes¹

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1. Scope*

1.1 This specification covers a group of requirements that, unless otherwise specified in an individual specification, shall apply to the ASTM product specifications noted below.

Title of Specification	ASTM Designation ⁴
Seamless Carbon-Molybdenum Alloy-Steel Boiler and Superheater Tubes	A209/A209M
Seamless Ferritic and Austenitic Alloy-Steel Boiler, Superheater, and Heat-Exchanger Tubes	A213/A213M
Welded Austenitic Steel Boiler, Superheater, Heat-Exchanger, and Condenser Tubes	A249/A249M
Electric-Resistance-Welded Ferritic Alloy-Steel Boiler and Superheater Tubes	A250/A250M
Seamless and Welded Ferritic and Martensitic Stainless Steel Tubing for General Service	A268/A268M
Seamless and Welded Austenitic Stainless Steel Tubing for General Service	A269
Seamless and Welded Austenitic Stainless Steel Sanitary Tubing	A270
Seamless and Welded Carbon and Alloy-Steel Tubes for Low-Temperature Service	A334/A334M
Welded Austenitic Stainless Steel Feedwater Heater Tubes	A668/A668M
Austenitic Stainless Steel Tubing for Breeder Reactor Core Components	A771/A771M
Seamless and Welded Ferritic/Austenitic Stainless Steel Tubing for General Service	A789/A789M
Welded Ferritic Stainless Steel Feedwater Heater Tubes	A803/A803M
Austenitic and Ferritic Stainless Steel Duct Tubes for Breeder Reactor Core Components	A826/A826M
High-Frequency Induction Welded, Unannealed Austenitic Steel Condenser Tubes	A851

⁴ These designations refer to the latest issue of the respective specifications.

1.2 In the case of conflict between a requirement of a product specification and a requirement of this general requirements specification, the product specification shall prevail. In the case of conflict between a requirement of the product specification or a requirement of this general requirements specification and a more stringent requirement of the purchase order, the purchase order shall prevail.

1.3 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 (SI) of the product specification is specified in the order.

2. Referenced Documents

2.1 ASTM Standards:²

A209/A209M Specification for Seamless Carbon-Molybdenum Alloy-Steel Boiler and Superheater Tubes

A213/A213M Specification for Seamless Ferritic and Austenitic Alloy-Steel Boiler, Superheater, and Heat-Exchanger Tubes

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 A01.10 on Stainless and Alloy Steel Tubular Products.

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² 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.



- A249/A249M Specification for Welded Austenitic Steel Boiler, Superheater, Heat-Exchanger, and Condenser Tubes
- A250/A250M Specification for Electric-Resistance-Welded Ferritic Alloy-Steel Boiler and Superheater Tubes
- A268/A268M Specification for Seamless and Welded Ferritic and Martensitic Stainless Steel Tubing for General Service
- A269 Specification for Seamless and Welded Austenitic Stainless Steel Tubing for General Service
- A270 Specification for Seamless and Welded Austenitic and Ferritic/Austenitic Stainless Steel Sanitary Tubing
- A334/A334M Specification for Seamless and Welded Carbon and Alloy-Steel Tubes for Low-Temperature Service
- A370 Test Methods and Definitions for Mechanical Testing of Steel Products
- A530/A530M Specification for General Requirements for Specialized Carbon and Alloy Steel Pipe
- A668/A668M Specification for Steel Forgings, Carbon and Alloy, for General Industrial Use
- A700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Shipment
- A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products
- A771/A771M Specification for Seamless Austenitic and Martensitic Stainless Steel Tubing for Liquid Metal-Cooled Reactor Core Components
- A789/A789M Specification for Seamless and Welded Ferritic/Austenitic Stainless Steel Tubing for General Service
- A803/A803M Specification for Welded Ferritic Stainless Steel Feedwater Heater Tubes
- A826/A826M Specification for Seamless Austenitic and Martensitic Stainless Steel Duct Tubes for Liquid Metal-Cooled Reactor Core Components
- A851 Specification for High-Frequency Induction Welded, Unannealed, Austenitic Steel Condenser Tubes
- A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys
- A1047/A1047M Test Method for Pneumatic Leak Testing of Tubing
- D3951 Practice for Commercial Packaging
- E92 Test Method for Vickers Hardness of Metallic Materials
- E213 Practice for Ultrasonic Testing of Metal Pipe and Tubing
- E273 Practice for Ultrasonic Testing of the Weld Zone of Welded Pipe and Tubing
- E309 Practice for Eddy-Current Examination of Steel Tubular Products Using Magnetic Saturation
- E426 Practice for Electromagnetic (Eddy-Current) Examination of Seamless and Welded Tubular Products, Austenitic Stainless Steel and Similar Alloys
- E570 Practice for Flux Leakage Examination of Ferromagnetic Steel Tubular Products
- 2.2 ASME Boiler and Pressure Vessel Code:
 - Section IX, Welding Qualifications³
 - 2.3 Federal Standard:
 - FED-STD-183 Continuous Identification Marking of Iron and Steel Products⁴
 - 2.4 Military Standards:
 - MIL-STD-271 Nondestructive Testing Requirements for Metals⁴
 - MIL-STD-163 Steel Mill Products Preparation for Shipment and Storage⁴
 - MIL-STD-792 Identification Marking Requirements for Special Purpose Equipment⁴
 - 2.5 Steel Structures Painting Council:
 - SSPC-SP6 Surface Preparation Specification No.6 Commercial Blast Cleaning⁵
 - 2.6 Other Documents:
 - SNT-TC-1A Recommended Practice for Nondestructive Personnel Qualification and Certification⁶
 - AIAG Bar Code Symbology Standard⁷

3. Terminology

3.1 Definitions:

- 3.1.1 The definitions in Test Methods and Definitions A370, Test Methods, Practices, and Terminology A751, and Terminology A941 are applicable to this specification and to those listed in 1.1.
- 3.1.2 *heat, n*—in secondary melting, all of the ingots remelted from a single primary heat.
- 3.1.3 *imperfection, n*—any discontinuity or irregularity found in a tube.

4. Manufacture

- 4.1 The steel shall be made by any process.

³ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

⁴ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, Attn: NPODS.

⁵ Available from Society for Protective Coatings (SSPC), 40 24th St., 6th Floor, Pittsburgh, PA 15222-4656, <http://www.sspc.org>.

⁶ Available from American Society for Nondestructive Testing (ASNT), P.O. Box 28518, 1711 Arlingate Ln., Columbus, OH 43228-0518, <http://www.asnt.org>.

⁷ Available from Automotive Industry Action Group (AIAG), 26200 Lahser Rd., Suite 200, Southfield, MI 48033, <http://www.aiag.org>.

4.2 The primary melting is permitted to incorporate separate degassing or refining and is permitted to be followed by secondary melting, such as electroslog remelting or vacuum-arc remelting.

4.3 When steel of different grades is sequentially strand cast, the resultant transition material shall be removed using an established procedure that positively separates the grades.

5. Ordering Information

5.1 It is the responsibility of the purchaser to specify all requirements that are necessary for product ordered under the product specification. Such requirements to be considered include, but are not limited to, the following:

- 5.1.1 Quantity (feet, metres, or number of pieces),
- 5.1.2 Name of material (stainless steel tubing),
- 5.1.3 Method of manufacture, when applicable (seamless (SML), welded (WLD), or heavily cold-worked (HCW)),
- 5.1.4 Grade or UNS number,
- 5.1.5 Size (outside diameter and average or minimum wall thickness),
- 5.1.6 Length (specific or random),
- 5.1.7 End finish if required,
- 5.1.8 Optional requirements,
- 5.1.9 Specific type of melting, if required,
- 5.1.10 Test report requirements,
- 5.1.11 Specification designation and year of issue, and
- 5.1.12 Special requirements or any supplementary requirements, or both.

6. Chemical Composition

6.1 *Chemical Analysis*—Samples for chemical analysis, and method of analysis, shall be in accordance with Test Methods, Practices, and Terminology A751.

6.2 *Heat Analysis*—An analysis of each heat of steel shall be made by the steel manufacturer to determine the percentages of the elements specified. If secondary melting processes are employed, the heat analysis shall be obtained from one remelted ingot or the product of one remelted ingot of each primary melt. The chemical composition thus determined, or that determined from a product analysis made by the tubular product manufacturer, shall conform to the requirements specified in the product specification.

6.2.1 For steels ordered under product specifications referencing this specification of general requirements, the steel shall not contain an unspecified element, other than nitrogen for stainless steels, for the ordered grade to the extent that the steel conforms to the requirements of another grade for which that element is a specified element having a required minimum content. For this requirement, a grade is defined as an alloy described individually and identified by its own UNS designation in a table of chemical requirements within any specification listed within the scope as being covered by this specification.

6.3 *Product Analysis*—Product analysis requirements and options, if any, shall be as contained in the product specification.

7. Tensile Properties

7.1 The material shall conform to the tensile property requirements prescribed in the individual product specification.

7.2 The yield strength, when specified, shall be determined corresponding to a permanent offset of 0.2 % of the gage length or to a total extension of 0.5 % of the gage length under load.

7.3 If the percentage of elongation of any test specimen is less than that specified and any part of the fracture is more than $\frac{3}{4}$ in. [19.0 mm] from the center of the gage length, as indicated by scribe marks on the specimen before testing, a retest shall be allowed.

8. Standard Mass per Unit Length

8.1 The calculated mass per foot, based upon a specified minimum wall thickness, shall be determined by the following equation (see Note 1):

$$W = C(D-t)t \quad (1)$$

where:

C = 10.69 [0.0246615],

W = mass per unit length, lb/ft [kg/m],

D = specified outside diameter, in. [mm], and

t = specified minimum wall thickness, in. [mm].

NOTE 1—The calculated masses given by Eq 1 are based on the masses for carbon steel tubing. The mass of tubing made of ferritic stainless steels may be up to about 5 % less, and that made of austenitic stainless steel up to about 2 % greater than the values given. Mass of ferritic/austenitic (duplex) stainless steel will be intermediate to the mass of fully austenitic and fully ferritic stainless steel tubing.

8.2 The permitted variations from the calculated mass per foot [kilogram per meter] shall be as prescribed in Table 1.



TABLE 1 Permitted Variations in Mass Per Foot^A

Method of Manufacture	Permitted Variation in Mass per Foot, %	
	Over	Under
Seamless, hot-finished	16	0
Seamless, cold-finished		
1½ in. [38 mm] and under OD	12	0
Over 1½ in. [38 mm] OD	13	0
Welded	10	0

^A These permitted variations in mass apply to lots of 50 tubes or more in sizes 4 in. [101.6 mm] and under in outside diameter, and to lots of 20 tubes or more in sizes over 4 in. [101.6 mm] in outside diameter.

9. Permitted Variations in Wall Thickness

9.1 Variations from the specified minimum wall thickness shall not exceed the amounts prescribed in Table 2.

9.2 For tubes 2 in. [50 mm] and over in outside diameter and 0.220 in. [5.6 mm] and over in thickness, the variation in wall thickness in any one cross section of any one tube shall not exceed the following percentage of the actual mean wall at the section. The actual mean wall is defined as the average of the thickest and thinnest wall in that section.

Seamless tubes ±10 %
Welded tubes ±5 %

9.3 When cold-finished tubes as ordered require wall thicknesses ¾ in. [19.1 mm] or over, or an inside diameter 60 % or less of the outside diameter, the permitted variations in wall thickness for hot-finished tubes shall apply.

10. Permitted Variations in Outside Diameter

10.1 Except as provided in 10.2.1, 10.3, and 25.10.4, variations from the specified outside diameter shall not exceed the amounts prescribed in Table 3.

10.2 Thin-wall tubes usually develop significant ovality (out-of-roundness) during final annealing, or straightening, or both. Thin-wall tubes are defined as those with a specified wall 3 % or less than the specified OD, or with a wall specified as 0.020 in. [0.5 mm] or less.

10.2.1 The diameter tolerances of Table 3 are not sufficient to provide for additional ovality expected in thin-wall tubes, and, for such tubes, are applicable only to the mean of the extreme (maximum and minimum) outside diameter readings in any one cross section. However, for thin wall tubes the difference in extreme outside diameter readings (ovality) in any one cross section shall not exceed the following ovality allowances:

Outside Diameter, in. [mm]	Ovality Allowance
1 [25.4] and under	0.020 [0.5]
Over 1 [25.4]	2.0 % of specified outside diameter

10.3 For cold-finished seamless austenitic and ferritic/austenitic tubes, an ovality allowance is necessary for all sizes less than 2 in. [50.8 mm] outside diameter, because they are likely to become out of round during their final heat treatment. For such tubes,

TABLE 2 Permitted Variations in Wall Thickness^A

Outside Diameter in. [mm]	Wall Thickness, %							
	0.095 [2.4] and Under		Over 0.095 to 0.150 [2.4 to 3.8], incl		Over 0.150 to 0.180 [3.8 to 4.6], incl		Over 0.180 [4.6]	
	Over	Under	Over	Under	Over	Under	Over	Under
Seamless, Hot-Finished Tubes								
4 [100] and under	40	0	35	0	33	0	28	0
Over 4 [100]	35	0	33	0	28	0
Seamless, Cold-Finished Tubes								
	Over		Under					
1½ [38.1] and under	20		0					
Over 1½ [38.1]	22		0					
Welded Tubes								
All sizes	18		0					

^A These permitted variations in wall thickness apply only to tubes, except internal-upset tubes, as rolled or cold-finished, and before swaging, expanding, bending, polishing, or other fabricating operations.

TABLE 3 Permitted Variations in Outside Diameter^A

Specified Outside Diameter, in. [mm]	Permitted Variations, in. [mm]	
	Over	Under
Hot-Finished Seamless Tubes		
4 [100] or under	1/64 [0.4]	1/32 [0.8]
Over 4 to 7 1/2 [100 to 200], incl	1/64 [0.4]	3/64 [1.2]
Over 7 1/2 to 9 [200 to 225], incl	1/64 [0.4]	1/16 [1.6]
Welded Tubes and Cold-Finished Seamless Tubes		
Under 1 [25]	0.004 [0.1]	0.004 [0.11]
1 to 1 1/2 [25 to 40], incl	0.006 [0.15]	0.006 [0.15]
Over 1 1/2 to 2 [40 to 50], excl	0.008 [0.2]	0.008 [0.2]
2 to 2 1/2 [50 to 65], excl	0.010 [0.25]	0.010 [0.25]
2 1/2 to 3 [65 to 75], excl	0.012 [0.3]	0.012 [0.3]
3 to 4 [75 to 100], incl	0.015 [0.38]	0.015 [0.38]
Over 4 to 7 1/2 [100 to 200], incl	0.015 [0.38]	0.025 [0.64]
Over 7 1/2 to 9 [200 to 225], incl	0.015 [0.38]	0.045 [1.14]

^A Except as provided in 10.2 and 10.3, these permitted variations include out-of-roundness. These permitted variations in outside diameter apply to hot-finished seamless, welded and cold-finished seamless tubes before other fabricating operations such as upsetting, swaging, expanding, bending, or polishing.

the maximum and minimum outside diameter at any cross section shall not deviate from the nominal diameter by more than ± 0.010 in. [± 0.25 mm]. However, the mean diameter at that cross section must still be within the given permitted variation given in Table 3. In the event of conflict between the provisions of 10.2.1 and those of 10.3, the larger value of ovality tolerance shall apply.

10.4 When the specified wall is 2 % or less of the specified OD, the method of measurement is per agreement between purchaser and manufacturer (see Note 2).

NOTE 2—Very thin wall tubing may not be stiff enough for the outside diameter to be accurately measured with a point contact method, such as with the use of a micrometer or caliper. When very thin walls are specified, “go” – “no go” ring gages are commonly used to measure diameters of 1 1/2 in. [38.1 mm] or less. A .002 in. [0.05 mm] additional tolerance is usually added on the “go” ring gage to allow clearance for sliding. On larger diameters, measurement is commonly performed with a pi tape. Other methods, such as optical methods, may also be considered.

11. Permitted Variations in Length

11.1 Variations from the specified length shall not exceed the amounts prescribed in Table 4.

12. Permitted Variations in Height of Flash on Electric-Resistance-Welded Tubes

12.1 For tubes over 2 in. [50.8 mm] in outside diameter, or over 0.135 in. [3.44 mm] in wall thickness, the flash on the inside of the tubes shall be mechanically removed by cutting to a maximum height of 0.010 in. [0.25 mm] at any point on the tube.

12.2 For tubes 2 in. [50.8 mm] and under in outside diameter and 0.135 in. [3.44 mm] and under in wall thickness, the flash on the inside of the tube shall be mechanically removed by cutting to a maximum height of 0.006 in. [0.15 mm] at any point on the tube.

13. Straightness and Finish

13.1 Finished tubes shall be reasonably straight and have smooth ends free of burrs. They shall have a workmanlike finish. It is permitted to remove surface imperfections by grinding, provided that a smooth curved surface is maintained, and the wall thickness is not decreased to less than that permitted by this or the product specification, or the purchase order. The outside diameter at the point of grinding may be reduced by the amount so removed.

14. Repair by Welding

14.1 Repair welding of base metal defects in tubing is permitted only with the approval of the purchaser and with the further

TABLE 4 Permitted Variations in Length^A

Method of Manufacture	Specified Outside Diameter, in. [mm]	Cut Length, in. [mm]	
		Over	Under
Seamless, hot-finished	All sizes	3/16 [5]	0 [0]
	Under 2 [50.8]	1/8 [3]	0 [0]
Seamless, cold-finished	2 [50.8] or over	3/16 [5]	0 [0]
	Under 2 [50.8]	1/8 [3]	0 [0]
Welded	2 [50.8] or over	3/16 [5]	0 [0]

^A These permitted variations in length apply to tubes before bending. They apply to cut lengths up to and including 24 ft [7.3 m]. For lengths greater than 24 ft [7.3 m], the above over-tolerances shall be increased by 1/8 in. [3 mm] for each 10 ft [3 m] or fraction thereof over 24 ft or 1/2 in. [13 mm], whichever is the lesser.

understanding that the tube shall be marked “WR” and the composition of the deposited filler metal shall be suitable for the composition being welded. Defects shall be thoroughly chipped or ground out before welding and each repaired length shall be reheat treated or stress relieved as required by the applicable specification. Each length of repaired tube shall be examined by a nondestructive test as required by the product specification.

14.2 Repair welding shall be performed using procedures and welders or welding operators that have been qualified in accordance with ASME Boiler and Pressure Vessel Code, Section IX.

15. Retests

15.1 If the results of the mechanical tests of any group or lot do not conform to the requirements specified in the individual specification, retests may be made on additional tubes of double the original number from the same group or lot, each of which shall conform to the requirements specified.

16. Reheat Treatment

16.1 If the individual tubes or the tubes selected to represent any group or lot fail to conform to the test requirements, the individual tubes or the group or lot represented may be reheat treated and resubmitted for test. Not more than two reheat treatments shall be permitted.

17. Test Specimens

17.1 Test specimens shall be taken from the ends of finished tubes prior to upsetting, swaging, expanding, or other forming operations, or being cut to length. They shall be smooth on the ends and free of burrs and flaws.

17.2 If any test specimen shows flaws or defective machining, it may be discarded and another specimen substituted.

18. Method of Mechanical Testing

18.1 The specimens and mechanical tests required shall be made in accordance with Test Methods and Definitions A370.

18.2 Specimens shall be tested at room temperature.

18.3 Small or subsize specimens as described in Test Methods and Definitions A370 may be used only when there is insufficient material to prepare one of the standard specimens. When using small or subsize specimens, the largest one possible shall be used.

19. Flattening Test

19.1 A section of tube not less than 2½ in. [60 mm] in length for seamless tubes and not less than 4 in. [100 mm] in length for welded tubes and for heavily cold-worked tubes shall be flattened cold between parallel plates in two steps. For welded tubes, the weld shall be placed 90° from the direction of the applied force (at a point of maximum bending). During the first step, which is a test for ductility, no cracks or breaks, except as provided for in 19.4, on the inside, outside, or end surfaces shall occur in seamless tubes, or on the inside or outside surfaces of welded tubes and heavily cold-worked tubes, until the distance between the plates is less than the value of H calculated by the following equation:

$$H = \frac{(1 + e)t}{e + t/D} \quad (2)$$

where:

H = distance between flattening plates, in. [mm],

t = specified wall thickness of the tube, in. [mm],

D = specified outside diameter of the tube, in. [mm], and

e = deformation per unit length (constant for a given grade of steel: 0.07 for medium-carbon steel (maximum specified carbon 0.19 % or greater), 0.08 for ferritic alloy steel, 0.09 for austenitic steel, and 0.09 for low-carbon steel (maximum specified carbon 0.18 % or less)).

During the second step, which is a test for soundness, the flattening shall be continued until the specimen breaks or the opposite walls of the specimen meet. Evidence of laminated or unsound material, or of incomplete weld that is revealed during the entire flattening test shall be cause for rejection.

19.2 Surface imperfections in the test specimens before flattening, but revealed during the first step of the flattening test, shall be judged in accordance with the finish requirements.

19.3 Superficial ruptures resulting from surface imperfections shall not be cause for rejection.

19.4 When low D -to- t ratio tubular products are tested, because the strain imposed due to geometry is unreasonably high on the inside surface at the six and twelve o'clock locations, cracks at these locations shall not be cause for rejection if the D -to- t ratio is less than 10.

20. Reverse Flattening Test

20.1 A section 4 in. [100 mm] in length of finished welded tubing in sizes down to and including ½ in. [12.7 mm] in outside diameter shall be split longitudinally 90° on each side of the weld and the sample opened and flattened with the weld at the point of maximum bend. There shall be no evidence of cracks or lack of penetration or overlaps resulting from flash removal in the weld.