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Standard Specification for Seamless Nickel and Nickel Alloy (UNS N06845) Condenser and Heat-Exchanger Tubes¹

This standard is issued under the fixed designation B163; 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.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This specification² covers seamless tubes of nickel and nickel alloys, as shown in Table 1, for use in condenser and heat-exchanger service.

1.2 This specification covers outside diameter and average wall, or outside diameter and minimum wall tube.

1.2.1 The sizes covered by this specification are 3 in. (76.2 mm) and under in outside diameter with minimum wall thicknesses of 0.148 in. (3.76 mm) and under, and with average wall thicknesses of 0.165 in. (4.19 mm) and under.

1.3 Tube shall be furnished in the alloys and conditions as shown in Table 2. For small diameter and light wall tube (converter sizes), see Appendix X2.

~~1.4 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.~~

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.

1.5 The following safety hazards caveat pertains only to the test method portion, Section 12, of this specification. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to become familiar with all hazards including those identified in the appropriate Material Safety Data Sheet (MSDS) for this product/material as provided by the manufacturer, to establish appropriate safety and health practices, and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:³

B829 Specification for General Requirements for Nickel and Nickel Alloys Seamless Pipe and Tube

B880 Specification for General Requirements for Chemical Check Analysis Limits for Nickel, Nickel Alloys and Cobalt Alloys

E8 Test Methods for Tension Testing of Metallic Materials [947-8a9d-450e-9a72-fe312c73297c/astm-b163-11](https://doi.org/10.1520/B0163-11)

E18 Test Methods for Rockwell Hardness of Metallic Materials

E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E76 Test Methods for Chemical Analysis of Nickel-Copper Alloys

E112 Test Methods for Determining Average Grain Size

E140 Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, and Scleroscope Hardness

E1473 Test Methods for Chemical Analysis of Nickel, Cobalt, and High-Temperature Alloys

2.2 Federal Standards:⁴

Fed. Std. No. 102 Preservation, Packaging and Packing Levels

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)

Fed. Std. No. 182 Continuous Identification Marking of Nickel and Nickel-Base Alloys

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.07 on Refined Nickel and Cobalt and Their Alloys.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SB-163 in Section II of that Code.

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 Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>.

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

TABLE 1 Chemical Requirements^A

| Alloy | Nickel02200 | Copper02201 | Molybdenum04400 | Iron06025 | Manganese06045 | Carbon06600 | Silicon06601 | Sulfur, max06603 | Chromium06686 | Aluminum | Titanium |
|---------------------------------------|-----------------------------------|------------------------------|-----------------------|-----------------------|----------------|------------------------|------------------------|------------------|-------------------------|-------------|----------|
| Nickel-UNS N02200 | 99.0 min ^B | 0.25- max | --- | 0.40- max | 0.35 | 0.15- max | 0.35 | 0.01 | --- | --- | --- |
| Nickel low-carbon | 99.0 min ^B | 0.25- max | --- | 0.40- max | 0.35 | 0.15- max | 0.35 | 0.01 | --- | --- | --- |
| Nickel-UNS N02204 | 99.0 min ^B | 0.25- max 28.0 to 34.0 | --- | 0.40- max 2.5 max | 0.35 2.0 | 0.02- max 0.3max | 0.35 0.5 | 0.01 | --- | --- | --- |
| Nickel-copper alloy-UNS N04400 | 63.0 min ^B | remainder ^B | 45.0 min ^B | 72.0 min ^B | 58.0-63.0 | remainder ^B | remainder ^B | 0.024 | --- | --- | --- |
| Nickel-copper alloy UNS N04400 | 63.0 min ^B | remainder ^B | 45.0 min ^B | 72.0 min ^B | 58.0-63.0 | remainder ^B | remainder ^B | 0.024 | --- | --- | --- |
| Nickel-chromium-iron alloy-UNS N06600 | 72.0 min ^B | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| Nickel-chromium-iron alloy UNS N06600 | 58.0 min ^B 0.5- max | --- | --- | 4.0 | 0.15- max | 0.5 | 0.015 | 14.0 to 17.0 | --- | --- | --- |
| Copper | 0.25 | 0.25 | 6.0 to 10.0 | 0.1 | 0.3 | 0.5 | 1.0 | 0.5 | --- | 0.5 | --- |
| Molybdenum | ... | ... | ... | ... | ... | ... | ... | ... | 15.0-17.0 | ... | --- |
| Nickel-chromium-iron alloy-UNS N06601 | 56.0 to 63.0 | 0.40 21.0 to 25.0 | 2.5 1.0 to 1.7 | 8.0-11.0 | 21.0-25.0 | 6.0-10.0 | remainder ^A | 4.0 | 0.10 | 0.50 | --- |
| Iron | 0.40 | 0.40 | 1.0 to 1.7 | ... | ... | ... | ... | ... | 5.0 | 7.0-11.0 | --- |
| Manganese | 0.015 | 0.35 | 2.0 | 7.0 to 11.0 | 0.5 | 0.05- max | 0.5 | 0.15 0.015 | 0.75 27.0 to 31.0 | 0.... | --- |
| Nickel-chromium-iron alloy-UNS N06690 | 56.0 min ^B 0.15 | 0.02 | 0.3 | 0.15-0.25 | 0.05-0.12 | 0.15 | 0.10 | 0.20-0.40 | 0.010 | 0.05 | --- |
| Carbon | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | --- |
| Silicon | 0.35 | 0.35 | 0.5 | 0.5 | 2.5-3.0 | 0.15 | 0.5 | 0.5 | 0.08 | 0.5 | --- |
| Sulfur | 0.01 | 0.01 | 0.01 | 0.01 | 0.01 | 0.01 | 0.01 | 0.01 | 0.01 | 0.01 | 0.01 |
| Nickel-chromium-iron alloy-UNS N06625 | remainder ^B 0.01 | 0.1- max | --- | 8.0 to 11.0 | 0.15 | 0.05- max to 0.25 | 0.5 | 0.010 | 24.0 to 26.0 | 1.8 to 0.15 | 0.015 |
| Sulfur | 0.01 | 0.01 | 0.024 | 0.010 | 0.010 | 0.015 | 0.015 | 0.010 | 0.02 | 0.015 | 0.015 |

TABLE 1 Chemical Requirements^A (continued)

| | N06696 | N06845 | N08120 | N08800 | N08801 | N08810 | N08811 | N08825 |
|------------|------------------------|------------------------|------------------------|-----------------------|-----------------------|-----------------------|------------------------|-----------------------|
| Nickel | remainder ^B | 44.0–50.0 | 35.0–39.0 | 30.0–35.0 | 30.0–34.0 | 30.0–35.0 | 30.0–35.0 | 36.0–46.0 |
| Copper | 1.5–3.0 | 2.0–4.0 | 0.50 | 0.75 | 0.50 | 0.75 | 0.75 | 1.5–3.0 |
| Molybdenum | 1.0–3.0 | 5.0–7.0 | 2.50 | ... | ... | ... | ... | 2.5–3.5 |
| Iron | 2.0–6.0 | remainder ^B | remainder ^B | 39.5 min ^B | 39.5 min ^B | 39.5 min ^B | 39.5 min ^B | 22.0 min ^B |
| Manganese | 1.0 | 0.5 | 1.5 | 1.5 | 1.50 | 1.5 | 1.5 | 1.0 |
| Carbon | 0.15 | 0.05 | 0.02–0.10 | 0.10 | 0.10 | 0.05–0.10 | 0.05–0.10 | 0.05 |
| Silicon | 1.0–2.5 | 0.5 | 1.0 | 1.0 | 1.00 | 1.0 | 1.0 | 0.5 |
| Sulfur | 0.010 | 0.010 | 0.03 | 0.015 | 0.015 | 0.015 | 0.015 | 0.03 |
| Chromium | 28.0–32.0 | 20.0–25.0 | 23.0–27.0 | 19.0–23.0 | 19.0–22.0 | 19.0–23.0 | 19.0–23.0 | 19.5–23.5 |
| Aluminum | ... | ... | 0.40 | 0.15–0.60 | ... | 0.15–0.60 | 0.15–0.60 ^C | 0.2 |
| Titanium | 1.0 | ... | 0.20 | 0.15–0.60 | 0.75–1.5 | 0.15–0.60 | 0.15–0.60 ^C | 0.6–1.2 |
| Phosphorus | ... | ... | 0.04 | ... | ... | ... | ... | ... |
| Cerium | ... | ... | ... | ... | ... | ... | ... | ... |
| Zirconium | ... | ... | ... | ... | ... | ... | ... | ... |
| Yttrium | ... | ... | ... | ... | ... | ... | ... | ... |
| Boron | ... | ... | 0.010 | ... | ... | ... | ... | ... |
| Cobalt | ... | ... | 3.0 | ... | ... | ... | ... | ... |
| Columbium | ... | ... | 0.4–0.9 | ... | ... | ... | ... | ... |
| (Nb) | ... | ... | ... | ... | ... | ... | ... | ... |
| Tungsten | ... | 2.0–5.0 | 2.50 | ... | ... | ... | ... | ... |
| Nitrogen | ... | ... | 0.13–0.30 | ... | ... | ... | ... | ... |

^A Maximum unless range or minimum is given. Where ellipses (...) appear in this table, there is no requirement and analysis for the element need not be determined or reported.

^B Element shall be determined arithmetically by difference.

^C Alloy UNS N08811: Al + Ti, 0.85 – 1.20.

TABLE 2 Alloy and Conditions

| Alloy | Condition |
|---|-----------------------------|
| Nickel UNS N02200 and low-carbon nickel UNS N02201 | annealed or stress-relieved |
| Nickel-copper alloy UNS N04400 | annealed or stress-relieved |
| Nickel-chromium-iron-aluminum alloy UNS N06603 | annealed |
| Nickel-chromium-iron-copper alloy UNS N06696 | annealed |
| Nickel-chromium-iron-aluminum alloy UNS N06601 | annealed |
| Nickel-chromium-iron alloy UNS N06600 | annealed |
| Low-carbon nickel-chromium-molybdenum-tungsten alloy UNS N06686 | annealed |
| Nickel-chromium-iron alloy UNS N06690 | annealed |
| Nickel-chromium-iron alloy UNS N06045 | annealed |
| Nickel-iron-chromium alloy UNS N08120 ^A | annealed or cold-worked |
| Nickel-iron-chromium alloy UNS N08800 ^A | annealed or cold-worked |
| Nickel-iron-chromium alloy UNS N08810 ^A | annealed |
| Nickel-iron-chromium alloy UNS N08811 ^A | annealed |
| Nickel-iron-chromium alloy UNS N08801 | annealed |
| Nickel-iron-chromium-molybdenum-copper alloy UNS N08825 | annealed |
| Nickel-chromium-iron alloy UNS N06025 | annealed |
| Nickel-iron-chromium-molybdenum-copper alloy UNS N06845 | annealed |

^A Alloy UNS N08800 is normally employed in service temperatures up to and including 1100°F (593°C). Alloys UNS N08810, UNS N08811, and UNS N08120 are normally employed in service temperatures above 1100°F (539°C) where resistance to creep and rupture is required, and it is annealed to develop controlled grain size for optimum properties in this temperature range.

2.3 Military Standard:⁴

MIL-STD-129 Marking for Shipment and Storage

3. Terminology

3.1 Definitions:

3.1.1 *average diameter, n*—average of the maximum and minimum outside diameters, as determined at any one cross section of the tube.

3.1.2 *tube, n*—hollow product of round or any other cross section having a continuous periphery.

4. Ordering Information

4.1 It is the responsibility of the purchaser to specify all requirements that are necessary for the safe and satisfactory performance of material ordered under this specification. Examples of such requirements include, but are not limited to, the following:

4.1.1 *Alloy* (Table 1).

4.1.2 *Condition (Temper)* Table 3 and Appendix X1 and Appendix X2.

4.1.2.1 If annealed ends for stress relieved tubing are desired, state length of end to be annealed and whether or not one end or both ends are to be annealed.

4.1.3 *Finish*.

4.1.4 *Dimensions*—Outside diameter, minimum or average wall thickness (in inches, not gage number), and length.

4.1.5 *Fabrication Operations*:

4.1.5.1 *Cold Bending or Coiling*.

4.1.5.2 *Packing*.

4.1.5.3 *Rolling or Expanding into Tube Sheets*.

4.1.5.4 *Welding or Brazing*—Process to be employed.

4.1.5.5 *Hydrostatic Test or Nondestructive Electric Test*—Specify type of test (6.5).

TABLE 3 Mechanical Properties of Tubes

| Material and Condition | Tensile Strength, min, ksi (MPa) | Yield Strength (0.2 % Offset), min, psi (MPa) | Elongation in 2 in. or 50 mm (or 4 D) min, % | Rockwell Hardness (or equivalent) for annealed ends ^A |
|--|-------------------------------------|---|--|--|
| <i>Nickel</i> UNS N02200: | | | | |
| Annealed | 55 (379) | 15 (103) | 40 | ... |
| Stress-relieved | 65 (448) | 40 (276) | 15 | B65 max |
| <i>Low-carbon nickel</i> UNS N02201: | | | | |
| Annealed | 50 (345) | 12 (83) | 40 | ... |
| Stress-relieved | 60 (414) | 30 (207) | 15 | B62 max |
| <i>Nickel-copper alloy</i> UNS N04400: | | | | |
| Annealed | 70 (483) | 28 (193) | 35 | ... |
| Stress-relieved | 85 (586) | 55 (379) | 15 | B75 max |
| <i>Nickel-chromium-iron alloys:</i> | | | | |
| Annealed alloy UNS N06600 | 80 (552) | 35 (241) | 30 | ... |
| Annealed alloy UNS N06601 | 80 (552) | 30 (207) | 30 | ... |
| Annealed alloy UNS N06690 | 85 (586) | 35 (241) | 30 | ... |
| Annealed alloy UNS N06045 | 90 (620) | 35 (240) | 35 | ... |
| Annealed alloy UNS N06025 | 98 (680) | 39 (270) | 30 | ... |
| Annealed alloy UNS N06603 | 94 (650) | 43 (300) | 25 | ... |
| Annealed alloy UNS N06696 | 85 (586) | 35 (240) | 30 | ... |
| <i>Low-carbon nickel-chromium-molybdenum-tungsten alloy:</i> | | | | |
| Annealed UNS N06686 | 100 (690) | 45 (310) | 45 | ... |
| <i>Nickel-iron-chromium alloys:</i> | | | | |
| Annealed alloy UNS N08120 | 90 (620) | 40 (276) | 30 | ... |
| Annealed alloy UNS N08800 | 75 (517) | 30 (207) | 30 | ... |
| Annealed alloy UNS N08801 | 65 (448) | 25 (172) | 30 | ... |
| Cold-worked alloy UNS N08800 | 83 (572) | 47 (324) | 30 | ... |
| Annealed alloy UNS N08810 | 65 (448) | 25 (172) | 30 | ... |
| Annealed alloy UNS N08811 | 65 (448) | 25 (172) | 30 | ... |
| <i>Nickel-iron-chromium-molybdenum-copper alloy:</i> | | | | |
| <i>Nickel-iron-chromium-molybdenum-copper alloys:</i> | | | | |
| Annealed UNS N08825 | 85 (586) | 35 (241) | 30 | ... |
| Annealed UNS N06845 | 100 (690) | 40 (276) | 30 | ... |

^A Rockwell or equivalent hardness values apply only to the annealed ends of stress-relieved tubing. Caution should be observed in using the Rockwell test on thin material, as the results may be affected by the thickness of specimen. For thickness under 0.050 in. (1.27 mm) the use of the Rockwell superficial or the Vickers hardness test is suggested. For hardness conversions for nickel and high-nickel alloys see Hardness Conversion Tables E140.

4.1.5.6 *Pressure Requirements*—If other than required by 6.5.

4.1.5.7 *Ends*—Plain ends cut and deburred will be furnished.

4.1.6 *Supplementary Requirements*—State nature and details.

4.1.7 *Certification*—State if certification is required (Section 15). —State if certification is required (15).

4.1.8 *Samples for Product (Check) Analysis*—Whether samples for product (check) analysis shall be furnished.

4.1.9 *Purchaser Inspection*—If purchaser wishes to witness tests or inspection of material at place of manufacture, the purchase order must so state indicating which tests or inspections are to be witnessed (Section 13).

4.1.10 *Small-Diameter and Light-Wall Tube (Converter Sizes)*—See Appendix X2.

5. Chemical Composition

5.1 The material shall conform to the composition limits specified in Table 1.

5.2 If a product (check) analysis is performed by the purchaser, the material shall conform to the product (check) analysis per Specification B880.

6. Mechanical Properties and Other Requirements

6.1 *Mechanical Properties*—The material shall conform to the mechanical properties specified in Table 3.

6.2 *Hardness*—When annealed ends are specified for tubing in the stress-relieved condition (see Table 3), the hardness of the ends after annealing shall not exceed the values specified in Table 3.

6.3 *Flare*—A flare test shall be made on one end of 1 % of the number of finished tube lengths from each lot. For less than 100 tubes in a lot, a flare test shall be made on one end of one tube length in the lot. In the case of stress relieved tubing with annealed ends, the test shall be made prior to, or subsequent to, annealing of the ends at the option of the manufacturer.

6.3.1 The flare test shall consist of flaring a test specimen with an expanding tool having an included angle of 60° until the specified outside diameter has been increased by 30 %. The flared specimen shall not exhibit cracking through the wall.

6.4 *Grain Size*—A transverse sample representing full-wall thickness of annealed alloys UNS N08120, UNS N08810 and UNS N08811 shall conform to an average grain size of ASTM No. 5 or coarser.

6.5 *Hydrostatic or Nondestructive Electric Test*—Each tube shall be subjected to either the hydrostatic test or the nondestructive electric test. The type of test to be used shall be at the option of the manufacturer, unless otherwise specified in the purchase order.

TABLE 4 Permissible Variations in Outside Diameter and Wall Thickness of Condenser and Heat Exchanger Tubes

NOTE 1—The tolerances in the table apply to individual measurements of outside diameter and include out-of-roundness (ovality), and apply to all materials and all conditions, except that for thin wall tubes having a nominal wall of 3 % or less of the outside diameter, the mean outside diameter shall comply with the permissible variations of the above table and individual measurements (including ovality) shall conform to the plus and minus values of the table with the values increased by ½ % of the nominal outside diameter.

NOTE 2—*Eccentricity*—The variation in wall thickness in any one cross section of any one tube shall not exceed plus or minus 10 % of the actual (measured) average wall of that section. The actual average wall is defined as the average of the thickest and thinnest wall of that section.

NOTE 3—For tolerances of small diameter and light wall tube (converter sizes) see Appendix X2 (Table X2.2).

| Material | Nominal Outside Diameter, in. (mm) | Permissible Variations ^A | | | | | |
|---|------------------------------------|-------------------------------------|--------------|-------------------|------|--------------|---|
| | | Outside Diameter, in. (mm) | | Wall Thickness, % | | | |
| | | + | - | Average Wall | | Minimum Wall | |
| | | | | + | - | + | - |
| UNS N02200, UNS N02201, and UNS N04400 | ½ to ⅝ (12.7 to 15.9), excl | 0.005 (0.13) | 0 | 12.5 | 12.5 | 25.0 | 0 |
| | ⅝ to 1½ (15.9 to 38.1), incl | 0.005 (0.13) | 0.005 (0.13) | 10.0 | 10.0 | 20.0 | 0 |
| | over 1½ to 3 (38.1 to 76.2), incl | 0.010 (0.25) | 0.010 (0.25) | 10.0 | 10.0 | 22.0 | 0 |
| UNS N06600, UNS N06601, UNS N06690, UNS N06045, UNS N06025, UNS N06603, UNS N06696, UNS N08800, UNS N08810, UNS N08811, UNS N08801, UNS N08825, and UNS N08120 UNS N08825, UNS N06845, and UNS N08120 UNS N06686 | ½ to ⅝ (12.7 to 15.9), excl | 0.005 (0.13) | 0.005 (0.13) | 12.5 | 12.5 | 25.0 | 0 |
| ⅝ to 1½ (15.9 to 38.1), incl | 0.0075 (0.19) | 0.0075 (0.19) | 10.0 | 10.0 | 20.0 | 0 | |
| over 1½ to 3 (38.1 to 76.2), incl | 0.010 (0.25) | 0.010 (0.25) | 10.0 | 10.0 | 22.0 | 0 | |

^A Wall variations as indicated above are applicable only to the wall as ordered, for instance, to minimum or to average wall, but not to both.

6.5.1 Hydrostatic Test:

6.5.1.1 Each tube with an outside diameter ⅜ in. (3.2 mm) and larger and tubes with wall thickness of 0.015 in. (0.38 mm) and over shall be tested by the manufacturer to an internal hydrostatic pressure of 1000 psi (6.9 MPa) provided that the fiber stress calculated in accordance with the following equation does not exceed the allowable fiber stress, *S*, indicated below. The tube shall show no evidence of leakage.