



Designation: **A426/A426M – 11a** **A426/A426M – 13**

## Standard Specification for Centrifugally Cast Ferritic Alloy Steel Pipe for High- Temperature Service<sup>1</sup>

This standard is issued under the fixed designation A426/A426M; 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 reappraisal. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reappraisal.

### 1. Scope\*

- 1.1 This specification<sup>2</sup> covers centrifugally cast alloy steel pipe intended for use in high-temperature, high-pressure service.
- 1.2 Several grades of ferritic steels are covered. Their compositions are given in **Table 1**.
- 1.3 Supplementary Requirements S1 through S12 are provided. The supplementary requirements provide for additional tests of an optional nature and when desired shall be so stated in the order (Section 4).
- 1.4 The values stated in either inch-pound units or SI units are to be regarded separately as standard. 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.
  - 1.4.1 Within the text, the SI units are shown in brackets.
- 1.5 *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 establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

### 2. Referenced Documents

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

- [A370 Test Methods and Definitions for Mechanical Testing of Steel Products](#)
- [A609/A609M Practice for Castings, Carbon, Low-Alloy, and Martensitic Stainless Steel, Ultrasonic Examination Thereof](#)
- [A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys](#)
- [A999/A999M Specification for General Requirements for Alloy and Stainless Steel Pipe](#)
- [E94 Guide for Radiographic Examination](#)
- [E165 Practice for Liquid Penetrant Examination for General Industry](#)
- [E186 Reference Radiographs for Heavy-Walled \(2 to 4½-in. \(50.8 to 114-mm\)\) Steel Castings](#)
- [E208 Test Method for Conducting Drop-Weight Test to Determine Nil-Ductility Transition Temperature of Ferritic Steels](#)
- [E280 Reference Radiographs for Heavy-Walled \(4½ to 12-in. \(114 to 305-mm\)\) Steel Castings](#)
- [E446 Reference Radiographs for Steel Castings Up to 2 in. \(50.8 mm\) in Thickness](#)
- [E709 Guide for Magnetic Particle Testing](#)

#### 2.2 ANSI Standard:<sup>4</sup>

- [B46.1 Surface Texture](#)

#### 2.3 ASME Boiler and Pressure Vessel Code:<sup>5</sup>

- [Section IX Welding and Brazing Qualifications](#)

#### 2.4 AWS Specifications<sup>6</sup>

- ~~[A5.5/A5.5M Low Alloy Steel Electrodes for Shielded Metal Arc Welding](#)~~
- ~~[A5.23/A5.23M Low Alloy Steel Electrodes and Fluxes for Submerged Arc Welding](#)~~

<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 A01.18 on Castings.

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<sup>2</sup> For ASME Boiler and Pressure Vessel Code applications see related Specification SA-426 in Section II of that Code.

<sup>3</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

<sup>4</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

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

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

TABLE 1 Chemical Requirements<sup>A</sup>

Composition, %									
Grade	UNS Number	Carbon	Manganese	Phosphorus, max	Sulfur, max	Silicon	Chromium	Molybdenum	Other
GP4	J12521	0.25 max	0.30-0.80	0.030	0.025	0.10-0.50	...	0.44-0.65	...
GP2	J11547	0.10-0.20	0.30-0.61	0.030	0.025	0.10-0.50	0.50-0.81	0.44-0.65	...
GP5	J42045	0.20 max	0.30-0.70	0.030	0.025	0.75 max	4.00-6.50	0.45-0.65	...
GP5b	J51545	0.15 max	0.30-0.60	0.030	0.025	1.00-2.00	4.00-6.00	0.45-0.65	...
GP9	J82090	0.20 max	0.30-0.65	0.030	0.025	0.25-1.00	8.00-10.00	0.90-1.20	...
GP9†	J84090	0.08-0.12	0.30-0.60	0.030	0.010	0.20-0.50	8.0-9.5	0.85-1.05	nickel, 0.40 max.; columbium, 0.060-0.10; nitrogen, 0.030-0.070; vanadium, 0.18-0.25; aluminum, 0.02 max.; titanium, 0.01 max.; zirconium, 0.01 max.
GP11	J12072	0.05-0.20	0.30-0.80	0.030	0.025	0.60 max	1.00-1.50	0.44-0.65	...
GP12	J11562	0.05-0.15	0.30-0.61	0.030	0.025	0.50 max	0.80-1.25	0.44-0.65	...
GP15	J11522	0.15 max	0.30-0.60	0.030	0.025	1.15-1.65	...	0.44-0.65	...
GP21	J31545	0.05-0.15	0.30-0.60	0.030	0.025	0.50 max	2.65-3.35	0.80-1.06	...
GP22	J21890	0.05-0.15	0.30-0.70	0.030	0.025	0.60 max	2.00-2.75	0.90-1.20	...
GPCA15	J91150	0.15 max	1.00 max	0.030	0.025	1.50 max	11.5-14.0	0.50 max	...

TABLE 1 Chemical Requirements<sup>A</sup>

Composition, %									
Grade	UNS Number	Carbon	Manganese	Phosphorus, max	Sulfur, max	Silicon	Chromium	Molybdenum	Other
CP1	J12521	0.25 max	0.30-0.80	0.030	0.025	0.10-0.50	...	0.44-0.65	...
CP2	J11547	0.10-0.20	0.30-0.61	0.030	0.025	0.10-0.50	0.50-0.81	0.44-0.65	...
CP5	J42045	0.20 max	0.30-0.70	0.030	0.025	0.75 max	4.00-6.50	0.45-0.65	...
CP5b	J51545	0.15 max	0.30-0.60	0.030	0.025	1.00-2.00	4.00-6.00	0.45-0.65	...
CP9	J82090	0.20 max	0.30-0.65	0.030	0.025	0.25-1.00	8.00-10.00	0.90-1.20	...
CP11	J12072	0.05-0.20	0.30-0.80	0.030	0.025	0.60 max	1.00-1.50	0.44-0.65	...
CP12	J11562	0.05-0.15	0.30-0.61	0.030	0.025	0.50 max	0.80-1.25	0.44-0.65	...
CP15	J11522	0.15 max	0.30-0.60	0.030	0.025	1.15-1.65	...	0.44-0.65	...
CP21	J31545	0.05-0.15	0.30-0.60	0.030	0.025	0.50 max	2.65-3.35	0.80-1.06	...
CP22	J21890	0.05-0.15	0.30-0.70	0.030	0.025	0.60 max	2.00-2.75	0.90-1.20	...
CPCA15	J91150	0.15 max	1.00 max	0.030	0.025	1.50 max	11.5-14.0	0.50 max	...

<sup>A</sup> Where ellipses appear in this table, there is no requirement.

[A5.28/A5.28M Low Alloy Steel Electrodes and Rods for Gas Shielded Arc Welding](#)

[A5.29/A5.29M Low Alloy Steel Electrodes for Flux Cored Arc Welding](#)

### 3. Ordering Information

3.1 Orders for material under this specification shall include the following, as required, to describe the desired material adequately:

3.1.1 Quantity (feet, centimetres, or number of lengths),

3.1.2 Name of material (centrifugally cast pipe),

- 3.1.3 Specification number,
- 3.1.4 Grade (**Table 1**),
- 3.1.5 Size (outside or inside diameter and minimum wall thickness),
- 3.1.6 Length (specific or random) (Section on Permissible Variations in Length of Specification **A999/A999M**),
- 3.1.7 End finish (Section on Ends of Specification **A999/A999M**),
- 3.1.8 Optional Requirements S1 through S12 and Section ~~15.14.1~~,<sup>1</sup>
- 3.1.9 Test report required (Section on Certified Test Report of Specification **A999/A999M**),
- 3.1.10 Service temperature if over 1000°F [540°C] (**Note 1**), and
- 3.1.11 Special requirements or additions to specification.

#### 4. General Requirements for Delivery

4.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification **A999/A999M** unless otherwise provided herein.

#### 5. Materials and Manufacture

5.1 *Heat-Treatment*—The pipe shall be furnished in the austenitized and tempered condition (**Note 1**) according to the requirements of **Table 2**.

5.1.1 Heat treatment shall be performed after the pipe has been allowed to cool below the transformation range. Definition of heat-treatment terms shall be as given in Terminology **A941**.

**NOTE 1**—~~Except for Grade CP91, it~~ It is recommended that the temperature for tempering should be at least 100°F [55°C] above the intended service temperature. The purchaser shall advise the manufacturer of the service temperature when it is over 1000°F [540°C]. (See **3.1.10**.)

5.2 *Machining*—The pipe shall be machined on the inner and outer surfaces to a roughness value no greater than 250 μ in. [6.35 μm] arithmetical average deviation (AA) from the mean line unless otherwise specified as in ANSI B46.1.

#### 6. Chemical Analysis

6.1 *Heat Analysis*—An analysis of each heat shall be made by the manufacturer to determine the percentages of elements specified in **Table 1**. The analysis shall be made on a test sample taken preferable during the pouring of the heat. The chemical composition thus determined shall conform to the requirements specified in **Table 1** (~~Note 2~~).

**NOTE 2**—The role of alloying elements in the development of Grade CP91 has been extensively investigated. V and Nb contribute to precipitation strengthening by forming fine and coherent precipitation of M(C,N)X carbo-nitrides in the ferrite matrix. V also precipitates as VN during tempering or during creep. Therefore, the addition of strong nitride forming elements, those with a stronger affinity for nitrogen than Nb and V, as deoxidation agents, interferes with these high-temperature strengthening mechanisms.<sup>7</sup>

6.2 *Product Analysis*—A product analysis may be made by the purchaser. The sample for analysis shall be selected so as to be representative of the pipe being analyzed. The chemical composition thus determined shall conform to the requirements of **Table 1**.  
<https://standards.iteh.ai/catalog/standards/sis/2151351-339a-48d0-8e02-200e1b351038/astm-a426-a426m-13>

#### 7. Tensile and Hardness Requirements

7.1 Steel used for the castings shall conform to the tensile and hardness requirements specified in **Table 3**.

#### 8. Permissible Variations in Dimensions

8.1 *Thickness*—The wall thickness shall not vary over that specified by more than 1/8 in. [3 mm]. There shall be no variation under the specified wall thickness.

#### 9. Number of Tests

9.1 One tension and one hardness test shall be made from each heat.

9.2 If a specimen is machined improperly or if flaws are revealed by machining or during testing, the specimen may be discarded and another substituted from the same heat.

#### 10. Retests

10.1 If the results of the mechanical tests for any heat do not conform to the requirements specified, the castings may be reheat-treated and retested, but may not be re-austenitized more than twice.

#### 11. Test Specimens

11.1 Test coupons from which tension test specimens are prepared shall be removed from heat-treated casting prolongations.

11.2 When agreed upon between the manufacturer and the purchaser, test coupons from which test specimens are prepared shall be cast attached to separate blocks from the same heat as the casting represented. The test blocks shall be heat treated in the same manner as the casting represented.



TABLE 2 Heat Treatment Requirements

Grade	Austenitizing Treatment	Tempering Temperature, min, unless a range is shown, °F [°C]
CP1	Normalized or Liquid Quenched	1100 [595]
CP2	Normalized or Liquid Quenched	1100 [595]
CP5	Normalized or Liquid Quenched	1250 [675]
CP5b	Normalized or Liquid Quenched	1250 [675]
CP9	Normalized or Liquid Quenched	1250 [675]
CP91	Austenitized at 1900-1975 °F [1040-1080 °C] and then Air Cooled or Liquid Quenched	1350-1470 [730-800]
CP11	Normalized or Liquid Quenched	1100 [595]
CP12	Normalized or Liquid Quenched	1100 [595]
CP15	Normalized or Liquid Quenched	1100 [595]
CP21	Normalized or Liquid Quenched	1250 [675]
CP22	Normalized or Liquid Quenched	1250 [675]
CPCA15	Normalized or Liquid Quenched	1250 [675]

11.3 Tension test specimens shall be machined to the form and dimensions of the standard round 2-in. [50-mm] gage length specimens shown in Fig. 6 of Test Methods and Definitions A370.

## 12. Hydrostatic Test

12.1 Except for Grade CP91, each Each length of pipe shall be hydrostatically tested in accordance with Specification A999/A999M.

12.2 When agreed to between the manufacturer and the purchaser and so stated in the order, the hydrostatic test may be deferred and shall be performed later by the purchaser. Pipe furnished without the hydrostatic test shall include with the mandatory marking the letters “NH.” The manufacturer is responsible for the satisfactory performance of the casting when it is tested.