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Standard Specification for Stainless Steel Jacketing for Insulation¹

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1. Scope

1.1 This specification covers stainless steel jacketing for thermal, acoustical, and fire protective insulation operating at either above or below ambient temperatures and in both indoor and outdoor locations. It does not cover insulation jacketing made from other materials such as mastics, fiber reinforced plastic, PVC, aluminum, or coated carbon steel (for example, aluminum-zinc, galvanized steel, or aluminized steel) nor does it cover the details of thermal, acoustical, or fire protective insulation systems.

1.2 While not intended to cover use inside the containment buildings of nuclear power plants, this standard does not preclude use of Class E material which does not have a moisture barrier in this containment building application.

1.3 This specification provides physical requirements for stainless steel jacketing for thermal and acoustical insulation. Guide C1423 provides guidance in selecting jacketing materials and their safe use.

1.4 This is a material specification and does not imply any performance of the installed system using the materials specified herein. For information about installation of stainless steel jacketing, see (1).²

1.5 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.

1.6 *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.*

¹ This test method is under the jurisdiction of ASTM Committee C16 on Thermal Insulation and is the direct responsibility of Subcommittee C16.40 on Insulation Systems.

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² The boldface numbers in parentheses refer to the list of references at the end of this standard.

2. Referenced Documents

2.1 ASTM Standards:³

A167 Specification for Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet, and Strip (Withdrawn 2014)⁴

A240/A240M Specification for Chromium and Chromium-Nickel Stainless Steel Plate, Sheet, and Strip for Pressure Vessels and for General Applications

A480/A480M Specification for General Requirements for Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet, and Strip

C168 Terminology Relating to Thermal Insulation

C450 Practice for Fabrication of Thermal Insulating Fitting Covers for NPS Piping, and Vessel Lagging

C585 Practice for Inner and Outer Diameters of Thermal Insulation for Nominal Sizes of Pipe and Tubing

C835 Test Method for Total Hemispherical Emittance of Surfaces up to 1400°C

C1371 Test Method for Determination of Emittance of Materials Near Room Temperature Using Portable Emisometers

C1423 Guide for Selecting Jacketing Materials for Thermal Insulation

C1729 Specification for Aluminum Jacketing for Insulation

C1785 Test Method for Concentration of Pinhole Detections in Moisture Barriers on Metal Jacketing

E84 Test Method for Surface Burning Characteristics of Building Materials

F1249 Test Method for Water Vapor Transmission Rate Through Plastic Film and Sheeting Using a Modulated Infrared Sensor

3. Terminology

3.1 *Definitions*—Definitions in Terminology C168 apply to terms used in this specification.

3.2 *Definitions of Terms Specific to This Standard:*

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 The last approved version of this historical standard is referenced on www.astm.org.

3.2.1 *box rib*—stainless steel sheet formed to have alternating parallel grooves and ridges with a cross section approximating a square wave.

3.2.2 *cladding (as related to insulation jacketing)*—synonymous with jacketing.

3.2.2.1 *Discussion*—The three terms “jacketing”, “lagging”, and “cladding” are considered synonymous in most applications and geographies. However, in some cases in the power industry in North America the term “lagging” has a different meaning than “jacketing” or “cladding” and refers specifically to a heavier gauge of jacketing.

3.2.3 *crevice corrosion*—localized corrosion of metal jacketing surface at, or immediately adjacent to an area that is shielded from full exposure to the environment because of close proximity between the metal and the surface of another material.

3.2.3.1 *Discussion*—This definition is taken from the ASTM Committee G01 on Corrosion of Metal.

3.2.4 *cross crimped*—synonymous with $\frac{3}{16}$ in. corrugated.

3.2.5 *deep corrugated*—stainless steel sheet formed to have alternating parallel grooves and ridges with a cross section approximating a sine wave.

3.2.6 *gore*—jacketing for elbows, fittings, or other non-straight portions of the piping system made from a multitude of similar overlapping pieces.

3.2.7 *lagging (as related to insulation jacketing)*—synonymous with jacketing.

3.2.7.1 *Discussion*—The three terms “jacketing”, “lagging”, and “cladding” are considered synonymous in most applications and geographies. However, in some cases in the power industry in North America the term “lagging” has a different meaning than “jacketing” or “cladding” and refers specifically to a heavier gauge of jacketing.

3.2.8 *mill finish*—the appearance of the stainless steel surface as supplied from the metal mill.

3.2.9 *moisture retarder (moister barrier)*—a layer of plastic film or other material applied to the inner side of metal jacketing to inhibit jacket corrosion by interfering with the formation of a galvanic cell between the dissimilar metals of the pipe and jacket or by preventing crevice corrosion.

3.2.9.1 *Discussion*—A moisture retarder is not an insulation system water vapor retarder and does not perform the same function.

3.2.10 *polykraft*—a multilayer composite film used as a moisture retarder on metal jacketing consisting of at least one layer of minimum 40 lb Kraft paper and one or more layers of plastic film, usually polyethylene at a minimum thickness of 1.5 mils.

3.2.10.1 *Discussion*—Kraft paper is commonly referred to by its basis weight which is the mass per area in units of lbs/3000 ft². In Metric units, this mass per area is called the grammage and is in units of g/m². 40 lb Kraft has a basis weight of 40 lbs/3000 ft² and a grammage of 65 g/m².

3.2.11 *polysurlyn*—a multilayer film used as a moisture retarder on metal jacketing consisting of at least one layer of

ethylene/methacrylic acid copolymer and one or more layers of other polymers, usually polyethylene.

3.2.12 *safety edge*—an edge of metal jacketing that has been de-burred or rounded by a rolling operation.

3.2.13 *safety hem*—a rounded edge of metal jacketing created by folding the edge of sheet jacketing completely back upon itself using a roll former or a brake.

3.2.13.1 *Discussion*—the fold is typically made toward the underside of the jacketing so that the original edge is hidden and the external appearance of the jacketing is preserved

3.2.14 *splice roll*—metal jacketing sold in roll form where the package contains two separate pieces of metal jacketing rolled approximately end to end.

3.2.14.1 *Discussion*—A splice roll occurs when the metal coil being used to form the roll jacketing reaches its end before the required roll length is obtained.

3.2.15 *split roll*—synonymous with splice roll.

3.2.16 *surface finish (as related to insulation jacketing)*—the final texture of the stainless steel jacketing surface.

4. Significance and Use

4.1 This specification is used to specify material by physical property requirements that address the prerequisites in Sections 6 to 10. The designer of an insulation system, after determining the system requirements, shall use this specification to specify the appropriate stainless steel jacketing.

5. Classification

5.1 Classification of stainless steel jacketing is based on three factors:

5.1.1 *Outer Surface Treatment and Emittance (ϵ):*

5.1.1.1 Type I = Bare surface, $\epsilon = 0.3$

5.1.2 *Alloy and Temper per Specification A240/A240M:*

5.1.2.1 Grade 1 = Alloy T-304/T-304L, annealed temper

5.1.2.2 Grade 2 = Alloy T-316/T-316L, annealed temper

NOTE 1—The four allowable alloys shown in 5.1.2 are of the austenitic type of stainless steel.

NOTE 2—The “L” in the alloy is an indication of low carbon content. Since the low carbon alloy will avoid corrosion problems caused by welding, a low carbon alloy is required on those rare occasions when the stainless steel jacketing will be subjected to direct welding or the heat from welding nearby metal. The low carbon and standard alloys are considered interchangeable for use as insulation jacketing.

5.1.3 *Moisture Retarder:*

5.1.3.1 Class A = polysurlyn, 3 mil thick

5.1.3.2 Class C = polykraft per section 3.2.10

5.1.3.3 Class E = no moisture retarder

NOTE 3—Classes B & D are omitted to maintain consistency with the similar standard for aluminum jacketing, Specification C1729.

6. Materials and Manufacture

6.1 Stainless steel jacketing materials are composed of a single material or a lamination of several components. The materials are supplied in the form of rolls or sheets or preformed to fit the surface to which they are to be applied. The materials are applied in the field or as a factory-applied composite with the insulation.

6.2 Material shall be stainless steel with a mill finish of either 2B or 2D per Specification **A240/A240M** unless an alternative finish is agreed to by both buyer and seller.

6.3 Material shall be stainless steel and shall have a surface finish that is smooth, $\frac{3}{16}$ in. corrugated, or stucco embossed. The dimensions of corrugations (pitch and depth) must be agreed to by manufacturer and purchaser to achieve interchangeability, constant rigidity, and appearance.

6.4 When agreed upon by purchaser and seller, stainless steel sheets used as pipe insulation jacketing (see **8.2**) shall have a safety edge or a $\frac{3}{8}$ to $\frac{1}{2}$ in. (9.5 to 12.7 mm) safety hem along one entire width edge of the sheet. Stainless steel jacketing with a safety edge or safety hem must still meet the length dimensions specified in **8.2.1**. A safety hem shall not be specified when the finish is $\frac{3}{16}$ in. corrugated.

6.5 In most cases, the inner surface of stainless steel jacketing material is coated or covered with a moisture resistant film to retard possible galvanic or chemical corrosion, or both, of the jacketing and underlying pipe or equipment.

6.6 The stainless steel used in this jacketing shall comply with the general, chemical composition, and mechanical property requirements of Specification **A240/A240M**—alloys T-304, T-304L, T-316, or T316L with annealed temper—Grades 1 or 2 per **5.1.2**.

NOTE 4—In some cases, compliance to Specification **A480/A480M** is requested for stainless steel jacketing. Specification **A240/A240M** requires compliance to a number of general requirements contained within **A480/A480M** and additionally has requirements for chemical composition and mechanical properties so it is preferred and more thorough to require compliance with Specification **A240/A240M**.

NOTE 5—In some cases, compliance to Specification **A167** is requested for stainless steel jacketing. Specification **A167-99(2009)** contains the following: “Grades that were previously covered in both Specifications **A167** and **A240/A240M** have been removed from this specification and may now be supplied and purchased in compliance with Specification **A240/A240M**. The chemical and mechanical property requirements of these grades were identical in Specifications **A167** and **A240/A240M** at the time of removal from Specification **A167**.” Since the grades used for stainless steel jacketing have effectively been transferred to and are now contained in **A240/A240M**, it is correct and preferred to require compliance with **A240/A240M**.

6.7 Stainless steel jacketing shall be specified by the thickness which shall be in the range from 0.010 to 0.050 in. (0.25 to 1.25 mm) with the exception of $\frac{3}{16}$ in. corrugated stainless steel which shall not be specified at greater than 0.024 in. (0.6 mm) thickness. Stainless steel jacketing of thickness greater than 0.032 in. (0.8 mm) is typically used only to provide the mass required in some acoustic jacketing.

NOTE 6—The thickness values mentioned in sections **6.7**, **6.8**, **6.9**, and **6.10** are nominal thickness. The tolerances shown in **Table 3** apply to these listed nominal values.

6.8 The measured thickness of metal jacketing will be affected by any forming or rolling such as that described in **10.4**. All requirements for and discussion of jacketing thickness and thickness tolerance in this specification including **Table 1** and **Table 3** apply to the base metal before any forming or rolling and do not include any coatings or films that are applied to the surface such as the moisture barriers described in **5.1.3**.

TABLE 1 Minimum Thickness for Pipe Jacketing

Nominal Outer Insulation Diameter (in.)	Minimum Allowable Stainless Steel Nominal ^A Thickness inches (mm)
≤ 8	0.010 (0.25)
over 8 thru 11	0.010 (0.25)
over 11 thru 24	0.010 (0.25)
over 24 thru 36	0.016 (0.4)
over 36	0.020 (0.5)

^A The minimum thickness values in this table are the minimum nominal thickness permitted. The tolerances shown in **Table 3** still apply to the minimum nominal values in this table.

TABLE 2 Physical Properties

Type Grade	I All		
	A	C	E
Emittance	0.3	0.3	0.3
Surface Burning (flame/smoke)	≤ 25/50	≤ 25/50	≤ 25/50
Moisture retarder pinhole detections (per 50 ft ²)	≤ 5	≤ 5	n.a.
Moisture retarder WVTR (g/100 in. ² /day)	≤ 0.1	≤ 1.1	n.a.

TABLE 3 Permissible Thickness Tolerances

Nominal thickness inches (mm)	Thickness tolerance in. (mm) for	
	Up to 39.4 in. (1 m) wide jacketing and deep corrugated sheet	48 in. (1.22 m) wide jacketing and box rib sheet
≤ to 0.012 (≤ to 0.30)	± 0.0010 (± 0.0254)	± 0.0015 (± 0.0381)
>0.012 and ≤ 0.016 (>0.30 and ≤ 0.40)	± 0.0015 (± 0.0381)	± 0.0015 (± 0.0381)
>0.016 and ≤ 0.020 (>0.40 and ≤ 0.50)	± 0.0015 (± 0.0381)	± 0.0015 (± 0.0381)
>0.020 and ≤ 0.024 (>0.50 and ≤ 0.60)	± 0.0020 (± 0.0508)	± 0.0020 (± 0.0508)
>0.024 and ≤ 0.032 (>0.60 and ≤ 0.80)	± 0.0020 (± 0.0508)	± 0.0020 (± 0.0508)
>0.032 and ≤ 0.040 (>0.80 and ≤ 1.0)	± 0.0025 (± 0.0635)	± 0.0025 (± 0.0635)
>0.040 and ≤ 0.050 (>1.0 and ≤ 1.25)	± 0.0030 (± 0.0762)	± 0.0030 (± 0.0762)

6.9 Box rib stainless steel jacketing pieces shall be 0.020 (0.5 mm), 0.024 (0.6 mm) or 0.032 in. (0.8 mm) thick, with a stucco embossed finish.

NOTE 7—Typical box rib widths available are 38.5 in. (978 mm) and 27.5 in. (699 mm). Typical lengths available are 8, 10, and 12 ft (2.4, 3.0, and 3.7 m). The pattern of grooves and ridges typically repeats on 4 in. (102 mm) centers and the height of each rib is typically 1 in. (25 mm).

6.10 Deep corrugated stainless steel jacketing pieces shall be 0.010 in. (0.25 mm), 0.016 in. (0.4 mm), 0.020 in. (0.5 mm), or 0.024 in. (0.6 mm) thick.

NOTE 8—Typical deep corrugated width is 33 in. (838 mm) and typical length is 6 to 12 ft (1.8 to 3.7 m). Two nominal repeating patterns are common: 1- $\frac{1}{4}$ in. (32 mm) on centers with a $\frac{1}{4}$ in. (6 mm) height and a 2- $\frac{1}{2}$ in. (64 mm) on centers with a $\frac{3}{8}$ in. (16 mm) height. For specific repeating pattern distances, the manufacturer shall be consulted.