



**International  
Standard**

**ISO 13680**

**Oil and gas industries including  
lower carbon energy — Corrosion-  
resistant alloy seamless products  
for use as casing, tubing, coupling  
stock and accessory material —  
Technical delivery conditions**

**Fifth edition  
2024-05**

*Industries du pétrole et du gaz y compris les énergies à faible teneur en carbone — Produits sans soudure en acier allié résistant à la corrosion utilisés comme tubes de cuvelage, tubes de production, tubes-ébauches pour manchons et matériau pour accessoires — Conditions techniques de livraison*

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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO document should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

ISO draws attention to the possibility that the implementation of this document may involve the use of (a) patent(s). ISO takes no position concerning the evidence, validity or applicability of any claimed patent rights in respect thereof. As of the date of publication of this document, ISO had not received notice of (a) patent(s) which may be required to implement this document. However, implementers are cautioned that this may not represent the latest information, which may be obtained from the patent database available at [www.iso.org/patents](http://www.iso.org/patents). ISO shall not be held responsible for identifying any or all such patent rights.

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 67, *Oil and gas industries including lower carbon energy*, Subcommittee SC 5, *Casing, tubing and drill pipe*.

This fifth edition cancels and replaces the fourth edition (ISO 13680:2020), which has been technically revised.

The main changes are as follows:

- adjustment of the scope and title to make it clear that bar material is now included (removal of the word "tubular");
- update of normative references;
- review of straightening requirements, including addition of [Figure B.9](#);
- clarification on the use of alternative method for visual inspection;
- clarification of PMI requirements;
- clarification of marking content and sequence;
- extension of records retention period to five years;
- review of [Annex H](#).

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html).

# Oil and gas industries including lower carbon energy — Corrosion-resistant alloy seamless products for use as casing, tubing, coupling stock and accessory material — Technical delivery conditions

**WARNING** — It is the purchaser's responsibility to specify the product specification level (PSL), corrosion-resistant alloy (CRA) group, category, grade, delivery conditions and any other requirement in addition to those specified herewith to ensure that the product is adequate for the intended service environment. The ISO 15156 series or NACE MR0175 should be considered when making specific requirements for H<sub>2</sub>S-containing environments; see [Annex G](#). It is the product user's responsibility to ensure that the product is suitable for the intended application with consideration of all environmental degradation threats during both normal operation and system upsets. There are other sources of hydrogen besides H<sub>2</sub>S-containing environments, which are not addressed by the ISO 15156 series or NACE MR0175. Not all PSL-1 categories and grades can be made cracking resistant in accordance with the ISO 15156 series or NACE MR0175 and are, therefore, not included in PSL-2.

## 1 Scope

This document specifies the technical delivery conditions for corrosion-resistant alloy seamless products for casing, tubing, coupling stock and accessory material (including coupling stock and accessory material from bar) for two product specification levels:

- PSL-1, which is the basis of this document;
- PSL-2, which provides additional requirements for a product that is intended to be both corrosion and cracking resistant for the environments and qualification method specified in [Annex G](#) and in the ISO 15156 series or NACE MR0175.

This document contains no provisions relating to the connection of individual lengths of pipe. Demonstration of conformance to ISO 15156-3:2020 or NACE MR0175-2021 of material affected by end sizing, connection manufacture or welding operations is outside the scope of this document.

This document contains provisions relating to marking of tubing and casing after threading.

This document is applicable to the following five groups of products:

- a) group 1, which is composed of stainless alloys with a martensitic or martensitic/ferritic structure;
- b) group 2, which is composed of stainless alloys with a ferritic-austenitic structure, such as duplex and super-duplex stainless alloy;
- c) group 3, which is composed of stainless alloys with an austenitic structure (iron base);
- d) group 4, which is composed of nickel-based alloys with an austenitic structure (nickel base);
- e) group 5, which is composed of bar only ([Annex F](#)) in age-hardened (AH) nickel-based alloys with austenitic structure.

## 2 Normative references

The following documents, as applicable for the product, are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited



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applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 377, *Steel and steel products — Location and preparation of samples and test pieces for mechanical testing*

ISO 404, *Steel and steel products — General technical delivery requirements*

ISO 525, *Bonded abrasive products — General requirements*

ISO 643, *Steels— Micrographic determination of the apparent grain size*

ISO 3452-1, *Non-destructive testing — Penetrant testing — Part 1: General principles*

ISO 4885, *Ferrous materials — Heat treatments — Vocabulary*

ISO 4948-1, *Steels — Classification — Part 1: Classification of steels into unalloyed and alloy steels based on chemical composition*

ISO 4948-2, *Steels — Classification — Part 2: Classification of unalloyed and alloy steels according to main quality classes and main property or application characteristics*

ISO 6508-1, *Metallic materials — Rockwell hardness test — Part 1: Test method*

ISO 6508-2, *Metallic materials — Rockwell hardness test — Part 2: Verification and calibration of testing machines and indenters*

ISO 6892-1, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature*

ISO 6892-2, *Metallic materials — Tensile testing — Part 2: Method of test at elevated temperature*

ISO 6929, *Steel products — Vocabulary*

ISO 8501-1, *Preparation of steel substrates before application of paints and related products — Visual assessment of surface cleanliness — Part 1: Rust grades and preparation grades of uncoated steel substrates and of steel substrates after overall removal of previous coatings*

ISO 9712, *Non-destructive testing — Qualification and certification of NDT personnel*

ISO 9934-1, *Non-destructive testing — Magnetic particle testing — Part 1: General principles*

ISO 10423, *Petroleum and natural gas industries — Drilling and production equipment — Wellhead and tree equipment*

ISO 10474, *Steel and steel products — Inspection documents*

ISO 10893-2, *Non-destructive testing of steel tubes — Part 2: Automated eddy current testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of imperfections*

ISO 10893-3, *Non-destructive testing of steel tubes — Part 3: Automated full peripheral flux leakage testing of seamless and welded (except submerged arc-welded) ferromagnetic steel tubes for the detection of longitudinal and/or transverse imperfections*

ISO 10893-4, *Non-destructive testing of steel tubes — Part 4: Liquid penetrant inspection of seamless and welded steel tubes for the detection of surface imperfections*

ISO 10893-5, *Non-destructive testing of steel tubes — Part 5: Magnetic particle inspection of seamless and welded ferromagnetic steel tubes for the detection of surface imperfections*

ISO 10893-8, *Non-destructive testing of steel tubes — Part 8: Automated ultrasonic testing of seamless and welded steel tubes for the detection of laminar imperfections*

ISO 10893-10, *Non-destructive testing of steel tubes — Part 10: Automated full peripheral ultrasonic testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of longitudinal and/or transverse imperfections*



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ISO 10893-12, *Non-destructive testing of steel tubes — Part 12: Automated full peripheral ultrasonic thickness testing of seamless and welded (except submerged arc-welded) steel tubes*

ISO 11484, *Steel products — Employer's qualification system for non-destructive testing (NDT) personnel*

ISO 14284, *Steel and iron — Sampling and preparation of samples for the determination of chemical composition*

ISO 15156 (all parts), *Petroleum and natural gas industries — Materials for use in H<sub>2</sub>S-containing environments in oil and gas production*

ISO 15156-3:2020, *Petroleum and natural gas industries — Materials for use in H<sub>2</sub>S-containing environments in oil and gas production — Part 3: Cracking-resistant CRAs (corrosion-resistant alloys) and other alloys*

ISO 21920-2, *Geometrical product specifications (GPS) — Surface texture: Profile — Part 2: Terms, definitions and surface texture parameters*

ISO 80000-1, *Quantities and units — Part 1: General*

API RP 578, *Guidelines for a Material Verification Program (MVP) for New and Existing Assets*

API Spec 6A, *Specification for Wellhead and Christmas Tree Equipment*

API Standard 6ACRA, *Age-hardened Nickel-based Alloys for Oil and Gas Drilling and Production Equipment*

ASNT SNT-TC-1A, *Recommended Practice — Non-Destructive Testing*

ASTM A370, *Standard Test Methods and Definitions for Mechanical Testing of Steel Products*

ASTM A604/A604M, *Standard Practice for Macroetch Testing of Consumable Electrode Remelted Steel Bars and Billets*

ASTM A941, *Standard Terminology Relating to Steel, Stainless Steel, Related Alloys and Ferroalloys*

ASTM E18, *Standard Test Methods for Rockwell Hardness of Metallic Materials*

ASTM E21, *Standard Test Methods for Elevated Temperature Tension Tests of Metallic Materials*

ASTM E23, *Standard Test Methods for Notched Bar Impact Testing of Metallic Materials*

ASTM E29, *Standard Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications*

ASTM E45, *Standard Test Methods for Determining the Inclusion Content of Steel*

ASTM E110, *Standard Test Method for Rockwell and Brinell Hardness of Metallic Materials by Portable Hardness Testers*

ASTM E112, *Standard Test Methods for determining the average Grain Size*

ASTM E165, *Standard Practice for Liquid Penetrant Examination for General Industry*

ASTM E213, *Standard Practice for Ultrasonic Testing of Metal Pipe and Tubing*

ASTM E309, *Standard Practice for Eddy-Current Examination of Steel Tubular Products Using Magnetic Saturation*

ASTM E340, *Standard Test Method for Macroetching Metals and Alloys*

ASTM E381, *Standard Method of Macroetch Testing Steel Bars, Billets, Blooms, and Forgings*

ASTM E562, *Standard Test Method for Determining Volume Fraction by Systematic Manual Point Count*

ASTM E570, *Standard Practice for Flux Leakage Examination of Ferromagnetic Steel Tubular Products*

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ASTM E1245, *Standard Practice for Determining the Inclusion or Second-Phase Constituent Content of Metals by Automatic Image Analysis*

ASTM E1476, *Standard Guide for Metals Identification, Grade Verification, and Sorting*

ASTM E3024, *Standard Practice for Magnetic Particle Testing for General Industry*

ASTM G48, *Standard Test Methods for Pitting and Crevice Corrosion Resistance of Stainless Steels and Related Alloys by Use of Ferric Chloride Solution*

NACE MR0175, *Petroleum and Natural Gas Industries — Materials for Use in H<sub>2</sub>S-containing Environments in Oil and Gas Production*

## 3 Terms, definitions, abbreviated terms and symbols

### 3.1 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 377, ISO 404, ISO 4885, ISO 4948-1, ISO 4948-2, ISO 6929, ISO 10474, ASTM A941 and the following apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

#### 3.1.1

##### **accessory material**

seamless *casing* (3.1.3) or *tubing* (3.1.23) or seamless thick-walled tube or *bar stock* (3.1.2) or hot forging used for the manufacture of accessories

#### 3.1.2

##### **bar stock**

##### **bar**

material with a solid uniform cross-section along its whole *length* (3.1.14)

#### 3.1.3

##### **casing**

tube intended to line the walls of a drilled well

#### 3.1.4

##### **cold-hardened**

##### **CH**

material condition where the mechanical properties are obtained by a cold finishing process not followed by heat treatment

Note 1 to entry: Cold finishing is a plastic deformation of material at a temperature below the recrystallization temperature such that permanent strain hardening occurs.

#### 3.1.5

##### **corrosion-resistant alloy**

##### **CRA**

alloy intended to be resistant to general and localized corrosion and/or environmental cracking in environments that are corrosive to carbon and low-alloy steels

Note 1 to entry: The corrosion-resistant alloys included in this document are special alloys in accordance with ISO 4948-1 and ISO 4948-2.

#### 3.1.6

##### **coupling blank**

unthreaded material used to produce an individual coupling

**3.1.7**

**coupling stock**

seamless thick-wall *product* (3.1.18) used for the manufacture of *coupling blanks* (3.1.6)

**3.1.8**

**defect**

*imperfection* (3.1.11) having sufficient magnitude to warrant rejection of the *length* (3.1.14)

Note 1 to entry: Based on criteria defined in this document.

**3.1.9**

**heat**

material of the same category melted in the same manufacturing process at the same time sequence poured into multiple ingots or continuous strand cast

Note 1 to entry: In case of a remelted alloy, each ingot shall be considered a different heat.

**3.1.10**

**hot-finished**

**HF**

material condition obtained by deforming metal plastically at such a temperature and strain rate that recrystallization takes place simultaneously with the deformation, thus preventing permanent strain hardening

**3.1.11**

**imperfection**

discontinuity on the *product* (3.1.18) surface or in the product wall that can be detected by visual inspection or non-destructive examination

**3.1.12**

**label 1**

dimensionless designation for the size or specified outside diameter that can be used when ordering *pipe* (3.1.17)

**3.1.13**

**label 2**

dimensionless designation for the linear density that can be used when ordering *pipe* (3.1.17)

Note 1 to entry: Linear density is sometimes designated by the deprecated term “mass per unit length”.

**3.1.14**

**length**

piece of *product* (3.1.18)

**3.1.15**

**linear imperfection**

*imperfection* (3.1.11) including, but not limited to, seams, laps, cracks, plug scores, cuts and gouges

**3.1.16**

**manufacturer**

firm, company or corporation that operates facilities for making seamless tubes for *casing* (3.1.3), *tubing* (3.1.23), *coupling stock* (3.1.7) or *accessory material* (3.1.1)

**3.1.17**

**pipe**

plain end, either upset or non-upset, furnished without threads, *casing* (3.1.3), *tubing* (3.1.23) and *pup joint* (3.1.19) as group

**3.1.18**

**product**

*pipe* (3.1.17) and/or *coupling stock* (3.1.7) and/or *accessory material* (3.1.1), either individually or collectively, as applicable

**3.1.19**

**pup joint**

*casing* (3.1.3) or *tubing* (3.1.23) shorter than range 1

**3.1.20**

**solution annealing**

heat treatment requiring heating to a suitable temperature, holding at that temperature long enough to cause one or more constituents to enter into solid solution, then cooling rapidly enough to hold such constituents in solution

Note 1 to entry: Solution annealing may be performed as a part of the hot forming process or as a separate operation.

**3.1.21**

**test lot**

**lot**

<products other than bars or drilled bars> unit formed by *lengths* (3.1.14) from the same *heat* (3.1.9), with the same specified outside diameter and wall thickness, the same grade, the same manufacturing process, the same final heat-treatment conditions, process facilities and parameters for all heat-treatment stages, processed sequentially for continuous furnaces or simultaneously for batch furnaces, the same cold hardening parameters (if applicable) and the same range length

Note 1 to entry: The maximum number of lengths in a test lot is given in [Table A.22](#) or [Table C.22](#).

**3.1.22**

**test lot**

**lot**

<bars or drilled bars> unit formed by *lengths* (3.1.14) from the same *heat* (3.1.9), with the same specified outside diameter, the same wall thickness (if applicable), the same grade, the same manufacturing process facilities and parameters for all heat-treatment stages, processed sequentially for continuous furnaces or simultaneously for batch furnaces

Note 1 to entry: The maximum number of lengths in a test lot is given in [F.5.1](#).

**3.1.23**

**tubing**

tube placed in a well to produce or inject fluids

<https://standards.iteh.ai/catalog/standards/iso/760e4297-95da-48f9-afa6-16c8fe8f0c5c/iso-13680-2024>

**3.2 Abbreviated terms**

AOD	argon oxygen decarburization
EDI	electronic data interchange
EMI	electromagnetic inspection
ESR	electro-slag remelting
HBW	Brinell hardness, when testing with a tungsten carbide ball
HRC	Rockwell hardness C-scale
ID	inside diameter
MPQT	manufacturing procedure qualification test
MT	magnetic-particle inspection
NDE	non-destructive examination
OD	outside diameter

PMI	positive material identification
PREN	pitting-resistance equivalent number
PSL	product specification level
QT	quenched and tempered
SA	solution-annealed
SI	International System of Units
UNS	unified numbering system
USC	United States customary system
UT	ultrasonic testing
VAD	vacuum arc degassing
VAR	vacuum arc remelting
VIM	vacuum induction melting
VOD	vacuum oxygen decarburization

### 3.3 Symbols

$A$	cross-sectional area of the tensile test specimen, expressed in square millimetres (square inches), based on specified outside diameter or nominal specimen width and specified wall thickness, rounded to the nearest 10 mm <sup>2</sup> (0.01 in <sup>2</sup> ), or 490 mm <sup>2</sup> (0.75 in <sup>2</sup> ), whichever is smaller
$C_v$	Charpy V-notch energy requirement, expressed in joules (foot pounds)
$D$	outside diameter of the product, expressed in millimetres (inches)
$d$	inside diameter of the product, expressed in millimetres (inches)
$e$	minimum elongation in 50 mm (2.0 in) gauge length for strip specimens or in 4D or 5D for round bar specimens, expressed in per cent
$m$	mass
$R_a$	average surface roughness as defined in ISO 21920-2
$R_m$	tensile strength
$R_{p0,2}$	yield strength (0,2 % non-proportional elongation), expressed in megapascals (thousand pounds per square inch)
$t$	wall thickness of the product, expressed in millimetres (inches)
$w_x$	mass fraction of element $x$ , expressed in per cent
$Y_{S,min}$	minimum specified yield strength, expressed in megapascals (thousand pounds per square inch)
$Y_{S,max}$	maximum specified yield strength, expressed in megapascals (thousand pounds per square inch)

## 4 General

### 4.1 Dual normative references

In the interests of worldwide application of this document, certain normative references listed in [Clause 2](#) are interchangeable in the context of the relevant requirement with the relevant document prepared by the American Petroleum Institute (API) or the American Society for Testing and Materials (ASTM), as recognized by the American National Standards Institute (ANSI). These latter documents are cited in the running text following the ISO reference and preceded by “or”, for example “ISO XXXX or API YYYY”.

Application of an alternative normative document cited in this manner can lead to technical results that differ from the use of the preceding ISO reference. However, both results are acceptable and these documents are, thus, considered interchangeable in practice.

### 4.2 Units of measurement

In this document, data are expressed in both the International System (SI) of units and the United States Customary (USC). For a specific order item, it is intended that only one system of units be used, without combining data expressed in the other system.

Products manufactured to specifications expressed in either of these unit systems shall be considered equivalent and totally interchangeable. Consequently, conformance to the requirements of this document as expressed in one system provides conformance to requirements expressed in the other system.

For data expressed in SI units, a comma is used as the decimal separator and a space as the thousands separator.

For data expressed in USC units, a dot (on the line) is used as the decimal separator and a space as the thousands separator.

In the text, data in SI units are followed by data in USC in parentheses.

Separate tables for data expressed in SI units and USC units are given in [Annex A](#) and [Annex C](#), respectively.

Figures are contained in [Annex B](#) and express data in both SI and USC units.

<https://standards.iteh.ai/catalog/standards/iso/760e4297-95da-48f9-afa6-16c8fe8f0c5c/iso-13680-2024>

## 5 Information supplied by the purchaser

5.1 The purchaser shall state the minimum information as given in [Table 1](#), as applicable, in the enquiry and purchase agreement.

**Table 1 — Minimum information to be supplied by purchaser**

Requirement	Reference
a) Quantity of product	—
b) Product designation: coupling stock or accessory material or plain end casing or tubing or upset product	For upset product, upset drawing and drift dimension shall be supplied by the purchaser
c) Reference to this document	—
d) Material category/grade	<a href="#">Table A.2</a> or <a href="#">Table C.2</a> and <a href="#">Table A.3</a> or <a href="#">Table C.3</a>
e) Label 1 and label 2 or specified outside diameter and specified wall thickness	<a href="#">Table A.16</a> or <a href="#">Table C.16</a> or as specified in purchase agreement per <a href="#">8.1.2</a>
f) Coupling stock or accessory material dimensions, expressed in millimetres (inches)	As specified in purchase agreement
g) Length requirements	<a href="#">8.2</a> ; <a href="#">Table A.17</a> or <a href="#">Table C.17</a> or as specified in purchase agreement