



Designation: **A814/A814M—08 A814/A814M – 15**

Standard Specification for Cold-Worked Welded Austenitic Stainless Steel Pipe¹

This standard is issued under the fixed designation A814/A814M; 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.

1. Scope*

1.1 This specification covers two classes of flanged and cold-bending quality cold-worked straight-seam single or double welded austenitic steel pipe intended for high-temperature and general corrosive services.

NOTE 1—When the impact test criterion for a low-temperature service would be 15 ft·lbf [20 J] energy absorption or 15 mils [0.38 mm] lateral expansion, some of the austenitic stainless steel grades covered by this specification are accepted by certain pressure vessel or piping codes without the necessity of making the actual test. For example, Grades 304, 304L, and 347 are accepted by the ASME Pressure Vessel Code, Section VIII Division 1, and by the Chemical Plant and Refinery Piping Code, ANSI B31.3 for service at temperatures as low as -425°F [-250°C] without qualification by impact tests. Other AISI stainless steel grades are usually accepted for service temperatures as low as -325°F [-200°C] without impact testing. Impact testing may, under certain circumstances, be required. For example, materials with chromium or nickel content outside the AISI ranges, and for material with carbon content exceeding 0.10 %, are required to be impact tested under the rules of ASME Section VIII Division 1 when service temperatures are lower than -50°F [-45°C].

1.2 Grades TP304H, TP304N, TP316H, TP316N, TP321H, TP347H, and TP348H are modifications of Grades TP304, TP316, TP321, TP347, and TP348, and are intended for high-temperature service.

1.3 Two classes of pipe are covered as follows:

1.3.1 *Class SW*—Pipe, single-welded with no addition of filler metal and

1.3.2 *Class DW*—Pipe, double-welded with no addition of filler metal.

1.4 Optional supplementary requirements are provided for pipe where a greater degree of testing is desired. These supplementary requirements call for additional tests to be made and, when desired, one or more of these may be specified in the order.

1.5 **Table 1** lists the dimensions of cold-worked single- or double-welded stainless steel pipe. Pipe having other dimensions may be furnished provided such pipe complies with all other requirements of this specification.

1.6 The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification. The inch-pound units shall apply unless the “M” designation of this specification is specified in the order.

2. Referenced Documents

2.1 *ASTM Standards*:²

[A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels](#)

[A370 Test Methods and Definitions for Mechanical Testing of Steel Products](#)

[A480/A480M Specification for General Requirements for Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet, and Strip](#)

[A999/A999M Specification for General Requirements for Alloy and Stainless Steel Pipe](#)

[E112 Test Methods for Determining Average Grain Size](#)

[E381 Method of Macroetch Testing Steel Bars, Billets, Blooms, and Forgings](#)

[E527 Practice for Numbering Metals and Alloys in the Unified Numbering System \(UNS\)](#)

2.2 *ANSI Standards*:³

[B31.3 Process Piping](#)

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.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

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



TABLE 1 Pipe Dimensions^A

NOTE 1—For pipe sizes not listed and for pipe ordered to the “M” designation of this specification, the dimensions and tolerances shall be by agreement between the purchaser and producer.

NPS No.	Outside Diameter	Outside Diameter Tolerance	Schedule	Wall	
				Thickness	Tolerance
1/8	0.405	+0.004 -0.002	10	0.049	±0.004
			40	0.068	±0.005
			80	0.095	±0.006
1/4	0.540	+0.005 -0.003	10	0.065	±0.005
			40	0.088	±0.006
			80	0.119	±0.009
3/8	0.675	+0.006 -0.004	10	0.065	±0.005
			40	0.091	±0.006
			80	0.126	±0.010
1/2	0.840	+0.007 -0.005	5	0.065	±0.005
			10	0.083	±0.006
			40	0.109	±0.009
			80	0.147	±0.011
3/4	1.060	+0.010 -0.007	5	0.065	±0.005
			10	0.083	±0.006
			40	0.113	±0.009
			80	0.154	±0.011
1	1.315	+0.010 -0.007	5	0.065	±0.005
			10	0.109	±0.009
			40	0.133	±0.011
			80	0.179	±0.014
1 1/4	1.660	+0.012 -0.0080	5	0.065	±0.005
			10	0.109	±0.009
			40	0.140	±0.011
			80	0.191	±0.014
1 1/2	1.900	+0.015 -0.008	5	0.065	±0.005
			10	0.109	±0.009
			40	0.145	±0.011
			80	0.200	±0.015
2	2.375	+0.018 -0.008	5	0.065	±0.005
			10	0.109	±0.009
			40	0.154	±0.011
			80	0.218	±0.015
2 1/2	2.875	+0.020 -0.009	5	0.065	±0.005
			10	0.120	±0.010
			40	0.203	±0.015
			80	0.276	±0.020
3	3.500	+0.025 -0.010	5	0.083	±0.006
			10	0.120	±0.010
			40	0.216	±0.015
			80	0.300	±0.020
3 1/2	4.000	+0.025 -0.010	5	0.083	±0.006
			10	0.120	±0.010
			40	0.226	±0.018
			80	0.318	±0.020
4	4.500	+0.025 -0.010	5	0.083	±0.006
			10	0.120	±0.010
			40	0.237	±0.019
			80	0.337	±0.020

TABLE 1 Pipe Dimensions^A

NPS No.	Outside Diameter	Outside Diameter Tolerance	Schedule	Wall	
	in. [mm]	in. [mm]		Thickness in. [mm]	Tolerance in. [mm]
e 1/8	0.405 [10.29]	+0.004 [0.10] -0.002 [0.05]	10	0.049 [1.24]	±0.004 [0.10]
			40	0.068 [1.72]	±0.005 [0.12]
			80	0.095 [2.41]	±0.006 [0.15]
1/4	0.540 [13.72]	+0.005 [0.12] -0.003 [0.08]	10	0.065 [1.65]	±0.005 [0.12]
			40	0.088 [2.24]	±0.006 [0.15]
			80	0.119 [3.02]	±0.009 [0.23]
3/8	0.675 [17.15]	+0.006 [0.15] -0.004 [0.10]	10	0.065 [1.65]	±0.005 [0.12]
			40	0.091 [2.31]	±0.006 [0.15]
			80	0.126 [3.20]	±0.010 [0.25]
1/2	0.840 [21.34]	+0.007 [0.18] -0.005 [0.12]	5	0.065 [1.65]	±0.005 [0.12]
			10	0.083 [2.11]	±0.006 [0.15]
			40	0.109 [2.77]	±0.009 [0.23]
			80	0.147 [3.73]	±0.011 [0.28]
3/4	1.050 [26.67]	+0.010 [0.25]	5	0.065 [1.65]	±0.005 [0.12]



NPS No.	Outside Diameter		Schedule	Wall	
	in. [mm]	Tolerance in. [mm]		Thickness in. [mm]	Tolerance in. [mm]
1	1.315 [33.40]	-0.007 [0.18]	10	0.083 [2.11]	±0.006 [0.15]
			40	0.113 [2.87]	±0.009 [0.23]
			80	0.154 [3.91]	±0.011 [0.28]
			5	0.065 [1.65]	±0.005 [0.12]
			10	0.109 [2.77]	±0.009 [0.23]
			40	0.133 [3.38]	±0.011 [0.28]
1¼	1.660 [42.16]	+0.012 [0.30]	5	0.065 [1.65]	±0.005 [0.12]
			10	0.109 [2.77]	±0.009 [0.23]
			40	0.140 [3.56]	±0.011 [0.28]
			80	0.179 [4.55]	±0.014 [0.36]
			5	0.065 [1.65]	±0.005 [0.12]
			10	0.109 [2.77]	±0.009 [0.23]
1½	1.900 [48.26]	+0.015 [0.38]	5	0.065 [1.65]	±0.005 [0.12]
			10	0.109 [2.77]	±0.009 [0.23]
			40	0.145 [3.68]	±0.011 [0.28]
			80	0.200 [5.08]	±0.015 [0.38]
			5	0.065 [1.65]	±0.005 [0.12]
			10	0.109 [2.77]	±0.009 [0.23]
2	2.375 [60.33]	+0.018 [0.46]	5	0.065 [1.65]	±0.005 [0.12]
			10	0.109 [2.77]	±0.009 [0.23]
			40	0.154 [3.91]	±0.011 [0.28]
			80	0.218 [5.54]	±0.015 [0.38]
			5	0.065 [1.65]	±0.005 [0.12]
			10	0.120 [3.05]	±0.010 [0.25]
2½	2.875 [73.03]	+0.020 [0.51]	5	0.065 [1.65]	±0.005 [0.12]
			10	0.120 [3.05]	±0.010 [0.25]
			40	0.203 [5.16]	±0.015 [0.38]
			80	0.276 [7.01]	±0.020 [0.51]
			5	0.065 [1.65]	±0.005 [0.12]
			10	0.120 [3.05]	±0.010 [0.25]
3	3.500 [88.90]	+0.025 [0.63]	5	0.083 [2.11]	±0.006 [0.15]
			10	0.120 [3.05]	±0.010 [0.25]
			40	0.216 [5.49]	±0.015 [0.38]
			80	0.300 [7.62]	±0.020 [0.51]
			5	0.083 [2.11]	±0.006 [0.15]
			10	0.120 [3.05]	±0.010 [0.25]
3½	4.000 [101.6]	+0.025 [0.63]	5	0.083 [2.11]	±0.006 [0.15]
			10	0.120 [3.05]	±0.010 [0.25]
			40	0.226 [5.74]	±0.018 [0.46]
			80	0.318 [8.08]	±0.020 [0.51]
			5	0.083 [2.11]	±0.006 [0.15]
			10	0.120 [3.05]	±0.010 [0.25]
4	4.500 [114.3]	+0.025 [0.63]	5	0.083 [2.11]	±0.006 [0.15]
			10	0.120 [3.05]	±0.010 [0.25]
			40	0.237 [6.02]	±0.019 [0.48]
			80	0.337 [8.56]	±0.020 [0.51]
			5	0.083 [2.11]	±0.006 [0.15]
			10	0.120 [3.05]	±0.010 [0.25]

⁴ All dimensions in inches.

ASME Standards
<http://standards.itec.org>
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ASTM A814/A814M-15

- 2.3 ASME Boiler and Pressure Vessel Code:⁴
 Section VIII Division 1, Pressure Vessels
- 2.4 SAE Standard:⁵
 SAE J 1086 Practice for Numbering Metals and Alloys (UNS)

3. Ordering Information

- 3.1 Orders for material under this specification should 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 (austenitic steel pipe),
 - 3.1.3 Class (1.3). If not specified by the purchaser, the producer shall have the option to furnish either single-welded (SW) or double-welded (DW) pipe,
 - 3.1.4 Grade (Table 2),
 - 3.1.5 Size (NPS or outside diameter and schedule number or average wall thickness),
 - 3.1.6 Length (specific or random) (Section 10),
 - 3.1.7 End finish (Section on Ends of Specification A999/A999M),
 - 3.1.8 Optional requirements (Section 9), (Supplementary Requirements S1 to S8),
 - 3.1.9 Test report required (Section on Certification of Specification A999/A999M),
 - 3.1.10 Specification designation, and
 - 3.1.11 Special requirements or exceptions to the specification.

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.
⁵ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.



TABLE 2 Chemical Requirements

Grade	UNS Designation ^A	Composition, %														
		Carbon, max ^B	Manganese, max ^B	Phosphorus, max	Sulfur, max	Silicon	Nickel	Chromium	Molybdenum	Titanium	Columbium plus Tantalum	Tantalum, max	Nitrogen ^C	Vanadium	Copper	Cerium
TP 201	S20100	0.15	5.5–7.5	0.060	0.030	1.00	3.5–5.5	16.0–18.0	0.25
TP 201LN	S20153	0.03	6.4–7.5	0.045	0.015	0.75	4.0–5.0	16.0–17.5	0.10–0.25	...	1.00	...
TP 304	S30400	0.08	2.00	0.045	0.030	1.00 max	8.0–11.0	18.0–20.0
TP 304H	S30409	0.04–0.10	2.00	0.045	0.030	1.00 max	8.0–11.0	18.0–20.0
TP 304L	S30403	0.030 ^D	2.00	0.045	0.030	1.00 max	8.0–13.0	18.0–20.0
TP 304N	S30451	0.08	2.00	0.045	0.030	1.00 max	8.0–11.0	18.0–20.0	0.10–0.16
TP 304LN	S30453	0.030	2.00	0.045	0.030	1.00 max	8.0–11.0	18.0–20.0	0.10–0.16
TP 309Cb	S30940	0.08	2.00	0.045	0.030	1.00 max	12.0–16.0	22.0–24.0	10 × C min, 1.10 max
TP309S	S30908	0.08	2.00	0.045	0.030	1.00 max	12.0–15.0	22.0–24.0
TP 310Cb	S31040	0.08	2.00	0.045	0.030	1.00 max	19.0–22.0	24.0–26.0	10 × C min, 1.10 max
TP 310S	S31008	0.08	2.00	0.045	0.030	1.00 max	19.0–22.0	24.0–26.0	0.75 max
TP 316	S31600	0.08	2.00	0.045	0.030	1.00 max	10.0–14.0	16.0–18.0	2.00–3.00
TP 316H	S31609	0.04–0.10	2.00	0.045	0.030	1.00 max	10.0–14.0	16.0–18.0	2.00–3.00
TP 316L	S31603	0.030 ^D	2.00	0.045	0.030	1.00 max	10.0–14.0	16.0–18.0	2.00–3.00
TP 316N	S31651	0.08	2.00	0.045	0.030	1.00 max	10.0–14.0	16.0–18.0	2.00–3.00	0.10–0.16
TP 316LN	S31653	0.030	2.00	0.045	0.030	1.00 max	10.0–14.0	16.0–18.0	2.00–3.00	0.10–0.16
TP 317	S31700	0.08	2.00	0.045	0.030	1.00 max	11.0–14.0	18.0–20.0	3.0–4.0
TP 317L	S31703	0.030	2.00	0.045	0.030	1.00 max	11.0–15.0	18.0–20.0	3.0–4.0
...	S31727	0.030	1.00	0.030	0.030	1.00	14.5–16.5	17.5–19.0	3.8–4.5	0.15–0.21	...	2.8–4.0	...
...	S32053	0.030	1.00	0.030	0.010	1.00	24.0–26.0	22.0–24.0	5.0–6.0	0.17–0.22
TP 321	S32100	0.08	2.00	0.045	0.030	1.00 max	9.00–13.0	17.0–19.0	...	E
TP 321H	S32109	0.04–0.10	2.00	0.045	0.030	1.00 max	9.00–13.0	17.0–19.0	...	F
TP 347	S34700	0.08	2.00	0.045	0.030	1.00 max	9.00–13.0	17.0–19.0	G
TP347H	S34709	0.04–0.10	2.00	0.045	0.030	1.00 max	9.00–13.0	17.0–19.0	H
TP 348	S34800	0.08	2.00	0.045	0.030	1.00 max	9.00–13.0	17.0–19.0	G	0.10
TP 348H	S34809	0.04–0.10	2.00	0.045	0.030	1.00 max	9.00–13.0	17.0–19.0	H	0.10
TP XM-10	S21900	0.08	8.0–10.0	0.045	0.030	1.00 max	5.5–7.5	19.0–21.5	0.15–0.40
TP XM-11	S21903	0.04	8.0–10.0	0.045	0.030	1.00 max	5.5–7.5	19.0–21.5	0.15–0.40
TP XM-15	S38100	0.08	2.00	0.030	0.030	1.50–2.50	17.5–18.5	17.0–19.0
TP XM-19	S20910	0.06	4.0–6.0	0.045	0.030	1.00 max	11.5–13.5	20.5–23.5	1.50–3.00	...	0.10–0.30	...	0.20–0.40	0.10–0.30
TP XM-29	S24000	0.08	11.5–14.5	0.060	0.030	1.00 max	2.3–3.7	17.0–19.0	0.20–0.40
...	S31254	0.020	1.00	0.030	0.010	0.80 max	17.5–18.5	19.5–20.5	6.0–6.5	0.18–0.22	...	0.50–1.00	...
...	S30815	0.05–0.10	0.80	0.040	0.030	1.40–2.00	10.0–12.0	20.0–22.0	0.14–0.20	0.03–0.08
...	N08367	0.030	2.00	0.040	0.030	1.00 max	23.5–25.5	20.0–22.0	6.0–7.0	0.18–0.25	...	0.75 max	...



^A ~~New~~ New designation established in accordance with Practice E527 and SAE J 1086.

^B ~~Maximum~~ Maximum, unless otherwise indicated.

^C ~~The~~ The method of analysis for nitrogen shall be a matter of agreement between the purchaser and manufacturer.

^D ~~For~~ For small diameter or thin walls or both, where many drawing passes are required, a carbon maximum of 0.040 % is necessary in grades TP304L and TP316L. Small outside diameter tubes are defined as those less than 0.500 in. [12.7 mm] in outside diameter and light wall tubes as those less than 0.049 in. [1.2 mm] in average wall thickness (0.044 in. [1 mm] in minimum wall thickness).

^E ~~The~~ The titanium content shall be not less than five times the carbon content and not more than 0.70 %.

^F ~~The~~ The titanium content shall be not less than four times the carbon content and not more than 0.70 %.

^G ~~The~~ The columbium plus tantalum content shall be not less than ten times the carbon content and not more than 1.10 %.

^H ~~The~~ The columbium plus tantalum content shall be not less than eight times the carbon content and not more than 1.10 %.

4. Materials and Manufacture

4.1 Manufacture:

4.1.1 The pipe shall be made by a machine-welding or an automatic-welding process, welding from one or both sides and producing full penetration welds with no addition of filler metal in the welding operation.

4.1.2 Weld repairs, with the addition of compatible filler metal, may be made to the weld joint in accordance with the requirements of the section on Repair by Welding of Specification A999/A999M.

4.1.3 Prior to final heat treatment of the pipe, the weld bead must be cold-worked by methods such as forging, planishing, drawing, swaging or bead rolling so as to obtain a flush condition on the inside and outside of the pipe. Undercuts shall be limited to shallow rounded depressions of less than 0.005 in. [0.127 mm] deep on either the inside or outside surface of the pipe with no encroachment of the minimum permitted wall thickness.

4.1.4 The pipe shall be pickled free of scale. When bright annealing is used, pickling is not necessary.

4.2 Heat Treatment:

4.2.1 All pipe shall be furnished in the heat-treated condition. The heat-treatment procedure, except for H grades, S30815, N 08367 and S 31254, shall consist of heating the pipe to a minimum temperature of 1900 °F [1040 °C] and quenching in water or rapidly cooling by other means.

4.2.2 All H grades and S30815 shall be furnished in the solution-treated condition. The minimum solution treating temperature for Grades TP321H, TP347H, and TP348H shall be 2000 °F [1100 °C] and for Grades TP304H and TP316H, 1900 °F [1040 °C]. The minimum temperature for S30815 shall be 1920 °F [1050 °C].

4.2.3 The heat-treatment procedure for S 31254 shall consist of heating the pipe to a minimum temperature of 2100 °F [1150 °C] and quenching in water or rapidly cooling by other means.

4.2.4 The heat-treatment procedure for S31727 and S32053 shall consist of heating the pipe to a minimum temperature of 1975 to 2155 °F [1080 to 1180 °C] and quenching in water or rapidly cooling by other means.

4.2.5 UNS N 08367 shall be solution annealed from 2025 °F [1110 °C] minimum followed by rapid quenching.

4.3 H grades and S30815 shall have a minimum grain size of 7 or coarser when measured in accordance with Test Methods E112.

5. Chemical Composition

5.1 The steel shall conform to the chemical composition prescribed in Table 2.

5.2 When specified on the purchase order, a product analysis shall be supplied from one tube or coil of steel per heat. The product analysis tolerance of Specification A480/A480M shall apply.

6. Tensile Requirements

6.1 The tensile properties of the material shall conform to the requirements prescribed in Table 3.

7. Permissible Variations in Dimensions

7.1 *Specified Diameter*—The diameter at any point in each length of pipe shall be within the tolerance specified in Table 1.

7.2 *Alignment (Camber)*—Using a 3-ft [1.0-m] straightedge placed so that both ends are in contact with the pipe, the camber shall not be more than 0.030-in. [0.8-mm].

7.3 *Thickness*—The wall thickness at any point in the pipe shall be within the thickness tolerance specified in Table 3¹, except that for pipe in which the wall thickness exceeds 0.188-in. [4.8-mm] a weld reinforcement of up to 0.015-in. [0.38-mm] is permitted on the inside of the pipe.

8. Lengths

8.1 Pipe lengths shall be in accordance with the following regular practice.

8.1.1 Unless otherwise agreed upon, all sizes up to and including NPS 4 are available in a length up to 24 ft (Note 2) with the permissible range of 15 ~~ft~~ to 24 ft (Note 2).



TABLE 3 Tensile Requirements

Grade	UNS Designation	Tensile Strength, min ksi [MPa]	Yield Strength, min ksi [MPa]
TP201	S20100	75 [515]	38 [260]
TP201LN	S20153	95 [665]	45 [130]
TP304L	S30403	70 [485]	25 [170]
TP316L	S31603	70 [485]	25 [170]
TP304	S30400	75 [515]	30 [205]
TP304H	S30409	75 [515]	30 [205]
TP309CB	S30940	75 [515]	30 [205]
TP309S	S30908	75 [515]	30 [205]
TP310Cb	S31040	75 [515]	30 [205]
TP310S	S31008	75 [515]	30 [205]
TP316	S31600	75 [515]	30 [205]
TP316H	S31609	75 [515]	30 [205]
TP317	S31700	75 [515]	30 [205]
TP317L	S31703	75 [515]	30 [205]
TP321	S32100	75 [515]	30 [205]
TP321H	S32109	75 [515]	30 [205]
TP347	S34700	75 [515]	30 [205]
TP347H	S34709	75 [515]	30 [205]
TP348	S34800	75 [515]	30 [205]
TP348H	S34809	75 [515]	30 [205]
TPXM-10	S21900	90 [620]	50 [345]
TPXM-11	S21903	90 [620]	50 [345]
TPXM-15	S38100	75 [515]	30 [205]
TPXM-29	S24000	100 [690]	55 [380]
TPXM-19	S20910	100 [690]	55 [380]
TP304N	S30451	80 [550]	35 [240]
TP316N	S31651	80 [550]	35 [240]
TP304LN	S30453	75 [515]	30 [205]
TP316LN	S31653	75 [515]	30 [205]
...	S31254	94 [650]	44 [300]
...	S31727	80 [550]	36 [245]
...	S32053	93 [640]	43 [295]
...	S30815	87 [600]	45 [310]
...	N08367		
	t≤0.187	100 [690]	45 [310]
	t>0.187	95 [655]	45 [310]

NOTE 2—The value(s) applies when the inch-pound designation of this specification is the basis of purchase. When the “M” designation of this specification is the basis of purchase, the corresponding metric value(s) shall be agreed upon between the manufacturer and purchaser.

8.1.2 If definite cut lengths are desired, the lengths required shall be specified in the order. No pipe shall be under the specified length and not more than ¼ in. [6 mm] over that specified.

8.1.3 No jointers are permitted unless otherwise specified.

9. Workmanship, Finish, and Appearance

9.1 The finished pipes shall be free of injurious imperfections and shall have a workmanlike finish. Minor imperfections may be removed by grinding, provided the wall thicknesses are not decreased to less than that permitted in Section 7.9.

10. General Requirements

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

11. Examination of Double-Welded Pipe

11.1 Both ends of each double-welded (Class DW) pipe shall be visually examined to determine that complete fusion was attained between the two welds. In lieu of examining the ends of the pipe, this examination may be performed on cropped ends removed from both ends of each double welded pipe.

12. Mechanical Tests Required

12.1 *Transverse or Longitudinal Tension Test*—One tension test shall be made on a specimen for lots of not more than 100 pipes. Tension tests shall be made on specimens from two tubes for lots of more than 100 pipes.

NOTE 3—The term “lot,” for mechanical tests, applies to all pipe of the same nominal size and wall thickness (or schedule) which is produced from the same heat of steel and subjected to the same finishing treatment (1) in a continuous heat-treatment furnace, or (2) in a batch-type heat-treatment furnace, equipped with recording pyrometers and automatically controlled within a 50 °F [30 °C] range, the larger of (a) Each 200 ft [60 m] or fraction