



Designation: **A789/A789M – 14** **A789/A789M – 16**

Standard Specification for Seamless and Welded Ferritic/Austenitic Stainless Steel Tubing for General Service¹

This standard is issued under the fixed designation A789/A789M; 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 specification² covers grades of average wall thickness, or, if specified on the order, minimum wall thickness, of stainless steel tubing for services requiring general corrosion resistance, with particular emphasis on resistance to stress corrosion cracking. These steels are susceptible to embrittlement if used for prolonged periods at elevated temperatures.

1.2 The values stated in either SI units or inch-pound 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. Within the text, the SI units are shown in brackets. 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*:³

A480/A480M Specification for General Requirements for Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet, and Strip
A1016/A1016M Specification for General Requirements for Ferritic Alloy Steel, Austenitic Alloy Steel, and Stainless Steel Tubes

E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

2.2 *SAE Standard*:⁴

SAE J 1086 Practice for Numbering Metals and Alloys (UNS)

3. Ordering Information

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

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

3.1.2 Name of product (seamless or welded tubes),

3.1.3 Grade (see **Table 1**),

3.1.4 Size (outside diameter and average wall thickness, unless minimum wall thickness is specified),

3.1.5 Length (specific or random),

3.1.6 Optional requirements (for product analysis, see **Section 8**; for hydrostatic or nondestructive electric test, see **Section 10**),

3.1.7 Test report required (see the Inspection section of Specification **A1016/A1016M**),

3.1.8 Specification designation, and

3.1.9 Special requirements.

4. General Requirements

4.1 Product furnished under this specification shall conform to the applicable requirements of Specification **A1016/A1016M**, unless otherwise provided herein.

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.

Current edition approved ~~Oct. 1, 2014~~ March 1, 2016. Published ~~October 2014~~ March 2016. Originally approved in 1981. Last previous edition approved in ~~2013~~ 2014 as **A789/A789M** **A789/A789M – 14**. ~~13a¹~~. DOI: ~~10.1520/A0789_A0789M-14~~ 10.1520/A0789_A0789M-16.

² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-789 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 Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

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

TABLE 1 Chemical Requirements^A

UNS Designation ^B	C	Mn	P	S	Si	Ni	Cr	Mo	N	Cu	Others
S31200	0.030	2.00	0.045	0.030	1.00	5.5–6.5	24.0–26.0	1.20–2.00	0.14–0.20
S31260	0.030	1.00	0.030	0.030	0.75	5.5–7.5	24.0–26.0	2.5–3.5	0.10–0.30	0.20–0.80	W 0.10–0.50
S31500	0.030	1.20–2.00	0.030	0.030	1.40–2.00	4.3–5.2	18.0–19.0	2.50–3.00	0.05–0.1
S31803	0.030	2.00	0.030	0.020	1.00	4.5–6.5	21.0–23.0	2.5–3.5	0.08–0.20
S32001	0.030	4.00–6.00	0.040	0.030	1.00	1.0–3.0	19.5–21.5	0.60	0.05–0.17	1.00	...
S32003	0.030	2.00	0.030	0.020	1.00	3.0–4.0	19.5–22.5	1.50–2.00	0.14–0.20
S32101	0.040	4.0–6.0	0.040	0.030	1.00	1.35–1.70	21.0–22.0	0.10–0.80	0.20–0.25	0.10–0.80	...
S32202	0.030	2.00	0.040	0.010	1.00	1.00–2.80	21.5–24.0	0.45	0.18–0.26
S32205	0.030	2.00	0.030	0.020	1.00	4.5–6.5	22.0–23.0	3.0–3.5	0.14–0.20
S32304	0.030	2.50	0.040	0.040	1.00	3.0–5.5	21.5–24.5	0.05–0.60	0.05–0.20	0.05–0.60	...
S32506	0.030	1.00	0.040	0.015	0.90	5.5–7.2	24.0–26.0	3.0–3.5	0.08–0.20	...	W 0.05–0.30
S32520	0.030	1.50	0.035	0.020	0.80	5.5–8.0	23.0–25.0	3.–5.	0.20–0.35	0.50–3.00	...
S32550	0.04	1.50	0.040	0.030	1.00	4.5–6.5	24.0–27.0	2.9–3.9	0.10–0.25	1.50–2.50	...
S32707	0.030	1.50	0.035	0.010	0.50	5.5–9.5	26.0–29.0	4.0–5.0	0.30–0.50	1.0 max	Co 0.5–2.0
S32750 ^C	0.030	1.20	0.035	0.020	0.80	6.0–8.0	24.0–26.0	3.0–5.0	0.24–0.32	0.50	...
S32760 ^D	0.030	1.00	0.030	0.010	1.00	6.0–8.0	24.0–26.0	3.0–4.0	0.20–0.30	0.50–1.00	W 0.50–1.00
S32808	0.030	1.10	0.030	0.010	0.50	7.0–8.2	27.0–27.9	0.80–1.20	0.30–0.40	...	W 2.10–2.50
S32900	0.08	1.00	0.040	0.030	0.75	2.5–5.0	23.0–28.0	1.00–2.00
S32906	0.030	0.80–1.50	0.030	0.030	0.80	5.8–7.5	28.0–30.0	1.50–2.60	0.30–0.40	0.80	...
S32950	0.030	2.00	0.035	0.010	0.60	3.5–5.2	26.0–29.0	1.00–2.50	0.15–0.35
S33207	0.030	1.50	0.035	0.010	0.80	6.0–9.0	29.0–33.0	3.0–5.0	0.40–0.60	1.0	...
S39274	0.030	1.00	0.030	0.020	0.80	6.0–8.0	24.0–26.0	2.5–3.5	0.24–0.32	0.20–0.80	W 1.50–2.50
S39277	0.025	0.80	0.025	0.002	0.80	6.5–8.0	24.0–26.0	3.00–4.00	0.23–0.33	1.20–2.00	W 0.80–1.21
S82011	0.030	2.0–3.0	0.040	0.020	1.00	1.00–2.00	20.5–23.5	0.10–1.00	0.15–0.27	0.50	...
S82441	0.030	2.50–4.00	0.035	0.005	0.70	3.0–4.5	23.0–25.0	1.00–2.00	0.20–0.30	0.10–0.80	...

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

^BDesignation established in accordance with Practice E527 and SAE J1086.

^C% Cr + 3.3 × % Mo + 16 × % N ≥ 41.

^D% Cr + 3.3 × % Mo + 16 × % N ≥ 40.

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5. Manufacture

5.1 The tubes shall be made by the seamless or welded process with no filler metal added.

6. Heat Treatment

6.1 All tubes shall be furnished in the heat-treated condition in accordance with the procedures shown in Table 2. For seamless tubes, as an alternate to final heat treatment in a continuous furnace or batch-type furnace, immediately following hot forming while the temperature of the tubes is not less than the specified minimum solution treatment temperature, tubes may be individually quenched in water or rapidly cooled by other means.

7. Chemical Composition

7.1 The steel shall conform to the chemical requirements prescribed in Table 1.

8. Product Analysis

8.1 An analysis of either one billet or one length of flat-rolled stock or one tube shall be made from each heat. The chemical composition thus determined shall conform to the requirements specified.

8.2 A product analysis tolerance (see the annex table on Chemical Requirements (Product Analysis Tolerances) in Specification A480/A480M) shall apply. The product analysis tolerance is not applicable to the carbon content for material with a specified maximum carbon of 0.04 % or less.

8.3 If the original test for product analysis fails, retests of two additional billets, lengths of flat-rolled stock, or tubes shall be made. Both retests for the elements in question shall meet the requirements of this specification; otherwise, all remaining material in the heat shall be rejected or, at the option of the producer, each billet or tube may be individually tested for acceptance. Billets, lengths of flat-rolled stock, or tubes that do not meet the requirements of this specification shall be rejected.

NOTE 1—For flange and flaring requirements, the term *lot* applies to all tubes prior to cutting of the same nominal size and wall thickness that are produced from the same heat of steel. When final heat treatment is in a batch-type furnace, a lot shall include only those tubes of the same size and from the same heat that are heat treated in the same furnace charge. When the final heat treatment is in a continuous furnace, or when heat treated condition is obtained directly by quenching after hot forming, the number of tubes of the same size and from the same heat in a lot shall be determined from the size of the tubes as prescribed in Table 3.

NOTE 2—For tension and hardness test requirements, the term *lot* applies to all tubes prior to cutting, of the same nominal diameter and wall thickness that are produced from the same heat of steel. When final heat treatment is in a batch-type furnace, a lot shall include only those tubes of the same size and from the same heat that are heat treated in the same furnace charge. When the final heat treatment is in a continuous furnace, or when heat treated condition is obtained directly by quenching after hot forming, a lot shall include all tubes of the same size and heat, heat treated in the same furnace at the same



TABLE 2 Heat Treatment

UNS Designation	Temperature °F [°C]	Quench
S31200	1920–2010 [1050–1100]	rapid cooling in water
S31260	1870–2010 [1020–1100]	rapid cooling in air or water
S31500	1800–1900 [980–1040]	rapid cooling in air or water
S31803	1870–2010 [1020–1100]	rapid cooling in air or water
S32001	1800–1950 [982–1066]	rapid cooling in air or water
S32003	1850–2050 [1010–1120]	rapid cooling in air or water
S32101	1870 [1020] min	quenched in water or rapidly cooled by other means
S32202	1870–1975 [1020–1080]	rapid cooling in air or water
S32205	1870–2010 [1020–1100]	rapid cooling in air or water
S32304	1700–1920 [925–1050]	rapid cooling in air or water
S32506	1870–2050 [1020–1120]	rapid cooling in air or water
S32520	1975–2050 [1080–1120]	rapid cooling in air or water
S32550	1900 [1040] min	rapid cooling in air or water
S32707	1975–2050 [1080–1120]	rapid cooling in air or water
S32750	1880–2060 [1025–1125]	rapid cooling in air or water
S32760	1960–2085 [1070–1140]	rapid cooling in air or water
S32808	1920–2100 [1050–1150]	rapid cooling in air or water
S32900	1700–1750 [925–955]	rapid cooling in air or water
S32906	1870–2100 [1020–1150]	rapid cooling in air or water
S32950	1820–1880 [990–1025]	air cool
S33207	1905–2085 [1040–1140]	rapid cooling in water or by other means
S39274	1920–2060 [1025–1125]	rapid cooling in air or water
S39277	1975–2155 [1080–1180]	rapid cooling in air or water
S82011	1850–2050 [1010–1120]	rapid cooling in air or water
S82441	1830 [1000] min	rapid cooling in air or water

TABLE 3 Number of Tubes in a Lot Heat Treated by the Continuous Process or by Direct Quench after Hot Forming

Size of Tube	Size of Lot
2 in. [50.8 mm] and over in outside diameter and 0.200 in. [5.1 mm] and over in wall thickness	not more than 50 tubes
Less than 2 in. [50.8 mm] but over 1 in. [25.4 mm] in outside diameter or over 1 in. [25.4 mm] in outside diameter and under 0.200 in. [5.1 mm] in wall thickness	not more than 75 tubes
1 in. [25.4 mm] or less in outside diameter	not more than 125 tubes

temperature, time at heat, and furnace speed, or all tubes of the same size and heat, hot formed and quenched in the same production run.

9. Mechanical Tests Required

9.1 *Tension Tests*—One tension test shall be made on a specimen for lots of not more than 50 tubes. Tension tests shall be made on specimens from two tubes for lots of more than 50 tubes (see **Note 2**).

9.2 *Flaring Test (for Seamless Tubes)*—One test shall be made on specimens from one end of one tube from each lot (see **Note 1**) of finished tubes. The minimum expansion of the inside diameter shall be 10 %.