



Designation: B622 – 17a

Standard Specification for Seamless Nickel and Nickel-Cobalt Alloy Pipe and Tube¹

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1. Scope*

1.1 This specification² covers seamless pipe and tube of nickel and nickel-cobalt alloys (UNS N10001, UNS N10242, UNS N10665, UNS N12160, UNS N10675, UNS N10276, UNS N06455, UNS N06007, UNS N08320, UNS N06975, UNS N06002, UNS N06985, UNS N06022, UNS N06035, UNS N06044, UNS N08135, UNS N06255, UNS N06058, UNS N06059, UNS N06200, UNS N10362, UNS N06030, UNS N08031, UNS N08034, UNS R30556, UNS N08535, UNS N06250, UNS N06060, UNS N06230, UNS N06686, UNS N10629, UNS N06210, UNS N10624, and UNS R20033)³ as shown in [Table 1](#).

1.2 Pipe and tube shall be supplied in the solution annealed and descaled condition. When atmosphere control is used, descaling is not necessary.

1.3 This specification is limited to tubes up to and including 3.5 in. (88.9 mm) outside diameter.

1.4 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.

1.5 *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 become familiar with all hazards including those identified in the appropriate Safety Data Sheet (SDS) for this product/material as provided by the manufacturer, to establish appropriate safety, health and environmental practices, and determine the applicability of regulatory limitations prior to use.*

1.6 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recom-*

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.07 on Refined Nickel and Cobalt and Their Alloys.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SB-622 in Section II of that Code.

³ Designation established in accordance with Practice E527 and SAE J1086, Practice for Numbering Metals and Alloys (UNS).

mendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.

2. Referenced Documents

2.1 *ASTM Standards:*⁴

[B829 Specification for General Requirements for Nickel and Nickel Alloys Seamless Pipe and Tube](#)

[E8 Test Methods for Tension Testing of Metallic Materials](#)

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

3. Terminology

3.1 *Definitions:*

3.1.1 *average diameter, n*—the average of the maximum and minimum outside diameters, or the maximum and minimum inside diameters, as determined at any cross section of the tube.

3.1.2 *pipe, n*—seamless tube conforming to the particular dimensions commercially known as standard pipe sizes ([Appendix X2](#)).

3.1.3 *tube, n*—a hollow product of round or any other cross section having a continuous periphery.

4. General Requirements

4.1 Material furnished under this specification shall conform to the applicable requirements of Specification [B829](#) unless otherwise provided herein.

5. Ordering Information

5.1 It is the responsibility of the purchaser to specify all requirements that are necessary for the material ordered under this specification. Examples of such requirements include, but are not limited to the following:

5.1.1 *Alloy* ([Table 1](#)).

5.1.2 *Dimensions:*

5.1.2.1 *Tube*—Outside diameter, minimum or average wall thickness, and length.

5.1.2.2 *Pipe*—Standard pipe size and schedule ([Appendix X2](#)).

⁴ 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.

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

TABLE 1 Chemical Requirements

	Composition Limits, %																								
	Ni	Cr	Mo	Fe	W	C	Si	Co	Mn	V	P	S	Ti	Cu	Cb (Nb) + Ta	Al	Zr	La	N	B	Cb (Nb)	Ta	Ni+ Mo	Mg	
Ni-Mo Alloys																									
N10001	remainder ^A	1.0	26.0-30.0	4.0-6.0	...	0.05	1.0	2.5	1.0	0.2-0.4	0.04	0.03	0.006	0.20	0.20	94.0-98.0	...	
N10665	remainder ^A	1.0	26.0-30.0	2.0 max	...	0.02	1.0	1.0	1.0	0.4	0.04	0.03	0.20	max	
N10675	65.0 min	1.0-3.0	27.0-32.0	1.0-3.0	3.0	0.01	1.0	3.0	3.0	0.20	0.030	0.010	0.20	0.20	0.50	0.50	0.10	max	max	
N10629	remainder ^A	0.5-3.0	26.0-30.0	1.0-6.0	...	0.01	0.05	2.5	1.5	...	0.04	0.01	...	0.5	0.1-0.5	
N10624	remainder ^A	6.0-10.0	21.0-25.0	5.0-8.0	...	0.01	0.10	1.0	1.0	...	0.025	0.01	...	0.5	
Ni-Mo-Cr-Fe Alloy																									
N10242	remainder ^A	7.0-9.0	24.0-26.0	2.0 max	...	0.03	0.80	1.00	0.80	0.030	0.015	0.015	...	0.50	0.50	0.50	max	0.006	max	
Low C Ni-Cr-Mo Alloys																									
N10276	remainder ^A	14.5-16.5	15.0-17.0	4.0-7.0	3.0-4.5	0.010	0.08	2.5	1.0	0.35	0.04	0.03	
N06022	remainder ^A	20.0-22.5	12.5-14.5	2.0-6.0	2.5-3.5	0.015	0.08	2.5	0.50	0.35	0.02	0.02	
N06035	remainder ^A	32.25-34.25	7.60-9.00	2.00 max	0.60	0.050	0.60	1.00	0.50	0.20	0.030	0.015	0.30	0.30	0.40	0.40	max	
N06044	balance	43.5-45.3	0.80-1.20	0.3 max	...	0.02	0.20	...	0.07-0.30	...	0.020	0.020	0.10-0.30	max	0.30	0.30	max	
N06058	balance	20.0-23.0	18.5-21.0	1.5 max	0.3	0.010	0.10	0.3	0.50	0.015	0.010	0.010	...	0.50	0.40	0.40	max	0.02-0.15	max	
N06059	balance	22.0-24.0	15.0-16.5	1.5 max	...	0.010	0.10	0.3	0.5	...	0.015	0.010	...	0.50	0.40	0.40	max	0.02-0.15	max	
N06455	remainder ^A	14.0-18.0	14.0-17.0	3.0 max	...	0.015	0.08	2.0	1.0	...	0.04	0.03	0.70	max	0.50	0.4	max	
Ni-Cr-Fe-Mo-Cu Alloys																									
N06007	remainder ^A	21.0-23.5	5.5-7.5	18.0-21.0	1.0	0.05	1.0	2.5	1.0-	...	0.04	0.03	...	1.5-	1.75-	0.4	
N06975	47.0-52.0	23.0-26.0	5.0-7.0	remainder ^A	...	0.03	1.0	max	2.0	...	0.03	0.03	0.70-1.50	2.5	2.5	0.03	0.03	0.70-1.50	
N06985	remainder ^A	21.0-23.5	6.0-8.0	18.0-21.0	1.5	0.015	1.0	5.0	1.0	...	0.04	0.03	...	1.5-	0.50	0.04	0.03	
N06030	remainder ^A	28.0-31.5	4.0-6.0	13.0-17.0	1.5-4.0	0.03	0.8	max	1.5	...	0.04	0.02	...	2.5	max	0.04	0.02	
N06255	47.0-52.0	23.0-26.0	6.0-9.0	remainder ^A	3.0	0.03	1.0	max	1.0	...	0.03	0.03	0.69	2.4	1.50	0.03	0.03	max	
N06250	50.0-54.0	20.0-23.0	10.1-12.0	remainder ^A	0.25-1.25	0.020	0.09	...	1.00	...	0.030	0.005	max	0.25-1.25	...	0.030	0.005	max	
Ni-Fe-Cr-Mo Alloys																									
N08320	25.0-27.0	21.0-23.0	4.0-6.0	remainder ^A	...	0.05	1.0	...	2.5	...	0.04	0.03	4xC	0.04	0.03	min	
N08135	33.0-38.0	20.5-23.5	4.0-5.0	remainder ^A	0.20-0.80	0.030	0.75	...	1.00	...	0.03	0.03	0.03	0.03	
N06002	remainder ^A	20.5-23.0	8.0-10.0	17.0-20.0	1.0	0.05-0.15	1.0	0.5-	1.0	...	0.04	0.03	0.04	0.03	

TABLE 1 Continued

	Composition Limits, %																								
	Ni	Cr	Mo	Fe	W	C	Si	Co	Mn	V	P	S	Ti	Cu	Cb (Nb) + Ta	Al	Zr	La	N	B	Cb (Nb)	Ta	Ni+ Mo	Mg	
N06060	54.0-60.0	19.0-22.0	12.0-14.0	remainder ^A	0.25-1.25	0.03 max	0.50	...	1.50 max	...	0.030 max	0.005 max	...	0.25-1.25	0.50-1.25
Ni-Fe-Cr-Co Alloy																									
R30556	19.0-22.5	21.0-23.0	2.5-4.0	remainder ^A	2.0-3.5	0.05-0.15	0.20-0.80	16.0-21.0	0.50-2.00	...	0.04	0.015	0.10-0.50	0.001-0.10	0.005-0.10	0.10-0.30	0.02 max	0.30 max	0.3-1.25	
Ni-Cr-W-Mo Alloys																									
N06230	remainder ^A	20.0-24.0	1.0-3.0	3.0 max	13.0-15.0	0.05-0.15	0.25-0.75	5.0 max	0.30-1.00	...	0.03	0.015	0.50 max	0.005-0.050	0.015 max	
Low C-Ni-Cr-Mo-Cu Alloy																									
N06200	remainder ^A	22.0-24.0	15.0-17.0	3.0 max	...	0.010 max	0.08	2.0 max	0.50 max	...	0.025	0.010	...	1.3-1.9	...	0.50 max	
Low C-Ni-Mo-Cr Alloy																									
N10362	remainder ^A	13.8-15.6	21.5-23.0	1.25 max	...	0.010 max	0.08	...	0.60 max	...	0.025	0.010	0.50 max	
Low C-Ni-Fe-Cr-Mo-Cu Alloys																									
N08031	30.0-32.0	26.0-28.0	6.0-7.0	balance	...	0.015 max	0.3	2.0 max	0.020	0.010	...	1.0-1.4	0.15-0.25	
N08034	33.5-35.0	26.0-27.0	6.0-7.0	balance	...	0.01 max	0.1	1.0-4.0	0.020	0.010	...	0.5-1.5	...	0.3 max	0.10-0.25	
N08535	29.0-36.5	24.0-27.0	2.5-4.0	remainder ^A	...	0.03 max	0.50	1.0 max	0.03	0.03	...	1.50 max	
Low C-Ni-Cr-Mo-W Alloy																									
N06686	remainder ^A	19.0-23.0	15.0-17.0	5.0 max	3.0-4.4	0.010 max	0.08	0.75 max	0.04	0.02	0.02-0.25	
Ni-Co-Cr-Si Alloy																									
N12160	remainder ^A	26.0-30.0	1.0 max	3.5 max	1.0 max	0.15 max	2.4-3.0	27.0-33.0	1.5 max	...	0.030	0.015	0.20-0.80	1.0 max	
Cr-Ni-Fe-N Alloy																									
R20033	30.0-33.0	31.0-35.0	0.50-2.0	balance	...	0.015 max	0.50	2.0 max	0.02	0.01	...	0.3-1.20	0.35-0.60	
Low C-Ni-Mo-Cr-Ta Alloy																									
N06210	remainder ^A	18.0-20.0	18.0-20.0	1.0 max	...	0.015 max	0.08	1.0 max	0.5 max	0.35 max	0.02	0.02	1.5-2.2	

^A See 12.1.