



Designation: **B622—17a** **B622 – 17b**

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

This standard is issued under the fixed designation B622; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

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 Recommendations 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.

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.

Current edition approved July 1, 2017/Nov. 1, 2017. Published August 2017/November 2017. Originally approved in 1977. Last previous edition approved in 2017 as **B622—17-B622 – 17a**. DOI: 10.1520/B0622-17a.10.1520/B0622-17b.

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).

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 max | Co | Mn | V | P max | S max | Ti | Cu | Cb (Nb) +Ta | Al | Zr | La | N | B | Cb (Nb) | Ta | Ni+ Mo | Mg |
|-----------------------|----------------|-----------------|---------------|----------------|---------------|---------------|-----------|-------------|---------------|-------------|----------|----------|---------------|---------------|-------------------|-------------|-------------|-----|---------------|-----|--------------|-------------|---------------|-----|
| Ni-Mo Alloys | | | | | | | | | | | | | | | | | | | | | | | | |
| N10001 | remainder A | 1.0 max | 26.0- 30.0 | 4.0-6.0 | ... | 0.05 max | 1.0 | 2.5 max | 1.0 max | 0.2- 0.4 | 0.04 | 0.03 | ... | ... | ... | | | | | | | | | |
| N10665 | remainder A | 1.0 max | 26.0- 30.0 | 2.0 max | ... | 0.02 max | 0.10 | 1.0 max | 1.0 max | ... | 0.04 | 0.03 | ... | ... | ... | | | | | | | | | |
| N10675 | 65.0 min | 1.0- 3.0 | 27.0- 32.0 | 1.0-3.0 | 3.0 max | 0.01 max | 0.10 | 3.0 max | 3.0 max | 0.20 max | 0.030 | 0.010 | 0.20 max | 0.20 max | ... | 0.50 max | 0.10 max | ... | ... | ... | 0.20 max | 0.20 max | 94.0- 98.0 | |
| N10629 | remainder A | 0.5- 1.5 | 26.0- 30.0 | 1.0-6.0 | ... | 0.01 max | 0.05 | 2.5 max | 1.5 max | ... | 0.04 | 0.01 | ... | 0.5 max | ... | 0.1- 0.5 | ... | ... | ... | ... | ... | ... | ... | ... |
| N10624 | remainder A | 6.0- 10.0 | 21.0- 25.0 | 5.0-8.0 | ... | 0.01 max | 0.10 | 1.0 max | 1.0 max | ... | 0.025 | 0.01 | ... | 0.5 max | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Ni-Mo-Cr-Fe Alloy | | | | | | | | | | | | | | | | | | | | | | | | |
| N10242 | remainder A | 7.0- 9.0 | 24.0- 26.0 | 2.0 max | | 0.03 max | 0.80 | 1.00 max | 0.80 max | | 0.030 | 0.015 | | 0.50 max | | 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 max | 0.08 | 2.5 max | 1.0 max | 0.35 max | 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 max | 0.08 | 2.5 max | 0.50 max | 0.35 max | 0.02 | 0.02 | ... | ... | ... | | | | | | | | | |
| N06035 | remainder A | 32.25- 34.25 | 7.60- 9.00 | 2.00 max | 0.60 max | 0.050 max | 0.60 | 1.00 max | 0.50 max | 0.20 max | 0.030 | 0.015 | ... | 0.30 max | ... | 0.40 max | ... | ... | ... | ... | ... | ... | ... | ... |
| N06044 | balance | 43.5- 45.3 | 0.80- 1.20 | 0.3 max | ... | 0.02 max | 0.20 | ... | 0.07- 0.30 | ... | 0.020 | 0.020 | 0.10- 0.30 | ... | 0.30 max | 0.40 max | ... | ... | ... | ... | ... | ... | ... | ... |
| N06058 | balance | 20.0- 23.0 | 18.5- 21.0 | 1.5 max | 0.3 max | 0.010 max | 0.10 | 0.3 max | 0.50 max | ... | 0.015 | 0.010 | ... | 0.50 max | ... | 0.40 max | ... | ... | 0.02- 0.15 | ... | ... | ... | ... | ... |
| N06059 | balance | 22.0- 24.0 | 15.0- 16.5 | 1.5 max | ... | 0.010 max | 0.10 | 0.3 max | 0.5 max | ... | 0.015 | 0.010 | ... | 0.50 max | ... | 0.4 max | ... | ... | ... | ... | ... | ... | ... | ... |
| N06455 | remainder A | 14.0- 18.0 | 14.0- 17.0 | 3.0 max | ... | 0.015 max | 0.08 | 2.0 max | 1.0 max | ... | 0.04 | 0.03 | 0.70 max | ... | ... | | | | | | | | | |
| Ni-Cr-Fe-Mo-Cu Alloys | | | | | | | | | | | | | | | | | | | | | | | | |
| N06007 | remainder A | 21.0- 23.5 | 5.5- 7.5 | 18.0-21.0 | 1.0 max | 0.05 max | 1.0 | 2.5 max | 1.0- 2.0 | ... | 0.04 | 0.03 | ... | 1.5- 2.5 | 1.75- 2.5 | | | | | | | | | |
| N06975 | 47.0-52.0 | 23.0- 26.0 | 5.0- 7.0 | remainder A | ... | 0.03 max | 1.0 | ... | 1.0 max | ... | 0.03 | 0.03 | 0.70- 1.50 | 0.70- 1.20 | ... | | | | | | | | | |
| N06985 | remainder A | 21.0- 23.5 | 6.0- 8.0 | 18.0-21.0 | 1.5 max | 0.015 max | 1.0 | 5.0 max | 1.0 max | ... | 0.04 | 0.03 | ... | 1.5- 2.5 | 0.50 max | | | | | | | | | |
| N06030 | remainder A | 28.0- 31.5 | 4.0- 6.0 | 13.0-17.0 | 1.5- 4.0 | 0.03 max | 0.8 | 5.0 max | 1.5 max | ... | 0.04 | 0.02 | ... | 1.0- 2.4 | 0.30- 1.50 | | | | | | | | | |
| N06255 | 47.0-52.0 | 23.0- 26.0 | 6.0- 9.0 | remainder A | 3.0 max | 0.03 max | 1.0 | ... | 1.0 max | ... | 0.03 | 0.03 | 0.69 max | 1.2 max | ... | | | | | | | | | |
| N06250 | 50.0-54.0 | 20.0- 23.0 | 10.1- 12.0 | remainder A | 0.25- 1.25 | 0.020 max | 0.09 | ... | 1.00 max | ... | 0.030 | 0.005 | ... | 0.25- 1.25 | ... | | | | | | | | | |
| Ni-Fe-Cr-Mo Alloys | | | | | | | | | | | | | | | | | | | | | | | | |
| N08320 | 25.0-27.0 | 21.0- 23.0 | 4.0- 6.0 | remainder A | ... | 0.05 max | 1.0 | ... | 2.5 max | ... | 0.04 | 0.03 | 4xC min | ... | ... | | | | | | | | | |
| N08135 | 33.0-38.0 | 20.5- 23.5 | 4.0- 5.0 | remainder A | 0.20- 0.80 | 0.030 max | 0.75 | ... | 1.00 max | ... | 0.03 | 0.03 | ... | ... | ... | | | | | | | | | |
| N06002 | remainder A | 20.5- 23.0 | 8.0- 10.0 | 17.0-20.0 | 0.20- 1.0 | 0.05- 0.15 | 1.0 | 0.5- 2.5 | 1.0 max | ... | 0.04 | 0.03 | ... | ... | ... | | | | | | | | | |

2

TABLE 1 Continued

Composition Limits, %

| | Ni | Cr | Mo | Fe | W | C | Si max | Co | Mn | V | P max | S max | 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.

iTech Standards
<https://standards.iteh.com/document/preview>
 Document Preview
 ASTM B622-17

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).

5.1.3 *Ends*—Plain ends cut and deburred will be furnished.

5.1.4 *Certification*—State if certification or a report of test results is required (Section 15).

5.1.5 *Samples for Check Analysis*—State whether samples for check analysis should be furnished.

5.1.6 *Purchaser Inspection*—If the purchaser wishes to witness tests or inspection of material at the place of manufacture, the purchase order must so state, indicating which tests or inspections are to be witnessed (Section 14).

6. Chemical Composition

6.1 The material shall conform to the composition limits specified in Table 1.

6.2 If a product (check) analysis is made by the purchaser, the material shall conform to the requirements specified in Table 1 subject to the permissible tolerances in accordance with Specification B829.

7. Mechanical Properties

7.1 The mechanical properties of the material at room temperature shall conform to those shown in Table 2.

8. Hydrostatic Test or Non-Destructive Electric Test

8.1 Each pipe or tube shall be tested by the manufacturer by either hydrostatic or a non-destructive electric test in accordance with Specification B829. Hydrostatic testing at a pressure greater than 1000 psi may be performed upon agreement between the purchaser and manufacturer or at the option of the manufacturer provided that the allowable fiber stress per Specification B829 is not exceeded.

9. Weight

9.1 For calculation of mass or weight, the following densities shall be used:

| Alloy | Density lb/in. ³ | Density g/cm ³ |
|---|--------------------------------|------------------------------|
| Nickel-molybdenum: | | |
| UNS N10001 | 0.334 | 9.24 |
| UNS N10242 | 0.327 | 9.05 |
| UNS N10665 | 0.333 | 9.22 |
| UNS N10675 | 0.333 | 9.22 |
| UNS N10629 | 0.333 | 9.22 |
| UNS N10624 | 0.322 | 8.9 |
| Low carbon nickel-chromium-molybdenum: | 0.296 | 8.18 |
| Low carbon nickel-chromium-molybdenum: | | |
| UNS N10276 | 0.321 | 8.87 |
| UNS N06022 | 0.314 | 8.69 |
| UNS N06035 | 0.296 | 8.18 |
| UNS N06044 | 0.287 | 7.97 |
| UNS N06455 | 0.312 | 8.64 |
| Nickel-chromium-iron-molybdenum-copper: | | |
| UNS N06007 | 0.300 | 8.31 |
| UNS N06975 | 0.295 | 8.17 |
| UNS N06985 | 0.300 | 8.31 |
| UNS N06030 | 0.297 | 8.22 |
| UNS N06255 | 0.299 | 8.29 |
| UNS N06250 | 0.307 | 8.58 |
| Nickel-iron-chromium-molybdenum: | | |
| UNS N08320 | 0.291 | 8.05 |
| UNS N08135 | 0.292 | 8.10 |
| Nickel-chromium-molybdenum-iron: | | |
| UNS N06002 | 0.297 | 8.23 |
| UNS N06060 | 0.315 | 8.71 |
| Nickel-iron-chromium-cobalt: | | |
| UNS R30556 | 0.297 | 8.23 |
| Nickel-chromium-tungsten-molybdenum: | | |
| UNS N06230 | 0.324 | 8.97 |
| Low carbon nickel-chromium-molybdenum: | | |
| UNS N06058 | 0.318 | 8.80 |
| UNS N06059 | 0.311 | 8.6 |
| UNS N06200 | 0.307 | 8.50 |