

SPECIFICATION FOR WELDED AUSTENITIC STEEL BOILER, SUPERHEATER, HEAT-EXCHANGER, AND CONDENSER TUBES



SA-249/SA-249M



(Identical with ASTM Specification A 249/A 249M-96a except for the deletion of S5, which addresses unstraightened tubes, and clarified heat treatment requirements in 6.2.) 98

1. Scope

1.1 This specification covers nominal-wall-thickness welded tubes made from the austenitic steels listed in Table 1, with various grades intended for such use as boiler, superheater, heat exchanger, or condenser tubes.

1.2 Grades TP304H, TP309H, TP309HCb, TP310H, TP310HCb, TP316H, TP321H, TP347H, and TP348H are modifications of grades TP304, TP309S, TP309Cb, TP310S, TP310Cb, TP316, TP321, TP347, and TP348, and are intended for high-temperature service such as for superheaters and reheaters.

1.3 The tubing sizes and thickness usually furnished to this specification are $\frac{1}{8}$ in. [3.2 mm] in inside diameter to 5 in. [127 mm] in outside diameter and 0.015 to 0.320 in. [0.4 to 8.1 mm], inclusive, in wall thickness. Tubing having other dimensions may be furnished, provided such tubes comply with all other requirements of this specification.

1.4 Mechanical property requirements do not apply to tubing smaller than $\frac{1}{8}$ in. [3.2 mm] in inside diameter or 0.015 in. [0.4 mm] in thickness.

1.5 Optional supplementary requirements are provided and, when one or more of these are desired, each shall be so stated in the order.

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.

1.7 The following safety hazards caveat pertains only to the test method described in the Supplementary Requirements of this specification. *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 establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.* A specific warning statement is given in Supplementary Requirement S7, Note 5. 98

2. Referenced Documents

2.1 ASTM Standards:

- A 262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels
- A 450/A 450M Specification for General Requirements for Carbon, Ferritic Alloy, and Austenitic Alloy Steel Tubes
- A 480/A 480M Specification for General Requirements for Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet and Strip

E 112 Test Methods for Determining Average Grain Size
 E 213 Practice for Ultrasonic Examination of Metal Pipe and Tubing
 E 273 Practice for Ultrasonic Examination of Longitudinal Welded Pipe and Tubing
 E 527 Practice for Numbering Metals and Alloys (UNS)

3. General Requirements

3.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification A 450/A 450M, unless otherwise provided herein.

4. Ordering Information

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

4.1.1 Quantity (feet, meters, or number of lengths),

4.1.2 Name of material (welded tubes),

4.1.3 Grade (Table 1),

4.1.4 Size (outside diameter and nominal wall thickness),

4.1.5 Length (specific or random),

4.1.6 Optional requirements (13.6),

4.1.7 Test report required (see Certification Section of Specification A 450/A 450M),

4.1.8 Specification designation, and

4.1.9 Special requirements and any supplementary requirements selected.

5. Manufacture

5.1 The tubes shall be made from flat-rolled steel by an automatic welding process with no addition of filler metal.

5.2 Subsequent to welding and prior to final heat treatment, the tubes shall be cold worked either in both weld and base metal or in weld metal only. The method of cold working may be specified by the purchaser. When cold drawn, the purchaser may specify the minimum amount of reduction in cross-sectional area or wall thickness, or both.

6. Heat Treatment

6.1 All material shall be furnished in the heat-treated condition. The heat-treatment procedure, except for "H" grades, S30815, S31254, S32654, N08367, N08904, and N08926 shall consist of heating the material to a minimum temperature of 1900°F [1040°C] and quenching in water or rapidly cooling by other means. **98**

6.2 All H grades, S33228, and S30815 shall be furnished in the heat-treated condition. For these grades, separate solution heat treatments are required for solution annealing; in-process heat treatments are not permitted as a substitute for the separate solution annealing treatments. 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 solution temperature for S33228 shall be 2050°F [1120°C]. The minimum solution-treating temperature for S30815 shall be 1920°F [1050°C]. The minimum solution treating temperature for TP309H, TP309HCb, TP310H, TP310HCb, shall be 1900°F [1040°C].

6.3 S31254 and S32654 shall be heat-treated to a minimum temperature of 2100°F [1150°C] followed by quenching in water or rapidly cooling by other means.

6.4 S24565 shall be heat-treated in the range 2050°F [1120°C] to 2140°F [1170°C] followed by quenching in water or rapidly cooling by other means.

6.5 N08904 shall be heat treated to a minimum temperature of 2000°F (1100°C) followed by quenching in water or rapidly cooling by other means. **98**

6.6 N08926 shall be heat-treated to a minimum temperature of 2000°F [1100°C] followed by quenching in water or rapidly cooling by other means. **98**

6.7 A solution annealing temperature above 1950°F [1065°C] may impair the resistance to intergranular corrosion after subsequent exposure to sensitizing conditions in TP309HCb, TP310HCb, TP321, TP321H, TP347, TP347H, TP348, and TP348H. When specified by the purchaser, a lower temperature stabilization or re-solution anneal shall be used subsequent to the initial **98**

high temperature solution anneal (see Supplementary Requirement S4).

98 **6.8** UNS N08367 should be solution annealed from 2025°F minimum followed by rapid quenching.

7. Chemical Composition

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

8. Product Analysis

8.1 An analysis of either one length of flat-rolled stock or one tube shall be made on each heat. The chemical composition thus determined shall conform to the requirements specified in Section 7.

8.2 A product analysis tolerance of Table A1.1 in Specification A 480/A 480M 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 lengths of flat-rolled stock or tubes shall be made. Both retests for the elements in question shall meet the requirements of the specification; otherwise all remaining material in the heat or lot (Note 1) shall be rejected or, at the option of the producer, each length of flat-rolled stock or tube may be individually tested for acceptance. Lengths of flat-rolled stock or tubes that do not meet the requirements of the specification shall be rejected.

NOTE 1 — For flattening and flange requirements, the term lot applies to all tubes prior to cutting, of the same nominal size and wall thickness which 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 which are heat treated in the same furnace charge. When the final heat treatment is in a continuous furnace, 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 2.

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 which 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 the same heat which are heat treated in the same furnace charge. When the final heat treatment is in a continuous furnace, a lot shall include all tubes of the same size and heat, annealed in the same furnace at the same temperature, time at heat, and furnace speed.

9. Tensile Requirements

9.1 The material shall conform to the tensile properties prescribed in Table 3.

10. Hardness Requirements

10.1 The tubes shall have a Rockwell hardness number not exceeding the values specified in Table 3.

11. Reverse-Bend Test Requirement

11.1 A section 4 in. [100 mm] in length shall be split longitudinally 90° on each side of the weld. The sample shall then be opened and bent around a mandrel with a diameter four times the wall thickness, with the mandrel parallel to the weld and on the outside of the tube. The weld shall be at the point of maximum bend. There shall be no evidence of cracks or lack of penetration in the weld, or of overlaps resulting from the reduction in thickness of the weld areas by cold working.

NOTE 3 — The reverse bend test is not applicable when the specified wall is 10% or more of the specified outside diameter, or the wall thickness is 0.134 in. [3.4 mm] or greater, or the outside diameter size is less than 0.375 in. [9.5 mm]. Under these conditions the reverse flattening test of Specification A 450/A 450 M shall apply.

12. Grain Size Requirement

12.1 The grain size of Grades TP309H, TP309HCb, TP310H and TP310HCb, as determined in accordance with Test Methods E 112, shall be No. 6 or coarser.

12.2 The grain size of Grade TP321H, as determined in accordance with Test Methods E 112, shall be No. 7 or coarser.

13. Mechanical Tests and Grain Size Determinations Required

13.1 Tension Test — 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 (Note 2).

13.2 Flattening Test — One flattening test shall be made on specimens from each end of one finished tube, not the one used for the flange test, from each lot (Note 1).

13.3 Flange Test — One flange test shall be made on specimens from each end of one finished tube, not

the one used for the flattening test, from each lot (Note 1).

13.4 Reverse-Bend Test — One reverse-bend test shall be made on a specimen from each 1500 ft [450 m] of finished tubing.

13.5 Hardness Test — Brinell or Rockwell hardness tests shall be made on specimens from two tubes from each lot (Note 2).

13.6 Hydrostatic or Nondestructive Electric Test — Each tube shall be subjected to either the hydrostatic or the nondestructive electric test. The purchaser may specify which test is to be used.

13.7 Grain Size — Grain size determinations on grades TP309H, TP309HCb, TP310H and TP310HCb shall be made on the same number of tubes as prescribed for the flattening test.

14. Permissible Variations in Dimensions

14.1 Dimensional tolerances other than wall thickness tolerances shall be in accordance with Specification A 450/A 450M. Wall thickness tolerances shall be $\pm 10\%$ of nominal wall for all tubing sizes.

15. Workmanship, Finish, and Appearance

15.1 Finished tubes shall have smooth ends free of burrs and shall not deviate from straightness by more than 0.030 in. [0.8 mm] in 3 ft [900 mm] of length.

16. Surface Condition

16.1 The tubes, after final heat treatment, shall be chemically descaled or pickled free of scale. When bright annealing is used, pickling or chemical descaling is not necessary.

17. Forming Operations

17.1 Tubes when inserted in the boiler shall stand expanding and beading without showing cracks or flaws. All tubes, when properly manipulated, shall be able to stand expanding and beading without showing cracks and flaws, and also shall stand all forging, welding, and bending operations necessary for application without developing defects.

18. Product Marking

18.1 In addition to the marking prescribed in Specification A 450/A 450M, the marking for Grades TP304H, TP309H, TP309HCb, TP310H, TP310HCb, TP316H, TP321H, TP347H, and TP348H shall also include the heat number and the heat-treatment lot identification.

19. Keywords

19.1 austenitic stainless steel; boiler tubes; condenser tube; heat exchanger tube; high temperature applications; steel tube; superheater tubes; temperature service applications, high; welded steel tube

TABLE 1
CHEMICAL REQUIREMENTS %

Grade	Composition, %																					
	TP 201	TP 202	TP 304	TP 304H	TP 304L	TP 304N	TP 304LN	TP 305	TP 309Cb	TP 309H	TP 309Hcb	TP 309S	TP 310Cb	TP 310H	TP 310Hcb	TP 310S	TP 316	TP 316H	TP 316L	TP 316N	TP 316LN	TP 317
UNS Designation ^a	S20100	S20200	S30400	S30409	S30403	S30451	S30453	S30500	S30940	S30909	S30941	S30908	S31040	S31009	S31041	S31008	S31600	S31609	S31603	S31651	S31653	S31700
Carbon	0.15 max	0.15 max	0.08 max	0.04-0.10	0.035 max ^b	0.08 max	0.12 max	0.08 max	0.08 max	0.04-0.10	0.04-0.10	0.08 max	0.08 max	0.04-0.10	0.04-0.10	0.08 max	0.08 max	0.04-0.10	0.035 max ^b	0.08 max	0.035 max ^b	0.08 max
Manganese, max ^h	5.50-7.50	7.50-10.0	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00
Phosphorus, max	0.060	0.060	0.040	0.040	0.040	0.040	0.045	0.045	0.045	0.040	0.045	0.045	0.045	0.040	0.045	0.045	0.040	0.040	0.040	0.040	0.040	0.04
Sulfur, max	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.03
Silicon, max	1.00	1.00	0.75	0.75	0.75	0.75	1.00	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75
Nickel	3.50-5.50	4.00-6.00	8.00-11.0	8.00-11.0	8.00-13.0	8.00-11.0	10.0-13.0	12.0-16.0	12.0-16.0	12.0-15.0	12.0-16.0	12.0-15.0	12.0-16.0	12.0-19.0	12.0-19.0	12.0-19.0	10.0-14.0	10.0-14.0	10.0-15.0	10.0-14.0	10.0-15.0	11.0-14.0
Chromium	16.0-18.0	17.0-19.0	18.0-20.0	18.0-20.0	18.0-20.0	18.0-20.0	17.0-19.0	22.0-24.0	22.0-24.0	22.0-24.0	22.0-24.0	24.0-26.0	24.0-26.0	24.0-26.0	24.0-26.0	24.0-26.0	16.0-18.0	16.0-18.0	16.0-18.0	16.0-18.0	16.0-18.0	18.0-20.0
Molybdenum	0.75 max	0.75 max	...	0.75 max	0.75 max	0.75 max	...	0.75 max	0.75 max	2.00-3.00	2.00-3.00	2.00-3.00	2.00-3.00	2.00-3.00	3.00-4.00
Titanium
Columbium + tantalum	10 x C min, 1.10 max	10 x C min, 1.10 max	...	10 x C min, 1.10 max	...	10 x C min, 1.10 max	...	10 x C min, 1.10 max
Tantalum, max
Nitrogen ^e	0.25 max	0.25 max	0.10-0.16	0.10-0.16	0.10-0.16	...
Vanadium
Others

TABLE 1
CHEMICAL REQUIREMENTS % (CONT'D)

Grade	Composition, %																							
	TP 317L	TP 321	TP 321H	TP 347	TP 347H	TP 348	TP 348H	XM-15	TP XM-19	TP XM-29	S30615	S31050	S31254	S30815	S31725	S51726	S24565	S33228	S30415	S32654	N08367	N08926	N08904	
UNS Designation	S31703	S32100	S32109	S34700	S34709	S34800	S34809	S38100	S20910	S24000	S30615	S31050	S31254	S30815	S31725	S51726	S24565	S33228	S30415	S32654	N08367	N08926	N08904	
Carbon	0.035 max	0.08 max	0.04-0.10	0.08 max	0.04-0.10	0.08 max	0.04-0.10	0.08 max	0.06 max	0.08 max	0.16-0.24	0.025 max	0.02 max	0.05-0.10	0.03 max	0.03 max	0.03 max	0.04-0.08	0.04-0.06	0.020 max	0.030 max	0.020 max	0.020 max	
Manganese, max [#]	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	4.00-6.00	11.5-14.5	2.00	2.00	1.00	0.80	2.00	2.00	5.0-7.0	1.0	0.80	2.00-4.00	2.00	2.00	2.00	
Phosphorus, max	0.04	0.04	0.04	0.04	0.04	0.04	0.04	0.03	0.04	0.04	0.03	0.020	0.03	0.04	0.045	0.045	0.030	0.020	0.045	0.030	0.040	0.03	0.045	
Sulfur, max	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.03	0.015	0.01	0.03	0.03	0.03	0.010	0.015	0.030	0.005	0.030	0.01	0.035	
Silicon, max [#]	0.75	0.75	0.75	0.75	0.75	0.75	0.75	1.50-2.50	1.00	1.00	3.2-4.0	0.4	0.80	1.40-2.00	0.75	1.00	1.00	0.30	1.00-2.00	0.50	1.00	0.5	1.00	
Nickel	11.0-15.0	9.00-13.0	9.00-13.0	9.00-13.0	9.00-13.0	9.00-13.0	9.00-13.0	17.5-18.5	11.5-13.5	2.25-3.75	13.5-16.0	20.5-23.5	17.5-18.5	10.0-12.0	13.5-17.5	13.5-17.5	16.0-18.0	31.0-33.0	9.00-10.00	21.0-23.0	23.50-25.50	24.00-26.00	23.0-28.0	
Chromium	18.0-20.0	17.0-20.0	17.0-20.0	17.0-20.0	17.0-20.0	17.0-20.0	17.0-20.0	17.0-19.0	20.5-23.5	19.0	17.0-19.5	24.0-26.0	19.5-20.5	20.0-22.0	18.0-20.0	23.0-25.0	23.0-25.0	26.0-28.0	18.0-19.0	20.00-22.00	20.00-22.00	19.00-21.00	19.0-23.0	
Molybdenum	3.00-4.00	1.50-3.00	1.6-2.6	6.00-6.50	...	4.0-5.0	4.0-5.0	4.0-5.0	7.00-8.00	6.00-7.00	6.0-7.0	4.0-5.0	
Titanium
Columbium + tantalum	0.10-0.30	0.1 max	...	0.6-1.0	
Tantalum, max
Nitrogen ⁶
Vanadium
Others	Al 0.8-1.5	Cu 0.05-1.00	Ce 0.03-0.08	Ce 0.03-0.08	Cu 0.75 max	Cu 0.75 max	...	Ce 0.05-0.10	Cu 0.03-0.08	Cu 0.30-0.60	Cu 0.75 max	Cu 0.5-1.5	Cu 1.0-2.0	

NOTES:
^A New designation established in accordance with Practice E 527 and SAE J1086, Practice for Numbering Metals and Alloys (UNS).
^B For small diameter or thin walls, or both, where many drawing passes are required, a carbon maximum of 0.040% is necessary in Grades TP 304L and TP 316L. Small outside diameter tubes are defined as those less than 0.500 in. [12.7 mm] in outside diameter and light wall are those less than 0.049 in. [1.2 mm] in average wall thickness (0.044 in. [1.1 mm] in minimum wall thickness).
^C Grade TP 321 shall have a titanium content of not less than five times the carbon content and not more than 0.70%.
^D Grade TP 347 and TP 348 shall have a columbium plus tantalum content of not less than ten times the carbon content and not more than 1.0%.
^E Grade TP 321H shall have a titanium content of not less than four times the carbon content and not more than 0.60%.
^F Grades TP 347H and TP 348H shall have a columbium plus tantalum content of not less than eight times the carbon content and not more than 1.0%.
^G The method of analysis for nitrogen shall be a matter of agreement between the purchaser and manufacturer.
^H Maximum, unless otherwise indicated.

TABLE 2
NUMBER OF TUBES IN A LOT HEAT TREATED BY
THE CONTINUOUS PROCESS

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

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TABLE 3
TENSILE AND HARDNESS REQUIREMENTS⁴

Grade	UNS Designation	Tensile Strength, min, ksi [MPa]	Yield Strength, min, ksi [MPa]	Elongation in 2 in. or 50 mm, min, %	Rockwell Hardness Number, max
TP201	S20100	95 [655]	38 [260]	35	B95
TP202	S20200	90 [620]	38 [260]	35	B95
TP304	S30400	75 [515]	30 [205]	35	B90
TP304H	S30409	75 [515]	30 [205]	35	B90
TP304L	S30403	70 [485]	25 [170]	35	B90
TP304N	S30451	80 [550]	35 [240]	35	B90
TP304LN	S30453	75 [515]	30 [205]	35	B90
TP305	S30500	75 [515]	30 [205]	35	B90
TP309Cb	S30940	75 [515]	30 [205]	35	B90
TP309H	S30909	75 [515]	30 [205]	35	B90
TP309HCb	S30941	75 [515]	30 [205]	35	B90
TP309S	S30908	75 [515]	30 [205]	35	B90
TP310Cb	S31040	75 [515]	30 [205]	35	B90
TP310H	S31009	75 [515]	30 [205]	35	B90
TP310HCb	S31041	75 [515]	30 [205]	35	B90
TP310S	S31008	75 [515]	30 [205]	35	B90
TP316	S31600	75 [515]	30 [205]	35	B90
TP316H	S31609	75 [515]	30 [205]	35	B90
TP316L	S31603	70 [485]	25 [170]	35	B90
TP316N	S31651	80 [550]	35 [240]	35	B90
TP316LN	S31653	75 [515]	30 [205]	35	B90
TP317	S31700	75 [515]	30 [205]	35	B90
TP317L	S31703	75 [515]	30 [205]	35	B90
TP321	S32100	75 [515]	30 [205]	35	B90
TP321H	S32109	75 [515]	30 [205]	35	B90
TP347	S34700	75 [515]	30 [205]	35	B90
TP347H	S34709	75 [515]	30 [205]	35	B90
TP348	S34800	75 [515]	30 [205]	35	B90
TP348H	S34809	75 [515]	30 [205]	35	B90
TPXM-15	S38100	75 [515]	30 [205]	35	B90
TPXM-19	S20910	100 [690]	55 [380]	35	C25
TPXM-29	S24000	100 [690]	55 [380]	35	B100
...	S30615	90 [620]	40 [275]	35	B95
...	S31050:				
	t ≤ 0.25 in.	84 [580]	39 [270]	25	B95
	t > 0.25 in.	78 [540]	37 [255]	25	B95
...	S31254	94 [650]	44 [300]	35	B96
...	S30815	87 [600]	45 [310]	35	B95
...	S31725	75 [515]	30 [205]	35	B90
...	S31726	80 [550]	35 [240]	35	B90
...	S24565	115 [795]	60 [415]	35	B100
...	S33228	73 [500]	27 [185]	30	B90
...	S30415	87 [600]	42 [290]	35	B96
...	S32654	109 [750]	62 [430]	35	B100
...	N08367				
	t ≤ 0.187	100 [690]	45 [310]	30	100
	t > 0.187	95 [655]	45 [310]	30	100
...	N08926	94 [650]	43 [295]	35	B100
...	N08904	71 [490]	31 [215]	35	B90

⁴ Not applicable to tubes less than 1/8 in. [3.2 mm] in outside diameter or having wall thickness below 0.015 in. [0.4 mm], or both. The tensile properties of such small diameter or thin wall tubes shall be a matter of agreement between the manufacturer and the purchaser.

SUPPLEMENTARY REQUIREMENTS

The following supplementary requirements shall apply only when specified by the purchaser in the inquiry, contract, or order.

S1. Stress-Relieved Annealed Tubes

S1.1 For use in certain corrosives, particularly chlorides where stress corrosion may occur, tubes in Grades TP304L, TP316L, TP321, TP347, and TP348 may be specified in the stress-relieved annealed condition. Details of these supplemental requirements shall be agreed upon by the manufacturer and the purchaser.

S1.2 When stress-relieved tubes are specified, tubes shall be given a heat treatment at 1550 to 1650°F [845 to 900°C] after roll straightening. Cooling from this temperature range may be either in air or by slow cooling. No mechanical straightening is permitted after the stress-relief treatment.

S1.3 Straightness of the tubes shall be a matter of negotiation between the purchaser and manufacturer.

S2. Minimum Wall Tubes

S2.1 When specified by the purchaser, tubes shall be furnished on a minimum wall basis. Such tubes shall satisfy the minimum wall thickness requirements of Specification A 450/A 450M rather than the nominal wall requirements of this specification. In addition to the marking required by Section 18, the tubing shall be marked S2.

S3. Air Underwater Pressure Test

98 S3.1 When specified, the tubing shall be examined by the air underwater pressure test.

S4. Stabilizing Heat Treatment

S4.1 Subsequent to the solution anneal required in Section 6, Grades TP309HCb, TP310HCb, TP321, TP321H, TP347, TP347H, TP348, and TP348H shall be given a stabilization heat treatment at a temperature lower than that used for the initial solution annealing heat treatment. The temperature of stabilization heat treatment shall be at a temperature as agreed upon between the purchaser and vendor.

S5. DELETED**S6. Intergranular Corrosion Test**

S6.1 When specified, material shall pass intergranular corrosion tests conducted by the manufacturer in accordance with Practices A 262, Practice E.

NOTE 4 — Practice E requires testing on the sensitized condition for low carbon or stabilized grades, and on the as-shipped condition for other grades.

S6.2 A stabilization heat treatment in accordance with Supplementary Requirement S4 may be necessary and is permitted in order to meet this requirement for the grades containing titanium or columbium, particularly in their H versions.

S7. Weld Decay Test

S7.1 When specified by the purchase order, one sample from each lot of tubing shall be subject to testing in boiling 20% hydrochloric acid.

S7.2 Saw cut the sample, approximately 2 in. length, from a production length of tubing. Then, split the sample longitudinally to allow for easy micrometer measurements. The desire is to split the tube longitudinally 90° on each side of the weld. However, for larger tubes, reduce the sample size to fit the Erlenmeyer flask. Thus, cuts shall range from a maximum of 30° on each side of the weld for a 5 in. diameter tube and up to 90° on each side of the weld for tubes with 2.75 in. diameter and less. Cut a similar size section from the balance of the tube opposite the weld consisting of 100% base metal. Remove all burrs and sharp edges by lightly grinding. Remove dust and grease by cleaning with soap and water or other suitable solvents. Then, place both sections from each sample tube in the same flask.

S7.3 Prepare the 20% hydrochloric acid solution by slowly adding reagent grade (37%) hydrochloric acid to an equal volume of distilled water.

NOTE 5: **Warning** — Protect eyes and use rubber gloves when handling acid. Mixing shall be done under a hood and testing shall be run under a hood.

S7.4 The test container shall be a 1-L Erlenmeyer flask equipped with ground-glass joints and an Ahlin condenser. The volume of the solution shall be approximately 700 mL.

S7.5 Measure the thickness of the tube at five locations along the weld area of the one sample section, and at five locations along the base-metal sample section. In both cases, take measurements at approximately 0.4 in. intervals along the section lengths. Make these measurements with a sharp, pointed micrometer accurate to at least 0.001 in.

S7.6 Immerse the sample sections into the solution. Add boiling chips and bring to a boil. Allow the chips to remain boiling throughout the test. The time of testing shall be that which is required to remove 40 to 60% of the original base-metal thickness. (Usually 2 h or less.)

S7.7 At the end of the test period, remove the pair of samples from the solution, rinse with distilled water, and dry.

S7.8 After exposure to the test solution, repeat the tube-thickness measurement as in S7.5.

S7.9 Calculate the corrosion ratio, R , as follows:

$$R = \frac{W_o - W}{B_o - B}$$

where:

W_o = average weld-metal thickness before the test,

W = average weld-metal thickness after the test,

B_o = average base-metal thickness before the test,
and

B = average base-metal thickness after the test.

S7.9.1 A corrosion ratio of 1.25 or less is satisfactory, but other values may be specified upon agreement between the producer and purchaser.

S8. Special Applications

S8.1 For special applications, such as hydraulic expansion of tubes into tube sheets, there shall be no dimensional indication of the weld. Tubes ordered to this requirement shall bear the additional marking of NB.

S9. Additional Testing of Welded Tubing per ASME Request

S9.1 Each tube shall be subjected to an ultrasonic inspection employing Practices E 273 and E 213 with the rejection criteria referenced in A 450/A 450M.

S9.2 If Practice E 273 is employed, a 100% volumetric inspection of the entire length of each tube shall also be performed using one of the non-destructive electric tests permitted by Specification A 450/A 450M.

S9.3 The test methods described in the supplement may not be capable of inspecting the end portions of tubes. This condition is referred to as end effect. This portion, as determined by the manufacturer, shall be removed and discarded.

S9.4 In addition to the marking prescribed in Specification A 450/A 450M, "SX" shall be added after the grade designation.