



ROLF

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Manufacturer & Exporters of

**High Tensile Carbon Steel, API 5L X52 to X70 PSL 1/2, LSAW, ERW & Seamless Pipes & Fittings,
Stainless Steel, Alloy Steel Pipes & Fittings, High Nickel Alloys, Monel, Inconel, Hastelloy, SM0254,
Duplex, Super Duplex, Titanium-B2, B5 - Pipes & Fittings, Finned Tubes, Studded Pipes.**



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

This standard is issued under the fixed designation A 789/A 789M; 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 nominal wall thickness, 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 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:³

A 480/A 480M Specification for General Requirements for Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet, and Strip

A 1016/A 1016M Specification for General Requirements for Ferritic Alloy Steel, Austenitic Alloy Steel, and Stainless Steel Tubes

E 527 Practice for Numbering Metals and Alloys (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 nominal wall thickness),

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 **A 1016/A 1016M**),

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 **A 1016/A 1016M**, unless otherwise provided herein.

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.

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 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.

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	...
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	...
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	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	0.05	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 40 min ^C
S32808	0.030	1.10	0.030	0.030	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
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

^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.

^B New designation established in accordance with Practice E 527 and SAE J1086.

^C % Cr + 3.3 % Mo + 163 % N.

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 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 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 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 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 %.

9.3 *Flange Test (for Welded Tubes)*—One test shall be made on specimens from one end of one tube from each lot (see Note 1) of finished tubes.

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

9.5 When more than one heat is involved, the tension, flaring, flanging, and hardness test requirements shall apply to each heat.

9.6 *Reverse Flattening Test*—For welded tubes, one reverse flattening test shall be made on a specimen from each 1500 ft [450 m] of finished tubing.

10. Hydrostatic or Nondestructive Electric Test

10.1 Each tube shall be subjected to the nondestructive electric test or the hydrostatic test. The type of test to be used shall be at the option of the manufacturer, unless otherwise specified in the purchase order.



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
S32205	1870–2010 [1020–1100]	rapid cooling in air or water
S32304	1700–1920 [925–1050]	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	2010–2085 [1100–1140]	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
S39274	1920–2060 [1025–1125]	rapid cooling in air or water
S39277	1975–2155 [1080–1180]	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

10.2 The hydrostatic test shall be in accordance with Specification A 1016/A 1016M, except that in the calculation of the hydrostatic test pressure 64000(441.2) shall be substituted for 32000(220.6).

TABLE 4 Tensile and Hardness Requirements^A

UNS Designation	Tensile Strength, min, ksi [MPa]	Yield Strength, min, ksi [MPa]	Elongation in 2 in. or 50 mm, min, %	Hardness, max	
				HBW	HRC
S31200	100 [690]	65 [450]	25	280	...
S31260 ^B	100 [690]	65 [450]	25	290	30
S31500	92 [630]	64 [440]	30	290	30
S31803	90 [620]	65 [450]	25	290	30
S32001	90 [620]	65 [450]	25	290	30
S32003 ^C	100 [690]	70 [485]	25	290	30
S32101					
Wall # 0.187 in. [5.00 mm]	101 [700]	77 [530]	30	290	...
Wall > 0.187 in. [5.00 mm]	94 [650]	65 [450]	30	290	...
S32205	95 [655]	70 [485]	25	290	30
S32304					
OD 1 in. [25 mm] and Under	100 [690]	65 [450]	25
OD over 1 in. [25 mm]	87 [600]	58 [400]	25	290	30
S32520	112 [770]	80 [550]	25	310	...
S32550	110 [760]	80 [550]	15	297	31
S32707	133 [920]	101 [700]	25	318	34
S32750	116 [800]	80 [550]	15	300	32
S32760	109 [750]	80 [550]	25	300	...
S32808	116 [800]	80 [550]	15	310	32
S32900	90 [620]	70 [485]	20	271	28
S32906					
Wall below 0.40 in. (10 mm)	116 [800]	94 [650]	25	300	32
Wall 0.40 in. (10 mm) and above	109 [750]	80 [550]	25	300	32
S32950 ^D	100 [690]	70 [480]	20	290	30
S39274	116 [800]	80 [550]	15	310	...
S39277	120 [825]	90 [620]	25	290	30

^A For tubing smaller than ½ in. [12.7 mm] in outside diameter, the elongation values given for strip specimens in Table 4 shall apply. Mechanical property requirements do not apply to tubing smaller than ⅜ in. [3.2 mm] in outside diameter or with walls thinner than 0.015 in. [0.4 mm].

^B Prior to A 789/A 789M–87, the values for S31260 were 92 ksi tensile strength, 54 ksi yield strength, and 30 % elongation.

^C Prior to A 789/A 789M–04, the values for S32003 were 90 ksi tensile strength and 65 ksi yield strength.

^D Prior to A 789/A 789M–89, the tensile strength value was 90 ksi for UNS S32950.

11. Tensile and Hardness Properties

11.1 The material shall conform to the tensile and hardness properties prescribed in Table 4.

12. Permissible Variations in Dimensions

12.1 Variations in outside diameter, wall thickness, and length from those specified shall not exceed the amounts prescribed in Table 5.

12.2 The permissible variations in outside diameter given in Table 5 are not sufficient to provide for ovality in thin-walled tubes, as defined in the table. In such tubes, the maximum and minimum diameters at any cross section shall deviate from the



TABLE 5 Permissible Variations in Dimensions

Group	Size, Outside Diameter, in. [mm]	Permissible Variations in Outside Diameter, in. [mm]	Permissible Variations in Wall Thickness, ^A %	Permissible Variations in Cut Length, in. ^B [mm]		Thin Walled Tubes ^C
				Over	Under	
1	Up to ½ [12.7], excl	60.005 [0.13]	615	⅛ [3]	0	...
2	½ to 1½ [12.7 to 38.1], excl	60.005 [0.13]	610	⅛ [3]	0	less than 0.065 in. [1.6 mm] nominal
3	1½ to 3½ [38.1 to 88.9], excl	60.010 [0.25]	610	⅜ [5]	0	less than 0.095 in. [2.4 mm] nominal
4	3½ to 5½ [88.9 to 139.7], excl	60.015 [0.38]	610	⅜ [5]	0	less than 0.150 in. [3.8 mm] nominal
5	5½ to 8 [139.7 to 203.2], incl	60.030 [0.76]	610	⅜ [5]	0	less than 0.150 in. [3.8 mm] nominal

^AWhen tubes as ordered require wall thicknesses ⅜ in. [19 mm] or over, or an inside diameter 60 % or less of the outside diameter, a wider variation in wall thickness is required. On such sizes a variation in wall thickness of 12.5 % over or under will be permitted.

For tubes less than ½ in. [12.7 mm] in inside diameter that cannot be successfully drawn over a mandrel, the wall thickness may vary 615 % from that specified.

^B These tolerances apply to cut lengths up to and including 24 ft [7.3 m]. For lengths greater than 24 ft [7.3 m], the above over-tolerances shall be increased by ⅛ in. [3 mm] for each 10 ft [3 m] or fraction thereof over 24 ft or ½ in. [13 mm], whichever is the lesser.

^COvality provisions of 12.2 apply.

nominal diameter by no more than twice the permissible variation in outside diameter given in Table 5; however, the mean diameter at that cross section must still be within the given permissible variation.

13. Surface Condition

13.1 All tubes shall be free of excessive mill scale, suitable for inspection. A slight amount of oxidation will not be considered as scale. Any special finish requirements shall be subject to agreement between the manufacturer and the purchaser.

14. Product Marking

14.1 In addition to the marking prescribed in Specification A 1016/A 1016M, the marking shall indicate whether the tubing is seamless or welded.

15. Keywords

15.1 duplex stainless steel; ferritic/austenitic stainless steel; seamless steel tube; stainless steel tube; steel tube; welded steel tube

SUPPLEMENTARY REQUIREMENTS

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

S1. Air-Underwater Pressure Test

S1.1 When specified, each tube shall be examined by the air underwater pressure test.

SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this specification since the last issue, A 789/A 789M-05a, that may impact the use of this specification. (Approved September 1, 2005)

- (1) Revised tensile properties for UNS S32003 in Table 4.
- (2) Revised the Si content in Table 1 for UNS 32906 from 0.50 % to 0.80 %.
- (3) Changed the annealing temperature in Table 2 for UNS

32906 to 1870–2100 °F [1020–1150 °C].

- (4) Added Austenitic-Ferritic Grade UNS 32707 to Table 1, Table 2, and Table 4.

Committee A01 has identified the location of selected changes to this specification since the last issue, A 789/A 789M-05, that may impact the use of this specification. (Approved June 1, 2005)

- (1) Added new grade UNS S32808 to Table 1, Table 2, and Table 4.

- (2) Editorially revised Table 1, Table 2, and Table 4.



Committee A01 has identified the location of selected changes to this specification since the last issue, A 789/A 789M-04a, that may impact the use of this specification. (Approved March 1, 2005)

(I) Added stainless steel 32101 to **Table 1**, **Table 2**, and **Table 4**.

Committee A01 has identified the location of selected changes to this specification since the last issue, A 789/A 789M-04, that may impact the use of this specification. (Approved July 1, 2004)

(I) Revised the quenching requirement for S31260 in **Table 2**.

Committee A01 has identified the location of selected changes to this specification since the last issue, A 789/A 789M-02a, that may impact the use of this specification. (Approved March 1, 2004)

(I) Moved Note 1 from Scope to Footnote A in **Table 4** and reordered the footnotes.

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