



Designation: A 268/A 268M – 04

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

This standard is issued under the fixed designation A 268/A 268M; 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.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This specification² covers a number of grades of nominal-wall-thickness, stainless steel tubing for general corrosion-resisting and high-temperature service. Most of these grades are commonly known as the “straight-chromium” types and are characterized by being ferromagnetic. Two of these grades, TP410 and UNS S 41500 (Table 1), are amenable to hardening by heat treatment, and the high-chromium, ferritic alloys are sensitive to notch-brittleness on slow cooling to ordinary temperatures. These features should be recognized in the use of these materials. Grade TP439 is used primarily for hot-water tank service and does not require post-weld heat treatment to prevent attack of the heat affected zone.

NOTE 1—TP329 (S32900) formerly in this specification, has been transferred to Specifications A 789/A 789M and A 790/A 790M.

1.2 An optional supplementary requirement is provided, and when desired, shall be so stated in the order.

NOTE 2—For tubing smaller than $\frac{1}{2}$ in. [12.7 mm] in outside diameter, the elongation values given for strip specimens in Table 2 shall apply. Mechanical property requirements do not apply to tubing smaller than $\frac{1}{8}$ in. [3.2 mm] in outside diameter or with walls thinner than 0.015 in. [0.4 mm].

1.3 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 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-268 in Section II of that Code.

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 763 Practices for Detecting Susceptibility to Intergranular Attack in Ferritic Stainless Steels
- A 789/A 789M Specification for Seamless and Welded Ferritic/Austenitic Stainless Steel Tubing for General Service
- A 790/A 790M Specification for Seamless and Welded Ferritic/Austenitic Stainless Steel Pipe
- A 941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys
- A 1016/A 1016M Specification for General Requirements for Ferritic Alloy Steel, Austenitic Alloy Steel, and Stainless Steel Tubes
- E 213 Practice for Ultrasonic Examination of Metal Pipe and Tubing
- E 273 Practice for Ultrasonic Examination of the Weld Zone of Welded Pipe and Tubing

3. Terminology

3.1 For definitions of terms used in this specification, refer to Terminology A 941.

4. Ordering Information

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

- 4.1.1 Quantity (feet, metres, or number of lengths),
- 4.1.2 Name of material (seamless or welded tubes),
- 4.1.3 Grade (Table 1),

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.

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



TABLE 1 Chemical Requirements

NOTE 1 — TP329 (S32900), formerly part of this specification, has been transferred to A 789/A 789M and A 790/A 790M.

Grade	TP405	TP410	TP429	TP430	TP443	TP446-1	TP446-2 ^A	...	TP409						
UNS Designation ^B	S40500	S41000	S42900	S43000	S44300	S44600	S44600	S40800	S40900						
Element	Composition, %														
C, max	0.08	0.15	0.12	0.12	0.20	0.20	0.12	0.08	0.08						
Mn, max	1.00	1.00	1.00	1.00	1.00	1.50	1.50	1.00	1.00						
P, max	0.040	0.040	0.040	0.040	0.040	0.040	0.040	0.045	0.045						
S, max	0.030	0.030	0.030	0.030	0.030	0.030	0.030	0.045	0.030						
Si, max	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00						
Ni	0.50 max	0.75 max	0.75 max	0.50 max	0.80 max	0.50 max						
Cr	11.5-14.5	11.5-13.5	14.0-16.0	16.0-18.0	18.0-23.0	23.0-27.0	23.0-27.0	11.5-13.0	10.5-11.7						
Mo						
Al	0.10-0.30	0.90-1.25						
Cu	0.25						
N						
Ti						
								12 × C min; 1.10 max	6 × C min; 0.75 max						
Grade	TP439	TP430 Ti	TP XM-27	TP XM-33 ^A	18Cr-2Mo	29-4	29-4-2	26-3-3	25-4-4	...	TP468				
UNS Designation	S41500 ^C	S43036	S44627	S44626	S44400	S44700	S44800	S44660	S44635	S44735	S42803	S40977	S43940	S42035	S46800
Element	Composition, %														
C, max	0.07	0.10	0.01 ^A	0.06	0.025	0.010	0.010	0.030	0.025	0.030	0.015 ^D	0.03	0.03	0.08	0.030
Mn, max	1.00	1.00	0.40	0.75	1.00	0.30	0.30	1.00	1.00	1.00	0.5	1.50	1.00	1.00	1.00
P, max	0.040	0.040	0.02	0.040	0.040	0.025	0.025	0.040	0.040	0.040	0.020	0.040	0.040	0.045	0.040
S, max	0.030	0.030	0.02	0.020	0.030	0.020	0.020	0.030	0.030	0.030	0.005	0.015	0.015	0.030	0.030
Si, max	1.00	1.00	0.40	0.75	1.00	0.20	0.20	1.00	0.75	1.00	0.50	1.00	1.00	1.00	1.00
Ni	0.50 max	0.75 max	0.5 ^E max	0.50 max	1.00 max	0.15 max	0.15 max	1.0-3.50	3.5-4.5	1.00 max	3.0-4.0	0.30-1.00	1.0-2.5	1.0-2.5	0.50
Cr	17.00-19.00	16.00-19.50	25.0-27.5	25.0-27.0	17.5-19.5	28.0-30.0	28.0-30.0	25.0-28.0	24.5-26.0	28.00-30.00	28.0-29.0	10.50-12.50	17.50-18.50	13.5-15.5	18.00-20.00
Mo	0.75-1.50	0.75-1.50	1.75-2.50	3.5-4.2	3.5-4.2	3.0-4.0	3.5-4.5	3.60-4.20	1.8-2.5	0.2-1.2	...
Al, max	0.15	0.15	0.15
Cu, max	0.2	0.20	...	0.020 ^F	0.020 ^F
N, max	0.04	...	0.015	0.040	0.035	0.040	0.035	0.045	0.020	0.030	0.030
Ti	0.20 + 4 (C + N) min; 1.10 max	0.75 max	...	7 × (C + N) but no less than 0.20 min; 1.00 max	(Ti + Cb) (Ti + Cb) (Ti + Cb) (C + N) min; 0.80 max	(Ti + Cb) = 0.20-1.00 and 6 × (C + N) min	(Ti + Cb) = 0.20 + 4 (C + N) min to 0.80 max	(Ti + Cb) = 0.20-1.00 and 6 × (C + N) min	0.10-0.60	...	0.10-0.60	0.30-0.50	0.07-0.30
Cb	0.05-0.20	0.15-0.50 ^G	...	(3 × %C + 0.30) min	...	0.10-0.60
															(Ti + Cb) = 0.20 + 4(C+N) min; 0.80 max

^A For small diameter or thin walls, or both, tubing, where many drawing passes are required, a carbon maximum of 0.015 % is necessary. Small outside diameter tubes are defined as those less than 0.500 in. [12.7 mm] in outside diameter and light wall tubes as those less than 0.049 in. [1.2 mm] in average wall thickness (0.040 in. [1 mm] in minimum wall thickness).

^B When intergranular corrosion testing is specified, the test will be Practices A 763, using samples prepared as agreed upon between the seller and the purchaser.

^C Plate version of CA6NM.

^D Carbon plus nitrogen = 0.30 max.

^E Nickel plus copper.

^F Carbon plus nitrogen = 0.025 % max.

^G Cb/(C + N) = 12 min.

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

4.1.4 Size (outside diameter and nominal wall thickness),

4.1.5 Length (specific or random),

4.1.6 Optional requirements (hydrostatic or nondestructive electric test, Section 15),

4.1.7 Test report required (Certification Section of Specification A 1016/A 1016M),

4.1.8 Specification designation, and

4.1.9 Special requirements.

5. General Requirements

5.1 Material furnished under this specification shall conform to the applicable requirements of Specification A 1016/A 1016M unless otherwise provided herein.

6. Manufacture

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

7. Heat Treatment

7.1 As a final heat treatment, tubes shall be reheated to a temperature of 1200°F [650°C] or higher and cooled (as appropriate for the grade) to meet the requirements of this specification.

7.2 The martensitic grade UNS S 41500 shall be reheated to a temperature of 950°F [510°C] or higher and cooled as appropriate to meet the requirements of this specification.

8. Chemical Composition

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

9. Product Analysis

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

9.2 The product analysis tolerance of the Chemical Requirements Table of 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.

9.3 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 the specification; otherwise all remaining material in the heat or lot (Note 3) 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 which do not meet the requirements of the specification shall be rejected.

NOTE 3—For flange and flaring 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 4—For tensile 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 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, heat treated in the same furnace at the same temperature, time at heat, and furnace speed.

10. Tensile Requirements

10.1 The material shall conform to the tensile properties prescribed in Tables 3 and 4.

11. Hardness Requirements

11.1 The tubes shall have a hardness number not to exceed those prescribed in Table 5.

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 6.

12.2 The permissible variations in outside diameter given in Table 6 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 nominal diameter by no more than twice the permissible variation in outside diameter given in Table 6; however, the mean diameter at that cross section must still be within the given permissible variation.

12.3 When the specified wall is 2 % or less of the specified outside diameter, the method of measurement is in accordance with the agreement between the purchaser and the manufacturer (see Note 5).

NOTE 5—Very thin wall tubing may not be stiff enough for the outside diameter to be accurately measured with a point contact test method, such as with the use of a micrometer or caliper. When very thin walls are specified, “go”–“no go” ring gages are commonly used to measure diameters of 1½ in. [38.1 mm] or less. A0.002-in. [0.05-mm] additional tolerance is usually added on the “go” ring gage to allow clearance for sliding. On larger diameters, measurement is commonly performed with a pi tape. Other test methods such as optical test methods may also be considered.

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.



TABLE 3 Tensile Requirements

NOTE 1—TP329 (S32900), formerly part of this specification, has been transferred to /A 789M and A 790/A 790M.

Grade and UNS Designation	Tensile strength, min,	Yield strength, min,	Elongation ^A in 2 in. or 50 mm, min, %
	ksi [MPa]	ksi [MPa]	
TP405	60 [415]	30 [205]	20
... S40500			
... S40800	55 [380]	30 [205]	20
TP410	60 [415]	30 [205]	20
... S41000			
TP429, TP430, and TP430 Ti	60 [415]	35 [240]	20
... S429000, S 43000, and S 43036			
TP443	70 [485]	40 [275]	20
... S44300			
TP446-1	70 [485]	40 [275]	18
... S44600			
TP446-2	65 [450]	40 [275]	20
... S44600			
TP409	55 [380]	25 [170]	20
... S40900			
TP439	60 [415]	30 [205]	20
... S43035			
... S41500	115 [795]	90 [620]	15
TPXM-27	65 [450]	40 [275]	20
... S44627			
TPXM-33	68 [470]	45 [310]	20
... S44626			
18Cr-2Mo	60 [415]	40 [275]	20
... S44400			
29-4 and 29-4-2	80 [550]	60 [415]	20
... S44700 and S 44800			
26-3-3	85 [585]	65 [450]	20
... OS44660			
25-4-4	90 [620]	75 [515]	20
... S44635			
... S44735	75 [515]	60 [415]	18
28-2-3.5			
... S32803	87 [600]	72 [500]	16
S40977	65 [450]	41 [280]	18
S43940	62 [430]	36 [250]	18
S42035	80 [550]	55 [380]	16
TP468	60 [415]	30 [205]	22
... S46800			

^A For longitudinal strip tests a deduction of 0.90 % for TP446-1 and S 44735 and 1.00 % for all other grades shall be made from the basic minimum elongation for each 1/2 in. [0.8 mm] decrease in wall thickness below 5/16 in. [8 mm]. The following table gives the computed minimum values:

14. Mechanical Tests Required

14.1 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 (Note 4).

14.2 Flaring Test (for Seamless Tubes)— One test shall be made on specimens from one end of one tube from each lot (Note 3) of finished tubes. The minimum expansion of the inside diameter shall be 10 %. For tubes over 8 in. [203.2 mm] in outside diameter, or tubes with wall thickness 3/8 in. [9.52 mm] and over, the flattening test may be performed instead of the flaring test unless the flaring test is specified in the purchase order.

14.3 Flange Test (for Welded Tubes)— One test shall be made on specimens from one end of one tube from each lot

TABLE 4 Minimum Elongation Values

Wall Thickness	Elongation ^A in 2 in. or 50 mm, min, %				
	in.	mm	TP446-1 and S 44735	S41500	All Other Grades
1/16 [0.312]		8	18	15	20
1/32 [0.281]		7.2	17	14	19
1/4 [0.250]		6.4	16	14	18
3/32 [0.219]		5.6	15	13	17
3/16 [0.188]		4.8	14	12	16
5/32 [0.156]		4	13	11	15
1/8 [0.125]		3.2	13	11	14
3/32 [0.094]		2.4	12	10	13
1/16 [0.062]		1.6	11	9	12
0.062–0.035, excl	1.6–0.9		10	8	12
0.035–0.022, excl	0.9–0.6		10	8	11
0.022–0.015, incl	0.6–0.4		10	8	11

^A Calculated elongation requirements shall be rounded to the nearest whole number.

Note—The above table gives the computed minimum values for each 1/32 in. [0.8 mm] decrease in wall thickness. Where the wall thickness lies between two values shown above, the minimum elongation value shall be determined by the following equation:

Grade	Equation
TP446-1 and S 44735	E = 28.8t + 9.00 [E = 1.13t + 9.00]
S41500	E = 24t + 7.5
All other grades	E = 32t + 10.00 [E = 1.25t + 10.00]

where:

E = elongation in 2 in. or 50 mm, %.
t = actual thickness of specimen, in. [mm].

TABLE 5 Hardness Requirements.

NOTE 1—TP329 (S32900), formerly part of this specification, has been transferred to A 790/A 790M and A 789/A 789M.

Grade	UNS Designation	Brinell Hardness, max	Rockwell Hardness, B Scale, max
TP405	S40500	207	95
...	S40800	207	95
TP410	S41000	207	95
TP429, TP430, and TP430 Ti	S42900, S 43000, and S 43036	190	90
TP443	S44300	207	95
TP446-1 and TP446-2	S44600	207	95
TP409	S40900	207	95
TP439	S43035 ^A	190	90
...	S41500	295 ^B	32
TPXM-33 and TPXM-27	S44626 and S44627	241	100
18CR-2Mo	S44400	217	95
29-4 and 29-4-2	S44700 and S44800	207	100
26-3-3	S44660	265	25 ^B
25-4-4	S44635	270	27 ^B
...	S44735	...	100
28-2-3.5	S32803	240	100
...	S40977	180	88
...	S43940	180	88
...	S42035	180	88

^A Editorially corrected October 2000.

^B Rockwell hardness, C scale.

(Note 3) of finished tubes. For tubes over 8 in. [203.2 mm] in outside diameter, or tubes with wall thickness 3/8 in. [9.52 mm]

TABLE 6 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	±0.005 [0.13]	±15	⅛ [3]	0	...
2	½ to 1½ [12.7 to 38.1], excl	±0.005 [0.13]	±10	⅛ [3]	0	less than 0.065 in. [1.6 mm] nominal
3	1½ to 3½ [38.1 to 88.9], excl	±0.010 [0.25]	±10	⅜ [5]	0	less than 0.095 in. [2.4 mm] nominal
4	3½ to 5½ [88.9 to 139.7], excl	±0.015 [0.38]	±10	⅜ [5]	0	less than 0.150 in. [3.8 mm] nominal
5	5½ to 8 [139.7 to 203.2], incl	±0.030 [0.76]	±10	⅜ [5]	0	less than 0.150 in. [3.8 mm] nominal

^AWhen tubes as ordered require wall thicknesses ¾ 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 which cannot be successfully drawn over a mandrel, the wall thickness may vary ±15 % from that specified.

^BThese 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 lesser.

^COvality provisions of 12.2 apply.

and over, the flattening test may be performed instead of the flange test unless the flange test is specified in the purchase order.

14.4 *Hardness Test*—Brinell or Rockwell hardness tests shall be made on specimens from two tubes from each lot (Note 4).

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

14.6 *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.

15. Hydrostatic or Nondestructive Electric Test

15.1 Each tube, seamless or welded, 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.

16. Product Marking

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

17. Keywords

17.1 ferritic stainless steel; seamless steel tube; stainless steel tube; steel tube; welded steel tube

SUPPLEMENTARY REQUIREMENTS

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

S1. Air-Underwater Pressure Test

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

S1.2 The tube shall be well-lighted, preferably by underwater illumination.

S1.3 Any evidence of air leakage of the pneumatic couplings shall be corrected prior to testing.

S1.4 After holding the pressure for not less than 5 s after the surface of the water has become calm, an inspection shall be made of the entire external surface of the tube.

S1.5 If any tube leaks during the air-underwater test, it shall be rejected. Any leaking areas may be cut out and the tube retested as above.

S2. Additional Testing of Welded Tubing per ASME Request

S2.1 Each tube shall be subjected to an ultrasonic inspection employing Practices E 273 or E 213 with the rejection criteria referenced in Specification A 1016/A 1016M.

S2.2 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 1016/A 1016M.

S2.3 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.

S2.4 In addition to the marking prescribed in Specification A 1016/A 1016M, “ S2” shall be added after the grade designation.

SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this specification since the last issue, A 268/A 268M – 03, which may impact the use of this specification (Approved May 1, 2004).

(1) Revised grades TP 409 and TP 410 in Table 3.

Committee A01 has identified the location of selected changes to this specification since the last issue, A 268/A 268M – 01, which may impact the use of this specification (Approved September 10, 2003).

(1) Replaced Specification A 450/A 450M with Specification A 1016/A 1016M throughout. (2) Clarified ordering requirements to include purchaser’s responsibility in Section 4.

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