



B 444

Standard Specification for Nickel-Chromium-Molybdenum-Columbium Alloys (UNS N06625 and UNS N06852) and Nickel-Chromium-Molybdenum-Silicon Alloy (UNS N06219) Pipe and Tube¹

This standard is issued under the fixed designation B 444; 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 (e) 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 nickel-chromium-molybdenum-columbium alloys (UNS N06625 and UNS N06852) and nickel-chromium-molybdenum-silicon alloy (UNS N06219)* in the form of cold-worked seamless pipe and tube. The general requirements for pipe and tube are covered by Specification B 829.

1.1.1 UNS N06625 products are furnished in two grades of different heat-treated conditions:

1.1.1.1 *Grade 1 (annealed)*—Material is normally employed in service temperatures up to 1100°F (593°C).

1.1.1.2 *Grade 2 (solution annealed)*—Material is normally employed in service temperatures above 1100°F (593°C) when resistance to creep and rupture is required.

NOTE 1—Hot-working or reannealing may change properties significantly, depending on working history and temperatures.

1.1.2 Alloys UNS N06219 and UNS N06852 are supplied in the solution annealed condition only.

1.2 The following precautionary caveat pertains only to the test methods portion, Section 9, 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 become familiar with all hazards including those identified in the appropriate Material Safety Data Sheet (MSDS) for this product/material as provided by the manufacturer, to establish appropriate safety and health practices, and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards³

B 829 Specification for General Requirements for Nickel and Nickel Alloys Seamless Pipe and Tube

3. General Requirement

3.1 Material furnished under this specification shall conform to the applicable requirements of Specification B 829 unless otherwise provided herein.

4. Ordering Information

4.1 Orders for material to this specification shall include information with respect to the following:

4.1.1 Alloy name or UNS number,

4.1.2 ASTM designation,

4.1.3 Condition (temper) (see 1.1.1, 1.1.2, Section 6, and Appendix X1 and Appendix X2),

4.1.3.1 If neither grade of N06625 is specified, Grade 1 will be supplied.

4.1.4 Finish (See Appendix X2),

4.1.5 *Dimensions*

4.1.5.1 *Tube*—Specify outside diameter and nominal or minimum wall,

4.1.5.2 *Pipe*—Specify standard pipe size and schedule,

4.1.5.3 *Length*—Cut to length or random,

4.1.6 *Quantity*—Feet (or metres) or number of pieces,

4.1.7 *Hydrostatic Test or Nondestructive Electric Test*—Specify type of test (see 6.2),

4.1.8 *Hydrostatic Pressure Requirements*—Specify test pressure if other than required by 9.1.1,

4.1.9 *Certification*—State if certification is required,

4.1.10 *Samples for Product (Check) Analysis*—State whether samples for product (check) analysis should be furnished (see 5.2),

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 Dec. 1, 2006. Published January 2007. Originally approved in 1966. Last previous edition approved in 2004 as B 444 - 04.

* New designation established in accordance with Practice E 527 and SAE J 1086, Practice for Numbering Metals and Alloys (UNS).

² For ASME Boiler and Pressure Vessel Code applications see related Specification SB-444 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.



4.1.11 *Purchaser Inspection*—If purchaser wishes to witness tests or inspection of material at place of manufacture, the purchase order must so state indicating which tests or inspections are to be witnessed, and

4.1.12 *Small Diameter and Light Wall Tube (Converter Sizes)*—See Appendix X1 and Table 1.

5. Chemical Composition

5.1 The material shall conform to the composition limits specified in Table 2. One test is required for each lot as defined in Specification B 829.

5.2 If a product (check) analysis is performed by the purchaser, the material shall conform to the product (check) analysis variations in Table 2 of Specification B 829.

6. Mechanical Properties and Other Requirements

6.1 *Tension Test*—The material shall conform to the tensile properties specified in Table 1. The sampling and specimen preparation are as covered in Specification B 829.

6.2 *Hydrostatic or Nondestructive Electric Test*—Each pipe or tube shall be subjected to either the hydrostatic test or to the nondestructive electric test. The type of test to be used shall be at the option of the manufacturer, unless otherwise specified in the purchase order.

7. Dimensions and Permissible Variations

7.1 Permissible variations for material specified as small-diameter and light-wall tube (converter size) shall conform to the permissible variations prescribed in Table X1.1 and Table X1.2.

TABLE 1 Room Temperature Tensile Properties and Heat Treatment Including Small Diameter and Light-Wall Tubing (Converter Sizes)^{AB}

Condition	Tensile Strength, min, ksi (MPa) ^C	Yield	
		Strength (0.2 % offset), min, ksi (MPa) ^C	Elongation in 2 in. or 50.8 mm (or 4D), min, %
Alloy N06625			
Grade 1 (annealed) ^D	120 (827)	60 (414)	30
Grade 2 (solution annealed) ^E	100 (690)	40 (276)	30
Alloy N06219			
All (solution annealed)	96 (660)	39 (270)	30
Alloy N06852			
All (solution annealed)	85 (586)	35 (241)	30

^A Not applicable to outside diameters under 1/8 in. (3.2 mm) and to wall thicknesses under 0.015 in. (0.38 mm).

^B Hot forming quality pipe and tubing is furnished to chemical requirements and surface inspection only. No tensile properties are required.

^C The minimum strength values apply only to tubing in straight lengths.

^D Annealed at 1600°F (871°C) minimum.

^E Solution annealed at 2000°F (1093°C) minimum, with or without subsequent stabilization anneal at 1800°F (982°C) minimum to increase resistance to sensitization.

TABLE 2 Chemical Requirements

Element	Composition Limits, %		
	N06852	N06625	N06219
Carbon	0.05 max	0.10 max	0.05 max
Manganese	0.50 max	0.50 max	0.50 max
Silicon	0.50 max	0.50 max	0.70-1.10
Phosphorus	0.015 max	0.015 max	0.020 max
Sulfur	0.015 max	0.015 max	0.010 max
Chromium	20.0-23.0	20.0 min	18.0-22.0
Columbium + tantalum	...	23.0 max	...
	...	3.15 min	...
Columbium	...	4.15 max	...
	0.51-1.00	...	...
Cobalt (if determined)	...	1.0 max	1.0 max
Molybdenum	8.0-10.0	8.0 min	7.0-9.0
Iron	...	10.0 max	...
	15.0-20.0	5.0 max	2.0-4.0
Aluminum	0.40 max	0.40 max	0.50 max
Titanium	0.40 max	0.40 max	0.50 max
Copper	...	...	0.50 max
Nickel ^A	Bal.	58.0 min	Bal.

^A Element shall be determined arithmetically by difference.

8. Number of Tests

8.1 *Chemical Analysis*—One test per lot.

8.2 *Tension*—One test per lot.

8.3 *Hydrostatic or Nondestructive Electric Test*—Each piece in each lot.

9. Test Methods

9.1 *Hydrostatic Test*—Each pipe or tube with an outside diameter 1/8 in. (3 mm) and larger and with wall thickness of 0.015 in. (0.38 mm) and over shall be tested in accordance with Specification B 829. The allowable fiber stress for material in the condition furnished, is as follows:

UNS N06625:

Grade 1—30 000 psi (207 MPa)

Grade 2—25 000 psi (172 MPa)

UNS N06219:

All—24 000 psi (165 MPa)

UNS N06852:

All—21 000 psi (145 MPa)

9.1.1 When so agreed upon by the manufacturer and purchaser, pipe or tube may be tested to 1½ times the allowable fiber stress given above.

9.1.2 If any pipe or tube shows leak during hydrostatic testing, it shall be rejected.

9.2 *Nondestructive Electric Test*—Each pipe or tube shall be examined with a nondestructive electric test as per prescribed in Specification B 829.

10. Keywords

10.1 seamless pipe; seamless tube; N06219; N06625



APPENDIXES

(Nonmandatory Information)

X1. CONVERTER SIZES

X1.1 Small-diameter and light-wall tube in outside diameters $1\frac{1}{4}$ in. (31.8 mm) and under may be furnished in a limited range of sizes and the manufacturer should be consulted as to

the various outside diameters and wall thicknesses that may be furnished. Material will have a bright finish. Such material shall conform to the requirements in Tables X1.1 and X1.2.

TABLE X1.1 Permissible Variations for Small-Diameter and Light-Wall Tube (Converter Sizes)^{A,B,C,D,E,F,G}

Specified Outside Diameter, in. (mm)	Outside Diameter		Inside Diameter		Wall Thickness, %	
	Plus	Minus, in. (mm)	Plus	Minus	Plus	Minus
Under $\frac{3}{32}$ (2.4)	0.002 (0.05)	0	0	0.002 (0.05)	10	10
$\frac{3}{32}$ to $\frac{1}{16}$ (2.4 to 4.8), excl	0.003 (0.08)	0	0	0.003 (0.08)	10	10
$\frac{1}{16}$ to $\frac{1}{2}$ (4.8 to 12.7), excl	0.004 (0.10)	0	0	0.004 (0.10)	10	10
$\frac{1}{2}$ to $1\frac{1}{4}$ (12.7 to 31.8), incl	0.005 (0.13)	0	0	0.005 (0.13)	10	10

^A Ovality, Normal-Wall Tube—Ovality will be held within 2 % of the theoretical average outside diameter.

^B Ovality, Light-Wall Tube—Ovality will be held within 3 % of the theoretical average outside diameter.

^C Wall Tolerances, Light-Wall Tube—The plus and minus wall tolerance shown in the table shall apply down to and including 0.005 in. (0.13 mm) in wall thickness. For wall thicknesses less than 0.005 in. (0.13 mm), the tolerance shall be 60.0005 in. (0.013 mm).

^D Random Lengths:

Where nominal random lengths on tubing $\frac{1}{8}$ in. (3.2 mm) and larger in outside diameter are specified, a length tolerance of $63\frac{1}{2}$ ft (1.07 m) applies to the nominal length. This is a total spread of 7 ft (2.13 m).

Random lengths in sizes $\frac{1}{8}$ in. (3.2 mm) and larger in outside diameter shall be subject to a length range of 5 to 24 ft (1.52 to 7.32 m). Long random lengths are subject to a range from 15 to 22 ft (4.57 to 6.71 m).

Random lengths in sizes up to, but not including $\frac{1}{8}$ in. (3.2 mm) in outside diameter, and fragile light-wall tubes over this outside diameter are subject to the length range from 1 to 15 ft (0.30 to 4.57 m).

^E Cut Lengths—Tolerances on cut lengths shall be in accordance with Table X1.1.

^F Straightness—Round tubing is subject to a straightness tolerance of 1 part in 600 [equivalent to a depth of arc of 0.030 in. (0.76 mm) in any 3 ft (0.91 m) of length].

^G When specified, the tolerance spreads of this table may be applied as desired. However, when not specified, the tolerances in this table will apply. It should be noted that inside diameter tolerances are based upon the outside diameter range.

TABLE X1.2 Tolerances on Cut Lengths of Light-Wall Tube

Length, ft (m)	Tube Size, in. (mm)	Permissible Variations, in. (mm)	
		Over	Under
Under 1 (0.30)	up to 1.250 (31.8), incl	$\frac{1}{32}$ (0.8)	0 (0)
1 to 4 (0.30 to 1.22), incl	up to 1.250 (31.8), incl	$\frac{1}{16}$ (1.6)	0 (0)
Over 4 to 10 (1.22 to 3.0), incl	up to 1.250 (31.8), incl	$\frac{3}{32}$ (2.4)	0 (0)
Over 10 (3.0)	up to 1.250 (31.8), incl	$\frac{3}{16}$ (4.8)	0 (0)

X2. CONDITIONS AND FINISHES NORMALLY SUPPLIED

X2.1 Scope

X2.1.1 This appendix lists the conditions and finishes in which pipe and tube (other than converter sizes) are normally supplied. These are subject to change, and the manufacturer should be consulted for the latest information available.

X2.2 Cold-Worked Tube and Pipe

X2.2.1 Cold-Drawn, Annealed or Solution Annealed with Ground Outside Diameter—The inside diameter may have a bright finish when material is annealed or solution annealed in a protective atmosphere; otherwise, the inside diameter is

supplied descaled as necessary. It is available in sizes $\frac{1}{2}$ to 4 in. (12.7 to 102 mm), incl, in outside diameter in both normal and heavy-wall tube, and pipe sizes, all schedules, of corresponding outside-diameter dimensions.

X2.2.2 Cold-Drawn, Annealed or Solution Annealed and Pickled (Not Ground)—Outside and inside diameter will have dull, matte (pickled) surfaces. Available in sizes $\frac{1}{2}$ to $6\frac{3}{8}$ in. (12.7 to 168 mm), incl, in outside diameter in both normal and heavy-wall tube, and pipe sizes, all schedules, of corresponding outside-diameter dimensions.



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SUMMARY OF CHANGES

Committee B02 has identified the location of selected changes to this standard since the last issue (B 444 - 04) that may impact the use of this standard. (Approved December 1, 2006.)

- (1) Introduction of nondestructive electric test in lieu of hydrostatic test at the option of the manufacturer. (2) Revision of 4.1, 6.2, 8.3, 9.1.2, and 9.2.

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