

DUPLEX STAINLESS STEEL PIPE SPECIFICATION

SEAMLESS & WELDED FERRITIC/AUSTENITIC STAINLESS STEEL PIPE

ASTM A790/A790M-05a

Duplex stainless steel pipe requirements for general corrosive service

DUPLEX STAINLESS GRADES

HEAT TREATMENT

CHEMICAL REQUIREMENTS

TENSILE & HARDNESS

HYDROSTATIC / NDE

DIMENSIONS APPENDIX

Technical reference prepared for product and project requirement review.

Confirm final material, dimensions, testing and documentation before ordering.

ASTM A790/A790M-05a

Technical data navigation

Use the index below to open the corresponding technical section.

SECTION	CONTENTS	PAGE
Scope, references & ordering	Pipe coverage, applicable documents and purchaser information	3
Manufacture, heat treatment & chemistry	Processes, grade heat treatments and chemical composition limits	4
Mechanical properties & testing	Tensile, yield, elongation, hardness and required mechanical tests	5
Hydrostatic and nondestructive examination	Hydrostatic, ultrasonic and eddy-current acceptance controls	6
Repair, marking & supplementary requirements	Field repair, identification and purchaser-selected tests	8
Pipe dimensions appendix	NPS outside diameters and Schedule 5S, 10S, 40S and 80S wall thicknesses	9
Project support	RFQ information and direct contact details	10
REFERENCE NOTE		
Source dimensional values and footnotes are retained. Confirm the applicable material, grade, schedule and project specification before ordering.		



Designation: A 790/A 790M – 05a

Standard Specification for Seamless and Welded Ferritic/Austenitic Stainless Steel Pipe¹

This standard is issued under the fixed designation A 790/A 790M; 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 seamless and straight-seam welded ferritic/austenitic steel pipe intended for general corrosive service, 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 Optional supplementary requirements are provided for pipe when a greater degree of testing is desired. These supplementary requirements call for additional tests to be made and, when desired, one or more of these may be specified in the order.

1.3 Appendix X1 of this specification lists the dimensions of welded and seamless stainless steel pipe as shown in ANSI B36.19. Pipe having other dimensions may be furnished provided such pipe complies with all other requirements of this specification.

1.4 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.

NOTE 1—The dimensionless designator NPS (nominal pipe size) has been substituted in this standard for such traditional terms as nominal diameter, size, and nominal size.

2. Referenced Documents

2.1 ASTM Standards:³

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products

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.

Current edition approved June 1, 2005. Published June 2005. Originally approved in 1981. Last previous edition approved in 2005 as A 790/A 790M – 05.

² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-790 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.

A 941 Terminology Relating to Steel, Stainless Steel, Related Alloys and Ferroalloys

A 999/A 999M Specification for General Requirements for Alloy and Stainless Steel Pipe

E 213 Practice for Ultrasonic Examination of Metal Pipe and Tubing

E 309 Practice for Eddy-Current Examination of Steel Tubular Products Using Magnetic Saturation

E 381 Method of Macroetch Testing Steel Bars, Billets, Blooms, and Forgings

E 426 Practice for Electromagnetic (Eddy-Current) Examination of Seamless and Welded Tubular Products, Austenitic Stainless Steel and Similar Alloys

E 527 Practice for Numbering Metals and Alloys (UNS)

2.2 ANSI Standards:⁴

B1.20.1 Pipe Threads, General Purpose

B36.10 Welded and Seamless Wrought Steel Pipe

B36.19 Stainless Steel Pipe

2.3 SAE Standard:⁵

SAE J 1086

2.4 Other Standard:⁶

SNT-TC-1A Personal Qualification and Certification in Nondestructive Testing

2.5 AWS Standard

A5.9 Corrosion-Resisting Chromium and Chromium-Nickel Steel Welding Rods and Electrodes

3. Terminology

3.1 *Definitions*—For definitions of terms used in this specification refer to Terminology A 941.

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, metres, or number of lengths),

4.1.2 Name of material (ferritic/austenitic steel pipe).

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

⁵ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001.

⁶ Available from The American Society for Nondestructive Testing (ASNT), P.O. Box 28518, 1711 Arlington Ln., Columbus, OH 43228-0518.

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



A 790/A 790M – 05a

- 4.1.3 Process (seamless or welded),
- 4.1.4 Grade (see Table 1),
- 4.1.5 Size (NPS designator or outside diameter and schedule number of average wall thickness),
- 4.1.6 Length (specific or random) (see Section 11),
- 4.1.7 End finish (section on ends of Specification A 999/A 999M),
- 4.1.8 Optional requirements (product analysis, Section 9; hydrostatic test or nondestructive electric test, Section 14),
- 4.1.9 Test report required (section on certification of Specification A 999/A 999M),
- 4.1.10 Specification designation, and
- 4.1.11 Special requirements and any supplementary requirements selected.

5. General Requirements

5.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification A 999/A 999M unless otherwise provided herein.

6. Materials and Manufacture

6.1 Manufacture:

6.1.1 The pipe shall be made by the seamless or an automatic welding process, with no addition of filler metal in the welding operation.

6.1.2 At the manufacturer's option, pipe may be either hot-finished or cold-finished.

TABLE 1 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
S32003	1850–2050 [1010–1120]	Rapid cooling in air or water
S32101	1870 [1020]	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
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	1900–1980 [1040–1080]	Rapid cooling in air or water
S32950	1820–1880 [990–1025]	Air cool
S32974	1920–2060 [1025–1125]	Rapid cooling in air or water
S32977	1975–2155 [1080–1180]	Rapid cooling in air or water

6.1.3 The pipe shall be pickled free of scale. When bright annealing is used, pickling is not necessary.

6.2 *Discard*—A sufficient discard shall be made from each ingot to secure freedom from injurious piping and undue segregation.

6.3 All pipe shall be furnished in the heat-treated condition as shown in Table 1. For seamless pipe, as an alternate to final heat treatment in a continuous furnace or batch-type furnace, immediately following hot forming while the temperature of the pipes is not less than the specified minimum solution treatment temperature, pipes shall be individually quenched in water or rapidly cooled by other means, except for UNS S32950, which shall be air cooled.

7. Chemical Composition

7.1 The steel shall conform to the chemical requirements as prescribed in Table 2.

8. Heat Analysis

8.1 An analysis of each heat of steel shall be made by the steel manufacturer to determine the percentages of the elements specified.

9. Product Analysis

9.1 At the request of the purchaser's inspector, an analysis of one billet or one length of flat-rolled stock from each heat, or two pipes from each lot, shall be made by the manufacturer. A lot of pipe shall consist of the following number of lengths of the same size and wall thickness from any one heat of steel:

NPS Designator	Lengths of Pipe in Lot
Under 2	400 or fraction thereof
2 to 5, incl	200 or fraction thereof
6 and over	100 or fraction thereof

9.2 The results of these analyses shall be reported to the purchaser or the purchaser's representative and shall conform to the requirements specified in Section 7.

9.3 If the analysis of one of the tests specified in 8.1 or 9.1 does not conform to the requirements specified in Section 7, an analysis of each billet or pipe from the same heat or lot may be made, and all billets or pipe conforming to the requirements shall be accepted.

10. Tensile and Hardness Properties

10.1 The material shall conform to the tensile and hardness properties prescribed in Table 3.

11. Lengths

11.1 Pipe lengths shall be in accordance with the following regular practice:

11.1.1 Unless otherwise agreed upon, all sizes from NPS ¼ to and including NPS 8 are available in a length up to 24 ft (see Note 2) with the permissible range of 15 to 24 ft (see Note 2). Short lengths are acceptable and the number and minimum length shall be agreed upon between the manufacturer and the purchaser.



A 790/A 790M – 05a

TABLE 2 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	4.2–5.2	18.0–19.0	2.50–3.00	0.05–0.10	...	...
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	...	...
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	1.5	0.035	0.020	0.80	5.5–8.0	24.0–26.0	3.0–5.0	0.20–0.35	0.5–3.00	...
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	...
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	0.5	...
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	0.50	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	3.0–4.0	0.23–0.33	1.20–2.00	W 0.8–1.2

^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.

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

^c% Cr + 3.3 × % Mo + 16 × % N.

TABLE 3 Tensile and Hardness Requirements

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	100 [690]	65 [450]	25	...	...
S31500	92 [630]	64 [440]	30	290	30
S31803	90 [620]	65 [450]	25	290	30
S32003	90 [620]	65 [450]	25	290	30
S32101	...	...	...	...	...
t ≤ 0.187 in. [5.00 mm]	101 [700]	77 [530]	30	290	...
t > 0.187 in. [5.00 mm]	94 [650]	65 [450]	30	290	...
S32205	95 [655]	65 [450]	25	290	30
S32304	87 [600]	58 [400]	25	290	30
S32520	112 [770]	80 [550]	25	310	...
S32550	110 [760]	80 [550]	15	297	31
S32750	116 [800]	80 [550]	15	300	32
S32760 ^a	109 [750]	80 [550]	25	270	...
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	100 [690]	70 [480]	20	290	30
S39274	116 [800]	80 [550]	15	310	...
S39277	120 [825]	90 [620]	25	290	30

^aPrior to A 790/A 790M – 04, the tensile strength value for UNS 32760 was 109–130 ksi [750–895 MPa]

NOTE 2—This value applies when the inch-pound designation of this

specification is the basis of purchase. When the *M* designation of this specification is the basis of purchase, the corresponding metric value(s) shall be agreed upon between the manufacturer and purchaser.

11.1.2 If definite cut lengths are desired, the lengths required shall be specified in the order. No pipe shall be less than the specified length and no more than ¼ in. [6 mm] over it.

11.1.3 No jointers are permitted unless otherwise specified.

12. Workmanship, Finish, and Appearance

12.1 The finished pipes shall be reasonably straight and shall have a workmanlike finish. Imperfections may be removed by grinding, provided the wall thicknesses are not decreased to less than that permitted, in the Permissible Variations in Wall Thickness Section of Specification A 999/A 999M.

13. Mechanical Tests Required

13.1 *Transverse or Longitudinal Tension Test*—One tension test shall be made on a specimen for lots of not more than 100 pipes. Tension tests shall be made on specimens from 2 pipes for lots of more than 100 pipes.

13.2 *Mechanical Testing Lot Definition*—The term *lot* for mechanical tests applies to all pipe of the same nominal size and wall thickness (or schedule) that is produced from the same heat of steel and subjected to the same finishing treatment as defined as follows:

13.2.1 Where the heat treated condition is obtained, consistent with the requirements of 6.3, in a continuous heat treatment furnace or by directly obtaining the heat treated condition by quenching after hot forming, the lot shall include all pipe of the same size and heat, heat treated in the same furnace at the same temperature, time at heat, and furnace

 A 790/A 790M – 05a

speed or all pipe of the same size and heat, hot formed and quenched in the same production run.

13.2.2 Where final heat treatment is obtained, consistent with the requirements of 6.3, in a batch-type heat-treatment furnace equipped with recording pyrometers and automatically controlled within a 50 °F [30 °C] or smaller range, the lot shall be the larger of (a) each 200 ft [60 m] or fraction thereof or (b) that pipe heat treated in the same batch furnace charge.

13.2.3 Where the final heat treatment is obtained, consistent with the requirements of 6.3, in a batch-type heat-treatment furnace not equipped with recording pyrometers and automatically controlled within a 50 °F [30 °C] or smaller range, the term *lot* for mechanical tests applies to the pipe heat treated in the same batch furnace charge, provided that such pipe is of the same nominal size and wall thickness (or schedule) and is produced from the same heat of steel.

13.3 *Flattening Test*—For pipe heat treated in a batch-type furnace, flattening tests shall be made on 5 % of the pipe from each heat-treated lot. For pipe heat treated by the continuous process, or by direct quenching after hot forming, this test shall be made on a sufficient number of pipes to constitute 5 % of the lot, but in no case less than two lengths of pipe.

13.3.1 For welded pipe with a diameter equal to or exceeding NPS 10, a transverse guided face bend test of the weld may be conducted instead of a flattening test in accordance with the method outlined in the steel tubular product supplement of Test Methods and Definitions A 370. The ductility of the weld shall be considered acceptable when there is no evidence of cracks in the weld or between the weld and the base metal after bending. Test specimens from 5 % of the lot shall be taken from the pipes or test plates of the same material as the pipe, the test plates being attached to the end of the cylinder and welded as a prolongation of the pipe longitudinal seam.

13.4 *Hardness Test*—Brinell or Rockwell hardness tests shall be made on specimens from two pipes from each lot (see 13.2).

14. Hydrostatic or Nondestructive Electric Test

14.1 Each pipe 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.

14.2 The hydrostatic test shall be in accordance with Specification A 999/A 999M, except that the value for *S* to be used in the calculation of the hydrostatic test pressure shall be equal to 50 % of the specified minimum yield strength of the pipe.

14.3 *Nondestructive Electric Test:*

Nondestructive electric tests shall be in accordance with Practices E 213 or E 309.

14.3.1 As an alternative to the hydrostatic test, and when specified by the purchaser, each pipe shall be examined with a nondestructive test in accordance with Practices E 213 or E 309. Unless specifically called out by the purchaser, the selection of the nondestructive electric test will be at the option of the manufacturer. The range of pipe sizes that may be examined by each method shall be subject to the limitations in the scope of the respective practices.

14.3.1.1 The following information is for the benefit of the user of this specification:

14.3.1.2 The reference standards defined in 14.3.1.3–14.3.1.5 are convenient standards for calibration of nondestructive testing equipment. The dimensions of these standards should not be construed as the minimum size imperfection detectable by such equipment.

14.3.1.3 The ultrasonic testing (UT) can be performed to detect both longitudinally and circumferentially oriented defects. It should be recognized that different techniques should be employed to detect differently oriented imperfections. The examination may not detect short, deep, defects.

14.3.1.4 The eddy-current testing (ET) referenced in this specification (see Practice E 426) has the capability of detecting significant discontinuities, especially the short abrupt type.

14.3.1.5 A purchaser interested in ascertaining the nature (type, size, location, and orientation) of discontinuities that can be detected in the specific application of these examinations should discuss this with the manufacturer of the tubular product.

14.4 *Time of Examination*—Nondestructive testing for specification acceptance shall be performed after all mechanical processing, heat treatments, and straightening operations. This requirement does not preclude additional testing at earlier stages in the processing.

14.5 *Surface Condition:*

14.5.1 All surfaces shall be free of scale, dirt, grease, paint, or other foreign material that could interfere with interpretation of test results. The methods used for cleaning and preparing the surfaces for examination shall not be detrimental to the base metal or the surface finish.

14.5.2 Excessive surface roughness or deep scratches can produce signals that interfere with the test.

14.6 *Extent of Examination:*

14.6.1 The relative motion of the pipe and the transducer(s), coil(s), or sensor(s) shall be such that the entire pipe surface is scanned, except as in 14.6.2.

14.6.2 The existence of end effects is recognized and the extent of such effects shall be determined by the manufacturer and, if requested, shall be reported to the purchaser. Other nondestructive tests may be applied to the end areas, subject to agreement between the purchaser and the manufacturer.

14.7 *Operator Qualifications*—The test unit operator shall be certified in accordance with SNT-TC-1A, or an equivalent recognized and documented standard.

14.8 *Test Conditions:*

14.8.1 For eddy-current testing, the excitation coil frequency shall be chosen to ensure adequate penetration yet provide good signal-to-noise ratio.

14.8.2 The maximum eddy-current coil frequency used shall be as follows:

- On specified walls up to 0.050 in.—100 KHz max
- On specified walls up to 0.150 in.—50 KHz max
- On specified walls over 0.150 in.—10 KHz max

14.8.3 *Ultrasonic*—For examination by the ultrasonic method, the minimum nominal transducer frequency shall be 2.00 MHz and the maximum nominal transducer size shall be 1.5 in. If the equipment contains a reject notice filter setting, this shall remain off during calibration and testing unless linearity can be demonstrated at that setting.



A 790/A 790M – 05a

14.9 Reference Standards—Reference standards of convenient length shall be prepared from a length of pipe of the same grade, size (NPS, or outside diameter and schedule or wall thickness), surface finish and heat treatment condition as the pipe to be examined.

14.9.1 For Ultrasonic Testing, the reference ID and OD notches shall be any one of the three common notch shapes shown in Practice E 213, at the option of the manufacturer. The depth of each notch shall not exceed $12\frac{1}{2}\%$ of the specified nominal wall thickness of the pipe or 0.004 in., whichever is greater. The width of the notch shall not exceed twice the depth. Notches shall be placed on both the OD and ID surfaces.

14.9.2 For Eddy-Current Testing, the reference standard shall contain, at the option of the manufacturer, any one of the following discontinuities:

14.9.2.1 Drilled Hole—The reference standard shall contain three or more holes equally spaced circumferentially around the pipe and longitudinally separated by a sufficient distance to allow distinct identification of the signal from each hole. The holes shall be drilled radially and completely through the pipe wall, with care being taken to avoid distortion of the pipe while drilling. One hole shall be drilled in the weld, if visible. Alternately, the producer of welded pipe may choose to drill one hole in the weld and run the calibration standard through the test coils three times with the weld turned at 120° on each pass. The hole diameter shall vary with NPS as follows:

NPS Designator	Hole Diameter
	0.039 in. (1 mm)
above $\frac{1}{2}$ to $1\frac{1}{4}$	0.055 in. (1.4 mm)
above $1\frac{1}{4}$ to 2	0.071 in. (1.8 mm)
above 2 to 5	0.087 in. (2.2 mm)
above 5	0.106 in. (2.7 mm)

14.9.2.2 Transverse Tangential Notch—Using a round tool or file with a $\frac{1}{4}$ -in. (6.4-mm) diameter, a notch shall be filed or milled tangential to the surface and transverse to the longitudinal axis of the pipe. Said notch shall have a depth not exceeding $12\frac{1}{2}\%$ of the specified nominal wall thickness of the pipe or 0.004 in. (0.102 mm), whichever is greater.

14.9.2.3 Longitudinal Notch—A notch 0.031 in. or less in width shall be machined in a radial plane parallel to the tube axis on the outside surface of the pipe to have a depth not exceeding $12\frac{1}{2}\%$ of the specified wall thickness of the pipe or 0.004 in., whichever is greater. The length of the notch shall be compatible with the testing method.

More or smaller reference discontinuities, or both, may be used by agreement between the purchaser and the manufacturer.

14.10 Standardization Procedure:

14.10.1 The test apparatus shall be standardized at the beginning and end of each series of pipes of the same size (NPS or diameter and schedule or wall thickness, grade, and heat treatment condition), and at intervals not exceeding 4 h. More frequent standardization may be performed at the manufacturer's option or may be required upon agreement between the purchaser and the manufacturer.

14.10.2 The test apparatus shall also be standardized after any change in test system settings, change of operator, equipment repair, or interruption due to power loss, process shut-down, or when a problem is suspected.

14.10.3 The reference standard shall be passed through the test apparatus at the same speed and test system settings as the pipe to be tested.

14.10.4 The signal-to-noise ratio for the reference standard shall be $2\frac{1}{2}$ to 1 or greater. Extraneous signals caused by identifiable causes such as dings, scratches, dents, straightener marks, and so forth shall not be considered noise. The rejection amplitude shall be adjusted to be at least 50 % of full scale of the readout display.

14.10.5 If upon any standardization, the rejection amplitude has decreased by 29 % (3 dB) of peak height from the last standardization, the pipe since the last calibration shall be rejected. The test system settings may be changed or the transducer(s), coil(s), or sensor(s) adjusted and the unit restandardized. But all pipe tested since the last acceptable standardization must be retested for acceptance.

14.11 Evaluation of Imperfections:

14.11.1 Pipes producing a signal equal to or greater than the lowest signal produced by the reference standard(s) shall be identified and separated from the acceptable pipes. The area producing the signal may be reexamined.

14.11.2 Such pipes shall be rejected if the test signal was produced by imperfections that cannot be identified or was produced by cracks or crack-like imperfections. These pipes may be repaired per Sections 12 and 13. To be accepted, a repaired pipe must pass the same non-destructive test by which it was rejected, and it must meet the minimum wall thickness requirements of this specification.

14.11.3 If the test signals were produced by visual imperfections such as: (1) scratches, (2) surface roughness, (3) dings, (4) straightener marks, (5) cutting chips, (6) steel die stamps, (7) stop marks, or (8) pipe reducer ripple. The pipe may be accepted based on visual examination, provided the imperfection is less than 0.004 in. (0.1 mm) or $12\frac{1}{2}\%$ of the specified wall thickness (whichever is greater).

14.11.4 Rejected pipe may be reconditioned and retested providing the wall thickness is not decreased to less than that required by this or the product specification. The outside diameter at the point of grinding may be reduced by the amount so removed. To be accepted, retested pipe shall meet the test requirement.

14.11.5 If the imperfection is explored to the extent that it can be identified as non-rejectable, the pipe may be accepted without further test providing the imperfection does not encroach on the minimum wall thickness.

15. Repair by Welding

15.1 For welded pipe of size NPS 6 or larger with a specified wall thickness of 0.188 in. [4.8 mm] or more, weld repairs made with the addition of compatible filler metal may be made to the weld seam with the same procedures specified for plate defects in the section on Repair by Welding of Specification A 999/A 999M.

15.2 Weld repairs of the weld seam shall not exceed 20 % of the seam length.



A 790/A 790M – 05a

15.3 Except as allowed by 15.3.1, weld repairs shall be made only with the gas tungsten-arc welding process using the same classification of bare filler rod qualified to the most current AWS Specification A5.9 as the grade of pipe being repaired as given in Table 4.

15.3.1 Subject to approval by the purchaser, it shall be permissible for weld repairs to be made with the gas tungsten-arc welding process using a filler metal more highly alloyed than the base metal, if needed for corrosion resistance or other properties.

TABLE 4 Pipe and Filler Metal Specification

Pipe		Filler Metal
UNS Designation	AWS A5.9 Class	UNS Designation
S31803	ER2209	S39209
S32205	ER2209	S39209
S31200	ER2553	S39553

15.4 Pipes that have had weld seam repairs with filler metal shall be identified with the symbol “WR” and shall be so stated and identified on the certificate of tests. If filler metal other than that listed in Table 4 is used, the filler metal shall be identified on the certificate of tests.

15.5 Weld repairs shall be completed prior to any heat treatment.

16. Product Marking

16.1 In addition to the marking prescribed in Specification A 999/A 999M, the marking shall include the manufacturer's private identifying mark and whether the pipe is seamless or welded. If specified in the purchase order, the marking for pipe larger than NPS 4 shall include the weight.

17. Keywords

17.1 duplex stainless steel; ferritic/austenitic stainless steel; seamless steel pipe; stainless steel pipe; steel pipe; welded steel pipe

SUPPLEMENTARY REQUIREMENTS FOR PIPE REQUIRING SPECIAL CONSIDERATION

One or more of the following supplementary requirements shall apply only when specified in the purchase order. The purchaser may specify a different frequency of test or analysis than is provided in the supplementary requirement. Subject to agreement between the purchaser and manufacturer, retest and retreatment provisions of these supplementary requirements may also be modified.

S1. Product Analysis

S1.1 For all pipe over NPS 5 there shall be one product analysis made of a representative sample from one piece for each ten lengths or fraction thereof from each heat of steel.

S1.2 For pipe smaller than NPS 5 there shall be one product analysis made from ten lengths per heat of steel or from 10 % of the number of lengths per heat of steel, whichever number is smaller.

S1.3 Individual lengths failing to conform to the chemical requirements specified in Section 7 shall be rejected.

S2. Transverse Tension Tests

S2.1 There shall be one transverse tension test made from one end of 10 % of the lengths furnished per heat of steel. This applies only to pipe over NPS 8.

S2.2 If a specimen from any length fails to conform to the tensile properties specified that length shall be rejected.

S3. Flattening Test

S3.1 The flattening test of Specification A 999/A 999M shall be made on a specimen from one end or both ends of each pipe. Crops ends may be used. If this supplementary require-

ment is specified, the number of tests per pipe shall also be specified. If a specimen from any length fails because of lack of ductility prior to satisfactory completion of the first step of the flattening test requirement, that pipe shall be rejected subject to retreatment in accordance with Specification A 999/A 999M and satisfactory retest. If a specimen from any length of pipe fails because of a lack of soundness that length shall be rejected, unless subsequent retesting indicates that the remaining length is sound.

S4. Etching Tests

S4.1 The steel shall be homogeneous as shown by etching tests conducted in accordance with the appropriate portions of Method E 381. Etching tests shall be made on a cross section from one end or both ends of each pipe and shall show sound and reasonably uniform material free of injurious laminations, cracks, and similar objectionable defects. If this supplementary requirement is specified, the number of tests per pipe required shall also be specified. If a specimen from any length shows objectionable defects, the length shall be rejected, subject to removal of the defective end and subsequent retests indicating the remainder of the length to be sound and reasonably uniform material.



A 790/A 790M – 05a

APPENDIX

(Nonmandatory Information)

X1. Table X1.1 IS BASED ON TABLE 1 OF THE AMERICAN NATIONAL STANDARD FOR STAINLESS STEEL PIPE (ANSI B36.19-1965)

TABLE X1.1 Dimensions of Welded and Seamless Stainless Steel Pipe

NOTE 1—The decimal thickness listed for the respective pipe sizes represents their nominal or average wall dimensions.

NPS Designator	Outside Diameter		Nominal Wall Thickness							
	in.	mm	Schedule 5S ⁴		Schedule 10S ⁴		Schedule 40S		Schedule 80S	
			in.	mm	in.	mm	in.	mm	in.	mm
1/8	0.405	10.29	...	...	0.049 ^B	1.24	0.068	1.73	0.095	2.41
1/4	0.540	13.72	...	...	0.065 ^B	1.65	0.088	2.24	0.119	3.02
3/8	0.675	17.15	...	...	0.065 ^B	1.65	0.091	2.31	0.126	3.20
1/2	0.840	21.34	0.065 ^B	1.65	0.083 ^B	2.11	0.109	2.77	0.147	3.73
3/4	1.050	26.67	0.065 ^B	1.65	0.083 ^B	2.11	0.113	2.87	0.154	3.91
1.0	1.315	33.40	0.065 ^B	1.65	0.109 ^B	2.77	0.133	3.38	0.179	4.55
1 1/4	1.660	42.16	0.065 ^B	1.65	0.109 ^B	2.77	0.140	3.56	0.191	4.85
1 1/2	1.900	48.26	0.065 ^B	1.65	0.109 ^B	2.77	0.145	3.68	0.200	5.08
2	2.375	60.33	0.065 ^B	1.65	0.109 ^B	2.77	0.154	3.91	0.218	5.54
2 1/2	2.875	73.03	0.083	2.11	0.120 ^B	3.05	0.203	5.16	0.276	7.01
3	3.500	88.90	0.083	2.11	0.120 ^B	3.05	0.216	5.49	0.300	7.62
3 1/2	4.000	101.60	0.083	2.11	0.120 ^B	3.05	0.226	5.74	0.318	8.08
4	4.500	114.30	0.083	2.11	0.120 ^B	3.05	0.237	6.02	0.337	8.56
5	5.563	141.30	0.109 ^B	2.77	0.134 ^B	3.40	0.258	6.55	0.375	9.52
6	6.625	168.28	0.109	2.77	0.134 ^B	3.40	0.280	7.11	0.432	10.97
8	8.625	219.08	0.109 ^B	2.77	0.148 ^B	3.76	0.322	8.18	0.500	12.70
10	10.750	273.05	0.134 ^B	3.40	0.165 ^B	4.19	0.365	9.27	0.500 ^B	12.70 ^B
12	12.750	323.85	0.156 ^B	3.96	0.180 ^B	4.57	0.375 ^B	9.52 ^B	0.500 ^B	12.70 ^B
14	14.000	355.60	0.156 ^B	3.96	0.188	4.78	...	...	...	...
16	16.000	406.40	0.165 ^B	4.19	0.188	4.78	...	...	...	...
18	18.000	457.20	0.165 ^B	4.19	0.188	4.78	...	...	...	...
20	20.000	508.00	0.188 ^B	4.78	0.218 ^B	5.54	...	...	...	...
22	22.000	558.80	0.188 ^B	4.78	0.218 ^B	5.54	...	...	...	...
24	24.000	609.60	0.218 ^B	5.54	0.250	6.35	...	...	...	...
30	30.000	762.00	0.250	6.35	0.312	7.92	...	...	...	...

⁴ Schedules 5S and 10S wall thicknesses do not permit threading in accordance with the American National Standard for Pipe Threads (ANSI B1.20.1).^B These do not conform to the American National Standard for Welded and Seamless Wrought Steel Pipe (ANSI B36.10-1979).

SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this specification since the last issue, A 790/A 790M – 05, that may impact the use of this specification. (Approved June 1, 2005)

(1) Added new Grade S32808 to Tables 1-3.

(2) Editorially corrected Tables 1-3.

Committee A01 has identified the location of selected changes to this specification since the last issue, A 790/A 790M – 04a, that may impact the use of this specification. (Approved March 1, 2005)

(1) Added stainless steel 32101 to Tables 1-3.

Committee A01 has identified the location of selected changes to this specification since the last issue, A 790/A 790M – 04, that may impact the use of this specification. (Approved June 1, 2004)

(1) Revised Table 3 to remove the maximum tensile strength value for grade S32760.

(2) Revised quenching requirement for S31260 in Table 1.

(3) Section 15 and Table 4 were added to cover weld seam repair by welding with addition of filler metal.

Send your requirement

Send a drawing, product list, size, material grade, standard, schedule or wall thickness, testing and project document requirements.

EMAILinfo@lkiping.com**WHATSAPP**[+86 139 0327 9556](https://wa.me/8613903279556)**TECHNICAL RESOURCES**www.lkiping.com/technical/

RESPONSE AND DOCUMENT COORDINATION

Initial enquiries are answered within 24 hours, including weekends, by email or WhatsApp. Drawing review, material/standard matching and project document requirements can be discussed and organized with the buyer. Third-party inspection can be buyer-nominated or coordinated on request.

ADDRESS

Longtan Industrial Zone, Yanta Road, Yanshan County, Cangzhou City,
Hebei Province, China