



Standard Specification for Seamless Carbon Steel Pipe for High-Temperature Service¹

This standard is issued under the fixed designation A106/A106M; 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 carbon steel pipe for high-temperature service (**Note 1**) in NPS $\frac{1}{8}$ to NPS 48 [DN 6 to DN 1200] (**Note 2**) inclusive, with nominal (average) wall thickness as given in ASME B 36.10M. It shall be permissible to furnish pipe having other dimensions provided such pipe complies with all other requirements of this specification. Pipe ordered under this specification shall be suitable for bending, flanging, and similar forming operations, and for welding. When the steel is to be welded, it is presupposed that a welding procedure suitable to the grade of steel and intended use or service will be utilized.

NOTE 1—It is suggested, consideration be given to possible graphitization.

NOTE 2—The dimensionless designator NPS (nominal pipe size) [DN (diameter nominal)] has been substituted in this standard for such traditional terms as “nominal diameter,” “size,” and “nominal size.”

1.2 Supplementary requirements of an optional nature are provided for seamless pipe intended for use in applications where a superior grade of pipe is required. These supplementary requirements call for additional tests to be made and when desired shall be so stated in the order.

1.3 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.4 The following precautionary caveat pertains only to the test method portion, Sections 11, 12, and 13 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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

¹ This specification is under the jurisdiction of Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.09 on Carbon Steel Tubular Products.

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² For ASME Boiler and Pressure Vessel Code applications see related Specifications SA-106 in Section II of that Code.

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:³

A530/A530M Specification for General Requirements for Specialized Carbon and Alloy Steel Pipe

E213 Practice for Ultrasonic Testing of Metal Pipe and Tubing

E309 Practice for Eddy Current Examination of Steel Tubular Products

E381 Method of Macroetch Testing Steel Bars, Billets, Blooms, and Forgings

E570 Practice for Flux Leakage Examination of Ferromagnetic Steel Tubular Products

2.2 ASME Standard:

ASME B 36.10M Welded and Seamless Wrought Steel Pipe⁴

2.3 Military Standards:

MIL-STD-129 Marking for Shipment and Storage⁵

MIL-STD-163 Steel Mill Products, Preparation for Shipment and Storage⁵

2.4 Federal Standard:

Fed. Std. No. 123 Marking for Shipments (Civil Agencies)⁵

Fed. Std. No. 183 Continuous Identification Marking of Iron and Steel Products⁵

2.5 Other Standards:

SSPC-SP 6 Surface Preparation Specification No. 6⁶

³ For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at www.astm.org/contact. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

⁵ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098.

⁶ Available from Society for Protective Coatings (SSPC), 40 24th St., 6th Floor, Pittsburgh, PA 15222-4656, <http://www.sspc.org>.

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



3. Ordering Information

3.1 The inclusion of the following, as required will describe the desired material adequately, when ordered under this specification:

- 3.1.1 Quantity (feet, metres, or number of lengths),
- 3.1.2 Name of material (seamless carbon steel pipe),
- 3.1.3 Grade (Table 1),
- 3.1.4 Manufacture (hot-finished or cold-drawn),
- 3.1.5 Size (NPS [DN] and weight class or schedule number, or both; outside diameter and nominal wall thickness; or inside diameter and nominal wall thickness),
- 3.1.6 Special outside diameter tolerance pipe (16.2.2),
- 3.1.7 Inside diameter tolerance pipe, over 10 in. [250 mm] ID (16.2.3),
- 3.1.8 Length (specific or random, Section 17),
- 3.1.9 Optional requirements (S1 to S9),
- 3.1.10 Test report required (Section on Certification of Specification A530/A530M),
- 3.1.11 Specification designation (A106 or A106M, including year-date),
- 3.1.12 End use of material,
- 3.1.13 Hydrostatic test in accordance with Specification A530/A530M or 13.3 of this specification, or NDE in accordance with Section 14 of this specification.
- 3.1.14 Special requirements.

4. Process

4.1 The steel shall be killed steel, with the primary melting process being open-hearth, basic-oxygen, or electric-furnace, possibly combined with separate degassing or refining. If secondary melting, using electroslag remelting or vacuum-arc remelting is subsequently employed, the heat shall be defined as all of the ingots remelted from a single primary heat.

4.2 Steel cast in ingots or strand cast is permissible. When steels of different grades are sequentially strand cast, identification of the resultant transition material is required. The producer shall remove the transition material by any established procedure that positively separates the grades.

TABLE 1 Chemical Requirements

	Composition, %		
	Grade A	Grade B	Grade C
Carbon, max	0.25 ^A	0.30 ^B	0.35 ^B
Manganese	0.27–0.93	0.29–1.06	0.29–1.06
Phosphorus, max	0.035	0.035	0.035
Sulfur, max	0.035	0.035	0.035
Silicon, min	0.10	0.10	0.10
Chromium, max ^C	0.40	0.40	0.40
Copper, max ^C	0.40	0.40	0.40
Molybdenum, max ^C	0.15	0.15	0.15
Nickel, max ^C	0.40	0.40	0.40
Vanadium, max ^C	0.08	0.08	0.08

^A For each reduction of 0.01 % below the specified carbon maximum, an increase of 0.06 % manganese above the specified maximum will be permitted up to a maximum of 1.35 %.

^B Unless otherwise specified by the purchaser, for each reduction of 0.01 % below the specified carbon maximum, an increase of 0.06 % manganese above the specified maximum will be permitted up to a maximum of 1.65 %.

^C These five elements combined shall not exceed 1 %.

4.3 For pipe NPS 1½ [DN 40] and under, it shall be permissible to furnish hot finished or cold drawn.

4.4 Unless otherwise specified, pipe NPS 2 [DN 50] and over shall be furnished hot finished. When agreed upon between the manufacturer and the purchaser, it is permissible to furnish cold-drawn pipe.

5. Heat Treatment

5.1 Hot-finished pipe need not be heat treated. When hot-finished pipe is heat treated, it shall be heat treated at a temperature of 1200 °F [650 °C] or higher.

5.2 Cold-drawn pipe shall be heat treated after the final cold draw pass at a temperature of 1200 °F [650 °C] or higher.

6. General Requirements

6.1 Material furnished to this specification shall conform to the applicable requirements of the current edition of Specification A530/A530M unless otherwise provided herein.

7. Chemical Composition

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

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 in Section 7. If the secondary melting processes of 5.1 are employed, the heat analysis shall be obtained from one remelted ingot or the product of one remelted ingot of each primary melt. The chemical composition thus determined, or that determined from a product analysis made by the manufacturer, if the latter has not manufactured the steel, shall be reported to the purchaser or the purchaser's representative, and shall conform to the requirements specified in Section 7.

9. Product Analysis

9.1 At the request of the purchaser, analyses of two pipes from each lot (see 20.1) shall be made by the manufacturer from the finished pipe. 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.

9.2 If the analysis of one of the tests specified in 9.1 does not conform to the requirements specified in Section 7, analyses shall be made on additional pipes of double the original number from the same lot, each of which shall conform to requirements specified.

10. Tensile Requirements

10.1 The material shall conform to the requirements as to tensile properties given in Table 2.

11. Bending Requirements

11.1 For pipe NPS 2 [DN 50] and under, a sufficient length of pipe shall stand being bent cold through 90° around a cylindrical mandrel, the diameter of which is twelve times the outside diameter (as shown in ASME B 36.10M) of the pipe,