



Designation: A178/A178M – 25

Standard Specification for Electric-Resistance-Welded Carbon Steel and Carbon- Manganese Steel Boiler and Superheater Tubes¹

This standard is issued under the fixed designation A178/A178M; 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 U.S. Department of Defense.

1. Scope*

1.1 This specification² covers minimum-wall-thickness, electric-resistance-welded tubes made of carbon steel and carbon-manganese steel intended for use as boiler tubes, boiler flues, superheater flues, and safe ends.

1.2 This specification covers Grades A, C, and D with differing chemical requirements (Section 7 and Table 1), differing tensile requirements (Section 8 and Table 2), and differing mechanical testing requirements (Section 8).

NOTE 1—Grades C and D tubes are not suitable for safe-ending for forge welding.

1.3 The tubing sizes and thicknesses usually furnished to this specification are ½ to 5 in. [12.7 to 127 mm] in outside diameter and 0.035 to 0.360 in. [0.9 to 9.1 mm], inclusive, in minimum wall thickness. Tubing having other dimensions may be furnished, provided such tubes comply with all other requirements of this specification.

1.4 Mechanical property requirements do not apply to tubing smaller than ⅛ in. [3.2 mm] in inside diameter or 0.015 in. [0.4 mm] in thickness.

1.5 Optional supplementary requirements are provided and when desired, shall be so stated in the order.

1.6 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 A01.09 on Carbon Steel Tubular Products.

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-178 in Section II of that Code.

1.7 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

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

A450/A450M Specification for General Requirements for Carbon and Low Alloy Steel Tubes

A751 Test Methods and Practices for Chemical Analysis of Steel Products

A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys

A1058 Test Methods for Mechanical Testing of Steel Products—Metric

E213 Practice for Ultrasonic Testing of Metal Pipe and Tubing

E273 Practice for Ultrasonic Testing of the Weld Zone of Welded Pipe and Tubing

3. Terminology

3.1 *Definition of Terms*—For definition of terms used in this standard that are not included in 3.2, refer to:

3.1.1 Terminology A941 for general steel terminology.

3.1.2 Test Methods and Definitions A370 and Test Methods A1058 for mechanical testing of steel products terminology.

3.1.3 Test Methods and Practices A751 for chemical analysis of steel products terminology.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *ductility, n*—the ability of a material to be plastically deformed without fracture.

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.

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



TABLE 1 Chemical Requirements

Element	Composition, %		
	Grade A, Low-Carbon Steel	Grade C, Medium-Carbon Steel	Grade D, Carbon-Manganese Steel
Carbon	0.06–0.18	0.35 max	0.27 max
Manganese	0.27–0.63	0.80 max	1.00–1.50
Phosphorus, max	0.035	0.035	0.030
Sulfur, max	0.035	0.035	0.015
Silicon	...	...	0.10 min

TABLE 2 Tensile Requirements

	Grade C	Grade D
Tensile strength, min, ksi [MPa]	60 [415]	70 [485]
Yield strength, min, ksi [MPa]	37 [255]	40 [275]
Elongation in 2 in. or 50 mm, min, %	30	30
For longitudinal strip tests a deduction for each 1/32-in. [0.8 mm] decrease in wall thickness below 5/16 in. [8 mm] from the basic minimum elongation of the following percentage points shall be made.	1.50 ^A	1.50 ^A

^A See Table 3 for the computed minimum values.

4. Ordering Information

4.1 It shall be the responsibility of the purchaser to specify all requirements that are necessary for products under this specification. Such requirements to be considered include, but may not be limited to, the following:

- 4.1.1 Quantity (feet, metres, or number of lengths),
- 4.1.2 Name of material (electric-resistance-welded tubes),
- 4.1.3 ASTM Designation and Year of Issue (A178/A178M – year of issue),
- 4.1.4 Grade (A, C, or D, see Table 1),
- 4.1.5 Size (outside diameter and minimum wall thickness),
- 4.1.6 Length (specific or random),
- 4.1.7 Optional requirements (product analysis, 7.2; crush test, 8.2.5; hydrostatic or nondestructive electric test, 9.1),
- 4.1.8 Test report required (Certification Section of Specification A450/A450M),
- 4.1.9 Individual supplementary requirements, if required, and
- 4.1.10 Special requirements.

5. General Requirements

5.1 Product furnished to this specification shall conform to the requirements of Specification A450/A450M, including any supplementary requirements indicated in the purchase order or contract. Failure to comply with the general requirements of Specification A450/A450M constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A450/A450M, this specification shall prevail.

6. Materials and Manufacture

6.1 Materials:

- 6.1.1 The steel may be made by any process.
- 6.1.2 The steel for Grade D shall be killed.

6.2 *Manufacture*—Tubes shall be made by the electric-resistance-welding process.

6.3 *Heat Treatment*—After welding, all tubes shall be heat treated at a temperature of 1650°F [900°C] or higher and followed by cooling in air or in the cooling chamber of a controlled-atmosphere furnace. Cold-drawn tubes shall be heat treated after the final cold-draw pass at a temperature of 1200°F [650°C] or higher.

7. Chemical Composition

7.1 Chemical Requirements:

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

7.1.2 When a grade is ordered under this specification, supplying an alloy grade that specifically requires the addition of any element other than those listed in Table 1 is not permitted.

7.2 Product Analysis:

7.2.1 Methods and practices relating to chemical analysis shall be in accordance with Test Methods and Practices A751.

7.2.2 When requested on the purchase order, a product analysis shall be made by the manufacturer or supplier from one tube per 100 pieces for sizes over 3 in. [76.2 mm] and one tube per 250 pieces for sizes 3 in. [76.2 mm] and under; or when tubes are identified by heat, one tube per heat shall be analyzed. The chemical composition thus determined shall conform to the requirements specified.

7.2.3 If the original test for product analysis fails, retests of two additional 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 2) shall be rejected or, at the option of the producer, each length of flat-rolled stock or tube may be individually tested for acceptance. Lengths of flat-rolled stock or tubes which do not meet the requirements of the specifications shall be rejected.

NOTE 2—A lot consists of 250 tubes for sizes 3 in. [76.2 mm] and under and of 100 tubes for sizes over 3 in. [76.2 mm], prior to cutting to length.

8. Mechanical Properties

8.1 Tension Test:

8.1.1 Grade A tubes do not have tensile property requirements. See Note 3.

8.1.2 Grade C and D tubes shall conform to tensile properties prescribed in Table 2.

NOTE 3—*Explanatory Note*—For purposes of design the following tensile properties may be assumed for Grade A tubes:

Tensile strength, min, ksi [MPa]	47 [325]
Yield Strength, min, ksi [MPa]	26 [180]
Elongation in 2 in. or 50 mm, min, %	35

8.1.3 Table 3 gives the computed minimum elongation 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:

$$E = 48t + 15.00 [E = 1.87t + 15.00]$$

where: