



Designation: A214/A214M – 25

Standard Specification for Electric-Resistance-Welded Carbon Steel Heat-Exchanger and Condenser Tubes¹

This standard is issued under the fixed designation A214/A214M; 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, carbon steel tubes to be used for heat exchangers, condensers, and similar heat-transfer apparatus.

1.2 The tubing sizes usually furnished to this specification are up to 3 in. [76.2 mm] in outside diameter, inclusive. Tubing having other dimensions may be furnished, provided such tubes comply with all other requirements of this specification.

1.3 Mechanical property requirements do not apply to tubing smaller than $\frac{1}{8}$ in. [3.2 mm] in inside diameter or 0.015 in. [0.4 mm] in thickness.

1.4 The purchaser shall specify in the order the outside diameter and minimum wall thickness. The inside diameter shall not be specified.

1.5 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.

1.6 *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.*

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-214 in Section II of that Code.

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

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

3. Terminology

3.1 The definitions of terms given in Test Methods and Definitions A370, Specification A450/A450M, and Terminology A941 are applicable to this specification.

4. Ordering Information

4.1 It shall be the responsibility of the purchaser to specify all requirements that are necessary for product 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 (A214/A214M – year of issue),

4.1.4 Size (outside diameter and minimum wall thickness),

4.1.5 Length (specific or random),

4.1.6 Optional requirements (Section 9 and 11.1),

4.1.7 Test report required (see Certification Section of Specification A450/A450M), and

4.1.8 Special requirements.

5. General Requirements

5.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification A450/A450M, unless otherwise provided herein.

6. Manufacture

6.1 Tubes shall be made by electric-resistance welding.

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