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.

Designation: A249/A249M – 24

Used in USDOE-NE Standards

Standard Specification for Welded Austenitic Steel Boiler, Superheater, Heat-Exchanger, and Condenser Tubes[1]

This standard is issued under the fixed designation A249/A249M; 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 specification[2] covers nominal-wall-thickness welded tubes and heavily cold worked welded tubes made from the austenitic steels listed in Table 1, with various grades intended for such use as boiler, superheater, heat exchanger, or condenser tubes.

1.2 Grades TP304H, TP309H, TP309HCb, TP310H, TP310HCb, TP316H, TP321H, TP347H, and TP348H are modifications of Grades TP304, TP309S, TP309Cb, TP310S, TP310Cb, TP316, TP321, TP347, and TP348, and are intended for high-temperature service such as for superheaters and reheaters.

1.3 The tubing sizes and thicknesses usually furnished to this specification are ⅛ in. [3.2 mm] in inside diameter to 12 in. [304.8 mm] in outside diameter and 0.015 to 0.320 in. [0.4 to 8.1 mm], inclusive, in 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 one or more of these are desired, each 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 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. The inch-pound units shall apply unless the "M" designation of this specification is specified in the order.

1.7 The following safety hazards caveat pertains only to the test method described in the Supplementary Requirements 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.* A specific warning statement is given in Supplementary Requirement S7, Note S7.1.

1.8 *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]

A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels

A480/A480M Specification for General Requirements for Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet, and Strip

A1016/A1016M Specification for General Requirements for Ferritic Alloy Steel, Austenitic Alloy Steel, and Stainless Steel Tubes

E112 Test Methods for Determining Average Grain Size

E213 Practice for Ultrasonic Testing of Metal Pipe and Tubing

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

E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

[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.

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[2] For ASME Boiler and Pressure Vessel Code applications see related Specification SA-249 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 Summary of Changes section appears at the end of this standard**

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TABLE 1 Chemical Requirements, %[A]

Grade	UNS Designation[B]	Composition, %										
		Carbon	Manganese	Phosphorous	Sulfur	Silicon	Chromium	Nickel	Molybdenum	Nitrogen[C]	Copper	Other
TP 201	S20100	0.15	5.50–7.5	0.060	0.030	1.00	16.0–18.0	3.5–5.5	...	0.25	...	...
TP 201LN	S20153	0.03	6.4–7.5	0.045	0.015	0.75	16.0–17.5	4.0–5.0	...	0.10–0.25	1.00	...
TP 202	S20200	0.15	7.5–10.0	0.060	0.030	1.00	17.0–19.0	4.0–6.0	...	0.25	...	...
TPXM-19	S20910	0.06	4.0–6.0	0.045	0.030	1.00	20.5–23.5	11.5–13.5	1.50–3.00	0.20–0.40	...	Nb[G] 0.10–0.30 V 0.10–0.30
TPXM-29	S24000	0.08	11.5–14.5	0.060	0.030	1.00	17.0–19.0	2.3–3.7	...	0.20–0.40	...	...
TP304	S30400	0.08	2.00	0.045	0.030	1.00	18.0–20.0	8.0–11.0	...	...	...	...
TP304L[D]	S30403	0.030	2.00	0.045	0.030	1.00	18.0–20.0	8.0–12.0	...	...	...	...
TP304H	S30409	0.04–0.10	2.00	0.045	0.030	1.00	18.0–20.0	8.0–11.0	...	...	...	...
...	S30415	0.04–0.06	0.80	0.045	0.030	1.00–2.00	18.0–19.0	9.0–10.	...	0.12–0.18	...	Ce 0.03–0.08
...	S30416	0.03	2.00	0.045	0.015	0.80–2.00	17.5–19.5	9.0–11.0	0.40–0.80	0.10	...	...
TP304N	S30451	0.08	2.00	0.045	0.030	1.00	18.0–20.0	8.0–11.0	...	0.10–0.16	...	...
TP304LN[D]	S30453	0.030	2.00	0.045	0.030	1.00	18.0–20.0	8.0–11.0	...	0.10–0.16	...	...
TP305	S30500	0.12	2.00	0.045	0.030	1.00	17.0–19.0	11.0–13.0	...	...	...	...
...	S30615	0.16–0.24	2.00	0.030	0.030	3.2–4.0	17.0–19.5	13.5–16.0	...	...	...	...
...	S30815	0.05–0.10	0.80	0.040	0.030	1.40–2.00	20.0–22.0	10.0–12.0	...	0.14–0.20	...	Ce 0.03–0.08
TP309S	S30908	0.08	2.00	0.045	0.030	1.00	22.0–24.0	12.0–15.0	...	...	...	...
TP309H	S30909	0.04–0.10	2.00	0.045	0.030	1.00	22.0–24.0	12.0–15.0	...	...	...	...

Grade	UNS Designation[B]	Composition, %										
		Carbon	Manganese	Phosphorous	Sulfur	Silicon	Chromium	Nickel	Molybdenum	Nitrogen[C]	Copper	Other
...	S30601	0.015	0.50–0.80	0.030	0.013	5.0–5.6	17.0–18.0	17.0–18.0	0.20	0.05	0.35	...
TP309Cb	S30940	0.08	2.00	0.045	0.030	1.00	22.0–24.0	12.0–16.0	...	...	...	Nb 10x C-1.10
TP309HCb	S30941	0.04–0.10	2.00	0.045	0.030	1.00	22.0–24.0	12.0–16.0	...	...	...	Nb 10x C-1.10
TP310S	S31008	0.08	2.00	0.045	0.030	1.00	24.0–26.0	19.0–22.0	...	...	...	...
TP310H	S31009	0.04–0.10	2.00	0.045	0.030	1.00	24.0–26.0	19.0–22.0	...	...	...	...
TP310Cb	S31040	0.08	2.00	0.045	0.030	1.00	24.0–26.0	18.0–22.0	...	...	...	Nb 10x C-1.10
TP310HCb	S31041	0.04–0.10	2.00	0.045	0.030	1.00	24.0–26.0	19.0–22.0	...	...	...	Nb 10x C-1.10
...	S31050	0.030	2.00	0.030	0.015	0.40	24.0–26.0	21.0–23.0	2.00–3.00	0.10–0.16	...	...
...	S31254	0.020	1.00	0.030	0.010	0.80	19.5–20.5	17.5–18.5	6.0–6.5	0.18–0.25	0.50–1.00	...
...	S31266	0.030	2.00–4.00	0.035	0.020	1.00	23.0–25.0	21.0–24.0	5.2–6.2	0.35–0.60	1.00–2.50	W 1.50–2.50
...	S31277	0.020	3.00	0.030	0.010	0.50	20.5–23.0	26.0–28.0	6.5–8.0	0.30–0.40	0.50–1.50	...
TP316	S31600	0.08	2.00	0.045	0.030	1.00	16.0–18.0	10.0–14.0	2.00–3.00	...	...	...
TP316L[D]	S31603	0.030	2.00	0.045	0.030	1.00	16.0–18.0	10.0–14.0	2.00–3.00	...	...	...
TP316H	S31609	0.04–0.10	2.00	0.045	0.030	1.00	16.0–18.0	10.0–14.0	2.00–3.00	...	...	...
TP316N	S31651	0.08	2.00	0.045	0.030	1.00	16.0–18.0	10.0–13.0	2.00–3.00	0.10–0.16	...	...
TP316LN[D]	S31653	0.030	2.00	0.045	0.030	1.00	16.0–18.0	10.0–13.0	2.00–3.00	0.10–0.16	...	...
	S31655	0.030	2.00	0.045	0.015	1.00	19.5–21.5	8.0–9.5	0.50–1.50	0.14–0.25	1.00	...
TP317	S31700	0.08	2.00	0.045	0.030	1.00	18.0–20.0	11.0–15.0	3.0–4.0	...	...	...
TP317L	S31703	0.030	2.00	0.045	0.030	1.00	18.0–20.0	11.0–15.0	3.0–4.0	...	...	...

Grade	UNS Designation[B]	Composition, %										
		Carbon	Manganese	Phosphorous	Sulfur	Silicon	Chromium	Nickel	Molybdenum	Nitrogen[C]	Copper	Other
...	S31725	0.030	2.00	0.045	0.030	1.00	18.0–20.0	13.5–17.5	4.0–5.0	0.20	...	...