



Designation: A334/A334M – 04a (Reapproved 2021)

Standard Specification for Seamless and Welded Carbon and Alloy-Steel Tubes for Low-Temperature Service¹

This standard is issued under the fixed designation A334/A334M; 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 several grades of minimum-wall-thickness, seamless and welded, carbon and alloy-steel tubes intended for use at low temperatures. Some product sizes may not be available under this specification because heavier wall thicknesses have an adverse affect on low-temperature impact properties.

1.2 Supplementary Requirement S1 of an optional nature is provided. This shall apply only when specified by the purchaser.

NOTE 1—For tubing smaller than $\frac{1}{2}$ in. [12.7 mm] in outside diameter, the elongation values given for strip specimens in Table 1 shall apply. Mechanical property requirements do not apply to tubing smaller than $\frac{1}{8}$ in. [3.2 mm] in outside diameter and with a wall thickness under 0.015 in. [0.4 mm].

1.3 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.

1.4 *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.*

1.5 *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.*

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 Sept. 1, 2021. Published October 2021. Originally approved in 1951. Last previous edition approved in 2016 as A334/A334M – 04a (2016). DOI: 10.1520/A0334_A0334M-04AR21.

² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-334 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

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

E23 Test Methods for Notched Bar Impact Testing of Metallic Materials

3. Ordering Information

3.1 Orders for material under this specification should include the following, as required to describe the desired material adequately:

- 3.1.1 Quantity (feet, metres, or number of lengths),
- 3.1.2 Name of material (seamless or welded tubes),
- 3.1.3 Grade (Table 1),
- 3.1.4 Size (outside diameter and minimum wall thickness),
- 3.1.5 Length (specific or random),
- 3.1.6 Optional requirements (other temperatures, Section 14; hydrostatic or electric test, Section 16),
- 3.1.7 Test report required, (Certification Section of Specification A1016/A1016M),
- 3.1.8 Specification designation, and
- 3.1.9 Special requirements and any supplementary requirements selected.

4. General Requirements

4.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification A1016/A1016M, unless otherwise provided herein.

5. Materials and Manufacture

5.1 The tubes shall be made by the seamless or automatic welding process with no addition of filler metal in the welding operation.

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.

TABLE 1 Chemical Requirements

Element	Composition, %						
	Grade 1 ^A	Grade 3	Grade 6 ^A	Grade 7	Grade 8	Grade 9	Grade 11
Carbon, max	0.30	0.19	0.30	0.19	0.13	0.20	0.10
Manganese	0.40–1.06	0.31–0.64	0.29–1.06	0.90 max	0.90 max	0.40–1.06	0.60 max
Phosphorus, max	0.025	0.025	0.025	0.025	0.025	0.025	0.025
Sulfur, max	0.025	0.025	0.025	0.025	0.025	0.025	0.025
Silicon	...	0.18–0.37	0.10 min	0.13–0.32	0.13–0.32	...	0.35 max
Nickel	...	3.18–3.82	...	2.03–2.57	8.40–9.60	1.60–2.24	35.0–37.0
Chromium	...	...	...	...	...	...	0.50 max
Copper	...	...	...	...	...	0.75–1.25	...
Cobalt	...	...	...	...	...	...	0.50 max
Molybdenum	...	...	...	...	...	...	0.50 max

^AFor each reduction of 0.01 % carbon below 0.30 %, an increase of 0.05 % manganese above 1.06 % will be permitted to a maximum of 1.35 % manganese.

6. Heat Treatment

6.1 All seamless and welded tubes, other than Grades 8 and 11, shall be treated to control their microstructure in accordance with one of the following methods:

6.1.1 Normalize by heating to a uniform temperature of not less than 1550 °F [845 °C] and cool in air or in the cooling chamber of an atmosphere controlled furnace.

6.1.2 Normalize as in 10.1.1, and, at the discretion of the manufacturer, reheat to a suitable tempering temperature.

6.1.3 For the seamless process only, reheat and control hot working and the temperature of the hot-finishing operation to a finishing temperature range from 1550 to 1750 °F [845 to 955 °C] and cool in a controlled atmosphere furnace from an initial temperature of not less than 1550 °F [845 °C].

6.1.4 Treat as in 6.1.3 and, at the discretion of the manufacturer, reheat to a suitable tempering temperature.

6.2 Grade 8 tubes shall be heat treated by the manufacturer by either of the following methods.

6.2.1 *Quenched and Tempered*—Heat to a uniform temperature of 1475 ± 25 °F [800 ± 15 °C]; hold at this temperature for a minimum time in the ratio of 1 h/in. [2 min/mm] of thickness, but in no case less than 15 min; quench by immersion in circulating water. Reheat until the pipe attains a uniform temperature within the range from 1050 to 1125 °F [565 to 605 °C]; hold at this temperature for a minimum time in the ratio of 1 h/in. [2 min/mm] of thickness, but in no case less than 15 min; cool in air or water quench at a rate no less than 300 °F [165 °C]/h.

6.2.2 *Double Normalized and Tempered*—Heat to a uniform temperature of 1650 ± 25 °F [900 ± 15 °C]; hold at this temperature for a minimum time in the ratio of 1 h/in. [2 min/mm] of thickness, but in no case less than 15 min; cool in air. Reheat until the pipe attains a uniform temperature of 1450 ± 25 °F [790 ± 15 °C]; hold at this temperature for a minimum time in the ratio of 1 h/in. [2 min/mm] of thickness, but in no case less than 15 min; cool in air. Reheat to a uniform temperature within the range from 1050 to 1125 °F [565 to 605 °C]; hold at this temperature for a minimum time of 1 h/in. [2 min/mm] of thickness but in no case less than 15 min; cool in air or water quench at a rate not less than 300 °F [165 °C]/h.

6.3 Material from which impact specimens are obtained shall be in the same condition of heat treatment as the finished tubes.

6.4 Whether to anneal Grade 11 tubes is per agreement between purchaser and supplier. When Grade 11 tubes are annealed they shall be normalized in the range of 1400 to 1600 °F [760 to 870 °C].

7. Chemical Composition

7.1 The steel shall conform to the requirements as to chemical composition prescribed in [Table 1](#).

7.2 When Grades 1 or 6 are ordered under this specification, supplying an alloy grade that specifically requires the addition of any element other than those listed for the ordered grade in [Table 1](#) is not permitted. However, the addition of elements required for the deoxidation of the steel is permitted.

8. Product Analysis

8.1 An analysis of either one billet or one length of flat-rolled stock or one tube shall be made for each heat. The chemical composition thus determined shall conform to the requirements specified.

8.2 If the original test for product analysis fails, retests of two additional billets, 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 shall be rejected or, at the option of the manufacturer, each billet, length of flat-rolled stock, or tube may be individually tested for acceptance. Billets, lengths of flat-rolled stock, or tubes which do not meet the requirements of the specification shall be rejected.

9. Sampling

9.1 For flattening, flare, and flange requirements, the term *lot* applies to all tubes prior to cutting of the same nominal size and wall thickness which are produced from the same heat of steel. When final heat treatment is in a batch-type furnace, a lot shall include only those tubes of the same size and from the same heat which are heat treated in the same furnace charge. When the final heat treatment is in a continuous furnace, the number of tubes of the same size and from the same heat in a lot shall be determined from the size of the tubes as prescribed in [Table 2](#).

9.2 For tensile and hardness test requirements, the term *lot* applies to all tubes prior to cutting, of the same nominal