



Designation: A420/A420M – 25a

Standard Specification for Piping Fittings of Wrought Carbon Steel and Alloy Steel for Low-Temperature Service¹

This standard is issued under the fixed designation A420/A420M; 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 wrought carbon steel and alloy steel fittings of seamless and welded construction, covered by the latest revision of ASME B16.9, ASME B16.11, MSS SP-79, MSS SP-83, MSS SP-95, and MSS SP-97. Fittings differing from these ASME and MSS standards shall be furnished in accordance with Supplementary Requirement S58 of Specification A960/A960M. These fittings are for use in pressure piping and pressure vessel service at low temperatures.

1.2 Optional supplementary requirements are provided for fittings where a greater degree of examination is desired. When desired, one or more of these supplementary requirements shall be specified in the order.

1.3 This specification is expressed in both inch-pound units and in SI units. However, unless the order specifies the applicable “M” specification designation (SI units), the material shall be furnished to inch-pound units.

1.4 The values stated in either SI units or inch-pound 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.

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 A01.22 on Steel Forgings and Wrought Fittings for Piping Applications and Bolting Materials for Piping and Special Purpose Applications.

Current edition approved Nov. 1, 2025. Published November 2025. Originally approved in 1958. Last previous edition approved in 2025 as A420/A420M – 25. DOI: 10.1520/A0420_A0420M-25A.

² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-420 in Section II of that Code.

2. Referenced Documents

2.1 In addition to those Referenced Documents listed in Specification A960/A960M, the following list of standards apply to this specification.

2.2 ASTM Standards:³

A350/A350M Specification for Carbon and Low-Alloy Steel Forgings, Requiring Notch Toughness Testing for Piping Components

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

A960/A960M Specification for Common Requirements for Wrought Steel Piping Fittings

A1058 Test Methods for Mechanical Testing of Steel Products—Metric

2.3 ASME Standards:

B16.9 Factory-Made Wrought Steel Butt-Welding Fittings⁴

B16.11 Forged Steel Fittings, Socket-Welding Threaded⁴

2.4 ASME Boiler and Pressure Vessel Code:⁴

Section III

Section VIII Division 1, Pressure Vessels⁴

Section IX

2.5 MSS Standards:

MSS SP-25 Standard Marking System for Valves, Fittings, Flanges, and Unions⁵

MSS SP-79 Socket Welding Reducer Inserts⁵

MSS SP-83 Steel Pipe Unions, Socket-Welding and Threaded⁵

MSS SP-95 Swage(d) Nipples and Bull Plugs⁵

MSS SP-97 Integrally Reinforced Forged Branch Outlet Fittings—Socket Welding, Threaded and Buttwelding Ends

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 Manufacturers Standardization Society of the Valve and Fittings Industry (MSS), 127 Park St., NE, Vienna, VA 22180-4602, <http://www.mss-hq.com>.

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



TABLE 1 Chemical Requirements

NOTE 1—All requirements are maximum unless otherwise indicated.

NOTE 2—Where an ellipsis (...) appears in this table, there is no requirement.

Grade ^A	Composition, %										
	C	Mn	P	S	Si	Ni	Cr	Mo	Cu	Nb ^E	V
WPL6	0.30	0.50–1.45	0.035	0.040	0.15–0.40	0.40	0.30	0.12	0.40	0.02 ^B	0.08
WPL9	0.20	0.40–1.06	0.030	0.030	...	1.60–2.24			0.75–1.25		
WPL3 ^C	0.20	0.31–0.64	0.05	0.05	0.13–0.37	3.2–3.8			...		
WPL8 ^D	0.13	0.90	0.030	0.030	0.13–0.37	8.4–9.6			...		

^A When fittings are of welded construction, the symbols above shall be supplemented by the letter "W".

^B By agreement, the limit for niobium may be increased up to 0.05 % on heat analysis and 0.06 % on product analysis.

^C Fittings made from plate or forgings may have 0.90 % max manganese.

^D Fittings made from plate may have 0.98 % max manganese.

^E Niobium and columbium are interchangeable names for the same element and both names are acceptable for use in A01.22 specifications.

2.6 ASNT Standards:

SNT-TC-1A Recommended Practice for Nondestructive Testing Personnel Qualification and Certification⁶

3. Ordering Information

3.1 See Specification **A960/A960M**.

4. General Requirements

4.1 Product furnished to this specification shall conform to the requirements of Specification **A960/A960M**, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification **A960/A960M** constitutes non-conformance with this specification. In case of conflict between the requirements of this specification and Specification **A960/A960M**, this specification shall prevail.

5. Material

5.1 The starting material for fittings shall be fully killed steel, consisting of forgings, bars, plates, sheet, and seamless or fusion welded tubular products with filler metal added and shall conform to the chemical requirements in **Table 1**. The steels shall be made using recognized melting practices necessary to produce steels that shall meet the impact requirements of this specification.

6. Manufacture

6.1 Forging or forming operations shall be performed by hammering, pressing, piercing, extruding, upsetting, working, bending, fusion-welding, or machining, or by a combination of two or more of these operations. The forming procedure shall be so applied that it will not produce injurious defects in the fittings.

6.2 All welds, including welds in tubular products from which fittings are made, shall be (1) made by welders, welding operators and welding procedures qualified under the provisions of ASME Section IX, (2) heat treated in accordance with Section 7 of this specification, and (3) nondestructively examined throughout the entire length of each weld in accordance with Section 15 of this specification. The radiography of welds

shall be done either prior to or after forming at option of manufacturer. Personnel performing NDE examinations shall be qualified in accordance with SNT-TC-1A.

6.3 The welded joints of the fittings shall be finished in accordance with the requirements of Paragraph UW-35 (a) of Section VIII, Division 1 of ASME Boiler and Pressure Vessel Code.

6.4 All butt-weld tees manufactured by cold-forming methods shall be liquid penetrant or magnetic particle examined by one of the methods specified in Supplementary Requirement S52 or S53 of Specification **A960/A960M**. This examination shall be performed after final heat treatment. Only the sidewall areas of the tee need be examined. This area is defined by a circle that covers the area from the weld bevel of the branch outlet to the centerline of the body or run. Internal and external surfaces shall be examined when size permits accessibility. No cracks shall be permitted. Other imperfections shall be treated in accordance with Section 13. After the removal of any surface discontinuity or crack, the tee shall be re-examined by the original method. All acceptable tees shall be marked with the symbol PT or MT, as applicable, to indicate compliance, regardless of whether or not repairs were needed. NDE personnel shall be qualified in accordance with SNT-TC-1A.

6.5 Stubends may be produced with the entire lap added by the welding of a ring, made from plate or bar of the same alloy grade and composition, to the outside of a straight section of pipe, provided the weld is double welded, is a full penetration joint, satisfies the requirements of 6.2 for qualifications and radiography and 7.1 for post weld heat treatment.

7. Heat Treatment

7.1 All fittings shall be furnished in the normalized, normalized and tempered, annealed, or quenched and tempered condition. All welding shall be completed prior to the austenitizing heat treatment.

7.2 The full thickness of the material from which impact test specimens are to be obtained shall be heat treated with a furnace charge as specified in 10.4.2 or 10.4.3.

7.3 After forming, the fittings shall be allowed to cool below the lower critical before applying one of the heat treatments listed in 7.1.

⁶ Available from American Society for Nondestructive Testing (ASNT), P.O. Box 28518, 1711 Arlingate Ln., Columbus, OH 43228-0518, <http://www.asnt.org>.