



Designation: A691/A691M – 19 (Reapproved 2025)

Standard Specification for Carbon and Alloy Steel Pipe, Electric-Fusion-Welded for High-Pressure Service at High Temperatures¹

This standard is issued under the fixed designation A691/A691M; 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 carbon and alloy steel pipe, electric-fusion-welded with filler metal added, fabricated from pressure-vessel-quality plate of several analyses and strength levels and suitable for high-pressure service at high temperatures. Heat treatment may or may not be required to attain the desired mechanical properties or to comply with applicable code requirements. Supplementary requirements are provided for use when additional testing or examination is desired.

1.2 The specification nominally covers pipe 16 in. [400 mm] in outside diameter and larger with wall thicknesses up to 3 in. [75 mm] inclusive. Pipe having other dimensions may be furnished provided it complies with all other requirements of this specification.

1.3 Several grades and classes of pipe are provided.

1.3.1 *Grade* designates the type of plate used as listed in **Table 1**.

1.3.2 *Class* designates the type of heat treatment performed in the manufacture of the pipe, whether the weld is radiographically examined, and whether the pipe has been pressure tested as listed in **1.3.3**.

1.3.3 Class designations are as follows (**Note 1**):

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.

Current edition approved Sept. 1, 2025. Published September 2025. Originally approved in 1974. Last previous edition approved in 2019 as A691/A691M – 19. DOI: 10.1520/A0691_A0691M-19R25.

² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-691 in Section II of that Code.

Class	Heat Treatment on Pipe	Radiography, see Section	Pressure Test, see Section
10	none	none	none
11	none	9	none
12	none	9	8.3
13	none	none	8.3
20	stress relieved, see 5.3.1	none	none
21	stress relieved, see 5.3.1	9	none
22	stress relieved, see 5.3.1	9	8.3
23	stress relieved, see 5.3.1	none	8.3
30	normalized, see 5.3.2	none	none
31	normalized, see 5.3.2	9	none
32	normalized, see 5.3.2	9	8.3
33	normalized, see 5.3.2	none	8.3
40	normalized and tempered, see 5.3.3	none	none
41	normalized and tempered, see 5.3.3	9	none
42	normalized and tempered, see 5.3.3	9	8.3
43	normalized and tempered, see 5.3.3	none	8.3
50	quenched and tempered, see 5.3.4	none	none
51	quenched and tempered, see 5.3.4	9	none
52	quenched and tempered, see 5.3.4	9	8.3
53	quenched and tempered, see 5.3.4	none	8.3

NOTE 1—Selection of materials should be made with attention to temperature of service. For such guidance, Specification A20/A20M may be consulted.

1.4 Optional requirements of a supplementary nature are provided, calling for additional tests and control of repair welding, when desired.

1.5 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. The inch-pound units shall apply unless the “M” designation of this specification is specified in the order.



TABLE 1 Plate Materials

Pipe Grade	Type of Steel	ASTM Specification		HB, max ^A
		Number	Grade	
CM-65	carbon-molybdenum steel	A204/A204M	A	201
CM-70	carbon-molybdenum steel	A204/A204M	B	201
CM-75	carbon-molybdenum steel	A204/A204M	C	201
CMSH-70	carbon-manganese-silicon steel, normalized	A537/A537M	1	
CMS-75	carbon-manganese-silicon steel	A299/A299M	...	...
CMSH-80	carbon-manganese-silicon steel, quenched and tempered	A537/A537M	2	
½ CR	½ % chromium, ½ % molybdenum steel	A387/A387M	2	201
1CR	1 % chromium, ½ % molybdenum steel	A387/A387M	12	201
1¼ CR	1¼ % chromium, ½ % molybdenum steel	A387/A387M	11	201
2¼ CR	2¼ % chromium, 1 % molybdenum steel	A387/A387M	22	201
3CR	3 % chromium, 1 % molybdenum steel	A387/A387M	21	201
5CR	5 % chromium, ½ % molybdenum steel	A387/A387M	5	225
9CR	9 % chromium, 1 % molybdenum steel	A387/A387M	9	241
91	9 % chromium, 1 % molybdenum, vanadium, niobium ^C	A387/A387M	91 ^B	241

^A Hardness values listed are applicable to S3.

^B Grade 91 shall be designated by Type 1 or Type 2 when required by the prevalent specification.

^C Element 41 has been identified as columbium or niobium. A01 considers them interchangeable and both acceptable. Subcommittee A01.09 has chosen to use niobium.

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.

2. Referenced Documents

2.1 ASTM Standards:³

A20/A20M Specification for General Requirements for Steel Plates for Pressure Vessels

A204/A204M Specification for Pressure Vessel Plates, Alloy Steel, Molybdenum

A299/A299M Specification for Pressure Vessel Plates, Carbon Steel, Manganese-Silicon

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

A387/A387M Specification for Pressure Vessel Plates, Alloy Steel, Chromium-Molybdenum

A435/A435M Specification for Straight-Beam Ultrasonic Examination of Steel Plates

A530/A530M Specification for General Requirements for Specialized Carbon and Alloy Steel Pipe

A537/A537M Specification for Pressure Vessel Plates, Heat-Treated, Carbon-Manganese-Silicon Steel

E165/E165M Practice for Liquid Penetrant Testing for General Industry

E709 Guide for Magnetic Particle Testing

2.2 ASME Boiler and Pressure Vessel Code:⁴

Section II

Section III

Section VIII

Section IX

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>.

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 A lot shall consist of 200 ft [60 m] or fraction thereof of pipe from the same heat of steel.

3.1.1.1 The description of a lot may be further restricted by use of Supplementary Requirement S12.

4. Ordering Information

4.1 The inquiry and order for material under this specification should include the following information:

4.1.1 Quantity (feet, metres, or number of lengths),

4.1.2 Name of the material (steel pipe, electric-fusion-welded),

4.1.3 Plate Specification number, including Grade and Type if applicable,

4.1.4 Pipe Grade and class designations (see 1.3),

4.1.5 Size (inside or outside diameter, nominal or minimum wall thickness),

4.1.6 Length (specific or random),

4.1.7 End finish,

4.1.8 Purchase options, if any (see 5.2.3, 11.3, 11.4, 13.1), and

4.1.9 Supplementary requirements, if any (refer to S1 through S13).

5. Materials and Manufacture

5.1 *Materials*—The steel plate material shall conform to the requirements of the applicable plate specification for the pipe grade ordered as listed in Table 1.

5.2 Welding:

5.2.1 The joints shall be double-welded full-penetration welds made in accordance with procedures and by welders or welding operators qualified in accordance with the ASME Boiler and Pressure Vessel Code, Section IX.

5.2.2 The welds shall be made either manually or automatically by an electric process involving the deposition of filler metal.

5.2.3 The welded joints shall have positive reinforcement at the center of each side of the weld, but no more than ¼ in. [3