



Designation: B 619 – 00

Standard Specification for Welded Nickel and Nickel-Cobalt Alloy Pipe¹

This standard is issued under the fixed designation B 619; 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 welded pipe of nickel and nickel-cobalt alloys (UNS N10001; UNS N10242; UNS N10665; UNS N12160; UNS N10624; UNS N10629; UNS N10675; UNS N10276; UNS N06455; UNS N06007; UNS N06975; UNS N08320; UNS N06002; UNS N06022; UNS N06058; UNS N06059; UNS N06200; UNS N06985; UNS N06030; UNS R30556; UNS N08031; UNS N06230; UNS N06686; UNS N06210; and UNS R20033)* as shown in Table 1.

1.2 This specification covers pipe in Schedules 5S, 10S, 40S, and 80S through 8-in. nominal pipe size as set forth in ANSI B36.19 (see Table 2).

1.3 Two classes of pipe are covered as follows:

1.3.1 *Class I*—As welded and solution annealed or welded and sized and solution annealed.

1.3.2 *Class II*—Welded, cold worked, and solution annealed.

1.4 All pipe shall be furnished in the solution annealed and descaled condition. When atmosphere control is used, descaling is not necessary.

1.5 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

2. Referenced Documents

2.1 ASTM Standards:

B 775 Specification for General Requirements for Nickel and Nickel Alloy Welded Pipe³

2.2 ANSI Standards:

B36.19 Stainless Steel Pipe⁴

B2.1 Pipe Threads⁴

3. General Requirement

3.1 Material furnished under this specification shall conform to the applicable requirements of Specification B 775 unless otherwise provided herein.

4. Ordering Information

4.1 It is the responsibility of the purchaser to specify all requirements that are necessary for the safe and satisfactory performance of material ordered under this specification. Examples of such requirements include, but are not limited to the following:

4.1.1 *Alloy* (Table 1),

4.1.2 *Class* (see 1.3),

4.1.3 *Quantity* (feet or number of lengths),

4.1.4 *Size* (nominal size or outside diameter and schedule number or average wall thickness),

4.1.5 *Length*—Specify cut length or random,

4.1.6 *Certification*—State if certification or a report of test results is required,

4.1.7 *Purchaser Inspection*—State which tests or inspections are to be witnessed,

4.1.8 *Ends*—Plain ends cut and deburred will be furnished, unless otherwise specified, and

4.1.9 *Samples for Product (Check) Analysis*—State whether samples shall be furnished.

5. Materials and Manufacture

5.1 The pipe shall be made from flat-rolled alloy by an automatic welding process with no addition of filler metal.

5.2 Subsequent to welding and prior to final heat treatment, Class II pipes shall be cold worked either in both weld and base metal or in weld metal only. The method of cold working may be specified by the purchaser.

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.07 on Refined Nickel and Cobalt and Their Alloys.

Current edition approved May. 10, 2000. Published June 2000. Originally published as B 619 – 81. Last previous edition B 619 – 99a.

² For ASME Boiler and Pressure Vessel Code applications see related Specification SB-619 in Section II of that Code.

* New designation established in accordance with Practice E 527 and SAE J1086, Practice for Numbering Metals and Alloys (UNS).

³ *Annual Book of ASTM Standards*, Vol 02.04.

⁴ Available from American National Standards Institute, 11 W. 42nd St., 13th Floor, New York, NY 10036.

TABLE 1 Chemical Requirements

	Composition Limits, %														
	Ni	Cr	Mo	Fe	W	C	Si max	Co	Mn	V	P max	S max	Ti	Cu	Cb (Nb) +Ta
Ni-Mo Alloys N10001	remainder ^A	1.0 max	26.0- 30.0	4.0- 6.0	...	0.05 max	1.0	2.5 max	1.0 max	0.2- 0.4	0.04	0.03			
N10665	remainder ^A	1.0 max	26.0- 30.0	2.0 max	...	0.02 max	0.10	1.0 max	1.0 max	...	0.04	0.03			
N10675	65.0 min	1.0- 3.0	27.0- 32.0	1.0-3.0	3.0 max	0.01 max	0.10	3.0 max	3.0 max	0.20 max	0.030	0.010	0.20 max	0.20 max	0.20 max
N10629	remainder ^A	0.5- 1.5	26.0- 30.0	1.0-6.0	...	0.01 max	0.05	2.5 max	1.5 max	...	0.04	0.01	...	0.5 max	...
N10624	remainder ^A	6.0- 10.0	21.0- 25.0	5.0- 8.0	...	0.01 max	0.10	1.0 max	1.0 max	...	0.025	0.01	...	0.5 max	...
Ni-Mo-Cr- Fe Alloy N10242	remainder ^A	7.0- 9.0	24.0- 26.0	2.0 max		0.03 max	0.80	1.00	0.80		0.030	0.015		0.50	0.006
Low C Ni- Mo-Cr Alloys N10276	remainder ^A	14.5- 16.5	15.0- 17.0	4.0-7.0	3.0- 4.5	0.010 max	0.08	2.5 max	1.0 max	0.35 max	0.04	0.03			
N06022	remainder ^A	20.0- 22.5	12.5- 14.5	2.0-6.0	2.5- 3.5	0.015 max	0.08	2.5 max	0.50 max	0.35 max	0.02	0.02			
N06455	remainder ^A	14.0- 18.0	14.0- 17.0	3.0 max	...	0.015 max	0.08	2.0 max	1.0 max	...	0.04	0.03	0.70 max		
Ni-Cr-Fe- Mo-Cu Alloys N06007	remainder ^A	21.0- 23.5	5.5- 7.5	18.0-21.0	1.0 max	0.05 max	1.0	2.5 max	1.0- 2.0		0.04	0.03		1.5- 2.5	1.75- 2.5
N06975	47.0-52.0	23.0- 26.0	5.0- 7.0	remainder ^A	...	0.03 max	1.0	...	1.0 max		0.03	0.03	0.70- 1.50	0.70- 1.20	0.50
N06985	remainder ^A	21.0- 23.5	6.0- 8.0	18.0-21.0	1.5 max	0.015 max	1.0	5.0 max	1.0 max	...	0.04	0.03	...	1.5- 2.5	0.50 max
N06030	remainder ^A	28.0- 31.5	4.0- 6.0	13.0-17.0	1.5- 4.0	0.03 max	0.8	5.0 max	1.5 max	...	0.04	0.02	...	1.0- 2.4	0.30- 1.50
Ni-Fe-Cr-Mo Alloys N08320	25.0-27.0	21.0- 23.0	4.0- 6.0	remainder ^A	...	0.05 max	1.0		2.5 max		0.04	0.03	4x min		

^AThe composition of the remainder shall be determined arithmetically by difference.