



Designation: B619 – 10^{ε1}

Standard Specification for Welded Nickel and Nickel-Cobalt Alloy Pipe¹

This standard is issued under the fixed designation B619; 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.

^{ε1} NOTE—The Si max for N06059 in Table 1 was corrected editorially in January 2012.

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 N06035; UNS N06058; UNS N06059; UNS N06200; UNS N10362; UNS N06985; UNS N06030; UNS R30556; UNS N08031; UNS N06230; UNS N06686; UNS N06210; and UNS R20033)³ as shown in Table 1.

1.2 This specification covers pipe in Schedules 5S, 10S, 40S, and 80S through 8-in. nominal pipe size and larger 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 standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.6 *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 become familiar with all hazards including those identified in the appropriate Material Safety Data Sheet (MSDS) for this product/material as provided by the manufacturer, to establish appropriate*

safety and health practices, and determine the applicability of regulatory limitations prior to use.

2. Referenced Documents

2.1 *ASTM Standards*:⁴

B775 Specification for General Requirements for Nickel and Nickel Alloy Welded Pipe

B899 Terminology Relating to Non-ferrous Metals and Alloys

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

2.2 *ANSI Standards*:⁵

B36.19 Stainless Steel Pipe

B2.1 Pipe Threads

2.3 *ASME Boiler and Pressure Vessel Code*⁶

Section IX Welding and Brazing Qualifications

3. Terminology

3.1 For definitions of terms used in this standard refer to Terminology **B899**.

4. General Requirement

4.1 Material furnished under this specification shall conform to the applicable requirements of Specification **B775** unless otherwise provided herein.

5. Ordering Information

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

5.1.1 Alloy (Table 1),

5.1.2 Class (see 1.3),

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.

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

³ New designation established in accordance with Practice **E527** and SAE J1086, Practice for Numbering Metals and Alloys (UNS).

⁴ 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.

⁵ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, http://www.ansi.org.

⁶ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, http://www.asme.org.

TABLE 1 Chemical Requirements

Composition Limits, %																								
	Ni	Cr	Mo	Fe	W	C	Si	Co	Mn	V	P	S	Ti	Cu	Cb (Nb) +Ta	Al	Zr	La	N	B	Cb (Nb)	Ta	Ni+ Mo	Mg
Ni-Mo Alloys	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	...	...	...									
	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	...	...	...									
	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	...	0.50 max	0.10 max	...	...	...	0.20 max	0.20 max	94.0-98.0	
	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	...	0.1-0.5	...	...	...	...	...	...	...
Ni-Mo-Cr-Fe Alloy	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	remainder ^A	7.0-9.0	24.0-26.0	2.0 max		0.03 max	0.80	1.00 max	0.80 max		0.030	0.015		0.50 max		0.50 max				0.006 max				
Low C Ni-Cr-Mo Alloys	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	...	...	...									
	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	0.5 max	0.35 max	0.02	0.02	...	...	...									
	remainder ^A	32.25-34.25	7.60-9.00	2.00 max	0.60 max	0.050 max	0.60	1.00 max	0.50 max	0.20 max	0.030	0.015	...	0.30 max	...	0.40 max								
	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	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									
	47.0-52.0	23.0-26.0	5.0-7.0	remainder	...	0.03 max	1.0	...	1.0 max	...	0.03	0.03	0.70-1.50	0.70-1.20	...									
	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									
	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	25.0-27.0	21.0-23.0	4.0-6.0	remainder	...	0.05 max	1.0	...	2.5 max	...	0.04	0.03	4xC min	...	...									
Ni-Cr-Mo-Fe Alloy	remainder ^A	20.5-23.0	8.0-10.0	17.0-20.0	0.20-1.0	0.05-0.15	1.0	0.5-2.5	1.0 max	...	0.04	0.03	...	...	...									
Ni-Fe-Cr-Co Alloy	19.0-22.5	21.0-23.0	2.5-4.0	remainder	2.0-3.5	0.05-0.15	0.20-0.80	16.0-21.0	0.50-2.00	...	0.04	0.015	...	...	...	0.10-0.50	0.001-0.10	0.005-0.10	0.10-0.30	0.02 max	0.30 max	0.3-1.25		
Ni-Cr-W-Mo Alloy	remainder ^A	20.0-24.0	1.0-3.0	3.0 max	13.0-15.0	0.05-0.15	0.25-0.75	5.0 max	0.30-1.00	...	0.03	0.015	...	...	...	0.50 max	...	0.005-0.050	...	0.015 max	...	...		
Low C-Ni-Cr-Mo Alloy																								