



Exploration & Production

GENERAL SPECIFICATION

PIPING VALVES VESSELS

GS EP PVV 618

Fabrication of alloy UNS 06625 Grade 1 materials

03	10/2009	Update of reference documents
02	10/2005	Addition of "EP" root to GS identification
01	10/2003	Change of Group name and logo
00	03/2001	First issue
Rev.	Date	Notes

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1. Scope

This specification covers specific requirements applicable to pieces of materials other than plates used either on equipment such as pressure vessels or heat exchangers, or as piping materials, and which are made of alloy UNS 06625 Grade 1 with reference to [ASTM B 444](#) and [ASTM B 705](#) (or equivalent in terms of strength requirements), in sizes up to 20 inches diameter and wall thickness up to 35 mm. Piping materials include in particular: pipes, fittings (tees, elbows, reducers, weldolets, etc.), flanges, valves, etc., either in the form of wrought products or powder Hot Iso Static pressing (HIP) products.

The present document applies to the actual manufacturing procedure requirements of individual pieces, and does not cover assembly of these pieces to each other by welding (welding is only considered if part of the fabrication of individual pieces such as welded pipes or fittings).

2. Reference documents

The reference documents listed below form an integral part of this General Specification. Unless otherwise stipulated, the applicable version of these documents, including relevant appendices and supplements, is the latest revision published at the EFFECTIVE DATE of the CONTRACT.

Since this specification brings additional requirements dealing with a specific material (i.e. UNS 06625 Grade 1 alloy), it is deemed to overrule any less stringent requirement appearing in any of the other contractual Reference Documents.

Any divergence between any of the contractual Reference Documents and this specification must be reported to the COMPANY for decision. In such a case, and unless otherwise agreed or decided by the COMPANY, it is understood that the more stringent requirement may apply at no additional cost.

Standards

Reference	Title
ASTM B 366	Standard Specification for Factory-Made Wrought Nickel and Nickel Alloy Fittings (grade WPNCMC, S (seamless) or WX (welded))
ASTM B 443	Standard Specification for Nickel-Chromium-Molybdenum-Columbium Alloy (UNS N06625) and Nickel-Chromium-Molybdenum-Silicon Alloy (UNS N06219)* Plate, Sheet, and Strip
ASTM B 444	Standard Specification for Nickel-Chromium-Molybdenum-Columbium Alloys (UNS N06625) and Nickel-Chromium-Molybdenum-Silicon Alloy (UNS N06219)* Pipe and Tube (seamless, diameter up to 6", wt = 12.5 mm max.)
ASTM B 446	Standard Specification for Nickel-Chromium-Molybdenum-Columbium Alloy (UNS N06625) and Nickel-Chromium-Molybdenum-Silicon Alloy (UNS N06219)* Rod and Bar
ASTM B 564	Standard Specification for Nickel Alloy Forgings: grade 1 (thicknesses up to 4")
ASTM B 705	Standard Specification for Nickel-Alloy (UNS N06625, N06219 and N08825) Welded Pipe (welded, diameter up to 6", wt = 12.5 mm max.)