



Designation: A 632 – 02a

Standard Specification for Seamless and Welded Austenitic Stainless Steel Tubing (Small-Diameter) for General Service¹

This standard is issued under the fixed designation A 632; 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 reappraisal. A superscript epsilon (ε) indicates an editorial change since the last revision or reappraisal.

1. Scope *

1.1 This specification covers grades of stainless steel tubing in sizes under ½ down to 0.050 in. (12.7 to 1.27 mm) in outside diameter and wall thicknesses less than 0.065 in. down to 0.005 in. (1.65 to 0.13 mm) for general corrosion-resisting and low- or high-temperature service, as designated in Table 1.

NOTE 1—The grades of austenitic stainless steel tubing furnished in accordance with this specification have been found suitable for low-temperature service down to –325°F (–200°C) in which Charpy notched-bar impact values of 15 ft·lbf (20 J), minimum, are required and these grades need not be impact tested.

1.2 Optional supplementary requirements are provided and, when desired, shall be so stated in the order.

1.3 The values stated in inch-pound units are to be regarded as the standard.

2. Referenced Documents

2.1 ASTM Standards:

A 262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels²

A 1016/A 1016M Specification for General Requirements for Ferritic Alloy Steel, Austenitic Alloy Steel, and Stainless Steel Tubes³

E 165 Test Method for Liquid Penetrant Examination⁴

E 527 Practice for Numbering Metals and Alloys (UNS)³

2.2 SAE Standard:

SAE J 1086 Practice for Numbering Metals and Alloys (UNS)⁵

3. Ordering Information

3.1 Orders for product under this specification should include the following, as required, to describe the desired material adequately:

- 3.1.1 Quantity (feet or number of lengths),
- 3.1.2 Name of product (seamless or welded tubes),
- 3.1.3 Grade (see Table 1),
- 3.1.4 Size (only two of the following: outside diameter, inside diameter, and average wall),
- 3.1.5 Length (specific or random),
- 3.1.6 Optional requirements (check analysis, see Section 7; hydrostatic, air underwater pressure test, or nondestructive electric test, see Section 13),
- 3.1.7 Test report required,
- 3.1.8 Specification designation, and
- 3.1.9 Special requirements or any supplementary requirements selected, or both.

4. General Requirements

4.1 Tubing furnished under this specification shall conform to the applicable requirements of the current edition of Specification A 1016/A 1016M, unless otherwise provided herein.

5. Manufacture

5.1 *Manufacture*—The tubes shall be cold finished and shall be made by the seamless or welded process.

5.2 *Heat Treatment*—All material shall be furnished in the heat-treated condition. The heat-treatment procedure shall consist of heating the material to a minimum temperature of 1800°F (980°C) and quenching in water or rapidly cooling by other means.

6. Chemical Composition

6.1 The steel shall conform to the requirements as to chemical composition as specified in Table 1.

7. Product Analysis

7.1 When specified on the purchase order, an analysis of either one billet or one length of flat-rolled stock or one tube shall be made from each heat. The chemical composition thus determined shall conform to the specified requirements.

7.2 If the analysis made in accordance with 7.1 does not conform to the specified requirements, an analysis of each billet or length of flat-rolled stock or tube from the same heat may be made and all billets, stock, or tubes thus conforming to the requirements shall be accepted so far as chemical composition is concerned.

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 A01.10 on Stainless and Alloy Steel Tubular Products.

Current edition approved Sept. 10, 2002. Published November 2002. Originally published as A 632 – 69. Last previous edition A 632 – 02.

² *Annual Book of ASTM Standards*, Vol 01.03.

³ *Annual Book of ASTM Standards*, Vol 01.01.

⁴ *Annual Book of ASTM Standards*, Vol 03.03.

⁵ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001.

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