



Standard Specification for Stainless Steel Needle Tubing¹

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1. Scope

1.1 This specification covers austenitic, stainless steel, needle tubing in hard-drawn tempers for industrial applications.

1.2 In general, needle tubing describes small-diameter tubing with outside diameters (ODs) in the range of 0.008 to 0.203 in. (0.2 to 5.2 mm) with nominal wall thicknesses in the range of 0.002 to 0.015 in. (0.05 to 0.4 mm). Needle tubing gages are normally 6 through 33.

1.3 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:*

A 450/A450M Specification for General Requirements for Carbon, Ferritic Alloy, and Austenitic Alloy Steel Tubes²

3. Ordering Information

3.1 Orders for material in accordance with this specification should include the following, as required, to describe the material adequately:

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

3.1.2 Gage or size (outside diameter and minimum wall thickness),

3.1.3 Length (specific or random), and

3.1.4 Test report required (see the section on certification in Specification A 450/A 450M).

4. Process

4.1 An electric furnace or other similar primary melting process with or without degassing or refining may be used.

5. General Requirements

5.1 Material furnished in accordance with this specification shall conform to the applicable requirements of the current edition of Specification A 450/A 450M, unless otherwise provided herein.

6. Manufacture

6.1 Needle tubing shall be made by the seamless or welded and drawn process and shall be furnished in the hard-drawn temper condition.

7. Heat Treatment

7.1 Unless otherwise specified by the purchaser, no heat treatment is required.

8. Chemical Composition

8.1 Stainless steel, Type 304, UNS S 30400, in accordance with Table 1 shall be used.

8.2 *Heat Analysis*—An analysis of each heat of steel shall be made by the manufacturer from samples made during the pour. The chemical composition thus determined shall meet the requirements of Table 1.

8.3 *Product Analysis*—An analysis may be made by the purchaser from finished tubing. The chemical composition thus determined shall meet the requirements of Table 1.

9. Mechanical Properties

9.1 *Tensile Requirements*—The tubing shall meet the tensile properties specified in Table 2. Yield strength, elongation, and hardness tests are not required for needle tubing.

9.2 *Number of Tests*—Two tension tests for each 5000 ft of product per heat shall be performed.

10. Dimensions

10.1 *Sizes and Tolerances*—Needle tubing sizes and dimensions shall be in accordance with Table 3.

11. Keywords

11.1 needle tubing; stainless steel

¹ This specification is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.10 on Steel Tubing.

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² *Annual Book of ASTM Standards*, Vol 01.01.