



Designation: A 928/A 928M – 004

Standard Specification for Ferritic/Austenitic (Duplex) Stainless Steel Pipe Electric Fusion Welded with Addition of Filler Metal¹

This standard is issued under the fixed designation A 928/A 928M; 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 specification covers electric-fusion-welded steel pipe suitable for corrosive service.

NOTE 1—The dimensionless designator NPS (nominal pipe size) has been substituted in this specification for traditional terms such as nominal diameter, size, and nominal size.

1.2 This specification covers ~~nine~~ grades of ferritic/austenitic steel as indicated in Table 1. The selection of the proper alloy and requirements for heat treatment shall be at the discretion of the purchaser, dependent on the service conditions to be encountered.

1.3 Five classes of pipe are covered as follows:

1.3.1 *Class 1*—Pipe shall be double welded by processes using filler metal in all passes and shall be radiographed completely.

1.3.2 *Class 2*—Pipe shall be double welded by processes using filler metal in all passes. No radiograph is required.

1.3.3 *Class 3*—Pipe shall be single welded by processes using filler metal in all passes and shall be radiographed completely.

1.3.4 *Class 4*—Same as Class 3, except that the weld pass exposed to the inside pipe surface ~~may~~ is permitted to be made without the addition of filler metal (see 6.2.2.1 and 6.2.2.2).

1.3.5 *Class 5*—Pipe shall be double welded by processes using filler metal in all passes and shall be spot radiographed.

1.4 Supplementary requirements covering provisions ranging from additional testing to formalized procedures for manufacturing practice are provided. Supplementary Requirements S1 through S4 are included as options to be specified in the purchase order when desired.

1.5 The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification. The inch-pound units shall apply unless the M designation of the specification is specified in the order.

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.

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