



Standard Specification for Nickel-Chromium-Molybdenum-Cobalt-Tungsten-Iron-Silicon Alloy (UNS N06333) Welded Tube¹

This standard is issued under the fixed designation B 726; 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 alloy UNS N06333 in the form of welded tube intended for heat-resisting applications and general corrosive service.

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.3 The following precautionary statement pertains only to the test methods portion, Section 13, of this specification: *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 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:

B 718 Specification for Nickel-Chromium-Molybdenum-Cobalt-Tungsten-Iron-Silicon Alloy (UNS N06333) Plate, Sheet, and Strip²

B 751 Specification for General Requirements for Nickel and Nickel Alloy Welded Tube²

3. General Requirement

3.1 Material furnished under this specification shall conform to the applicable requirements of Specification B 751 unless otherwise provided herein.

4. Ordering Information

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

- 4.1.1 Alloy or UNS number,
- 4.1.2 ASTM designation and date of issue,
- 4.1.3 Dimensions (outside or inside diameter and nominal-wall thickness),
- 4.1.4 Length (specific or random),
- 4.1.5 Quantity (feet or number of pieces),
- 4.1.6 *Certification*—State if certification is required,
- 4.1.7 *Samples for Product (Check) Analysis*—State whether samples should be furnished, and
- 4.1.8 *Purchaser Inspection*—If purchaser wishes to witness tests or inspection of material at place of manufacture, the purchase order must so state indicating which tests or inspections are to be witnessed.

5. Materials and Manufacture

5.1 The tube shall be made from flat-rolled alloy conforming to Specification B 718, by an automatic welding process with no addition of filler metal.

5.2 Tube shall be furnished annealed after welding, with oxide removed. When the final heat treatment is performed in a protective atmosphere, descaling is not necessary.

6. Chemical Composition

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

TABLE 1 Chemical Requirements

Element	Composition Limits, %
Carbon	0.10 max
Manganese	2.0 max
Phosphorus	0.03
Sulfur	0.03
Silicon	1.5 max
Chromium	24.0 to 27.0
Nickel	44.0 to 48.0
Molybdenum	2.5 to 4.0
Cobalt	2.5 to 4.0
Tungsten	2.5 to 4.0
Iron ^A	remainder

^A Element may be determined arithmetically by difference.

6.2 If a product (check) analysis is performed by the purchaser, the material shall conform to the product (check) analysis variations in Specification B 751.

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 *Annual Book of ASTM Standards*, Vol 02.04.