

**SPECIFICATION FOR NICKEL-COPPER ALLOY
SEAMLESS PIPE AND TUBE**



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ASTM-B165

Specification for Nickel-Copper Alloy Seamless Pipe and Tube

1. Scope

1.1 This specification covers nickel-copper alloy UNS N04400 in the form of cold-worked seamless pipe and tube in the conditions shown in Table 1 and Table X1.1.

1.1.1 DELETED

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *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 (MSDS) for this product/material as provided by the manufacturer, to establish appropriate safety, health, and environmental practices, and determine the applicability of regulatory limitations prior to use.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:

- B829 Specification for General Requirements for Nickel and Nickel Alloys Seamless Pipe and Tube
- E8 Test Methods for Tension Testing of Metallic Materials [Metric] E0008_E0008M
- E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- E76 Test Methods for Chemical Analysis of Nickel-Copper Alloys (Withdrawn 2003)

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *average diameter, n*—average of the maximum and minimum outside diameters, as determined at any one cross-section of the pipe or tube.

3.1.2 *pipe, n*—tube conforming to the particular dimensions commercially known as pipe sizes, see Table X2.1.

3.1.3 *seamless pipe or tube, n*—pipe or tube produced with a continuous periphery in all stages of the operations.

3.1.4 *tube, n*—hollow product of round or any other cross-section having a continuous periphery.

4. Ordering Information

4.1 Orders for material to this specification shall include information with respect to the following:

- 4.1.1 Alloy name or UNS number.
- 4.1.2 ASTM designation and year of issue.
- 4.1.3 *Condition* (see Appendix X3).
- 4.1.4 *Finish* (see Appendix X3).
- 4.1.5 *Dimensions*:
 - 4.1.5.1 *Tube*—Specify outside diameter and nominal or minimum wall.
 - 4.1.5.2 *Pipe*—Specify standard pipe size and schedule.
 - 4.1.5.3 *Length*—Cut to length or random.
- 4.1.6 *Quantity*—Feet or number of pieces.
- 4.1.7 *Hydrostatic Test or Nondestructive Electric Test*—Specify type of test (see 6.2).
- 4.1.8 *Hydrostatic Pressure Requirements*—Specify test pressure if other than required by 12.3.1.

TABLE 1 Mechanical Properties of Pipe and Tube

Condition and Size	Tensile Strength, min, psi (MPa)	Yield Strength, min. (0.2 % offset), min, psi (MPa)	Elongation in 2 in. or 50 mm (or 4 D), min, %
Annealed:			
5 in. (127 mm) outside diameter and under	70 000 (480)	28 000 (195)	35
Over 5 in. (127 mm) outside diameter	70 000 (480)	25 000 (170)	35
Stress-Relieved: All sizes	85 000 (585)	55 000 (380)	15

4.1.9 *Samples for Product (Check) Analysis*—State whether samples for product (check) analysis should be furnished (see 5.2).

4.1.10 *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 (Section 13).

4.1.11 *Small-Diameter Tube and Tube with Specified Wall Thickness 3 % or Less of the Specified Outside Diameter (Converter Sizes)*—See Appendix X1.

5. Chemical Composition

5.1 The material shall conform to the composition limits specified in Table 2.

5.2 If a product (check) analysis is performed by the purchaser, the material shall conform to the product (check) analysis variations in Table 2.

6. Mechanical and Other Requirements

6.1 *Tension Test*—The material shall conform to the tensile properties specified in Table 1.

6.1.1 Tensile properties for material specified as small-diameter tube and tube with specified wall thickness 3 % or less of the specified outside diameter (converter sizes) shall be in accordance with Table X1.1.

6.2 *Hydrostatic or Nondestructive Electric Test*—Each pipe or tube shall be subjected to either the hydrostatic test or the nondestructive electric test. The type of test to be used shall be at the option of the manufacturer, unless otherwise specified in the purchase order.

TABLE 2 Chemical Requirements

Element	Composition Limits, %	Product (Check) Analysis Variations, under min or over max, of the Specified Limit of Element
Ni ⁴	63.0 min	0.45
Cu	28.0 min 34.0 max	0.15 0.20
Fe	2.5 max	0.05
Mn	2.0 max	0.04
C	0.3 max	0.02
Si	0.5 max	0.03
S	0.024 max	0.005

⁴ Element shall be determined arithmetically by difference.

7. Dimensions and Permissible Variations

7.1 *Diameter and Wall Thickness*—The permissible variations in the outside diameter and wall thickness shall conform to the permissible variations prescribed in Table 3.

7.2 *Length*—When material is ordered cut-to-length, the length shall conform to the permissible variations prescribed in Table 4.

7.3 *Straightness*—Material shall be reasonably straight and free of bends and kinks.

7.4 *Ends*—Ends shall be plain cut and deburred.

7.5 Permissible variations for material specified as small-diameter tube and tube with specified wall thickness 3 % or less of the specified outside diameter (converter size) shall conform to the permissible variations prescribed in Table X1.2.

8. Workmanship, Finish, and Appearance

8.1 The material shall be uniform in quality and temper, smooth, commercially straight, and free of injurious imperfections.

9. Sampling

9.1 *Lot Definition*:

9.1.1 A lot for chemical analysis shall consist of one heat.

9.1.2 A lot for all other testing shall consist of all material from the same heat, nominal size (excepting length), and condition.

9.1.2.1 Where material cannot be identified by heat, a lot shall consist of not more than 500 lb (227 kg) of material in the same condition and nominal size (excepting length).

9.2 *Test Material Selection*:

9.2.1 *Chemical Analysis*—Representative samples from each lot shall be taken during pouring or subsequent processing.

9.2.1.1 Product (Check) Analysis shall be wholly the responsibility of the purchaser.

9.2.2 *Mechanical and other Properties*—Samples of the material to provide test specimens for mechanical and other properties shall be taken from such locations in each lot as to be representative of that lot. Test specimens shall be taken from material in the final condition.

10. Number of Tests

10.1 *Chemical Analysis*—One test per lot.

10.2 *Tension*—One test per lot.

10.3 *Hydrostatic or Nondestructive Electric Test*—Each piece in each lot.

11. Specimen Preparation

11.1 *Room Temperature Tensile Specimen*—Material shall be tested in the direction of fabrication. Whenever possible, all pipe and tube shall be tested in full tubular size. When testing in full tubular size is not possible, longitudinal strip specimens, or the largest possible round specimen, shall be used. In the event of disagreement when full tubular testing is not possible, a longitudinal strip specimen with reduced gauge length as contained in Test Methods E8 shall be used.

TABLE 3 Permissible Variations for Outside Diameter and Wall Thickness of Seamless Cold Worked Pipe and Tube^{A,B}

Nominal Outside diameter, in. (mm)	Permissible Variations				% of Thickness of Specified Minimum Wall	
	Outside Diameter, in. (mm)		% of Thickness of Specified Nominal Wall		+	-
	+	-	+	-		
Over 0.400 (10) to 5/8 (16), excl	0.005 (0.13)	0.005 (0.13)	15.0	15.0	30	0
5/8 (16) to 1 1/2 (38), incl	0.0075 (0.19)	0.0075 (0.19)	10.0	10.0	22	0
Over 1 1/2 (38) to 3 (76), incl	0.010 (0.25)	0.010 (0.25)	10.0	10.0	22	0
Over 3 (76) to 4 1/2 (114), incl	0.015 (0.38)	0.015 (0.38)	10.0	10.0	22	0
Over 4 1/2 (114) to 6 (152), incl	0.020 (0.51)	0.020 (0.51)	12.5	12.5	28	0
Over 6 (152) to 6 3/8 (168), incl	0.025 (0.64)	0.025 (0.64)	12.5	12.5	28	0
Over 6 3/8 (168) to 8 3/4 (219), incl	0.031 (0.79)	0.031 (0.79)	12.5	12.5	28	0

^A *Ovality*—The permissible variations in this table apply to individual measurements, including out-of-roundness (ovality) except for the following:
 For pipe and tube having a nominal wall thickness of 3 % or less of the nominal outside diameter, the mean outside diameter shall conform to the permissible variations of this table and individual measurements (including ovality) shall conform to the plus and minus values of the table, with the values increased by 0.5 % of the nominal outside diameter.

For pipe and tube over 4 1/2 in. (114 mm) in outside diameter with a nominal wall thickness greater than 3 % of the nominal outside diameter, the mean outside diameter shall conform to the permissible variations of this table and individual measurements shall not exceed twice the permissible variations of the table.

^B *Eccentricity*—The permissible variations in this table apply to individual measurements including eccentricity.

TABLE 4 Permissible Variations in Length^A

Outside Diameter, in. (mm)	Cut Length, in. (mm)	
	Over	Under
Under 2 (50.8)	1/8 (3.2)	0
2 (50.8) and over	3/16 (4.8)	0

^A These permissible variations in length apply to pipe or tube in straight lengths. They apply to cut lengths up to and including 24 ft (7.3 m). For lengths over 24 ft, an additional over-tolerance of 1/8 in. (3.2 mm) for each 10 ft (3.0 m) or fraction thereof shall be permissible up to a maximum additional over-tolerance of 1/2 in. (12.7 mm).

12. Test Methods

12.1 *Chemical Composition*—In case of disagreement, the chemical composition shall be determined in accordance with Test Methods E76.

12.2 *Tension Test*—Tension testing shall be conducted in accordance with Test Methods E8.

12.3 *Hydrostatic or Nondestructive Electric Test*—Each pipe or tube with an outside diameter 1/8 in. (3 mm) and larger and with wall thickness of 0.015 in. (0.38 mm) and over shall be tested by the manufacturer to an internal hydrostatic pressure of 1000 psi (6.9 MPa) provided that the fiber stress calculated in accordance with the following equation does not exceed the allowable fiber stress, *S*, indicated below:

$$P = 2St/D \tag{1}$$

where:

P = hydrostatic test pressure, psi (or MPa)
S = allowable fiber stress, for material in the condition (temper) furnished as follows:

<i>Annealed:</i>	
5 in. (127 mm) outside diameter and under	17 500 psi (120 MPa)
Over 5 in. (127 mm) outside diameter	16 700 psi (115 MPa)
<i>Stress-relieved:</i>	
All sizes	21 200 psi (145 MPa)

t = minimum wall thickness, in. (or mm), equal to the specified nominal wall minus the permissible minus wall tolerance, or the specified minimum wall thickness, and,
D = outside diameter of the pipe or tube, in. (or mm).

12.3.1 When so agreed upon between the manufacturer and purchaser, pipe or tube may be tested to 1 1/2 times the allowable fiber stress given above.

12.3.2 If any pipe or tube shows leaks during hydrostatic testing, it shall be rejected.

12.4 *Nondestructive Electric Test*—Each pipe or tube shall be examined with a nondestructive electric test in accordance with Specification B829.

12.5 *Rounding Method*—For purposes of determining compliance with the specified limits for requirements of the properties listed in the following table, an observed value, or a calculated value, shall be rounded as indicated below, in accordance with the rounding method of Practice E29:

Test	Rounded Unit for Observed or Calculated Value
Chemical composition and tolerances (when expressed in decimals)	nearest unit in the last right-hand place of figures of the specified limit. If two choices are possible, as when the digits dropped are exactly a 5 or a 5 followed only by zeros, choose the one ending in an even digit with zero defined as an even digit.
Tensile strength, yield strength	nearest 1000 psi (6.9 MPa)
Elongation	nearest 1 %

13. Inspection

13.1 Inspection of the material shall be agreed upon between the purchaser and the supplier as part of the purchase contract.

14. Rejection and Rehearing

14.1 Material that fails to conform to the requirements of this specification may be rejected. Rejection should be reported to the producer or supplier promptly and in writing. In case of dissatisfaction with the results of the test, the producer or supplier may make claim for a rehearing.

15. Certification

15.1 A manufacturer's certification shall be furnished to the purchaser stating that material has been manufactured, tested, and inspected in accordance with this specification, and that the test results on representative samples meet specification requirements. A report of the test results shall be furnished.

16. Product Marking

16.1 The following information shall be marked on the material or included on the package, or on a label or tag

attached thereto: The name of the material or UNS number, heat number, condition (temper), this specification number, the size, gross, tare and net weight, consignor and consignee address, contract or order number, or such other information as may be defined in the contract or order.

17. Keywords

17.1 seamless pipe; seamless tube; N04400

SUPPLEMENTARY REQUIREMENTS

The following supplementary requirements shall apply only when specified by the purchaser in the inquiry, contract, or order, for agencies of the U. S. Government.

S1. Referenced Documents

S1.1 The following documents of the issue in effect on date of material purchased form a part of this specification to the extent referenced herein:

S1.1.1 Federal Standards:

Fed. Std. No. 102 Preservation, Packaging and Packing Levels

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)

Fed. Std. No. 182 Continuous Identification Marking of Nickel and Nickel-Base Alloys

S1.1.2 Military Standard:

MIL-STD-129 Marking for Shipment and Storage

S2. Quality Assurance*S2.1 Responsibility for Inspection:*

S2.1.1 Unless otherwise specified in the contract or purchase order, the manufacturer is responsible for the performance of all inspection and test requirements specified. Except as otherwise specified in the contract or purchase order, the manufacturer may use his own or any other suitable facilities for the performance of the inspection and test requirements unless disapproved by the purchaser at the time the order is

placed. The purchaser shall have the right to perform any of the inspections or tests set forth when such inspections and tests are deemed necessary to assure that the material conforms to prescribed requirements.

S3. Identification Marking

S3.1 All material shall be properly marked for identification in accordance with Fed. Std. No. 182, except that the ASTM specification number and the alloy number shall be used.

S4. Preparation for Delivery*S4.1 Preservation, Packaging, Packing:*

S4.1.1 *Military Agencies*—The material shall be separated by size, composition, grade, or class and shall be preserved and packaged, level A or C, packed level A, B, or C as specified in the contract or purchase order.

S4.1.2 *Civil Agencies*—The requirements of Fed. Std. No. 102 shall be referenced for definitions of the various levels of packaging protection.

S4.2 Marking:

S4.2.1 *Military Agencies*—In addition to any special marking required by the contract or purchase order, marking for shipment shall be in accordance with MIL-STD-129.

S4.2.2 *Civil Agencies*—In addition to any special marking required by the contract or purchase order, marking for shipment shall be in accordance with Fed. Std. No. 123.

APPENDIXES

(Nonmandatory Information)

X1. CONVERTER SIZES

X1.1 Small-diameter tube and tube with specified wall thickness 3 % or less of the specified outside diameter in outside diameters 1¼ in. (31.8 mm) and under may be furnished in the conditions listed in Table X1.1 when so specified. The material is furnished in a limited range of sizes and the manufacturer should be consulted as to the various outside diameters and wall thicknesses that may be furnished. Material will have a bright finish. Such material shall conform to the applicable requirements in Table X1.1 and Table X1.2.

TABLE X1.1 Mechanical Properties^A of Small-Diameter Tube and Tube with Specified Wall Thickness 3 % or Less of the Specified Outside Diameter (Converter Sizes)

Condition	Tensile Strength, psi (MPa)	Yield Strength (0.2 % offset) min, psi (MPa)	Elongation in 2 in. or 50 mm, (or 4 <i>D</i>), min, %
Annealed ^B	85 000 (585) max	28 000 (195)	32
Half-hard ^C	85 000 (585) min	55 000 (380)	12
Full hard ^D	110 000 (760) min	90 000 (620)	3

^A Not applicable to outside diameters under ⅛ in. (3.2 mm) and wall thicknesses under 0.015 in. (0.38 mm).

^B This condition is sometimes designated as "No. 1 Temper."

^C This condition is sometimes designated as "No. 2 Temper."

^D This condition is sometimes designated as "No. 3 Temper."

TABLE X1.2 Permissible Variations for Small-Diameter Tube and Tube with Specified Wall Thickness ≤ 3 % of the Specified Outside Diameter (Converter Sizes)^{A,B,C,D,E,F,G}

Specified Outside Diameter, in. (mm)	Outside Diameter		Inside Diameter, in. (mm)		Wall Thickness, %	
	+	-	+	-	+	-
Under 3/32 (2.4)	0.002 (0.05)	0 (0)	0 (0)	0.002 (0.05)	10	10
3/32 to 3/16 (2.4 to 4.8), excl	0.003 (0.08)	0 (0)	0 (0)	0.003 (0.08)	10	10
3/16 to 1/2 (4.8 to 12.7), excl	0.004 (0.10)	0 (0)	0 (0)	0.004 (0.10)	10	10
1/2 to 1 1/4 (12.7 to 31.8), incl	0.005 (0.13)	0 (0)	0 (0)	0.005 (0.13)	10	10

^A *Ovality, Tube with Specified Wall Thickness > 3 % of the Specified Outside Diameter*—As-Drawn (No. 2 and 3) Tempers—Ovality will be held within the outside diameter tolerances shown in the table.

Annealed (No. 1) Temper—Ovality will be held within 2 % of the theoretical average outside diameter.

^B *Ovality, Tube with Specified Wall Thickness ≤ 3 % of the Specified Outside Diameter*—As-Drawn (No. 2 and 3) Tempers—Up to but not including 1 1/4 in. (31.8 mm) in outside diameter, ovality will be held within 2 % of the theoretical average outside diameter.

Annealed (No. 1) Temper—Ovality will be held within 3 % of the theoretical average outside diameter.

^C *Wall Tolerances, Tube with Specified Wall Thickness ≤ 3 % of the Specified Outside Diameter*—The plus and minus wall tolerance shown in the table shall apply down to and including 0.005 in. (0.13 mm) in wall thickness. For wall thicknesses less than 0.005 in. (0.13 mm), the tolerance shall be ±0.0005 in. (0.013 mm).

^D *Random Lengths:*

Where nominal random lengths on tubing 1/8 in. (3.2 mm) and larger in outside diameter are specified, a length tolerance of ±3 1/2 ft (106 cm) applies to the nominal length. This is a total spread of 7 ft (210 cm).

Random lengths in sizes 1/8 in. (3.2 mm) and larger in outside diameter shall be subject to a length range of 5 to 24 ft (150 to 730 cm). Long random lengths are subject to a range of 15 to 22 ft (457 to 670 cm).

Random lengths in sizes up to, but not including 1/8 in. (3.2 mm) in outside diameter, and fragile tubes with specified wall thickness ≤ 3 % of the specified outside diameter over this outside diameter are subject to the length range of 1 to 15 ft (30 to 457 cm).

^E *Cut Lengths*—Tolerances on cut lengths shall be in accordance with Table X1.3.

^F *Straightness*—Round tubing is subject to a straightness tolerance of one part in 600 (equivalent to a depth of arc of 0.030 in. (0.76 mm) in any 3 ft (91 cm) of length).

^G When specified, the tolerance spreads of this table may be applied as desired. However, when not specified, the tolerances in this table will apply. It should be noted that inside diameter tolerances are based upon the outside diameter range.

TABLE X1.3 Tolerances on Cut Lengths of Tube with Specified Wall Thickness ≤ 3 % of the Specified Outside Diameter

Length, ft (cm)	Tube Size, in. (mm)	Permissible Variations, in. (mm)	
		Over	Under
Under 1 (30)	up to 1.250 (31.8), incl	1/32 (0.8)	0 (0)
1 to 4 (30 to 122), incl	up to 1.250 (31.8), incl	1/16 (1.6)	0 (0)
Over 4 to 10 (122 to 300), incl	up to 1.250 (31.8), incl	3/32 (2.4)	0 (0)
Over 10 (300)	up to 1.250 (31.8), incl	3/16 (4.8)	0 (0)

X2. PIPE SCHEDULES

X2.1 The schedules of pipe shown in Table X2.1 are regularly available. Other schedules may be furnished, and the manufacturer should be consulted. Table X2.1 is published for information only.

TABLE X2.1 Pipe Schedules^A

Nominal Pipe Size in.	Outside Diameter in. (mm)	Nominal Wall Thickness, in. (mm)			
		Schedule No. 5 in. (mm)	Schedule No. 10 in. (mm)	Schedule No. 40 in. (mm)	Schedule No. 80 in. (mm)
1/8	0.405 (10.3)	...	0.049 (1.2)	0.068 (1.7)	0.095 (2.4)
1/4	0.540 (13.7)	...	0.065 (1.6)	0.088 (2.2)	0.119 (3.0)
3/8	0.675 (17.1)	...	0.065 (1.6)	0.091 (2.3)	0.126 (3.2)
1/2	0.840 (21.3)	0.065 (1.6)	0.083 (2.1)	0.109 (2.8)	0.147 (3.7)
3/4	1.050 (26.7)	0.065 (1.6)	0.083 (2.1)	0.113 (2.8)	0.154 (3.9)
1	1.315 (33.4)	0.065 (1.6)	0.109 (2.8)	0.133 (3.4)	0.179 (4.5)
1 1/4	1.660 (42.2)	0.065 (1.6)	0.109 (2.8)	0.140 (3.6)	0.191 (4.8)
1 1/2	1.900 (48.3)	0.065 (1.6)	0.109 (2.8)	0.145 (3.7)	0.200 (5.1)
2	2.375 (60.3)	0.065 (1.6)	0.109 (2.8)	0.154 (3.9)	0.218 (5.5)
2 1/2	2.875 (73.0)	0.083 (2.1)	0.120 (3.0)	0.203 (5.2)	0.276 (7.0)
3	3.500 (88.9)	0.083 (2.1)	0.120 (3.0)	0.216 (5.5)	0.300 (7.6)
3 1/2	4.000 (101.6)	0.083 (2.1)	0.120 (3.0)	0.226 (5.7)	0.318 (8.1)
4	4.500 (114.3)	0.083 (2.1)	0.120 (3.0)	0.237 (6.0)	0.337 (8.6)
5	5.563 (141.3)	0.109 (2.8)	0.134 (3.4)	0.258 (6.5)	0.375 (9.5)
6	6.625 (168.3)	0.109 (2.8)	0.134 (3.4)	0.280 (7.1)	0.432 (10.9)
8	8.625 (219.1)	0.322 (8.2)	0.500 (12.7)

^A The pipe schedules shown above conform with standards adopted by the American National Standards Institute.

X3. CONDITIONS AND FINISHES NORMALLY SUPPLIED

X3.1 This appendix lists the conditions and finishes in which pipe and tube (other than converter sizes) are normally supplied. These are subject to change, and the manufacturer should be consulted for the latest information available.

X3.2.2 *Stress-Relieved*—Thermally treated below the annealing temperature to relieve the major portion of the internal stresses, with a thin, light- to medium-dark surface.

X3.2 Nickel-Copper Alloy (UNS N04400)

X3.2.1 *Annealed*—Soft, with a dull matte finish.