



Standard Specification for Welded UNS N08120, UNS N08800, UNS N08810, and UNS N08811 Alloy Tubes¹

This standard is issued under the fixed designation B 515; 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 welded UNS N08120, UNS N08800, UNS N08810 and UNS N08811* alloy boiler, heat exchanger, and condenser tubes for general corrosion resisting and low or high-temperature service.

1.2 This specification covers tubes $\frac{1}{8}$ to 5 in. (3.18 to 127 mm), inclusive, in outside diameter and 0.015 to 0.500 in. (0.38 to 12.70 mm), inclusive, in wall thickness. Table 2 of Specification B 751 lists the dimensional requirements of these sizes. Tubes having other dimensions may be furnished provided such tubing complies with all other requirements of this specification.

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

1.4 *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 751 Specification for General Requirements for Nickel and Nickel Alloy Welded Tube²

3. Ordering Information

3.1 Orders for material to this specification should include the following information:

3.1.1 Quantity (feet or number of lengths),

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* New designation established in accordance with ASTM E 527 and SAE J1086, Practice for Numbering Metals and Alloys (UNS).

² *Annual Book of ASTM Standards*, Vol 02.04.

3.1.2 UNS Number,

3.1.3 Size (outside diameter minimum or average wall thickness),

3.1.4 Length (random or specific),

3.1.5 Class,

3.1.6 ASTM Designation,

3.1.7 Product Analysis—State if required,

3.1.8 Certification—State if a certification or a report of test results is required, and

3.1.9 Purchaser Inspection—State which tests or inspections are to be witnessed, if any.

4. Materials and Manufacture

4.1 Tube shall be made from flat-rolled alloy by an automatic welding process with no addition or filler metal. Subsequent to welding and prior to final annealing, the material shall be cold-worked in either the weld metal only or both weld and base metal.

4.2 Tube shall be furnished with oxide removed. When bright annealing is used, descaling is not necessary.

5. Chemical Composition

5.1 The material shall conform to the composition limits specified in Table 1. One test is required for each lot as defined in Specification B 751.

5.2 If a product analysis is performed, it shall meet the chemistry limits prescribed in Table 1, subject to the analysis tolerances specified in Table 6 of Specification B 751.

6. Mechanical and Other Properties

6.1 *Mechanical Properties*—The material shall conform to the mechanical property requirements specified in Table 2. One test is required for each lot as defined in Specification B 751.

6.2 *Grain Size*—A transverse sample representing the full-wall thickness of annealed alloys UNS N08120, N08810, and N08811 shall conform to an average grain size of ASTM No. 5 or coarser.

6.3 *Flattening Test*—A flattening test shall be made on each end of one tube per lot. Superficial ruptures resulting from surface imperfections shall not be cause for rejection.

6.4 *Flange Test*—A flange test shall be made on each end of one tube per lot.

TABLE 1 Chemical Requirements

Element	Composition Limits, %			
	Alloy N08120	Alloy N08800	Alloy N08810	Alloy N08811
Nickel, min	35.0	30.0	30.0	30.0
, max	39.0	35.0	35.0	35.0
Chromium, min	23.0	19.0	19.0	19.0
, max	27.0	23.0	23.0	23.0
Iron, min	remainder	39.5 ^A	39.5 ^A	39.5 ^A
Manganese, max	1.5	1.5	1.5	1.5
Carbon, min	0.02
, max	0.10	0.10	0.05 to 0.10	0.06 to 0.10
Copper, max	0.50	0.75	0.75	0.75
Silicon, max	1.0	1.0	1.0	1.0
Sulfur, max	0.03	0.015	0.015	0.015
Aluminum, min ^B	...	0.15	0.15	0.15
, max	0.40	0.60	0.60	0.60
Titanium, min ^B	...	0.15	0.15	0.15
, max	0.20	0.60	0.60	0.60
Columbium, min	0.4
, max	0.9
Molybdenum, max	2.50
Phosphorus, max	0.040
Tungsten, max	2.50
Cobalt, max	3.0
Nitrogen, min	0.15
, max	0.30
Boron, max	0.010

^A Iron shall be determined arithmetically by difference.

^B Alloy UNS N08811: Al + Ti, 0.85–1.20.

6.5.1 *Class 1*—Each piece of each lot shall be subject to one of the following four tests: hydrostatic, pneumatic (air underwater), eddy current, or ultrasonic.

6.5.2 *Class 2*—Each piece in each lot shall be subjected to a leak test and an electric test as follows:

6.5.2.1 *Leak Test*—Hydrostatic or pneumatic (air underwater).

6.5.2.2 *Electric Test*—Eddy current or ultrasonic.

6.6 The manufacturer shall have the option to test Class 1 or Class 2 and select the nondestructive test methods, if not specified by the purchaser.

7. General Requirements

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

8. Keywords

8.1 UNS N08120; UNS N08800; UNS N08810; UNS N08811; welded tube

TABLE 2 Mechanical Property Requirements

Alloy	Condition (Temper)	Tensile Strength, min, psi (MPa)	Yield Strength, 0.2 % Offset, min, psi (MPa)	Elongation in 2 in. or 50 mm, min, %
UNS N08120	annealed	90 000 (621)	40 000 (276)	30
UNS N08800	annealed	75 000 (520)	30 000 (205)	30
UNS N08810 and UNS N08811	annealed	65 000 (450)	25 000 (170)	30

6.5 Nondestructive Test Requirements:

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