

# STAINLESS STEEL PIPING & TUBING SPECS

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## STAINLESS STEEL PIPE

**ASTM A312:** Seamless and Welded Austenitic Stainless Steel Pipe covers both seamless and welded without filler metal. Stainless pipe comes in 38 grades as designated in table 1 of ASTM A312.

**ASTM A778:** Welded Unannealed Austenitic Stainless Steel Tubular Products intended for low & moderate temperature service where heat treatment is not necessary for corrosion resistance, and sometimes referred to as "As-Welded Pipe." This is frequently used in the pulp and paper industry.

## SEAMLESS STAINLESS STEEL TUBING

**ASTM A213/SA213:** "Seamless Ferritic & Austenitic Alloy Steel Boiler Superheater and Heat Exchanger Tubes."

**ASTM A269:** "Seamless and Welded Austenitic Stainless Steel Tubing for General Service."  
Seamless tubing may be furnished as hot finished or cold finished as specified.

## WELDED STAINLESS STEEL TUBING

**ASTM A 269:** "Seamless and Welded Austenitic Stainless Steel Tubing for General Service."

**ASTM A 249/SA 249:** "Welded Austenitic Steel Boiler, Superheater, Heat Exchanger and Condenser Tube."

**ASTM A 270:** "Seamless and Welded Austenitic Stainless Steel Tubing is generally used for sanitary, food, dairy, beverage, pharmaceutical, and biopharmaceutical applications".

Welded tube may be cold drawn, annealed and pickled or full finished, annealed and pickled or bright annealed.

*Note:* A249 is used for "High Temperature Service" so it requires cold working subsequent to welding but prior to final heat treatment. ASTM A269 and A632 are for "General Service" and do not require cold working.