



Designation: B 337 – 95

AMERICAN SOCIETY FOR TESTING AND MATERIALS
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Standard Specification for Seamless and Welded Titanium and Titanium Alloy Pipe¹

This standard is issued under the fixed designation B 337; 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 approval. A superscript (a) indicates an editorial change since the last revision or approval.

This specification has been approved for use by agencies of the Department of Defense. Consult the DoD Index of Specifications and Standards for the specific year of issue which has been adopted by the Department of Defense.

1. Scope

1.1 This specification² covers eight grades of seamless and welded titanium pipe intended for general corrosion-resisting and elevated-temperature 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.

2. Referenced Documents

2.1 ASTM Standards³:

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products⁴

E 120 Test Methods for Chemical Analysis of Titanium and Titanium Alloys⁵

2.2 ANSI Standard:

B 36.19 Stainless Steel Pipe⁶

3. Ordering Information

3.1 Orders for materials under this specification shall include the following information as required:

- 3.1.1 Quantity,
- 3.1.2 Grade number (see 5.1 and 7.1),
- 3.1.3 Nominal pipe size and schedule (Section 14 and Table X1.1),
- 3.1.4 Lengths, random or specified cut lengths (see 14.3),
- 3.1.5 Method of manufacture and finish (Section 4 and 15.1),
- 3.1.6 Restrictive chemistry, if desired (see 3.1, Table 1),
- 3.1.7 Product analysis, if desired (Section 6),
- 3.1.8 Special mechanical properties, if desired (see 7.1, Table 3),
- 3.1.9 Flattening tests (see 9.1),
- 3.1.10 Finish (see 15.1),
- 3.1.11 Marking (see 19.1),
- 3.1.12 Packaging (see 18.1),
- 3.1.13 Inspection and required reports (Section 16), and
- 3.1.14 Disposition of rejected material (Section 17).

¹ This specification is under the jurisdiction of ASTM Committee B-10 on Refractory Metals and Alloys and is the direct responsibility of Subcommittee B10.01 on Titanium.

² Current edition approved Feb. 15, 1995. Published April 1995. Originally published as B 337 – 89 T. Last previous edition B 337 – 94.

³ For ASME Boiler and Pressure Vessel Code applications see related Specification SB-337 in Section II of that Code.

⁴ Annual Book of ASTM Standards, Vol 01.03.

⁵ Annual Book of ASTM Standards, Vol 03.05.

⁶ Available from American National Standards Institute, 11 W. 42nd St., 13th Floor, New York, NY 10018.

4. Materials and Manufacture

4.1 Seamless pipe may be made by any seamless method that will yield a product meeting the requirements of this specification.

4.2 Welded pipe shall be made from flat-rolled products by an arc-welding process that will yield a product meeting the requirements of this specification. Filler metal, if used, shall be the same grade as the base metal, or the next lower strength grade for welding Grades 2 and 3. For welding Grades 7, 9, 10, 11, and 12, the filler metal, if used, shall be the same as the grade specified. Welded pipe may be further reduced.

4.3 The pipe shall be furnished annealed, except for Grade 9, which may be furnished in either the annealed or stress-relief annealed condition, and Grade 10, which shall be solution treated.

5. Chemical Composition

5.1 The titanium shall conform to the chemical requirements prescribed in Table 1.

6. Product Analysis

6.1 When requested by the purchaser and stated in the purchase order, product analysis for any elements listed in Table 1 shall be made on the finished product.

6.2 The product analysis tolerances, listed in Table 2, do not broaden the specified heat analysis requirements, but cover variations between different laboratories in the measurement of chemical content. The manufacturer shall not ship finished product outside the limits specified in Table 1 for the applicable grade.

7. Tensile Requirements

7.1 The tensile properties of the pipe in the condition specified at room temperature, shall conform to the requirements prescribed in Table 3. Mechanical properties for other conditions may be established by agreement between the manufacturer and the purchaser.

8. Bending Test

8.1 Pipe 2 in. (51 mm) and under in nominal diameter, shall be capable of being bent cold through 90° around a cylindrical mandrel that is twelve times the nominal diameter of the pipe, without developing cracks.

9. Flattening Test

9.1 Welded or seamless pipe shall be capable of withstanding, without cracking, flattening under a load applied

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