



# Standard Specification for Seamless and Welded Zirconium and Zirconium Alloy Pipe<sup>1</sup>

This standard is issued under the fixed designation B 658/B 658M; 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 reappraisal. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reappraisal.

## 1. Scope

1.1 This specification<sup>2</sup> covers three grades of seamless and welded zirconium pipe.

1.2 Unless a single unit is used, for example corrosion mass gain in  $\text{mg}/\text{dm}^2$ , the values stated in either inch-pound or SI units are to be regarded separately as standard. The values stated in each system are not exact equivalents; therefore each system must be used independently of the other. SI values cannot be mixed with inch-pound values.

1.3 The following precautionary caveat pertains only to the test methods portions 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 establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

## 2. Referenced Documents

2.1 *ASTM Standards:*

E 8 Test Methods for Tension Testing of Metallic Materials<sup>3</sup>

2.2 *ANSI Standard:*

B36.19 Stainless Steel Pipe<sup>4</sup>

2.3 *ASME Standard:*

ASME Boiler and Pressure Vessel Code, Section IX<sup>5</sup>

## 3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *annealed*—for purposes of this specification “annealed” denotes material that exhibits a recrystallized grain structure.

3.2 *Lot Definitions:*

3.2.1 *castings*—a lot shall consist of all castings produced from the same pour.

3.2.2 *ingot*—no definition required.

3.2.3 *rounds, flats, tubes, and wrought powder metallurgical products (single definition, common to nuclear and non-nuclear standards)*—a lot shall consist of a material of the same size, shape, condition, and finish produced from the same ingot or powder blend by the same reduction schedule and the same heat treatment parameters. Unless otherwise agreed between manufacturer and purchaser, a lot shall be limited to the product of an 8 h period for final continuous anneal, or to a single furnace load for final batch anneal.

3.2.4 *sponge*—a lot shall consist of a single blend produced at one time.

3.2.5 *weld fittings*—definition is to be mutually agreed upon between manufacturer and the purchaser.

## 4. Classification

4.1 The pipe is furnished in three grades as follows:

4.1.1 *Grade R60702*—Unalloyed zirconium.

4.1.2 *Grade R60704*—Zirconium-tin alloy.

4.1.3 *Grade R60705*—Zirconium-niobium alloy.

## 5. Ordering Information

5.1 Orders for materials under this specification should include the following information:

5.1.1 Quantity (weight or total length),

5.1.2 Name of material (zirconium pipe),

5.1.3 Grade number (see 4.1),

5.1.4 Nominal pipe size and schedule (Table X1.1),

5.1.5 Lengths (random or specified cut lengths),

5.1.6 Method of manufacture (Section 6),

5.1.7 Workmanship and quality level requirements (Section 10),

5.1.8 ASTM designation and year of issue, and

5.1.9 Additions to the specification and supplementary requirements, if required.

NOTE 1—A typical ordering description is as follows: 240-ft (70 mm) zirconium pipe, seamless, descaled 3.0-in. (75 mm) Schedule 40 by 12-ft (3 m) lengths, ASTM B 658, dated \_\_\_\_, Grade R60702.

## 6. Materials and Manufacture

6.1 Seamless pipe shall be made from any seamless method that will yield a product meeting this specification.

6.2 Pipe containing welded seams or other joints made by

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<sup>2</sup> For ASME Boiler and Pressure Vessel Code Applications, see related Specification SB-658 in Section II of that Code.

<sup>3</sup> *Annual Book of ASTM Standards*, Vol 03.01.

<sup>4</sup> Available from American National Standards Institute, 11 W. 42nd St., 13th Floor, New York, NY 10036.

<sup>5</sup> Available from American Society of Mechanical Engineers, 345 E. 47th St., New York, NY 10017.

welding shall comply with the following provisions:

6.2.1 Welded by welders, welding operators, and welding procedures qualified under the provisions of Section IX of the ASME Boiler and Pressure Vessel Code.

6.2.2 Filler metal, when used, shall be the same grade as the base metal.

6.3 The pipe shall be furnished in the annealed or stress-relieved condition.

## 7. Chemical Composition

7.1 The material shall conform to the requirements as to chemical composition prescribed in Table 1.

7.2 The manufacturer's ingot analysis shall be considered the chemical analysis for piping, except for hydrogen and nitrogen, which shall be determined on the finished product.

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

7.3.1 The manufacturer's analysis shall be considered as verified if the check analysis confirms the manufacturer's reported values within the tolerances prescribed in Table 2.

## 8. Tensile Requirements

8.1 The material, as represented by the test specimens, shall conform to the tensile properties prescribed in Table 3.

## 9. Permissible Variations in Dimensions

9.1 *Diameter*—Variations in outside diameters shall not exceed those prescribed in Table 4.

9.2 *Thickness*—The variation in thickness at any point shall not be more than  $\pm 12.5\%$  of the nominal wall thickness specified.

### 9.3 Length:

9.3.1 Pipe shall be furnished in lengths as specified in the purchase order. No pipe shall be under the specified length and not more than  $\frac{1}{4}$  in. (6.4 mm) over that specified.

9.3.2 For pipe ordered to random lengths, the lengths and variations shall be agreed upon between the manufacturer and the purchaser.

NOTE 2—A system of standard pipe sizes approved by the American National Standards Institute as ANSI B36.19, reproduced as Table X1.1, shall apply, pending the development of similar standards for zirconium.

## 10. Workmanship, Finish and Appearance

10.1 The finished pipe shall be reasonably straight, shall

**TABLE 2 Permissible Variation in Check Analysis Between Different Laboratories**

Element	Permissible Variation in Product Analysis, %
Hydrogen	0.002
Nitrogen	0.01
Carbon	0.01
Hafnium	0.1
Iron + chromium	0.025
Tin	0.05
Niobium	0.05
Oxygen	0.02

**TABLE 3 Tensile Requirements**

	UNS Grade Designations		
	R60702	R60704	R60705
Tensile strength, min, ksi (MPa)	55 (380)	60 (415)	80 (550)
Yield strength, min, ksi (MPa)	30 (205)	35 (240)	55 (380)
Elongation in 2 in. or 50 mm, min, % <sup>A</sup>	16	14	16

<sup>A</sup>When a sub-size specimen is used, the gage length shall be as specified in Test Methods E 8 for that specimen.

**TABLE 4 Permissible Variations in Diameter<sup>A</sup>**

Nominal Diameter, in. (mm)	Permissible Variations in Outside Diameter, in. (mm)	
	Over	Under
$\frac{1}{8}$ to $1\frac{1}{2}$ (3.2 to 40), incl	$\frac{1}{64}$ (.4)	$\frac{1}{32}$ (.8)
Over $1\frac{1}{2}$ to 4 (40 to 100), excl	$\frac{1}{32}$ (.8)	$\frac{1}{32}$ (.8)
Over 4 to 8 (100 to 200), incl	$\frac{1}{16}$ (1.6)	$\frac{1}{32}$ (.8)
Over 8 to 12 (200 to 305), excl	$\frac{3}{32}$ (2.4)	$\frac{1}{32}$ (.8)

<sup>A</sup>For seamless pipe only. Tolerances on welded pipe shall be as agreed upon between the manufacturer and the purchaser.

have smooth ends, free of burrs, and shall be free of cracks, seams, blisters, and other injurious imperfections in accordance with standards of acceptability agreed upon between the manufacturer and the purchaser. Minor defects may be removed provided the dimensional tolerances in accordance with Section 9 are not exceeded. Unless otherwise specified, the pipe shall be furnished free of scale.

## 11. Sampling

11.1 The lot shall be in accordance with 3.2.

**TABLE 1 Chemical Requirements<sup>A</sup>**

Element	Composition, %		
	R60702	UNS Grade Designation R60704	R60705
Zirconium + hafnium, min	99.2	97.5	95.5
Hafnium, max	4.5	4.5	4.5
Iron + chromium	0.2 max	0.2 to 0.4	0.2 max
Tin	...	1.0 to 2.0	...
Hydrogen, max	0.005	0.005	0.005
Nitrogen, max	0.025	0.025	0.025
Carbon, max	0.05	0.05	0.05
Niobium	...	...	2.0 to 3.0
Oxygen, max	0.16	0.18	0.18

<sup>A</sup>By agreement between the purchaser and the manufacturer, analysis may be required and limits established for elements and compounds not specified in the table of chemical compositions.

## 12. Number of Tests and Retests

12.1 One longitudinal tension test shall be made from each lot, see 13.1.

12.2 One chemistry test for hydrogen and nitrogen content shall be made from each lot of finished product, see 13.3.

12.3 A hydrostatic proof test shall be performed on each length of pipe, 13.2.

12.4 *Retests:*

12.4.1 If any sample or specimen exhibits obvious surface contamination or improper preparation disqualifying it as a truly representative sample, it shall be discarded and a new sample or specimen substituted.

12.4.2 If the results of any tests of any lot do not conform to the requirements specified, retests shall be made on additional pipe of double the original number from the same lot, each of which shall conform to the requirements specified.

12.4.3 Retesting after failure of initial retests may be done only with the approval of the purchaser.

## 13. Test Methods

13.1 *Tension Tests*—Conduct the tension test in accordance with Test Methods E 8. Determine the yield strength by the offset (0.2 %) method. Determine the tensile properties using a strain rate of 0.003 to 0.007 in./in. (mm/mm)/min through the yield strength. After the yield strength has been exceeded, the cross-head speed may be increased to approximately 0.05 in./in. (mm/mm)/min to failure.

13.2 *Hydrostatic Tests*—Prior to dimensional checks, upsetting, swaging, expanding, or other forming operations, test each pipe 1/8 in. (3.2 mm) and larger in outside diameter, and with wall thickness of 0.015 in. (0.4 mm) and over to a hydrostatic pressure sufficient to produce a fiber stress of three fourths of the minimum yield strength of the tubing, provided that the test pressure does not exceed 5000 psi (35 MPa). Determine the test pressure as follows:

$$P = 2St/D \quad (1)$$

where:

$P$  = hydrostatic test pressure, psi (MPa),

$S$  = allowable fiber stress of three fourths of the minimum yield strength (Table 2), psi (MPa),

$t$  = average wall thickness of the pipe, in. (mm), and

$D$  = nominal diameter of the pipe, in. (mm).

13.3 *Chemical Tests*—Conduct the chemical analysis by the standard techniques normally used by the manufacturer.

## 14. Inspection

14.1 The manufacturer shall inspect the material covered by this specification prior to shipment and, on request, shall furnish the purchaser with certificates of test. If so specified in the purchase order, the purchaser or his representative may witness the testing and inspection of the material at the place of manufacture. In such cases, the purchaser shall state in his purchase order which tests he desires to witness. The manufacturer shall give ample notice to the purchaser as to the time

and place of the designated tests. If the purchaser's representative does not present himself at the time agreed upon for the testing, the manufacturer shall consider the requirement for the purchaser's inspection at the place of manufacture to be waived.

14.2 The manufacturer shall afford the inspector representing the purchaser, without charge, all reasonable facilities to satisfy him that the material is being furnished in accordance with this specification. This inspection shall be so conducted as not to interfere unnecessarily with the operation of the works.

## 15. Rejection

15.1 Rejection for failure of the material to meet the requirements of this specification shall be reported to the manufacturer within 60 calendar days from the receipt of the material by the purchaser. Unless otherwise specified, rejected material may be returned to the manufacturer at the manufacturer's expense, unless the purchaser receives, within three weeks of the notice of rejection, other instructions for disposition.

## 16. Certification

16.1 A producer or supplier shall furnish the purchaser with a certificate that the material was manufactured, sampled, tested, and inspected in accordance with this specification and has been found to meet the requirements. The certificate shall include a report of the test results.

## 17. Referee

17.1 In the event of disagreement between the manufacturer and the purchaser on the conformance of the material to the requirements of this specification or any special test specified by the purchaser, a mutually acceptable referee shall perform the tests in question. The results of the referee's testing shall be used in determining conformance of the material to this specification.

## 18. Product Marking

18.1 Unless otherwise specified, each length of pipe 3/8 in. (9.5 mm) nominal diameter and larger, manufactured in accordance with this specification, shall be marked legibly, either by stenciling, stamping, or rolling, with the manufacturer's private identifying mark, the ASTM designation, the grade, and head number. On smaller than 3/8-in. (9.5-mm) nominal diameter pipe that is bundled, the same information may be stamped legibly on a metal tag securely attached to each bundle.

## 19. Packaging and Package Marking

19.1 Pipe shall be packaged suitably in such a manner as to assure safe delivery to its destination when properly transported by common carrier.

## 20. Keywords

20.1 pipe; zirconium; zirconium alloy

**APPENDIX**
**(Nonmandatory Information)**
**X1. PIPE DIMENSIONS**

X1.1 Table X1.1 is from Table 1 of ANSI B36.19, with the SI units added in this standard.

**TABLE X1.1 Dimensions of Welded and Seamless Zirconium Pipe**

NOTE 1—The decimal thickness listed for the respective pipe sizes represents their nominal or average wall dimensions.

Nominal Pipe Size, in. (mm)	Outside Diameter, in. (mm)	Nominal Wall Thickness, in. (mm)			
		Schedule 5S	Schedule 10S	Schedule 40S	Schedule 80S
1/8 (3.2)	0.405 (10.3)	...	0.049 (1.24)	0.068 (1.73)	0.095 (2.41)
1/4 (6.4)	0.540 (13.7)	...	0.065 (1.65)	0.088 (2.24)	0.119 (3.02)
3/8 (9.5)	0.675 (17.1)	...	0.065 (1.65)	0.091 (2.31)	0.126 (3.20)
1/2 (13)	0.840 (21.3)	0.065 (1.65)	0.083 (2.11)	0.109 (2.77)	0.147 (3.73)
3/4 (20)	1.050 (26.7)	0.065 (1.65)	0.083 (2.11)	0.113 (2.87)	0.154 (3.91)
1 (25)	1.315 (33.4)	0.065 (1.65)	0.109 (2.77)	0.133 (3.38)	0.179 (4.55)
1 1/4 (32)	1.660 (42.2)	0.065 (1.65)	0.109 (2.77)	0.140 (3.56)	0.191 (4.85)
1 1/2 (38)	1.900 (48.3)	0.065 (1.65)	0.109 (2.77)	0.145 (3.68)	0.200 (5.08)
2 (50)	2.375 (60.3)	0.065 (1.65)	0.109 (2.77)	0.154 (3.91)	0.218 (5.54)
2 1/2 (64)	2.875 (73.0)	0.083 (2.11)	0.120 (3.05)	0.203 (5.16)	0.276 (7.01)
3 (76)	3.500 (88.9)	0.083 (2.11)	0.120 (3.05)	0.216 (5.49)	0.300 (7.62)
3 1/2 (90)	4.000 (101.6)	0.083 (2.11)	0.120 (3.05)	0.226 (5.74)	0.318 (8.08)
4 (100)	4.500 (114.3)	0.083 (2.11)	0.120 (3.05)	0.237 (6.02)	0.337 (8.56)
5 (125)	5.583 (141.3)	0.109 (2.77)	0.134 (3.40)	0.258 (6.55)	0.375 (9.52)
6 (150)	6.625 (168.3)	0.109 (2.77)	0.134 (3.40)	0.280 (7.11)	0.432 (10.97)
8 (200)	8.625 (219.1)	0.109 (2.77)	0.148 (3.76)	0.322 (8.18)	0.500 (12.7)
10 (250)	10.750 (273.0)	0.134 (3.40)	0.165 (4.19)	0.365 (9.27)	0.500 (12.7)
12 (300)	12.750 (323.8)	0.156 (3.96)	0.180 (4.57)	0.375 (9.52)	0.500 (12.7)

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