

ASTM SPECIFICATION & TOLERANCE FOR TUBING & PIPING									
ASTM Specification		Allowable Outside Diameter Variation			Allowable Wall		Exact Length		Testing
		Nominal Diameter	Over	Under	%Over	%Under	Over	Under	
ASTM-A213	Seamless Boiler Superheater and Heat Exchanger Tubes	Under 25.4	0.1016	0.1016	20	0	3.175	0	Flattening Test Tension Test Flare Test Hardness Test 100% Hydrostatic test Refer to ASTM A-450
		25.4-38.1 incl	0.1524	0.1524	22	0	3.175	0	
		38.1-50.8 excl	0.2032	0.2032	22	0	3.176	0	
		50.8-63.5 excl	0.254	0.254	22	0	4.46	0	
		63.5-76.2 excl	0.3048	0.3048	22	0	4.76	0	
		76.2-101.6 incl	0.381	0.381	22	0	4.76	0	
ASTM-A249	Welded Boiler Superheater, Heat Exchanger And Condenser Tubes	Under 25.4	0.1016	0.1016	10	-10	3.175	0	Tension Test Flattening Test Flange Test Reverse Bend Test Hardness Test 100% Hydrostatic Test
		25.4-38.1 incl	0.1524	0.1524	10	-10	3.175	0	
		38.1-50.8 Excl	0.2032	0.2032	10	-10	3.175	0	
		50.0-63.5 excl	0.254	0.254	10	-10	4.762	0	
		63.5-76.2 excl	0.3848	0.3048	10	-10	4.762	0	
		76.2-101.6 incl	0.381	0.381	10	-10	4.762	0	
ASTM-A269	Seamless & Welded Tubing for General Service	Untp 12.7	0.13	0.13	15	-15	3.2	0	Flare Test (Seamless Only) Flange Test (Welded Only) Hardness Test Reverse Flattening Test (Welded only) 100% Hydrostatic Test
		12.7-38.1 excl	0.13	0.13	10	-10	3.2	0	
		38.1-88.9 excl	0.25	0.25	10	-10	4.8	0	
		88.9-139.7 excl	0.38	0.38	10	-10	4.8	0	
		139.7-203.2 excl	0.76	0.76	10	-10	4.8	0	
ASTM-A270	Seamless & Welded Sanitary Tubing	25.4	0.05	0.2	10	-10	3.2	0	Reverse flattening Test 100% Hydrostatic Test External' polish on all tubes Refer to ASTM A-270
		38.1	0.05	0.2	10	-10	3.2	0	
		50.8	0.05	0.28	10	-10	3.2	0	
		60.5	0.05	0.28	10	-10	3.2	0	
		76.2	0.08	0.3	10	-10	3.2	0	
		101.6	0.08	0.38	10	-10	4.8	0	
ASTM-A312	Seemless & Welded pipe	3.175-38.1 incl	0.4	0.79	Minimum Wall 12.5% under nominal wall Specified		6.4	0	Tension Test Flattening Test 100% Hydrostatic Test Refer to ASTM A-530
		38.1-1016 incl	0.79	0.79			6.4	0	
		101.6-203.2 incl	1.59	0.79			6.4	0	
ASTM A-358	Welded pipe	219.08-750mm	0.50%	----	-0.3	---	6	----	Refer to ASTM A-530

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