Standard Specification for
Piping Fittings of Wrought Carbon Steel and Alloy Steel for
Moderate and High Temperature Service¹

1. Scope

1.1 This specification covers wrought carbon steel and alloy steel fittings of seamless and welded construction covered by the latest revision of ASME B16.9, B16.11, MSS-SP-79, MSS-SP-83, MSS-SP-95, and MSS-SP-97. These fittings are for use in pressure piping and in pressure vessel fabrication for service at moderate and elevated temperatures. Fittings differing from those ASME and MSS standards shall be furnished in accordance with Supplementary Requirement S58 of Specification A960/A960M.

1.2 Optional supplementary requirements are provided for fittings where a greater degree of examination is desired. When desired, one or more of these supplementary requirements may be specified in the order.

1.3 This specification does not cover cast welding fittings or fittings machined from castings. Cast steel welding fittings are governed by Specifications A216/A216M and A217/A217M.

1.4 This specification is expressed in both inch-pound units and in SI units. However, unless the order specifies the applicable “M” specification designation (SI units), the material shall be furnished to inch-pound units.

1.5 The values stated in either SI units or inch-pound units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.6 This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.

2. Referenced Documents

2.1 In addition to those reference documents listed in Specification A960/A960M, the following list of standards apply to this specification.

2.2 ASTM Standards:³
A105/A105M Specification for Carbon Steel Forgings for Piping Applications
A216/A216M Specification for Steel Castings, Carbon, Suitable for Fusion Welding, for High-Temperature Service
A217/A217M Specification for Steel Castings, Martensitic Stainless and Alloy, for Pressure-Containing Parts, Suitable for High-Temperature Service
A960/A960M Specification for Common Requirements for Wrought Steel Piping Fittings

2.3 ASME Standards:⁴
B16.9 Steel Butt-Welding Fittings
B16.11 Forged Steel Fittings, Socket Welding and Threaded
2.4 ASME Boiler and Pressure Vessel Code:⁴
Section V
Section VIII, Division 1
Section IX

2.5 MSS Standards:⁵
MSS-SP-25 Standard Marking System for Valves, Fittings, Flanges, and Unions
MSS-SP-79 Socket Welding Reducer Inserts
MSS-SP-83 Steel Pipe Unions, Socket-Welding and Threaded

¹This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.22 on Steel Forgings and Wrought Fittings for Piping Applications and Bolting Materials for Piping and Special Purpose Applications. Current edition approved May 15, 2013. Published June 2017. Originally approved in 1940. Last previous edition approved in 2016 as A234/A234M-16. DOI: 10.1520/A0234/A0234M-17.

³For ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For Annual Book of ASTM Standards volume information, refer to the standard’s Document Summary page on the ASTM website.


*A Summary of Changes section appears at the end of this standard
MSS-SP-95 Swage(d) Nipples and Bull Plugs
MSS-SP-97 Integrally Reinforced Forged Branch Outlet
Fittings—Socket Welding, Threaded and Butt welding
Ends

2.6 ASNT Standard. 6
SNT-TC-1A Recommended Practice for Nondestructive
Testing Personnel Qualification and Certification

2.7 AWS Specifications 7
A5.5/A5.5M Specification for Low-Alloy Steel Electrodes
for Shielded Metal Arc Welding
A5.23/A5.23M Specification for Low-Alloy Steel Elec-
trodes and Fluxes for Submerged Arc Welding
A5.28/A5.28M Specification for Low-Alloy Steel Elec-
trodes for Gas Shielded Arc Welding
A5.29/A5.29M Low-Alloy Steel Electrodes for Flux Cored
Arc Welding

3. Ordering Information
3.1 See Specification A960/A960M.

4. General Requirements

4.1 Product furnished to this specification shall conform to
the requirements of Specification A960/A960M, including any
supplementary requirements that are indicated in the purchase
order. Failure to comply with the requirements of Specification
A960/A960M constitutes non-conformance with this specifi-
cation. In case of a conflict between the requirements of this
specification and Specification A960/A960M, this specification
shall prevail.

5. Materials

5.1 The starting material for fittings shall be fully killed
steel, consisting of forgings, bars, plates, sheet, and seamless or
fusion-welded tubular products with filler metal added and
shall conform to the chemical requirements of Table 1. Unless
otherwise specified for carbon steel plates and sheet, the steel
may be made to either coarse grain or fine grain practice. Grade
WP9 shall be made to fine grain practice.

5.2 A starting material specification that specifically re-
quires the addition of any element beyond those listed for the
materials in Table 1 for the applicable grade of material is not
permitted. This does not preclude the use of deoxidizers or the
judicious use of elements for grain size control.

6. Manufacture

6.1 Forging or shaping operations may be performed by
hammering, pressing, piercing, extruding, upsetting, rolling,
bending, fusion welding, machining, or by a combination of
two or more of these operations. The forming procedure shall
be so applied that it will not produce injurious imperfections in
the fittings.

6.2 Fittings NPS-4 and under may be machined from
hot-forged or rolled, cold-sized, and straightened bar stock
having the chemical composition of the Grade in Table 1 and
the mechanical properties of the Grade in Table 2. Heat
treatment shall be in accordance with Section 7. All caps
machined from bar stock shall be examined by liquid penetrant
or magnetic particle in accordance with S52 or S53 in
Specification A960/A960M.

6.3 All welds including welds in tubular products from
which fittings are made shall be (J) made by welders, welding
operators, and welding procedures qualified under the provi-
sions of ASME Section IX, (2) heat treated in accordance with
Section 7 of this specification, and (3) radiographically exam-
ined throughout the entire length of each weld in accordance
with Article 2, ASME Section V with acceptance limits in
accordance with Paragraph UW-51 of ASME Section VIII,
Division 1 of the ASME Boiler & Pressure Vessel Code. In
place of radiographic examination, welds may be ultrasonically
examined in accordance with Appendix 12 of Section VIII. The
NDE of welds in Grades WP5, WPC, WP1, WP11 Class 1,
WP11 Class 2, WP11 Class 3, WP12 Class 1, WP12 Class 2,
and WPR may be performed either prior to or after forming.
NDE of welds in Grades WP5, WP9, WP91, WP92, WP22
Class 1, WP22 Class 3, and WP24 shall be done after
forming.

6.3.1 All welds in WP91 shall be made, with one of the
following welding processes and consumables: SMAW, A5.5/
A5.5M E90XX-B9; SAW, A5.23/A5.23M EB9 + flux; GTAW,
A5.28/A5.28M ER90S-B9; and FCAW A5.29/A5.29M E91T1-
B9. In addition, the Ni+Mn content of all welding consumables
used to fabricate WP91 fittings shall not exceed 1.0%.

6.3.2 All welds in WP92 and WP911 shall be made using
welding consumables meeting the chemical requirements for
the grade in Table 1.

6.4 Personnel performing NDE examinations shall be quali-
fied in accordance with SNT-TC-1A.

6.5 The welded joints of the fittings shall be finished in
accordance with the requirements of Paragraph UW-35 (a)
of ASME Section VIII, Division 1.

6.6 All butt-weld tees manufactured by cold-forming meth-
od(s) shall be liquid penetrant or magnetic particle examined
by one of the methods specified in Supplementary Requirement
S52 or S53 in Specification A960/A960M. This examination
shall be performed after final heat treat. Only the side wall area
of the tees need be examined. This area is defined by a circle
that covers the area from the weld bevel of the branch outlet
to the center line of the body or run. Internal and external surfaces
shall be examined when size permits accessibility. No cracks
shall be permitted. Other imperfections shall be treated in
accordance with Section 14 on Surface Quality. After the
removal of any crack, the tee(s) shall be re-examined by the
original method. Acceptable tees shall be marked with the
symbol PT or MT, as applicable, to indicate compliance.

6.7 Stubends may be produced with the entire lap added by
the welding of a ring, made from plate or bar of the same alloy
grade and composition, to the outside of a straight section of
pipe, provided the weld is double welded, is a full penetration

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6 Available from American Society for Nondestructive Testing (ASNT), P.O. Box
7 Available from American Welding Society (AWS), 550 NW LeJeune Rd.,
### TABLE 1 Chemical Requirements

<table>
<thead>
<tr>
<th>Grade and Marking Symbol</th>
<th>Carbon</th>
<th>Manganese</th>
<th>Phosphorus</th>
<th>Sulfur</th>
<th>Silicon</th>
<th>Chromium</th>
<th>Molybdenum</th>
<th>Nickel</th>
<th>Copper</th>
<th>Others</th>
</tr>
</thead>
<tbody>
<tr>
<td>WPG-2,2,2,2,2</td>
<td>0.30</td>
<td>0.29-1.08</td>
<td>0.050</td>
<td>0.058</td>
<td>0.10 min</td>
<td>0.40</td>
<td>0.15 max</td>
<td>0.40</td>
<td>0.40</td>
<td>Vanadium 0.08</td>
</tr>
<tr>
<td>WPC-2,2,2,2,2</td>
<td>0.35</td>
<td>0.29-1.08</td>
<td>0.050</td>
<td>0.058</td>
<td>0.10 min</td>
<td>0.40</td>
<td>0.15 max</td>
<td>0.40</td>
<td>0.40</td>
<td>Vanadium 0.08</td>
</tr>
<tr>
<td>WP1</td>
<td>0.28</td>
<td>0.30-0.80</td>
<td>0.045</td>
<td>0.045</td>
<td>0.10-0.50</td>
<td>0.40</td>
<td>0.15 max</td>
<td>0.40</td>
<td>0.40</td>
<td>Vanadium 0.08</td>
</tr>
<tr>
<td>WP12 CL1, WP12 CL2</td>
<td>0.05-0.20</td>
<td>0.30-0.80</td>
<td>0.045</td>
<td>0.045</td>
<td>0.60</td>
<td>0.60-1.25</td>
<td>0.44-0.65</td>
<td>0.40</td>
<td>0.40</td>
<td>Vanadium 0.08</td>
</tr>
<tr>
<td>WP11 CL1, WP11 CL2</td>
<td>0.05-0.15</td>
<td>0.30-0.60</td>
<td>0.030</td>
<td>0.030</td>
<td>0.50</td>
<td>1.00-1.60</td>
<td>0.44-0.65</td>
<td>0.40</td>
<td>0.40</td>
<td>Vanadium 0.08</td>
</tr>
<tr>
<td>WP11 CL2, WP11 CL3</td>
<td>0.05-0.20</td>
<td>0.30-0.80</td>
<td>0.040</td>
<td>0.040</td>
<td>0.50</td>
<td>1.00-1.60</td>
<td>0.44-0.65</td>
<td>0.40</td>
<td>0.40</td>
<td>Vanadium 0.08</td>
</tr>
<tr>
<td>WP22 CL1, WP22 CL3</td>
<td>0.05-0.15</td>
<td>0.30-0.60</td>
<td>0.040</td>
<td>0.040</td>
<td>0.50</td>
<td>1.90-2.60</td>
<td>0.67-1.13</td>
<td>0.75-1.25</td>
<td>Aluminum 0.20</td>
<td></td>
</tr>
<tr>
<td>WP24</td>
<td>0.05-0.10</td>
<td>0.30-0.70</td>
<td>0.020</td>
<td>0.010</td>
<td>0.15-0.45</td>
<td>2.20-2.60</td>
<td>0.90-1.10</td>
<td>0.75-1.25</td>
<td>Aluminum 0.20</td>
<td></td>
</tr>
</tbody>
</table>

| WP5 CL1, WP5 CL3        | 0.15    | 0.30-0.60  | 0.040      | 0.030  | 0.50     | 4.0-8.0   | 0.44-0.65  | 0.40   | 0.40   | Vanadium 0.18-0.25 |
| WP9 CL1, WP9 CL3        | 0.15    | 0.30-0.60  | 0.030      | 0.030  | 1.00     | 8.0-10.0  | 0.90-1.10  | 0.40   | 0.40   | Vanadium 0.18-0.25 |
| WPR                     | 0.20    | 0.40-1.06  | 0.045      | 0.050  | 0.50     | 8.0-10.0  | 0.90-1.10  | 0.40   | 0.40   | Vanadium 0.18-0.25 |
| WP91                    | 0.08-0.12 | 0.30-0.60  | 0.020      | 0.010  | 0.20-0.50 | 8.0-10.0  | 0.90-1.10  | 0.40   | 0.40   | Vanadium 0.18-0.25 |
| WP911                   | 0.09-0.13 | 0.30-0.60  | 0.020      | 0.010  | 0.10-0.50 | 8.5-9.5   | 0.90-1.10  | 0.40   | 0.40   | Vanadium 0.18-0.25 |
| WP92                    | 0.07-0.13 | 0.30-0.60  | 0.020      | 0.010  | 0.50     | 8.50-9.50 | 0.90-1.10  | 0.40   | 0.40   | Vanadium 0.18-0.25 |

- **When fittings are of welded construction, the grade and marking symbol shown above shall be supplemented by letter "W".**
- **Fittings made from bar or plate may have 0.35 max carbon.**
- **Fittings made from forgings may have 0.35 max carbon and 0.35 max silicon with no minimum.**
- **For each reduction of 0.01% below the specified carbon maximum, an increase of 0.08% manganese above the specified maximum will be permitted, up to a maximum of 1.85%.**
- **The sum of Copper, Nickel, Chromium, and Molybdenum shall not exceed 1.00%.**
- **The sum of Copper, Nickel, Chromium, and Molybdenum shall not exceed 1.00%.**
- **The sum of Copper, Nickel, Chromium, and Molybdenum shall not exceed 1.00%.**
- **The sum of Copper, Nickel, Chromium, and Molybdenum shall not exceed 1.00%.**

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Joint, satisfies the requirements of 6.3 for qualifications and 7.3.4 for post weld heat treatment.

7. **Heat Treatment**

7.1 **Heat Treatment Procedures**—Fittings, after forming at an elevated temperature, shall be cooled to a temperature below the critical range under suitable conditions to prevent injurious defects caused by too rapid cooling, but in no case more rapidly than the cooling rate in still air. Heat treatment temperatures specified are metal (part) temperatures. Heat-treated fittings shall be treated according to paragraph 7 in Specification A960/A960M.

7.2 **WPB, WPC, and WPR Fittings:**

7.2.1 Hot-formed WPB, WPC, and WPR fittings upon which the final forming operation is completed at a temperature above 1150 °F [620 °C] and below 1800 °F [980 °C] need not be heat treated provided they are cooled in still air.

7.2.2 Hot-formed or forged WPB, WPC, and WPR fittings finished at temperature in excess of 1800 °F [980 °C] shall subsequently be annealed, normalized, or normalized and tempered. Hot-forged fittings NPS 4 or smaller need not be heat treated.

7.2.3 WPB, WPC, and WPR fittings over NPS 12, produced by locally heating a portion of the fitting stock to any
### TABLE 2 Tensile Requirements

**Note 1**—Where an ellipsis (...) appears in this table, there is no requirement.

<table>
<thead>
<tr>
<th>Grade and Marking Symbol</th>
<th>WPB</th>
<th>WP11 CL2, WP12 CL2</th>
<th>WP1</th>
<th>WP11 CL1, WP22 CL1, WP5 CL1</th>
<th>WPR</th>
<th>WP11 CL3, WP22 CL3, WP5 CL3</th>
<th>WP12 CL3</th>
<th>WP24</th>
<th>WP91</th>
<th>WP92</th>
<th>WP911</th>
<th>WP12 CL1</th>
</tr>
</thead>
</table>

#### Elongation Requirements

<table>
<thead>
<tr>
<th>Grades</th>
<th>Longitudinal</th>
<th>Transverse</th>
<th>Longitudinal</th>
<th>Transverse</th>
<th>Longitudinal</th>
<th>Transverse</th>
</tr>
</thead>
<tbody>
<tr>
<td>All Grades except WP91, WP911</td>
<td>22</td>
<td>14</td>
<td>20</td>
<td>20</td>
<td></td>
<td></td>
</tr>
<tr>
<td>WP91, WP92, WP911</td>
<td>30</td>
<td>20</td>
<td>28</td>
<td>28</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

*Rectangular specimen for wall thickness 9⁄32 in. [7.94 mm] and over, and for all small sizes tested in full section; min % in 2 in. [50 mm]*

For each 3⁄8 in. [0.79 mm] decrease in wall thickness below 9⁄32 in. [7.94 mm], a deduction of 1.5 % for longitudinal and 1.0 % for transverse from the values shown above is permitted. The following table gives the minimum value for various wall thicknesses.

#### Wall Thickness

<table>
<thead>
<tr>
<th>Grades</th>
<th>Longitudinal</th>
<th>Transverse</th>
<th>Longitudinal</th>
<th>Transverse</th>
</tr>
</thead>
<tbody>
<tr>
<td>All Grades except WP91, WP911</td>
<td>28.0</td>
<td>20.0</td>
<td>20.0</td>
<td>19.0</td>
</tr>
<tr>
<td>WP91, WP92, WP911</td>
<td>25.0</td>
<td>18.0</td>
<td>23.5</td>
<td>17.5</td>
</tr>
</tbody>
</table>

**Note**—This table gives the computed minimum % elongation value for each 3⁄8 in. [0.79 mm] decrease in wall thickness. Where the wall thickness lies between two values above, the minimum elongation value is determined by the following equations:

**Direction of Test**

<table>
<thead>
<tr>
<th>Equation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Longitudinal</td>
</tr>
<tr>
<td>Transverse</td>
</tr>
</tbody>
</table>

**where:**

\[ E = \text{elongation in 2 in. or [50 mm], \%} \]

\( t = \text{actual thickness of specimen, in. [mm]} \).
temperature for forming, shall be subsequently annealed, normalized, or normalized and tempered. Fittings such as elbows, tees, header tees, reducers and lap joint stub ends with a carbon content less than 0.26 %, NPS 12 and under, shall not require heat treatment after forming a locally heated portion of the fitting.

7.2.4 Cold-formed WPB, WPC, and WPR fittings, upon which the final forming operation is completed at a temperature below 1150 °F [620 °C], shall be normalized, or shall be stress relieved at 1100 to 1275 °F [595 to 690 °C].

7.2.5 WPB, WPC, and WPR fittings produced by fusion welding and having a nominal wall thickness at the welded joint of ¾ in. [19 mm] or greater shall be post-weld heat treated at 1100 to 1250 °F [595 to 675 °C], or in accordance with 7.2.6.

7.2.6 At the option of the manufacturer, WPB and WPC fittings produced by any of the methods in Section 6 may be annealed, normalized, or normalized and tempered.

7.3 Fittings Other than WPB, WPC, and WPR:

7.3.1 Fittings of Grades WP1, WP11 Class 1, WP11 Class 2, WP11 Class 3, WP12 Class 1, WP12 Class 2, WP2 Class 1, WP2 Class 3, WP5, and WP9 shall be furnished in the annealed, isothermal-annealed, or normalized and tempered condition. If normalized and tempered, the tempering temperature for WP11 Class 1, WP11 Class 2, WP11 Class 3, WP12 Class 1, and WP12 Class 2 shall not be less than 1150 °F [620 °C]; for Grades WP5, WP9, WP22 Class 1, and WP22 Class 3 the tempering temperature shall not be less than 1250 °F [675 °C].

7.3.2 Fittings of Grades WP1, WP12 Class 1, or WP12 Class 2 either hot formed or cold formed may be given a final heat treatment at 1200 °F [650 °C] instead of the heat treatment specified in 7.3.1.

7.3.3 Fittings of WP24 either hot formed or cold formed shall be furnished in the normalized and tempered condition. The normalizing temperature range shall be 1800 to 1975 °F [980 to 1080 °C]. The tempering temperature range shall be 1350 to 1470 °F [730 to 800 °C].

7.3.4 Fittings in all thicknesses produced by fusion welding after the heat treatment specified in 7.3.1 shall be post-weld heat treated at a temperature not less than prescribed above for tempering except that Grade WP1 is required to be post-weld heat treated only when the nominal wall thickness at the welded joint is ½ in. [13 mm] or greater, and except that preheat and post weld heat treatment are not required for WP24 fittings whose section thickness does not exceed 0.500 in. [12.7 mm].

7.3.5 Except when Supplementary Requirement S1 is specified by the purchaser, Grade WP91 shall be normalized at 1900 °F [1040 °C] minimum, and 1975 °F [1080 °C] maximum, and tempered in the temperature range of 1350 °F [730 °C] to 1470 °F [800 °C] as a final heat treatment.

7.3.6 Grade WP911 shall be normalized in the temperature range of 1900 to 1975 °F [1040 to 1080 °C], and tempered in the temperature range of 1365 to 1435 °F [740 to 780 °C] as a final heat treatment.

7.3.7 Grade WP92 shall be normalized at 1900 °F [1040 °C] minimum, and 1975 °F [1080 °C] maximum, and tempered in the temperature range of 1350 °F [730 °C] to 1470 °F [800 °C] as a final heat treatment.

7.4 WPB and WPC Fittings Made from Bar—Cold-finished bars reduced in cross-sectional area more than 10 % by cold drawing or cold rolling are not acceptable for use in the manufacture of these fittings unless the bars have been either stress relieved in the temperature range of 1100 to 1250 °F [595 to 675 °C], normalized, normalized and tempered, or annealed. Mechanical testing must be performed subsequent to the final heat treating operation.

7.5 Liquid quenching followed by tempering shall be permitted for all grades when approved by the purchaser. Minimum tempering temperature shall be 1100 °F [595 °C] for WPB, WPC, and WPR, 1150 °F [620 °C] for Grades WP1, WP11 Class 1, WP11 Class 2, WP 12 Class 1, and WP12 Class 2 and 1250 °F [675 °C] for Grades WP5, WP9, WP22 Class 1, and 1350 °F [730 °C] for Grade WP91 and WP911. The tempering temperature range for WP24 shall be as in 7.3.3.

7.5.1 Liquid quenching followed by tempering for grades WP11 Class 3 and WP22 Class 3 shall be permitted at the manufacturer's option unless otherwise provided in the purchase order. The minimum tempering temperature for WP11 Class 3 shall be 1150 °F [620 °C] and for WP22 Class 3 shall be 1250 °F [675 °C].

8. Chemical Composition

8.1 The chemical composition of each cast or heat used shall be determined and shall conform to the requirements of the chemical composition for the respective materials listed in Table 1. The ranges as shown have been expanded to include variations of the chemical analysis requirements that are listed in the various specifications for the starting materials (pipe, tube, plate, bar, and forgings) normally used in the manufacturing of fittings to this specification.

8.2 The steel shall not contain any unspecified elements for the ordered grade to the extent that it conforms to the requirements of another grade for which that element is a specified element having a required minimum content.

8.3 Weld metal used in the construction of carbon-steel fittings shall be mild steel analysis No. A1 of Table QW-442, Section IX of the ASME Boiler and Pressure Vessel Code, No. A2 may be used for Grade WPCW.

8.4 The molybdenum and chromium content of the deposited weld metal of alloy steel fittings shall be within the same percentage range as permitted for the base metal.

8.5 Weld metal used in the construction of WP24 fittings shall be of the composition: 2.25 % Cr, 1 % Mo, 0.25 % V.

9. Tensile Requirements

9.1 The tensile properties of the fitting material shall conform to the requirements listed in Table 2.

9.1.1 Longitudinal or transverse specimens cut from either fitting or from the starting plate or pipe they were manufactured from shall be acceptable for the tension test. For fittings made from forgings, the test specimen shall meet the requirements of Specification A105/A105M for the tension test.
9.1.2 While Table 2 specifies elongation requirements for both longitudinal and transverse specimens, it is not the intent that both requirements apply simultaneously. Instead, it is intended that only the elongation requirement that is appropriate for the specimen used be applicable.

9.2 One tension test shall be made on each heat of material and in the same condition of heat treatment as the finished fittings it represents. Where plate or pipe is used for the test specimen, the specimen thickness tested shall represent all fittings made from the same heat of material in the same heat treat condition in any thickness up to and including the tested thickness.

9.3 When cold-formed fittings are furnished, samples of the raw material shall be normalized or stress relieved as required in 7.2.4. Tension tests conducted on these heat-treated samples shall be considered to be the tensile properties of the cold-formed fittings.

9.4 Records of the tension tests shall be certification that the material of the fitting meets the tensile requirements of this specification provided the heat treatments are the same. If the raw material was not tested, or the fitting is not in the same condition of heat treatment, the fitting manufacturer shall perform the required test on material representative of the finished fitting from each heat of starting material.

10. Hardness

10.1 Except when only one fitting is produced, and except for Grade WP91, a minimum of two pieces, per batch or continuous run shall be hardness tested to ensure the fittings are within the following limits for each grade in Table 2. The purchaser may verify that the requirement has been met by testing at any location on the fitting provided such testing does not render the fitting useless.

10.1.1 Fittings of Grades WP5, WP9, and WPR—217 HBW maximum.

10.1.2 Fittings of Grade WP24 and WP911—248 HBW maximum.

10.1.3 Fittings of Grade WP92—269 HBW maximum.

10.1.4 Fittings of all other grades—190 HBW maximum.

10.2 All fittings of Grade WP91 shall be hardness tested and shall have a hardness of 190 HBW-250 HBW.

10.3 When additional hardness testing of the fittings is required, see Supplementary Requirement S57 in Specification A960/A960M.

11. Hydrostatic Tests

11.1 See Specification A960/A960M.

12. Nondestructive Examination

12.1 For WP91 and WP92 fittings, one of the following examinations, as found in the Supplementary Requirements of Specification A960/A960M, shall be performed: S52 Liquid Penetra...
18.1.1 Chemical analysis results, Section 8 (Table 1), reported results shall be to the same number of significant figures as the limits specified in Table 1 for that element.

18.1.2 Tensile property results, Section 9 (Table 2), report the yield strength and tensile strength in ksi [MPa] and elongation in percent.

18.1.3 Hardness results, Section 10.

18.1.4 Type heat treatment, if any, Section 7.

18.1.5 Seamless or welded,

18.1.6 Starting material, specifically pipe, plate, etc.,

18.1.7 Statement regarding radiographic or ultrasonic examination, Section 6.3, and

18.1.8 Any supplementary testing required by the purchase order.

19. Product Marking

19.1 In addition to marking requirements of A960/A960M, the following marking requirements shall apply:

19.1.1 Butt-welding fittings shall be marked with the fitting designation for marking in accordance with Annex A1.

19.1.2 Butt-welding fittings containing welds that have been ultrasonically examined instead of radiography shall be marked U after heat identity.

19.1.3 Threaded or socket-welding fittings shall be marked with the pressure class and fitting designation for marking in accordance with Annex A1. Plugs and bushings furnished to ASME B16.11 requirements are not required to be marked.

19.1.4 When agreed upon between the purchaser and manufacturer, and specified in the order, the markings shall be painted or stenciled on the fitting or stamped on a metal or plastic tag which shall be securely attached to the fitting.

19.2 Bar Coding—In addition to the requirements in 19.1, bar coding is acceptable as a supplemental identification method. The purchaser may specify in the order a specific bar coding system to be used. The bar coding system, if applied at the discretion of the supplier, should be consistent with one of the published industry standards for bar coding. If used on small fittings, the bar code may be applied to the box or a substantially applied tag.

20. Keywords

20.1 pipe fittings—steel; piping applications; pressure containing parts; pressure vessel service; temperature service applications—elevated

SUPPLEMENTARY REQUIREMENTS

These requirements shall not be considered unless specified in the order, in which event, the supplementary requirements specified shall be made at the place of manufacture, unless otherwise agreed upon, at the purchaser’s expense. The test specified shall be witnessed by the purchaser’s inspector before shipment of material, if so specified in the order.

S1. Alternative Heat Treatment—Grade WP91

S1.1 Grade WP91 shall be normalized in accordance with 7.3.5 and tempered at a temperature, to be specified by the purchaser, less than 1350 °F [730 °C]. It shall be the purchaser’s responsibility to subsequently temper the entire fitting in the temperature range of 1350 °F [730 °C] to 1470 °F [800 °C] as a final heat treatment. All mechanical tests shall be made on material heat treated in accordance with 7.3.5. The certification shall reference this supplementary requirement indicating the actual tempering temperature applied. The notation “S1” shall be included with the required marking of the fitting.

S2. Restricted Vanadium Content

S2.1 The vanadium content of the fittings shall not exceed 0.03 %.

S3. Carbon Equivalent

S3.1 For grades WPB and WPC, the maximum carbon equivalent (C.E.), based on heat analysis and the following formula, shall be 0.50.

\[
C.E. = C + \frac{Mn}{5} + \frac{Cr+Mo+V}{5} + \frac{Ni+Cu}{15}
\]

S3.2 A lower maximum carbon equivalent may be agreed upon between the purchaser and the supplier.

S3.3 The C.E. shall be reported on the test report.
### TABLE A1.1 Fitting Designation for Marking Purposes

<table>
<thead>
<tr>
<th>Grade</th>
<th>Class</th>
<th>Construction</th>
<th>Mandatory Marking</th>
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<tr>
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<td>WP12 CL1W^A</td>
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<td>CL2</td>
<td>S (Seamless construction)</td>
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</tr>
<tr>
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</table>

^A Add "U" to marking if welds are ultrasonic inspected in lieu of radiography.

### SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this specification since the last issue, A234/A234M – 16 that may impact the use of this specification. (Approved May 15, 2017)

1. Revised 9.1.1 and 9.2 to clarify tensile testing requirements for various starting materials product forms and add the referenced document Specification A105/A105M.

Committee A01 has identified the location of selected changes to this specification since the last issue, A234/A234M – 15 that may impact the use of this specification. (Approved Dec. 1, 2016)

1. Revised 7.3.1 and 7.4.