



Standard Specification for Seamless Cold-Drawn Low-Carbon Steel Heat-Exchanger and Condenser Tubes¹

This standard is issued under the fixed designation A179/A179M; 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 reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification² covers minimum-wall-thickness, seamless cold-drawn low-carbon steel tubes for tubular heat exchangers, condensers, and similar heat transfer apparatus.

1.2 This specification covers tubes $\frac{1}{8}$ to 3 in. [3.2 to 76.2 mm], inclusive, in outside diameter.

NOTE 1—Tubing smaller in outside diameter and having a thinner wall than indicated in this specification is available. Mechanical property requirements do not apply to tubing smaller than $\frac{1}{8}$ in. [3.2 mm] in outside diameter or with a wall thickness under 0.015 in. [0.4 mm].

1.3 The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification. The inch-pound units shall apply unless the “M” designation of this specification is specified in the order.

2. Referenced Documents

- 2.1 *ASTM Standards*:³
[A450/A450M Specification for General Requirements for Carbon and Low Alloy Steel Tubes](#)

3. Ordering Information

3.1 Orders for material under this specification should include the following, as required, to describe the desired material adequately:

- 3.1.1 Quantity (feet, metres, or number of lengths),
- 3.1.2 Name of material (seamless tubes),
- 3.1.3 Manufacture (cold-drawn),

¹ This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.09 on Carbon Steel Tubular Products.

Current edition approved March 1, 2012. Published November 2012. Originally approved in 1935. Last previous edition approved in 2005 as A179/A179M – 90a (2005). DOI: 10.1520/A0179_A0179M-90AR12.

² For ASME Boiler and Pressure Vessel Code applications see related Specification SA-179 in Section II of that Code.

³ For referenced 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.

- 3.1.4 Size (outside diameter and minimum wall thickness),
- 3.1.5 Length (specific or random),
- 3.1.6 Optional requirements (product analysis, Section 9, flange test, 11.3),
- 3.1.7 Test report required (Certification Section of Specification [A450/A450M](#)),
- 3.1.8 Specification number, and
- 3.1.9 Special requirements.

4. General Requirements

4.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification [A450/A450M](#), unless otherwise provided herein.

5. Manufacture

5.1 Tubes shall be made by the seamless process and shall be cold drawn.

6. Heat Treatment

6.1 Tubes shall be heat treated after the final cold draw pass at a temperature of 1200°F [650°C] or higher.

7. Surface Condition

7.1 Finished tubes shall be free of scale. A slight amount of oxidation will not be considered as scale.

8. Chemical Composition

8.1 The steel shall conform to the following requirements as to chemical composition:

Carbon, %	0.06–0.18
Manganese, %	0.27–0.63
Phosphorus, max, %	0.035
Sulfur, max, %	0.035

8.2 Supplying an alloy grade that specifically requires the addition of any element other than those listed in 8.1 is not permitted.

9. Product Analysis

9.1 When requested on the purchase order, a product analysis shall be made by the supplier from 1 tube per 250 pieces or when tubes are identified by heat, one tube per heat shall be analyzed. The chemical composition thus determined shall conform to the requirements specified.