



Designation: A815/A815M – 24

# Standard Specification for Wrought Ferritic, Ferritic/Austenitic, and Martensitic Stainless Steel Piping Fittings<sup>1</sup>

This standard is issued under the fixed designation A815/A815M; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## 1. Scope\*

1.1 This specification covers two general classes, WP and CR, of wrought ferritic, ferritic/austenitic, and martensitic stainless steel fittings of seamless and welded construction covered by the latest revision of Specification [A960/A960M](#). Fittings differing from these standards may be furnished in accordance with Supplementary Requirement S58 of Specification [A960/A960M](#).

1.1.1 Class WP fittings are subdivided into four subclasses: Classes WP-S, WP-W, WP-WX, and WP-WU. They are manufactured to the requirements of Specification [A960/A960M](#), and they shall have pressure ratings compatible with [13.2](#). Class WP-S fittings are those manufactured from seamless product by a seamless method of manufacture (marked with class symbol WP-S); Class WP-W fittings are those which contain welds where the fitting fabrication or construction welds have been radiographed (marked with class symbol WP-W); and Class WP-WX fittings are those which contain welds where all welds have been radiographed (marked with class symbol WP-WX); and Class WP-WU fittings are those which contain welds where all welds have been ultrasonically tested (marked with class symbol WP-WU).

1.1.2 Class CR fittings are those manufactured to the requirements of MSS SP-43, and they shall have pressure ratings compatible with [13.3](#).

1.2 This specification does not apply to cast fittings.

1.3 Optional supplementary requirements are provided. When desired, one or more of these may be specified in the order.

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 ASTM Standards:<sup>2</sup>

- [A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels](#)
- [A388/A388M Practice for Ultrasonic Examination of Steel Forgings](#)
- [A751 Test Methods and Practices for Chemical Analysis of Steel Products](#)
- [A763 Practices for Detecting Susceptibility to Intergranular Attack in Ferritic Stainless Steels](#)
- [A923 Test Methods for Detecting Detrimental Intermetallic Phase in Duplex Austenitic/Ferritic Stainless Steels](#)
- [A960/A960M Specification for Common Requirements for Wrought Steel Piping Fittings](#)
- [E165/E165M Practice for Liquid Penetrant Testing for General Industry](#)

### 2.2 ASME Standards:<sup>3</sup>

- [B16.9 Factory-Made Wrought Butt-Welding Fittings](#)
- [B16.11 Forged Fittings, Socket-Welding and Threaded](#)

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.22 on Steel Forgings and Wrought Fittings for Piping Applications and Bolting Materials for Piping and Special Purpose Applications.

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<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard’s Document Summary page on the ASTM website.

<sup>3</sup> Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

\*A Summary of Changes section appears at the end of this standard

### 2.3 MSS Standards:<sup>4</sup>

MSS SP-43 Standard Practice for Light Weight Stainless Steel Butt-Welding Fittings

MSS SP-79 Socket-Welding Reducer Inserts

MSS SP-83 Steel Pipe Unions, Socket-Welding and Threaded

MSS SP-95 Swage(d) Nipples and Bull Plugs

MSS SP-97 Integrally Reinforced Forged Branch Outlet Fittings—Socket Welding, Threaded and Buttwelding Ends

### 2.4 ASME Boiler and Pressure Vessel Codes:<sup>3</sup>

Section VIII Division I

Section IX

### 2.5 ASNT Standard:<sup>5</sup>

SNT-TC-1A Recommended Practice for Nondestructive Testing Personnel Qualification and Certification

5.2 All classes of fittings shall be heat treated in accordance with Section 6.

5.3 Fittings ordered as Class WP-S shall be of seamless construction and shall meet all requirements of Specification A960/A960M.

5.4 Fittings ordered as Class WP-W shall meet the requirements of Specification A960/A960M and (1) shall have all welds made by the fitting manufacturer and all pipe welds made with the addition of filler metal radiographically examined throughout the entire length in accordance with Paragraph UW-51 of Section VIII, Division 1, of the ASME Boiler and Pressure Vessel Code; and (2) shall not require radiography of the starting pipe weld if the pipe was welded without the addition of filler metal. In place of radiographic examination, welds made by the fitting manufacturer may be ultrasonically examined in accordance with the code requirements stated in 5.6.

5.5 Fittings ordered as Class WP-WX shall meet the requirements of Specification A960/A960M and shall have all welds, whether made by the fitting manufacturer or the starting material manufacturer, radiographically examined throughout their entire length in accordance with Paragraph UW-51 of Section VIII, Division I of the ASME Boiler and Pressure Vessel Code. The radiography of welds for this class of fittings can be done either prior to or after forming at the option of the manufacturer.

5.6 Fittings ordered as Class WP-WU shall meet the requirements of Specification A960/A960M and shall have all welds, whether made by the fitting manufacturer or the starting material manufacturer, ultrasonically examined throughout their entire length in accordance with Appendix 12 of Section VIII, Division 1 of ASME Boiler and Pressure Vessel Code.

5.7 The radiography or ultrasonic examination for this class of fittings may be done at the option of the manufacturer, either prior to or after forming.

5.8 Personnel performing NDE examinations shall be qualified in accordance with SNT-TC-1A.

5.9 Fittings covered in Specification A960/A960M and ordered as CR shall meet the requirements of Specification A960/A960M and do not require nondestructive examination.

5.10 All classes of fittings shall have the welders, welding operators, and welding procedures qualified under the provisions of Section IX of the ASME Boiler and Pressure Vessel Code except that starting pipe welds made without the addition of filler metal do not require such qualification.

5.11 All joints welded with filler metal shall be finished in accordance with the requirements of Paragraph UW-35 (a) of Section VIII, Division 1, of the ASME Boiler and Pressure Vessel Code.

5.12 Fittings machined from bar shall be restricted to NPS 4 or smaller.

5.12.1 All caps machined from bar shall be examined by liquid penetrant in accordance with Practice E165/E165M.

## 3. Common Requirements and Ordering Information

3.1 Material 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 common requirements of Specification A960/A960M constitutes nonconformance with this specification. In case of conflict between this specification and Specification A960/A960M, this specification shall prevail.

3.2 Specification A960/A960M identifies the ordering information that should be complied with when purchasing material to this specification.

## 4. Materials

4.1 The material for fittings shall consist of forgings, bars, plates, or seamless or welded tubular products that conform to the chemical requirements in Table 1.

4.2 The steel shall be melted by one of the following processes:

4.2.1 Electric furnace (with separate degassing and refining optional),

4.2.2 Vacuum furnace, or

4.2.3 Electric furnace followed by vacuum or electroslag-consumable remelting.

4.3 If secondary melting is employed, the heat shall be defined as all ingots remelted from a primary heat.

## 5. Manufacture

5.1 *Forming*—Forging or shaping operations may be performed by hammering, pressing, piercing, extruding, upsetting, rolling, bending, fusion welding, machining or by combination of two or more of these operations. The forming procedure shall be so applied that it will not produce surface discontinuities deeper than 5 % of the specified nominal thickness of the fitting.

<sup>4</sup> Available from Manufacturers Standardization Society of the Valve and Fittings Industry (MSS), 127 Park St., NE, Vienna, VA 22180-4602, <http://www.mss-hq.com>.

<sup>5</sup> Available from American Society for Nondestructive Testing (ASNT), P.O. Box 28518, 1711 Arlingate Ln., Columbus, OH 43228-0518, <http://www.asnt.org>.

**TABLE 1 Chemical Requirements**

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

Composition, %														
Grade <sup>A</sup>														
Grade WP	Grade CR	UNS	Carbon, max	Manganese <sup>B</sup>	Phosphorus, max	Sulfur, max	Silicon, max	Nickel <sup>B</sup>	Chromium	Molybdenum	Copper <sup>B</sup>	Nitrogen <sup>B</sup>	Titanium	Other
Ferritic Steels														
WP27	CR27	S44627	0.010	0.75	0.020	0.020	0.40	0.50	25.0–27.5	0.75–1.50	0.20	0.015	...	Nb <sup>D</sup> 0.05–0.20
WP33	CR33	S44626	0.06	0.75	0.040	0.020	0.75	0.50	25.0–27.0	0.75–1.50	0.20	0.040	0.20–1.00 (7×(C+N)) min	...
WP429	CR429	S42900	0.12	1.0	0.040	0.030	0.75	0.50	14.0–16.0	...	...	...	...	...
WP430	CR430	S43000	0.12	1.00	0.040	0.030	1.00	0.50	16.0–18.0	...	...	...	...	...
WP430Ti	CR430Ti	S43036	0.10	1.00	0.040	0.030	1.00	0.75	16.0–19.5	...	...	...	(5×C) min 0.75 max	...
WP446	CR446	S44600	0.20	1.50	0.040	0.030	0.75	0.50	23.0–27.0	...	...	0.25	...	...
Ferritic/Austenitic Steels														
WPS31803	CRS31803	S31803	0.030	2.00	0.030	0.020	1.0	4.5–6.5	21.0–23.0	2.5–3.5	...	0.08–0.20	...	...
WPS32101	CRS32101	S32101	0.040	4.0–6.0	0.040	0.030	1.00	1.35–1.70	21.0–22.0	0.10–0.80	0.10–0.80	0.20–0.25	...	...
WPS32202	CRS32202	S32202	0.030	2.00	0.040	0.010	1.00	1.00–2.80	21.5–24.0	0.45	...	0.18–0.26	...	...
WPS32750	CRS32750	S32750	0.030	1.20	0.035	0.020	0.8	6.0–8.0	24.0–26.0	3.0–5.0	0.5	0.24–0.32	...	...
WPS32950	CRS32950	S32950	0.030	2.00	0.035	0.010	0.60	3.5–5.2	26.0–29.0	1.00–2.50	...	0.15–0.35	...	...
WPS32760	CRS32760	S32760	0.030	1.00	0.030	0.010	1.00	6.0–8.0	24.0–26.0 <sup>C</sup>	3.0–4.0 <sup>C</sup>	0.50–1.00	0.20–0.30 <sup>C</sup>	...	W 0.50–1.00
WPS39274	CRS39274†	S39274	0.030	1.00	0.030	0.020	0.80	6.0–8.0	24.0–26.0	2.50–3.50 <sup>C</sup>	0.20–0.80	0.24–0.32	...	W 1.50–2.50
WPS32550	CRS32550	S32550	0.04	1.50	0.040	0.030	1.00	4.5–6.5	24.0–27.0	2.9–3.9	1.50–2.50	0.10–0.25	...	...
WPS32205	CRS32205	S32205	0.030	2.00	0.030	0.020	1.00	4.5–6.5	22.0–23.0	3.0–3.5	...	0.14–0.20	...	...
Martensitic Steels														
WP410	CR410	S41000	0.15	1.00	0.040	0.030	1.00	0.50 max	11.5–13.5	...	...	...	...	...
WPS41008	CRS41008	S41008	0.08	1.00	0.040	0.030	1.00	0.60	11.5–13.5	...	...	...	...	...
WPS41500	CRS41500	S41500	0.05	0.50–1.00	0.030	0.030	0.60	3.5–5.5	11.5–14.0	0.50–1.00	...	...	...	W 0.50–1.00

<sup>A</sup> Naming system developed and applied by ASTM International.

<sup>B</sup> Maximum unless otherwise indicated.

<sup>C</sup> % Cr + 3.3 × % Mo + 16 × % N = 40 min.

<sup>D</sup> Niobium and columbium are interchangeable names for the same element and both names are acceptable for use in A01.22 specifications.

5.13 Weld buildup is permitted to dimensionally correct unfilled areas produced during forming of stub ends. Radiographic examination of the weld buildup shall not be required provided that all of the following steps are adhered to:

5.13.1 The weld procedure and welders or welding operators meet the requirements of 5.10,

5.13.2 Heat-treatment is performed after welding and prior to machining,

5.13.3 All weld surfaces are liquid penetrant examined in accordance with Appendix 8 of Section VIII, Division 1 of the ASME Boiler and Pressure Vessel Code, and

5.13.4 Repair of areas in the weld is permitted, but 5.13.1, 5.13.2, and 5.13.3 must be repeated.

5.14 Stub ends may be produced with the entire lap added as weld metal to a straight pipe section provided the welding satisfies the requirements of 5.10 for qualifications and Section 6 for post weld heat treatment.

5.14.1 *Class WP-W*—Radiographic inspection of the weld is required (see 5.4).

5.14.2 *Class WP-WX*—Radiographic inspection of all welds is required (see 5.5).