GB

NATIONAL STANDARD OF THE

PEOPLE'S REPUBLIC OF CHINA

ICS 77.140.75
H 48

GB/T 18984-2016

Replacing GB/T 18984-2003

Seamless steel tubes for low-temperature-service piping

低温管道用无缝钢管

Issued on: December 30, 2016 **Implemented on: September 1, 2017**

Issued by: General Administration of Quality Supervision, Inspection and Quarantine of the People's Republic of China;

Standardization Administration of the People's Republic of China.

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Foreword

This Standard is drafted in accordance with the rules given in GB/T 1.1-2009.

This Standard replaces GB/T 18984-2003 “Seamless steel tubes for low-temperature-service piping”, compared with GB/T 18984-2003, the main technical changes are as follows:

- MODIFY the normative references;
- MODIFY the scope of steel tubes’ ordering specifications;
- MODIFY the allowable deviation of steel tubes’ dimension;
- MODIFY the allowable deviation of cut to length;
- MODIFY the curvature specifications;
- ADD the steel grade of 06Ni9DG;
- MODIFY the requirements for phosphorus and sulfur content of steel;
- MODIFY the smelting method of steel;
- MODIFY the delivery state of steel tubes;
- MODIFY the scope of applicable specifications and determination requirements of flattening test;
- MODIFY the requirements for low magnification inspection;
- MODIFY the requirements for nonmetallic inclusion testing;
- MODIFY the requirements for nondestructive testing;
- MODIFY the batching rules.

This Standard is proposed by the China Iron and Steel Association.

This Standard is under the jurisdiction of National Technical Committee on Steel of Standardization Administration of China (SAC/TC 183).

Drafting organizations of this Standard: Chengdu Steel Vanadium Co., Ltd. of Panzhihua Iron and Steel Group, Hengyang Valin Steel Tube Co., Ltd., China Metallurgical Information and Standardization Institute.

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Seamless steel tubes for low-temperature-service piping

1 Scope

This Standard specifies the category, code, order content, dimension, shape, mass, technical requirements, test methods, inspection rules, packaging, marking and quality certificates of seamless steel tubes for low-temperature-service piping.

This Standard applies to seamless steel tubes for -45 °C grade to -196 °C grade low-temperature pressure vessel piping and low-temperature heat exchanger piping.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the dated edition cited applies. For undated references, the latest edition of the referenced document (including all amendments) applies.

GB/T 222 Permissible tolerances for chemical composition of steel products

GB/T 223.5 Steel and iron - Determination of acid-soluble silicon and total silicon content - Reduced molybdosilicate spectrophotometric method

GB/T 223.9 Iron steel and alloy - Determination of aluminium content - Chrom azurol S photometric method

GB/T 223.14 Methods for chemical analysis of iron, steel and alloy - The N-benzoy-N-phenylhydroxylamine extraction photometric method for the determination of vanadium content

GB/T 223.16 Methods for chemical analysis of iron, steel and alloy - The chromotropic acid photometric method for the determination of titanium content

GB/T 223.25 Methods for chemical analysis of iron, steel and alloy - The dimethylglyoxime gravimetric method for the determination of nickel content

GB/T 223.26 Iron steel and alloy - Determination of molybdenum content - The thiocyanate spectrophotometric method

GB/T 223.40 Iron steel and alloy - Determination of niobium content by the

sulphochlorophenol S spectrophotometric method

GB/T 223.59 Iron steel and alloy - Determination of phosphorus content - Bismuth phosphomolybdate blue spectrophotometric method and antimony phosphomolybdate blue spectrophotometric method

GB/T 223.63 Methods for chemical analysis of iron, steel and alloy - The sodium (potassium) periodate photometric method for the determination of manganese content

GB/T 223.68 Methods for chemical analysis of iron, steel and alloy - The potassium iodate titration method after combustion in the pipe furnace for the determination of sulfur content

GB/T 223.69 Iron steel and alloy - Determination of carbon contents - Gas-volumetric method after combustion in the pipe furnace

GB/T 226 Test method for macrostructure and defect of steel by etching

GB/T 228.1 Metallic materials - Tensile testing - Part 1: Method of test at room temperature

GB/T 229 Metallic materials - Charpy pendulum impact test method

GB/T 241 Metallic materials - Tube - Hydrostatic pressure test

GB/T 242 Metallic materials - Tube - Drift-expending test

GB/T 244 Metallic materials - Tube - Bend test

GB/T 246 Metallic materials - Tube - Flattening test

GB/T 1979 Standard diagrams for macrostructure and defect of structural steels

GB/T 2102 Acceptance packing marking and quality certification of steel pipe

GB/T 2975 Steel and steel products - Location and preparation of test pieces for mechanical testing

GB/T 4336 Standard test method for spark discharge atomic emission spectrometric analysis of carbon and low - Alloy steel (routine method)

GB/T 5777-2008 Seamless steel pipe and tubing methods for ultrasonic testing

GB/T 7735-2016 Automated eddy current testing of seamless and welded (except submerged arc-welded) steel tubes for detection of imperfections

GB/T 10561-2005 Steel - Determination of content of nonmetallic inclusions -

The normal length of steel tubes is 4000 mm ~ 12000 mm.

Negotiated by supply and demand parties and specified in the contract, short-length steel tubes with a length shorter than 4000 mm but not shorter than 3000 mm can be delivered, but the quantity shall not exceed 5 % of the total quantity of the steel tube delivered.

5.2.2 Cut to length and multiple length

5.2.2.1 According to the requirements of the demand party, through the negotiation between supply and demand parties, and specified in the contract, steel tubes can be delivered in cut to length or multiple length. The total length of steel tubes' cut to length or multiple length shall be within the normal length.

5.2.2.2 Allowable deviation of cut to length of steel tubes shall comply with the following specifications:

a) length ≤ 6000 mm, 0 mm ~ 10 mm;

b) length > 6000 mm, 0 mm ~ 15 mm.

5.2.2.3 Each multiple length shall be given an incision margin as follows:

a) when D ≤ 159 mm, the incision margin is 5 mm ~ 10 mm;

b) when D > 159 mm, the incision margin is 10 mm ~ 15 mm.

5.3 Curvature

The curvature of steel tubes shall be not more than the following:

a) when S ≤ 15 mm, the curvature is not more than 1.5 mm/m;

b) when S > 15 mm ~ 30mm, the curvature is not more than 2.0 mm/m;

c) when S > 30 mm or D ≥ 351 mm, the curvature is not more than 3.0 mm/m.

5.4 End shape

The end surface of two ends of steel tubes shall be perpendicular to the axis of steel tubes, and the burrs on the incision shall be removed.

5.5 Out-of-roundness and unevenness of wall thickness

According to the requirements of the demand party, through the negotiation between supply and demand parties, and specified in the contract, the out-of-roundness and unevenness of wall thickness of steel tubes shall not exceed 80 % of the outer diameter tolerance and wall thickness tolerance respectively.

replace hydrostatic pressure test. When the magnetic flux leakage testing is used, the longitudinal groove of the outer surface of the sample tube for comparison shall comply with the specifications of acceptance grade F4 in GB/T 12606-2016. When the eddy current testing is used, the artificial defect of the sample tube for comparison shall comply with the specifications of acceptance grade E4H or E4 in GB/T 7735-2016.

6.6 Process performance

6.6.1 Flattening

Steel tubes with a diameter greater than 22 mm shall be subjected to the flattening test. The distance between the plates after flattening the sample is calculated according to formula (2). When the sample is pressed to such that the distance between two plates is *H*, the fractures or cracks are not allowed on the sample.

$$H = \frac{(1+\alpha)/S}{\alpha+S/D} \qquad \text{..... (2)}$$

where:

H - the distance between plates, in millimeters (mm);

S - the nominal wall thickness of steel tubes, in millimeters (mm);

D - the nominal diameter of steel tubes, in millimeters (mm);

A - the deformation coefficient of unit length, 0.08.

6.6.2 Bending

According to the requirements of the demand party, through the negotiation between supply and demand parties, and specified in the contract, steel tubes with an outer diameter less than 40 mm may be subjected to the bending test. The bending radius of the bending test is 6 times the nominal outer diameter of steel tubes and the bending angle is 90°. Fractures or cracks are not allowed on the sample after bending.

6.6.3 Drift-expanding test

According to the requirements of the demand party, through the negotiation between supply and demand parties, and specified in the contract, steel tubes with an outer diameter not more than 150 mm and a wall thickness not more than 10 mm may be subjected to the drift-expanding test. For the drift-expanding test, the taper of the top core is 60°, and the drift-expanding rate of the outer diameter of the sample shall comply with the specifications of Table 5. Fractures or cracks are not allowed on the sample after drift-expanding.

Table 5 Drift-expanding rate of outer diameter

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