

## Comparison of domestic and foreign standards for stainless steel seamless steel pipes (reference)

ASTMA213/A213M			ASTMA312/A312M			JISG3459				
TP304 TP316 TP317 TP347 TP309H*	TP304L TP316L TP317L TP310S TP310H* TP321H△		TP304 TP316 TP317 TP317*	TP304L TP316L TP317L TP310S TP310H* TP321H△		SUS 304TB SUS 316TB SUS 317TB SUS 310TB SUS 321TB SUS321HTB*	SUS304LTB SUS316LTB SUS317LTB SUS310STB SUS 347TB			
≥170;≥205			≥170;≥205			≥177				
≥485;≥515			≥485;≥515			≥481;≥520				
≥35			≥35			≥27 ;≥35				
H=1.09t/(0.09+t/D) H=1.09t/(0.09+t/D) and test completeness			H=1.09t/(0.09+t/D) H=1.09t/(0.09+t/D) and test completeness			H=1.09t/(0.09+t/D)				
21 -68% Expanding rate of inside diameter is 21 ~68%						α=60° 扩 12%D α=60° Expanding 12%D				
.△"ASTME112" A*#或7#上 6#或6#上 •△\ASTME112•△*#or7#上 6#orabw©6#上			.△"ASTME112" A*#或7#上 6#或6#上 •△\ASTME112•△*#or7#上 6#orabw©6#上			JISG0551 7#or7# above ' JISG0551 7#orabove7#				
D	Pmax	Hydrostatictest P=220.6t/D Hydraiiictesi designated by user and can be replaced by nondestructive □aw detection	D	Pmax	AST- MA530/A530M D≤270mm P=2Rt/D 式中R=50%○0.2 AST- MA530/A530MD ≤270mm P=2Rt/Dinthe formulaR=50%○0.2	P=2Rt/D in the formula R=ob/4 Can be replaced by non-destructive testing P=2Rt/D in the formula R= a b/4 can be replaced by nondestructive □aw detection				
<25.4	7		≤88.9	17						
25.4-<38.1	10		> 88.9	19						
38.1-<50.8	14									
50.8-<76.2	17									
76.2-<127	24									
>127	31									
ASTMA262 E 法(补充需要) ASTMA262 E method (supplemental requirement)			ASTMA262 E 法(补充需要) ASTMA262 E method (supplemental requirement)			JIS G0575(special needs ) JIS G0575(special requirement)				
ASTME213 E309E426			ASTME213 E309E426			Eddy current or ultrasonic flaw detection available JIS G0583EV ultrasound JIS G0582 UD				
Requirements			Requirements			Requirements				
Outside diameter	Outside diameter deviation		Outside diameter	Permitted error		Outside diameter	Permitted error			
<25.4	±0.10		10.3-48.3	+0.40/-0.80		<60	±0.25			
25.4-≤38.1	±0.15		>48.3-114.3	+0.80/-0.08		≥60-<80	±0.30			
>38.1-<50.8	±0.20		>114.3-219.1	+1.60/-0.80		≥80-<100	±0.40			
50.8-<63.5	±0.25		>219.1-457.2	+2.40-0.80		≥100-<120	+0.40/-0.60			
63.5-<76.2	±0.30		>457.2-660.4	+3.20/-0.80		≥120-<160	+0.40/-0.80			
76.2-≤101.6	±0.38		>660.4-864	+4.00/-0.08		≥160-<200	+0.40/-1.20			
>101.6-≤190.5	±0.38/-0.64		>864-1219.2	+4.80/-0.08			+0.40/-1.60			
>190.5—≤228.6	±0.38/-1.14					well thickness	Deviation	Outside diameter		
Outside diameter	Error of wall thickness( mm )		+ not specified-12.5%t +not de□ned/-12.5%t			t < 2	+0.4/0	D < 40	D ≥ 40	
≤38.1	+20%t/0					t > 2	+20%t/0		+22%t/0	
>38.1	+22%t/0									
Reasonable straightness			Reasonable straightness			Practical straightness				
HRB<90			HRB<90			Hafdness HRS <90 (special requirement)				