

TECHNICAL SPECIFICATION

CARBON STEEL PIPE (AMENDMENTS/SUPPLEMENTS TO ASTM A 671)

MESC SPE 74/005

November 2012

MESC SPECIFICATION DOCUMENT



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The information set forth in these publications is provided to Shell companies for their consideration and decision to implement. This is of particular importance where MESC SPEs may not cover every requirement or diversity of condition at each locality. The system of MESC SPEs is expected to be sufficiently flexible to allow individual Operating Units to adapt the information set forth in MESC SPEs to their own environment and requirements.

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All administrative queries should be directed to the MESC SPE Administrator in Shell GSI.

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PART I INTRODUCTION

1.1 SCOPE

This MESC SPE specifies requirements for carbon steel pipe.

This MESC SPE shall apply in addition to the applicable MESC Buying Description, purchase order or requisition sheet.

This MESC SPE only applies to carbon steel pipe to ASTM A 671, Grade CC65, Class 22.

This MESC SPE is written as amendments and supplements to ASTM A 671:2010, which are covered in Part II of this MESC SPE. The clause numbering of ASTM A 671:2010 has been retained and any amendments are identified as 'Add', 'Modify to read' or 'Delete'. Any clauses of ASTM A 671:2010 that are not amended or supplemented by this MESC SPE shall apply as written.

1.2 DISTRIBUTION, INTENDED USE AND REGULATORY CONSIDERATIONS

Unless otherwise authorised by Shell GSI, the distribution of this MESC SPE is confined to Shell companies and, where necessary, to Contractors and Manufacturers/Suppliers nominated by them.

This MESC SPE is intended for use in oil refineries, chemical plants, gas plants, exploration and production facilities and, where applicable, supply/distribution installations.

If national and/or local regulations exist in which some of the requirements may be more stringent than in this MESC SPE the Contractor shall determine by careful scrutiny which of the requirements are the more stringent and which combination of requirements will be acceptable with regards to safety, environmental, economic and legal aspects. In all cases the Contractor shall inform the Principal of any deviation from the requirements of this MESC SPE which is considered to be necessary in order to comply with national and/or local regulations. The Principal may then negotiate with the Authorities concerned, the objective being to obtain agreement to follow this MESC SPE as closely as possible.

1.3 DEFINITIONS

The **Contractor** is the party that carries out all or part of the design, engineering, procurement, construction, commissioning or management of a project, or operation or maintenance of a facility. The Principal may undertake all or part of the duties of the Contractor.

The **Manufacturer/Supplier** is the party that manufactures or supplies equipment and services to perform the duties specified by the Contractor.

The **Principal** is the party that initiates the project and ultimately pays for its design and construction. The Principal will generally specify the technical requirements. The Principal may also include an agent or consultant authorised to act for, and on behalf of, the Principal.

The word **shall** indicates a requirement.

The word **should** indicates a recommendation.

1.4 CHANGES SINCE PREVIOUS EDITION

The previous edition of this MESC SPE was dated **May 2010. The change is to update ASTM A671 version, to update impact testing requirements, to incorporate new section on "Length" for pipes and email address of MESC SPE administrator.**

1.5 COMMENTS ON THIS MESC SPE

Comments on this MESC SPE may be sent to the MESC SPE Administrator at MESC@shell.com. Shell staff may also post comments on this MESC SPE on the Surface Global Network (SGN) under the Standards folder.

PART II AMENDMENTS/SUPPLEMENTS TO ASTM A 671:2010

- 5.1 *Add:*
- The following amendments to the chemical composition shall apply:
- The carbon content shall not exceed 0.23 %.
 - Supplementary requirement S54.2 and S54.3 of ASTM A 516 shall apply, although CE shall not exceed 0.43 irrespective of the specified wall thickness.
- 5.2.2 *Modify to read:*
- The longitudinal seam weld shall be made by the automatic submerged arc welding (SAW) process.
- 5.3.7 *Add* Plate material conforming to clause 5.1 of ASTM A 516 shall be furnished in the normalised condition.
- 5.4 *Add* The following requirements shall apply if sour service is specified:
- In order to ensure effective resistance against both Hydrogen Induced Cracking (HIC) and Sulphide Stress Corrosion (SSC), the chemical composition shall be in accordance with Table 3 unless ASTM A 516 Grade 65 is more restrictive.
 - Supplementary requirement S54.2 and S54.3 of ASTM A 516 shall apply, although CE shall not exceed 0.43 irrespective of the specified wall thickness.
 - The micro-alloying elements Boron (B), Titanium (Ti), Niobium (Nb) and Vanadium (V) shall not be intentionally added to the steel, unless approved by the Principal.
 - The plate shall be vacuum-treated, fully deoxidised, desulphurised and dephosphorised. The manufacturing/rolling process shall result in a homogeneous microstructure with no ferrite/perlite banding.
 - For plate with sulphur content of 0.001 % and higher, calcium treatment shall be applied for inclusion shape control. The calcium content shall not exceed 3 times the sulphur content.

Table 3 *Add*

Table 3 – Chemical composition for sour service		
Single elements	Identification	Maximum wt. %
Carbon	C	0.20
Manganese	Mn	1.30
Phosphorous	P	0.01
Sulphur	S	0.002
Silicon	Si	0.40
Copper	Cu	0.40
Nickel	Ni	0.40
Chromium	Cr	0.30
Molybdenum	Mo	0.12
Vanadium	V	0.015
Niobium	Nb	0.015
Titanium	Ti	0.02
Boron	B	0.005
Combined elements	Cr + Mo	0.30
	Ni + Cu + Cr + Mo	0.72
	V + Nb	0.02

- 7.4 *Add* If sour service is specified, the weld metal deposit shall not contain more than 1.00 % nickel.
- 8.4 *Add* **Hardness testing**
If post-weld heat-treatment is performed, supplementary requirement S3 shall apply on one finished pipe representing each lot. Hardness tests shall be executed after post-weld heat-treatment. The hardness of the weld, heat affected zone or base metal shall not exceed 248 HV 10.
- 8.5 *Add* **Impact testing**
Add:
Supplementary requirement S2 shall apply.
Low temperature carbon steel pipes shall be impact tested at a temperature of minus 50 °C (minus 58 °F).
Impact test results as an average of three tests shall be at least 27 J for standard size specimens (10 mm x 10 mm). Only one result may be lower than 27 J, but it shall be at least 21 J. The impact values for sub-size specimens, as defined in Table 4 of ASTM A 333, shall be multiplied by 1.5.
Alternatively, the impact tests may be carried out at minus 46 °C (minus 50 °F) but the impact values shall be at least 33J for standard size specimens.
The impact test temperature for pipes with a wall thickness > 50 mm (1.97 in) shall be -46 °C (-50 °F).
- 8.6 *Add* Hydrostatic testing
Hydrostatic testing shall be performed after heat treatment.
- 8.7 *Add* **Sour service**
The following requirements for examination shall apply, if sour service is specified:
 - The plate shall be checked for laminations by ultrasonic examination in accordance with EN 10160 with acceptance levels S₁ and E₄.
 - The plate material shall be HIC tested in accordance with MESC SPE 74/125 after a simulation of the final heat treatment of the pipe.
- 13.1 *Add:*
In addition, marking shall also include the nominal pipe size (DN), and the pipe schedule number or specified wall thickness (mm).
Marking shall also include the charge number (heat number) and, where applicable, the heat treatment batch number.
- 13.3 *Add* If die stamping is used, the stamps shall be low stress stamps.
- 13.4 *Add* If sour service is specified, marking shall also include the identification "SOUR" behind the ASTM designation.
- 14 *Add* **Certification**
Unless specified otherwise, inspection and test certificates shall be supplied to the Principal.
- 15 *Add* Length**
Unless specified otherwise in the purchase order, the Unit of Length (UoL) for pipe is in meter or feet. The form of delivery shall be in single random length (SRL or double random length (DRL). The specified quantities of random lengths on the purchase order shall be converted to aggregate length on the basis of 6.1 m (20 ft) for single random length and 12.2 m (40 ft) for double random length.

To satisfy the purchase order required pipe length, the delivered quantities of random lengths shall amount to at least the calculated aggregate length.

PART III REFERENCES

In this MESC SPE, reference is made to the following publications:

NOTES:

1. Unless specifically designated by date, the latest edition of each publication shall be used, together with any amendments/supplements/revisions thereto.
2. Most of the referenced external standards are available to Shell staff on the SWW (Shell Wide Web) at <http://sww.shell.com/standards>.

SHELL STANDARDS

Hydrogen Induced Cracking sensitivity test MESC SPE 74/125

AMERICAN STANDARDS

Standard Specification for Seamless and Welded Steel Pipe for Low-Temperature Service ASTM A 333

Standard Specification for Pressure Vessel Plates, Carbon Steel, for Moderate- and Lower-Temperature Service ASTM A 516

Standard Specification for Electric-Fusion-Welded Steel Pipe for Atmospheric and Lower Temperatures ASTM A 671:2010

Issued by:
American Society for Testing and Materials
1916 Race Street, Philadelphia
19103, USA

EUROPEAN STANDARDS

Ultrasonic Testing of Steel Flat Product of Thickness Equal or Greater Than 6 mm (Reflection Method) EN 10160

Issued by:
Comité Européen de Normalisation
Secrétariat Central
Rue de Stassart 36
B-1050 Brussels
Belgium

Copies can also be obtained from national standards