

<b>Material Type:</b>	304L or 316L Stainless steel, as directed by customer purchase order
<b>Dimensions:</b>	<b>ASTM Tube Sizes:</b> • 1/4" o.d. to 6" o.d. (6.35mm to 152.4mm)
<b>Reference Documents:</b>	<b>ASME:</b> BPE Standard <b>ASTM:</b> A 269, A 270
<b>Tube Lengths:</b>	• 4-meter, (13.123 ft) nominal lengths • 6-meter, (19.685 ft) nominal lengths
<b>Manufacturing Method &amp; Mechanical Properties:</b>	Seamless or welded, as directed by customer's purchase order Tensile Strength 70 ksi (483 MPa) minimum.
<b>Tolerances:</b>	<ul style="list-style-type: none"> <li>• <b>1/4" to 1" (6.35mm to 25.4mm):</b> ± .010" (± 0.254mm)</li> <li>• <b>1-1/2" to 2" (38.1mm to 50.4mm):</b> ± .016" (± 0.406mm)</li> <li>• <b>2-1/2" to 3" (63.5mm to 76.2mm):</b> ± .020" (± 0.508mm)</li> <li>• <b>4" (101.6mm):</b> ± .030" (± 0.762mm)</li> <li>• <b>6" (152.4mm):</b> ± .060" (± 1.52mm)</li> </ul>
<b>I.D. Surface Roughness (Ra):</b>	<ul style="list-style-type: none"> <li style="width: 50%;">• <b>SF0</b>, No finish requirement</li> <li style="width: 50%;">• <b>SF4</b>, 15µin (.38µm) max, electropolished</li> <li style="width: 50%;">• <b>SF1</b>, 20µin (.51µm) max</li> <li style="width: 50%;">• <b>SF5</b>, 20µin (.51µm) max, electropolished</li> <li style="width: 50%;">• <b>SF2</b>, 25µin (.64µm) max</li> <li style="width: 50%;">• <b>SF6</b>, 25µin (.64µm) max, electropolished</li> <li style="width: 50%;">• <b>SF3</b>, 30µin (.76µm) max</li> </ul>
<b>Weld Ends:</b>	Square ends suitable for orbital welding
<b>Testing &amp; Inspection:</b>	<ul style="list-style-type: none"> <li style="width: 50%;">• Visual inspection</li> <li style="width: 50%;">• Helium-leak test</li> <li style="width: 50%;">• Surface roughness measurement</li> <li style="width: 50%;">• Dimensional inspection</li> </ul>
<b>Marking &amp; Traceability:</b>	Each component is marked with the following: Heat number and Vallex ID number. that is traceable to the Material Test Report, Material alloy (SS304L or SS316L), "Valex", ASME Single Certification Mark with BPE Certification Designator, Surface code, size and configuration. <i>Note: Exceptions may apply where space is limited, information may be omitted in reverse order as presented above.</i>
<b>Labeling:</b>	Each component's bag is affixed with a label identifying the component's part number, date, and Vallex ID and lot numbers.
<b>Documentation:</b>	Test report including material chemistry and mechanical properties, and Certificate of Compliance to this specification and ASME BPE Standard.
<b>Packaging:</b>	All tube and fittings are purged with UHP nitrogen, capped, bagged and packaged for shipment in such a manner which prevents damage to product and primary-product packaging.