

Chemical composition for API 5L Sour Service Pipe with wall thickness ≤ 25.0 mm (0.984 in)

| Steel Grade<br>(Steel Name) | Mass fraction, based upon heat and product analyses |      |                 |       |                    |      |      |      |                      | Carbon equivalent<br>% maximum |                   |
|-----------------------------|---|------|-----------------|-------|--------------------|------|------|------|----------------------|--------------------------------|-------------------|
|                             | % maximum   |      |                 |       |                    |      |      |      |                      |                                |                   |
|                             | C <sup>a</sup>                                      | Si   | Mn <sup>b</sup> | P     | S                  | V    | Nb   | Ti   | other <sup>c,d</sup> | CE <sub>min</sub>              | CE <sub>max</sub> |
| Seamless and welded pipes   |   |      |                 |       |                    |      |      |      |                      |                                |                   |
| L245NS or BNS               | 0.14  | 0.40 | 1.35            | 0.020 | 0.003 <sup>e</sup> | -    | -    | 0.04 | g                    | 0.36                           | 0.19 <sup>h</sup> |
| L290NS or X42NS             | 0.14  | 0.40 | 1.35            | 0.020 | 0.003 <sup>e</sup> | 0.05 | 0.05 | 0.04 | -                    | 0.36                           | 0.19 <sup>h</sup> |
| L320NS or X46NS             | 0.14  | 0.40 | 1.40            | 0.020 | 0.003 <sup>e</sup> | 0.07 | 0.05 | 0.04 | g                    | 0.38                           | 0.20 <sup>h</sup> |
| L360NS or X52NS             | 0.16  | 0.45 | 1.65            | 0.020 | 0.003 <sup>e</sup> | 0.10 | 0.05 | 0.04 | g                    | 0.43                           | 0.22 <sup>h</sup> |
| L245QS or XQBS              | 0.14  | 0.40 | 1.35            | 0.020 | 0.003 <sup>e</sup> | 0.04 | 0.04 | 0.04 | -                    | 0.34                           | 0.19 <sup>h</sup> |
| L290QS or X42QS             | 0.14  | 0.40 | 1.35            | 0.020 | 0.003 <sup>e</sup> | 0.04 | 0.04 | 0.04 | -                    | 0.34                           | 0.19 <sup>h</sup> |
| L320QS or X46QS             | 0.15  | 0.45 | 1.40            | 0.020 | 0.003 <sup>e</sup> | 0.05 | 0.05 | 0.04 | -                    | 0.36                           | 0.20 <sup>h</sup> |
| L360QS or X52QS             | 0.16  | 0.45 | 1.65            | 0.020 | 0.003 <sup>e</sup> | 0.07 | 0.05 | 0.04 | g                    | 0.39                           | 0.20 <sup>h</sup> |
| L390QS or X56QS             | 0.16  | 0.45 | 1.65            | 0.020 | 0.003 <sup>e</sup> | 0.07 | 0.05 | 0.04 | g                    | 0.40                           | 0.21 <sup>h</sup> |
| L415QS or X60QS             | 0.16  | 0.45 | 1.65            | 0.020 | 0.003 <sup>e</sup> | 0.08 | 0.05 | 0.04 | g,i,k                | 0.41                           | 0.22 <sup>h</sup> |
| L450QS or X65QS             | 0.16  | 0.45 | 1.65            | 0.020 | 0.003 <sup>e</sup> | 0.09 | 0.05 | 0.06 | g,i,k                | 0.42                           | 0.22 <sup>h</sup> |
| L485QS or X70QS             | 0.16  | 0.45 | 1.65            | 0.020 | 0.003 <sup>e</sup> | 0.09 | 0.05 | 0.06 | g,i,k                | 0.42                           | 0.22 <sup>h</sup> |
| Welded pipe                 |   |      |                 |       |                    |      |      |      |                      |                                |                   |
| L245MS or BMS               | 0.10  | 0.40 | 1.25            | 0.020 | 0.002 <sup>e</sup> | 0.04 | 0.04 | 0.04 | -                    | -                              | 0.19              |
| L290MS or X42MS             | 0.10  | 0.40 | 1.25            | 0.020 | 0.002 <sup>e</sup> | 0.04 | 0.04 | 0.04 | -                    | -                              | 0.19              |
| L320MS or X46MS             | 0.10  | 0.45 | 1.35            | 0.020 | 0.002 <sup>e</sup> | 0.05 | 0.05 | 0.04 | -                    | -                              | 0.20              |
| L360MS or X52MS             | 0.10  | 0.45 | 1.45            | 0.020 | 0.002 <sup>e</sup> | 0.05 | 0.06 | 0.04 | -                    | -                              | 0.20              |
| L390MS or X56MS             | 0.10  | 0.45 | 1.45            | 0.020 | 0.002 <sup>e</sup> | 0.06 | 0.08 | 0.04 | g                    | -                              | 0.21              |
| L415MS or X60MS             | 0.10  | 0.45 | 1.45            | 0.020 | 0.002 <sup>e</sup> | 0.08 | 0.08 | 0.06 | g,i                  | -                              | 0.21              |
| L450MS or X65MS             | 0.10  | 0.45 | 1.60            | 0.020 | 0.002 <sup>e</sup> | 0.10 | 0.08 | 0.06 | g,i,k                | -                              | 0.22              |
| L485MS or X70MS             | 0.10  | 0.45 | 1.60            | 0.020 | 0.002 <sup>e</sup> | 0.10 | 0.08 | 0.06 | g,i,k                | -                              | 0.22              |

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**Yi-Tong Ma**



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