



Standard Specification for Seamless Brass Tube [Metric]¹

This standard is issued under the fixed designation B 135M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

^{€1} NOTE—The headings and footnotes in Tables 2 and 3 were editorially corrected from inch/pound to SI units in February 2002.

1. Scope

1.1 This specification covers seamless round and rectangular including square copper alloy tube in straight lengths. Ten alloys are specified having the following nominal compositions:

Copper Alloy UNS No.	Previously Used Designation ⁴	Nominal Composition, %			
		Copper	Zinc	Lead	Tin
C22000	7	90.0	10.0
C23000	1	85.0	15.0
C26000	2	70.0	30.0
C27000	9	65.0	35.0
C27200	8	63.0	37.0
C27400	...	62.5	37.5
C28000	5	60.0	40.0
C33000	3	66.0	33.5	0.5	...
C33200	4	66.0	32.4	1.6	...
C37000	6	60.0	39.0	1.0	...
C44300	...	71	27.5	...	1.00

⁴Alloy Designations of ASTM Specification B 135 – 63 which was published in the 1966 Book of ASTM Standards, Part 5.

NOTE 1—This specification is the metric companion of Specification B 135.

1.2 **Warning**—Mercury is a definite health hazard in use and disposal. (See 10.1.)

2. Referenced Documents

2.1 The following documents of the issue in effect on date of material purchase form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards:*

B 153 Test Method for Expansion (Pin Test) of Copper and

Copper-Alloy Pipe and Tubing²

B 154 Test Method for Mercurous Nitrate Test for Copper and Copper Alloys²

B 251M Specification for General Requirements for Wrought Seamless Copper and Copper-Alloy Tube [Metric]²

B 601 Practice for Temper Designations for Copper and Copper Alloys—Wrought and Cast²

E 243 Practice for Electromagnetic (Eddy-Current) Examination of Copper and Copper-Alloy Tubes³

E 527 Practice for Numbering Metals and Alloys (UNS)⁴

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *capable of*—as used in this specification, the test need not be performed by the producer of the material. However, should subsequent testing by the purchaser establish that the material does not meet these requirements the material shall be subject to rejection.

4. Ordering Information

4.1 Orders for material under this specification shall include the following information:

4.1.1 Alloy (Section 1),

4.1.2 Temper (Section 7),

4.1.3 Whether tension tests are required (for drawn tempers only (see 8.1)),

4.1.4 Dimensions, the diameter or distance between parallel surfaces and wall thickness (see 11.2 and 11.3),

4.1.5 Length (see 12.4),

4.1.6 Mercurous nitrate test, if required (Section 10),

4.1.7 Total length of each size,

4.1.8 Hydrostatic pressure test, when specified, and

4.1.9 Pneumatic test, when specified.

¹ This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.04 on Pipe and Tube.

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² *Annual Book of ASTM Standards*, Vol 02.01.

³ *Annual Book of ASTM Standards*, Vol 03.03.

⁴ *Annual Book of ASTM Standards*, Vol 01.01.

5. General Requirements

5.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification B 251M.

6. Chemical Composition

6.1 The material shall conform to the chemical requirements specified in Table 1.

6.2 These specification limits do not preclude the presence of other elements. Limits for unnamed elements are to be established by agreement between manufacturer or supplier and purchaser.

6.2.1 For copper alloys in which zinc is specified as the remainder, either copper or zinc shall be taken as the difference between the sum of all the elements analyzed and 100 %.

6.2.1.1 When all the elements in Table 1 are analyzed, their sum shall be as shown in the following table.

Copper Alloy UNS No.	Copper Plus Named Elements, % min
C22000	99.8
C23000	99.8
C26000	99.7
C27000	99.7
C27200	99.7
C27400	99.7
C28000	99.7
C33000	99.6
C33200	99.6
C37000	99.6
C44300	99.6

7. Temper

7.1 *Drawn Tempers, H*—The tempers of drawn tube shall be designated as light-drawn (H55), drawn (H58), and hard-drawn (H80) (see Table 2). Light-drawn (bending) temper is used only when a tube of some stiffness but yet capable of being bent is needed. Drawn temper is for general purposes and is most commonly used where there is no specific requirement for high strength on the one hand or for bending qualities on the other. Hard-drawn temper is used only where there is need for a tube as strong as is commercially feasible for the sizes indicated. For any combination of diameter and wall thickness not covered under hard-drawn temper, the values given for drawn temper shall be used. Rectangular including square tubes shall normally be supplied only in drawn (general purpose) temper. When there is a need for light-drawn or hard-drawn tempers

these are to be supplied as agreed upon between the manufacturer and the purchaser.

7.2 *Annealed Tempers, O*—The tempers of annealed tube shall be designated as light anneal (O50) and soft anneal (O60) (Table 3).

NOTE 2—Tube of Copper Alloy UNS No. C23000, when specified to meet the requirements of the *ASME Boiler and Pressure Vessel Code*, shall have in the annealed condition a minimum tensile strength of 275 MPa and a minimum yield strength of 80 MPa at 0.5 % extension under load, in which case the provisions for grain size and Rockwell hardness in 8.2 do not apply.

8. Mechanical Properties

8.1 *Drawn Temper*—Tube shall conform to the mechanical properties prescribed in Table 2. Tension tests are required for tubes with a wall thickness under (0.508 mm) and for round tubes having an inside diameter under 8.0 mm and for rectangular including square tubes having a major distance between inside parallel surfaces under 5.0 mm. The tension test for other sizes of tubes need not be made except when indicated by the purchaser at the time of placing the order. A convenient method of indicating that the tension test is required is to specify that “Test procedure ‘T’ is required” (see 4.1.3). When agreement on the Rockwell hardness tests cannot be reached, the tensile strength requirements of Table 2 shall be the basis for acceptance or rejection.

8.2 *Annealed Temper*—Tube shall conform to the grain size and Rockwell hardness limits prescribed in Table 3.

9. Expansion Test for Round Tube

9.1 Tube ordered in the annealed (O) condition, selected for test, shall be capable of withstanding in accordance with Test Method B 153 an expansion of the outside diameter by the following amount:

Outside Diameter, mm	Expansion of Outside Diameter, %
19.0 and under	20
Over 19.0	15

The expanded tube shall show no cracking or rupture visible to the unaided eye. Tube ordered in the drawn (H) condition is not subject to this test.

NOTE 3—The term “unaided eye,” as used herein, permits the use of corrective spectacles necessary to obtain normal vision.

9.2 As an alternative to the expansion test for tube over 102

TABLE 1 Chemical Requirements

Copper Alloy UNS No.	Composition, %					
	Copper	Lead	Arsenic	Tin	Iron, max	Zinc
C22000	89.0–91.0	0.05 max	0.05	remainder
C23000	84.0–86.0	0.05 max	0.05	remainder
C26000	68.5–71.5	0.07 max	0.05	remainder
C27000	63.0–68.5	0.10 max	0.07	remainder
C27200	62.0–65.0	0.07 max	0.07	remainder
C27400	61.0–64.0	0.10 max	0.05	remainder
C28000	59.0–63.0	0.30 max	0.07	remainder
C33000	65.0–68.0	0.25 ^A –0.7	0.07	remainder
C33200	65.0–68.0	1.5–2.5	0.07	remainder
C37000	59.0–62.0	0.9–1.4	0.15	remainder
C44300	70.0–73.0	0.07 max	0.02–0.06	0.9–1.2	0.06	remainder

^AIn the case of Copper Alloy UNS No. C33000 or tube sizes greater than 127 mm in outside diameter, or distance between outside parallel surfaces, the lead content shall be 0.7 % maximum, no minimum is specified.

TABLE 2 Mechanical Property Requirements of Drawn Temper Tube

Copper Alloy UNS No.	Temper Designation ^A		Outside Diameter, in. or Major Distance Between Outside Parallel Surfaces, mm	Wall Thickness, mm	Tensile Strength, MPa	Rockwell Hardness ^B 30T
	Standard	Former				
C22000	H58	drawn (general purpose)	all	all	275 min	38 min
C22000	H80	hard drawn ^C	up to 25, incl	0.050 to 3.0, incl	360 min	55 min
C22000	H80	hard drawn ^C	over 25 to 40, incl	0.090 to 5.50, incl	360 min	55 min
C22000	H80	hard drawn ^C	over 50 to 100, incl	1.5 to 6.0, incl	360 min	55 min
C23000	H55	light drawn ^C	all	all	305–400	43–75
C23000	H58	drawn (general purpose)	all	all	305 min	43 min
C23000	H80	hard drawn ^C	up to 25, incl	0.050 to 3.0, incl	395 min	65 min
C23000	H80	hard drawn ^C	over 25 to 50, incl	0.090 to 5.0, incl	395 min	65 min
C23000	H80	hard drawn ^C	over 50 to 100, incl	1.5 to 6.0, incl	395 min	65 min
C26000, C27000, C27200, C27400, C33000, and C33200	H58	drawn (general purpose)	all	all	370 min	53 min
C26000, C27000, C27200, C27400, C33000, and C33200	H80	hard drawn ^C	up to 25, incl	0.050 to 3.0, incl	455 min	70 min
C26000, C27000, C27200, C27400, C33000, and C33200	H80	hard drawn ^C	over 25 to 50, incl	0.090 to 5.0, incl	455 min	70 min
C26000, C27000, C27200, C27400, C33000, and C33200	H80	hard drawn ^C	over 50 to 100, incl	1.5 to 6.0, incl	455 min	70 min
C28000 and C37000	H58	drawn (general purpose)	all	all	370 min	55 min
C44300	H58	drawn (general purpose)	all	all	370 min	53 min
C44300	H80	hard drawn ^C	all	all	455 min	70 min

^AStandard designations defined in Practice B 601.

^BRockwell hardness values shall apply only to tubes having a wall thickness of 0.30 mm or over and to round tubes having an inside diameter of 8.0 mm or over and to rectangular including square tubes having an inside major distance between parallel surfaces of 5.0 mm or over. Rockwell hardness shall be made on the inside surface of the tube. When suitable equipment is not available for determining the specified Rockwell hardness, other Rockwell scales and values shall be specified subject to agreement between the manufacturer and the purchaser.

^CLight-drawn and hard-drawn tempers are available in round tube only.

mm in diameter in the annealed condition, a section 102 mm in length shall be cut from the end of one of the lengths for a flattening test. This 102-mm test specimen shall be flattened so that a gage set at three times the wall thickness will pass over the tube freely throughout the flattened part. The tube so tested shall develop no cracks or flaws visible to the unaided eye (Note 3) as a result of this test. In making the flattening test, the elements shall be slowly flattened by one stroke of the press.

9.3 Drawn temper tube shall not be required to withstand these tests.

10. Mercurous Nitrate Test

10.1 **Warning**—Mercury is a definite health hazard. Use equipment for the detection and removal of mercury vapor. Wear rubber gloves when conducting the test.

10.2 When specifically required, test specimens 152 mm in length of both annealed and drawn tempers shall withstand, after proper cleaning, an immersion for 30 min without cracking in the standard mercurous nitrate solution prescribed in Method B 154. Immediately after removal from the solution, the specimen shall be wiped free of excess mercury and examined for cracks.

11. Nondestructive Testing

11.1 Unless nondestructive testing has been waived, tubes shall be subjected to a nondestructive test. The manufacturer

shall select the nondestructive test that is most suitable for the tube size and the application.

11.1.1 Eddy-current testing is the standard nondestructive test, and all tubes of appropriate size shall be eddy-current tested in accordance with 11.2.

11.1.2 Tubes that are not of a size suitable for eddy-current test capabilities shall be tested by the hydrostatic test as described in 11.3.1, or by the pneumatic test as described in 11.3.2.

11.2 *Eddy-Current Test*—Each tube up to 79 mm in outside diameter shall be subjected to an eddy-current test. Testing shall follow the procedure of Practice E 243, except the determination of “end effect” is not required. Tubes shall be passed through an eddy-current test unit adjusted to provide information on the suitability of the tube for the intended application.

11.2.1 Notch-depth standards rounded to the nearest 0.03 mm shall be 22 % of the nominal wall thickness. The notch-depth tolerance shall be ± 0.01 mm. Alternatively, if the manufacturer uses speed insensitive eddy-current units that are equipped so that a fraction of the maximum unbalance signal is able to be selected, the following percent maximum unbalance signals shall be used.

TABLE 3 Mechanical Property Requirements of Annealed Temper Tube

Copper Alloy UNS No.	Temper Designation ^A		Wall Thickness, mm	Rockwell Hardness ^B		Average Grain Size, mm	
	Standard	Former		Scale	Max	Min	Max
C22000	O60	soft anneal	up to 1.0, incl	30T	30	0.025	0.060
C22000	O60	soft anneal	over 1.0	F	70	0.025	0.060
C22000	O50	light anneal	up to 1.0, incl	30T	37	^C	0.035
C22000	O50	light anneal	over 1.0	F	78	^C	0.035
C23000	O60	soft anneal	up to 1.0, incl	30T	36	0.025	0.060
C23000	O60	soft anneal	over 1.0	F	75	0.025	0.060
C23000	O50	light anneal	up to 1.0, incl	30T	39	^C	0.035
C23000	O50	light anneal	over 1.0	F	85	^C	0.035
C26000, C33000, and C33200	O60	soft anneal	up to 0.080, incl	30T	40	0.025	0.060
C26000, C33000, and C33200	O60	soft anneal	over 0.080	F	80	0.025	0.060
C26000, C28000, C33000, C332000, and C37000	O50	light anneal	up to 0.080, incl	30T	60	^C	0.035
C26000, C28000, C33000, C332000, and C37000	O50	light anneal	over 0.080	F	90	^C	0.035
C27000, C27200, and C27400	O60	soft anneal	up to 0.080, incl	30T	40	0.025	0.060
C27000, C27200, and C27400	O60	soft anneal	over 0.080	F	80	0.025	0.060
C27000, C27200, and C27400	O50	light anneal	up to 0.080, incl	30T	60	^C	0.035
C27000, C27200, and C27400	O50	light anneal	over 0.080	F	90	^C	0.035
C44300	O60	soft anneal	up to 0.080, incl	30T	40	0.025	0.060
C44300	O60	soft anneal	over 0.080	F	80	0.025	0.060
C44300	O50	light anneal	up to 0.080, incl	30T	60	^C	0.035
C44300	O50	light anneal	over 0.080	F	90	^C	0.035

^AStandard designations defined in Practice B 601.

^BRockwell hardness values shall apply only to tubes having a wall thickness of 0.40 mm or over and to round tubes having an inside diameter of 8.0 mm or over and to rectangular including square tubes having an inside major distance between parallel surfaces of 5.0 mm or over. For all other tube no Rockwell hardness values shall apply. Rockwell hardness tests shall be made on the inside surface of the tube. When suitable equipment is not available for determining the specified Rockwell hardness, other Rockwell scales and values shall be specified subject to agreement between the manufacturer and the purchaser.

^CAlthough no minimum grain size is specified, the product must nevertheless have a fully recrystallized grain structure.

Standard Tube Size, mm	Maximum Percent Unbalance Signal Magnitude
Up to and including 12	0.2
15 to 54 incl	0.3
Over 54 to 79 incl	0.4

stand, without showing evidence of leakage, an internal hydrostatic pressure sufficient to subject the material to a fiber stress of 48 MPa, determined by the following equation for thin hollow cylinders under tension:

$$P = 2St/(D - 0.8t) \tag{1}$$

where:

- P = hydrostatic pressure, MPa;
- t = wall thickness of the material, mm;
- D = outside diameter of the material, mm; and
- S = allowable stress of the material.

11.3.2 *Pneumatic Test*—When specified, the tube shall be subjected to an internal air pressure of 400 kPa minimum for 5 s without showing evidence of leakage. The test method used shall provide for easy visual detection of any leakage, such as by immersion of the tube under water or by the pressure-differential method. Any evidence of leakage shall be cause for rejection.

12. Dimensions and Permissible Variations

12.1 The dimensions and tolerances for material covered by this specification shall be as prescribed in the current edition of Specification B 251M, with particular reference to Section 5 and the following tables of that specification:

11.2.2 Tubes that do not actuate the signalling device of the eddy-current testers shall be considered as conforming to the requirements of this test. If reexamined or retested, tubes with signals that are found to have been caused by minor mechanical damage, soil, or moisture, shall not be cause for rejection of the tubes provided the tube dimensions are still within prescribed limits and the tube is suitable for its intended application.

11.3 A pressure test shall be specified for tube sizes over 79 mm in outside diameter or tube of dimensions beyond the capabilities of the eddy-current test apparatus or as an alternative to the eddy-current test. The purchaser shall have the option to specify either a hydrostatic test in 11.3.1 or the pneumatic test in 11.3.2. When, in the case in which subsequent testing by the purchaser establishes that the material does not meet these requirements, then the tubes shall be subject to rejection.

11.3.1 *Hydrostatic Test*—When specified, the tube shall

- 12.2 *Wall Thickness Tolerances*—See 5.2, Tables 1 and 6.
12.3 *Tolerances for Diameter or Distance Between Parallel Surfaces*—See 5.3, Tables 2 and 7.
12.4 *Length Tolerances*—See 5.5, Tables 3 and 4.
12.5 *Roundness*—See 5.4.
12.6 *Squareness of Cut*—See 5.6.
12.7 *Straightness Tolerances*—For round tubes see 5.7.1, Table 5. For rectangular including square tubes see 5.7.2.
12.8 *Corner Radius for Rectangular Including Square Tubes*—See 5.8, Table 8.

- 12.9 *Twist Tolerances for Rectangular and Square Tubes*—See 5.9.

13. Workmanship, Finish, and Appearance

- 13.1 Annealed tube shall be either bright annealed or acid cleaned after final annealing operations.

14. Keywords

- 14.1 brass tube; seamless brass tube; seamless tube

SUPPLEMENTARY REQUIREMENTS

The following supplementary requirements shall apply only when specified by the purchaser in the inquiry, contract, or order, for agencies of the U.S. Government.

S1. Referenced Documents

S1.1 The following documents of the issue in effect on date of material purchase form a part of this specification to the extent referenced herein:

- S1.1.1 *Federal Standards*:⁵
Fed. Std. No. 102 Preservation, Packaging and Packing Levels
Fed. Std. No. 123 Marking for Shipment (Civil Agencies)
Fed. Std. No. 185 Identification Marking of Copper and Copper-Base Alloy Mill Products
S1.1.2 *Military Standard*:⁵
MIL-STD-129 Marking for Shipment and Storage
S1.1.3 *Military Specification*:⁵
MIL-C-3993 Packaging of Copper and Copper-Base Alloy Mill Products

S2. Quality Assurance

- S2.1 *Responsibility for Inspection*:
S2.1.1 Unless otherwise specified in the contract or purchase order, the manufacturer is responsible for the performance of all inspection and test requirements specified. Except as otherwise specified in the contract or purchase order, the manufacturer shall use his own or any other suitable facilities for the performance of the inspection and test requirements unless disapproved by the purchaser at the time the order is

placed. The purchaser shall have the right to perform any of the inspections or tests set forth when such inspections and tests are deemed necessary to assure that the material conforms to prescribed requirements.

S3. Identification Marking

S3.1 All material shall be properly marked for identification in accordance with Fed. Std. No. 185 except that the ASTM specification number and the alloy number shall be used.

S4. Preparation for Delivery

- S4.1 *Preservation, Packaging, Packing*:
S4.1.1 *Military Agencies*—The material shall be separated by size, composition, grade, or class and shall be preserved and packaged, Level A or C, packed, Level A, B, or C, as specified in the contract or purchase order, in accordance with the requirements of MIL-C-3993.
S4.1.2 *Civil Agencies*—The requirements of Fed. Std. No. 102 shall be referenced for definitions of the various levels of packaging protection.
S4.2 *Marking*:
S4.2.1 *Military Agencies*—In addition to any special marking required by the contract or purchase order, marking for shipment shall be in accordance with MIL-STD-129.
S4.2.2 *Civil Agencies*—In addition to any special marking required by the contract or purchase order, marking for shipment shall be in accordance with Fed. Std. No. 123.

⁵ Available from Standardization Documents Order Desk, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, ATTN: NPODS.



B 135M

SUMMARY OF CHANGES

Committee B05 has identified the location of selected changes to this standard since the publication of B 135M - 96 that may impact the use of this standard.

(I) Mandatory language was incorporated. Sections 3, 6, 10, and 11 and Tables 1-3 were affected.

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