



Designation: **B 569 – 9804**

Standard Specification for Brass Strip in Narrow Widths and Light Gage for Heat- Exchanger Tubing¹

This standard is issued under the fixed designation B 569; 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.

1. Scope*

1.1 This specification establishes the requirements for brass strip in narrow widths and light gages produced from Copper Alloys Nos. C23000, C26000, and C26130.

NOTE 1—This product is commonly used for the manufacture of thin-wall tubes for water passages in heat exchangers for internal combustion engines and other closed system heat sources.

~~1.2 Values given~~

~~1.2 Units—The values stated in inch-pound units are to be regarded as standard, except for grain size, which are given in SI units. The values given in parentheses are mathematical conversions to SI units, which are provided for information only and are not considered standard.~~

¹ This specification is under the jurisdiction of ASTM Committee B-5 B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.01 on Plate, Sheet, and Strip.

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*A Summary of Changes section appears at the end of this standard.

2. Referenced Documents

2.1 *ASTM Standards:*²

- B 248 Specification for General Requirements for Wrought Copper and Copper-Alloy Plate, Sheet, Strip, and Rolled Bar
- ~~B 601 Practice 601 Classification~~ for Temper Designations for Copper and Copper Alloys—Wrought and Cast
- B 846 Terminology for Copper and Copper Alloys
- ~~E 3 Methods of 3 Practice for~~ Preparation of Metallographic Specimens
- E 8 Test Methods for Tension Testing of Metallic Materials
- E 29 Practice for Using Significant Digits in Test Data to Determine Conformance With Specifications
- E 112 Test Methods for Determining Average Grain Size
- E 478 Test Methods for Chemical Analysis of Copper Alloys

3. Terminology

3.1 *Definitions*— For definitions of terms used in this specification, refer to Terminology B 846.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *capable of*—the test need not be performed by the producer of the ~~product; however, should~~ material. However, if subsequent testing by the purchaser establishes that the ~~product~~ material does not meet these requirements, the ~~product~~ material shall be subject to rejection.

4. Ordering Information

~~4.1 Orders for products should include~~

4.1 Include the following information when placing orders for products to this specification:

- 4.1.1 ASTM designation and year of issue (for example, B 569–XX),
- 4.1.2 Copper Alloy UNS No. designation (for example, C26000),
- 4.1.3 Temper (Section 7),
- 4.1.4 Dimensions: thickness, width, ~~length, and so forth~~ length (Section 14), and
- 4.1.5 Quantity: total weight each form, temper, and size.

4.2 The following options are available and should be specified at the time of placing an order when required:

- 4.2.1 Heat identification or traceability details,
- 4.2.2 Certification, and
- 4.2.3 Mill test report.

5. Materials and Manufacture

5.1 *Material:*

5.1.1 The material of manufacture shall be cast bar, cake, or slab of Copper Alloy UNS No. C23000, C26000, or C26130 of such purity and soundness as to be suitable for processing into the products prescribed herein.

5.1.2 In the event heat identification or traceability is required, the purchaser shall specify the details desired.

NOTE 2—Because of the discontinuous nature of the processing of castings into wrought products, it is not always practical to identify a specific casting analysis with a specific quantity of finished material.

5.2 *Manufacture:*

5.2.1 The product width shall be no greater than 3 in. (76.2 mm), and ~~under, and~~ thickness shall be less than 0.0181 in. (0.457 mm).

5.2.2 The product shall be manufactured by such hot-working, cold-working, and annealing processes as to produce a uniform wrought structure in the finished product.

5.2.2.1 The product shall be hot- or cold-worked to the finished size, and subsequently annealed, when required, to meet the temper properties specified.

5.2.3 Edges—Slit edges shall be furnished.

6. Chemical Composition

6.1 The material shall conform to the chemical compositional requirements in Table 1 for Copper Alloy UNS No. designation specified in the ordering information.

6.1.1 These composition limits do not preclude the presence of other elements. Limits ~~may~~ shall be established and analysis required for unnamed elements ~~by agreement when agreed upon~~ between the manufacturer and the purchaser.

~~6.2 Zinc, specified~~

6.2 For alloys in which zinc is listed as “remainder,” zinc is the “Remainder,” may be taken as the difference between the sum of results for of all elements determined and 100 %.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards*, Vol 02.01, volume information, refer to the standard’s Document Summary page on the ASTM website.

TABLE 1 Chemical Requirements

Copper Alloy UNS No.	Composition, %				
	Copper	Lead, max	Iron, max	Arsenic	Zinc
C23000	84.0–86.0 ^A	0.05	0.05	...	Remainder
C26000	68.5–71.5 ^B	0.07	0.05	...	Remainder
C26130	68.5–71.5 ^B	0.05	0.05	0.02–0.08	Remainder

^A Cu + Sum of Named Elements = 99.8 %.

^B Cu + Sum of Named Elements = 99.7 %.

6.2.1 When zinc is determined, however, copper may be taken by difference, and when so taken, the results must conform with the requirements of Table 1 for copper.

6.3 When all elements listed in Table 1 are determined for C26000 and C26130 the sum of results shall be 99.7 % min and for C23000 the sum of results shall be 99.8 % min.

7. Temper

7.1 Products shall be produced in tempers H01 (¼ hard), H02 (½ hard), O81 (Annealed-to-Temper—¼ hard), and O82 (Annealed-to-Temper—½ hard) as defined in Practice Classification B 601.

NOTE 3—The purchaser should confer with the manufacturer or supplier for the availability of product in a specific temper.

8. Grain Size of Annealed Tempers

8.1 Annealed-to-Temper (O81 and O82) strip shall have an average grain size of 0.015 mm maximum as determined by Test Methods E 112.

9. Mechanical Property Requirement

9.1 *Tensile Strength Requirement* —The product furnished shall conform to the requirements prescribed in Tables 2 and 3 for the temper specified in the ordering information when tested in accordance with Test Methods E 8.

9.2 *Yield Strength Requirement* —The product furnished shall be capable of conforming to the requirements prescribed in Tables 2 and 3 for the temper specified in the ordering information when tested in accordance with Test Methods E 8.

9.3 *Elongation Test Requirement* —The product furnished shall conform to the requirements prescribed in Tables 2 and 3 for the temper specified in the ordering information when tested in accordance with Test Methods E 8.

10. Dimensions, Mass, and Permissible Variations

10.1 Unless closer tolerances are specified in the contract or purchase order, the product furnished shall conform to the following thickness and width tolerances:

10.1.1 *Thickness Tolerances*—Table 4.

10.1.2 *Width Tolerances*—Table 5.

10.2 *Straightness Tolerances*—The maximum edgewise curvature (depth of arc) in any 72-in. (1830-mm) continuous length shall not exceed ⅛ in. (3.18 mm).

11. Workmanship, Finish and Appearance

11.1 The strip shall be free of defects, but blemishes of a nature that do not interfere with normal commercial operations are acceptable. It shall be well-cleaned and free of dirt. A superficial film of residual light lubricant may be present and is acceptable unless otherwise specified.

11.2 The surface finish and appearance shall be the normal commercial quality for the alloy, thickness, and temper ordered. When application information is provided with the purchase order, the surface shall be that commercially producible for the application. Superficial films of discoloration, or lubricants, or tarnish inhibitors are permissible unless otherwise specified.

12. Sampling

12.1 *Sampling*—The lot size, portion size, and selection of sample pieces shall be as follows:

TABLE 2 Tensile Strength Requirements and Tension Test Values for Rolled-to-Temper Material

Copper Alloy UNS No.	Tensile Strength, ksi (MPa ^A)				Yield Strength, ksi (MPa ^A)				% Elongation In 2 in. (50 mm)
	Temper Designation				At 0.5 % Extension Under Load		At 0.2 % Offset		
	Standard	Former	Minimum	Maximum	Minimum	Maximum	Minimum	Maximum	
C23000	H01	¼ Hard	44 (305)	54 (370)	25 (170)	48 (330)	23 (160)	48 (330)	18
C26000 and C26130	H01	¼ Hard	49 (340)	59 (405)	33 (230)	48 (330)	30 (205)	45 (205)	12
C26000 and C26130	H02	½ Hard	58 (400)	68 (470)	43 (295)	58 (400)	40 (275)	55 (380)	10

^A See Appendix X1.

TABLE 3 Tensile Strength Requirements and Tension Test Values for Annealed-to-Temper Material

Copper Alloy UNS No.	Tensile Strength, ksi (MPa ^A)				Yield Strength, ksi (MPa ^A)			% Elongation In 2 in. (50 mm)
	Standard Temper Designation	Minimum	Maximum	At 0.5 % Extension Under Load		At 0.2 % Offset		
				Minimum	Maximum	Minimum	Maximum	
C23000	O81	42 (210)	52 (360)	21 (145)	36 (250)	20 (140)	35 (240)	34
C26000 and C26130	O82	60 (415)	70 (485)	35 (240)	50 (345)	34 (235)	49 (340)	25

^A See Appendix X1.

TABLE 4 Thickness Tolerances

Thickness, in. (mm)	Thickness Tolerance, ±in. (mm), ^{A,B} 3 in. (7.62 mm) and Under in Width
0.006 (0.01) and under	0.0003 (0.008)
Over 0.0006 to 0.009 (0.152 to 0.229)	0.0004 (0.010)
Over 0.009 to 0.018 (0.229 to 0.330)	0.0005 (0.013)

^A When tolerances are specified as all plus or minus, double the values shown.

^B Some applications may require a closer tolerance control within any one coil even though the overall tolerance between coils or shipments can be to the tolerance shown. Such special tolerance requirements shall be negotiated between the manufacturer or supplier and the purchaser at the time the order is placed.

TABLE 5 Width Tolerances for Slit Metal

Width, in. (mm)	Width Tolerances, ±in. (mm), ^{A,B} for Thicknesses 0.018 in. (0.330 mm) and Under
1.750 (44.45) and under	0.003 (0.08)
Over 1.750 to 3 (44.5 to 76.2)	0.005 (0.13)

^A When tolerances are specified as all plus or minus, double the values shown.

^B Some applications may require a closer tolerance control within any one coil even though the overall tolerance between coils or shipments can be to the tolerance shown. Such special tolerance requirements shall be negotiated between the manufacturer or supplier and the purchaser at the time the order is placed.

12.1.1 *Lot Size*—An inspection lot shall be 10 000 lb (4550 kg) or less of material of the same mill form, alloy, temper, and nominal dimensions, subject to inspection at one time or shall be the product of one cast bar from a single melt charge, whose weight shall not exceed 25 000 lb (11 350 kg), that has been processed continuously and subject to inspection at one time.

12.1.2 *Portion Size*—A portion shall be four or more pieces selected to be representative of each lot. If the lot consists of less than four pieces, representative samples shall be taken from each piece.

12.1.2.1 *Chemical Analysis*—The sample for chemical analysis shall be taken in accordance with Practice E 255 for product in its final form. Unless otherwise required by the purchaser, at the time the order is placed the manufacturer shall have the option of determining conformance to chemical composition by analyzing samples taken at the time the castings are poured or samples taken from the semifinished product if heat identity can be maintained throughout all operations. If the manufacturer determines the chemical composition during manufacture, he shall not be required to sample and analyze the finished product. The minimum weight of the composite sample in accordance with Practice E 255 shall be 150 g.

12.1.2.2 *Samples for All Other Tests*—Samples for all other tests shall be taken from the sample portion in 12.1.2 and be of a convenient size to accommodate the test and comply with the requirements of the appropriate ASTM product standards and test methods.

13. Number of Tests and Retests

13.1 Tests:

13.1.1 *Chemical Composition*—Composition shall be determined as ~~the~~ per the element mean of results from at least two replicate analyses of the sample and the results of each replication must meet the requirements of the product specification.

13.1.2 Other Tests:

13.1.2.1 *Grain Size*—The average grain size of two specimens shall be the arithmetic average of at least three determinations, each in a different field and the test results for each specimen shall be reported.

13.1.2.2 *Tensile Strength and Elongation*, shall be reported from specimens prepared from each of two pieces selected in 12.1.2 and each specimen must meet the requirements of the product specification.

13.2 Retests:

13.2.1 When requested by the manufacturer or supplier, a retest shall be permitted ~~should test~~ when results of tests obtained by the purchaser or supplier fail to conform ~~with specification requirements~~.

~~13.2.2 Retesting~~ to the requirements of the product specification.

13.2.2 The retest shall be as directed in the product specification for the initial test except that the number of test specimens shall be twice that normally required for the initial specified test.

13.2.3 Test results for all specimens shall conform to the product specification requirements in retest and f. Failure to conform shall be cause for lot rejection.

14. Specimen Preparation

14.1 *Chemical Analysis*—The analytical specimen preparation shall be the responsibility of the reporting laboratory.

14.2 *Grain Size*—The test specimen shall be prepared in accordance with ~~Methods Practice E 3.~~

14.3 *Tensile Test*— The test specimen shall conform to the requirements prescribed for the specific product described in the Test Specimen section of Test Methods E 8. The test specimen shall be taken so that the longitudinal axis is parallel to the direction of rolling.

15. Test Methods

15.1 *Chemical Analysis:*

15.1.1 Composition shall be determined, in case of disagreement, as follows:

Element	Test Method
Copper	E 478
Iron	E 478
Lead	E 478 (AA)
Zinc	E 478 (Titrimetric)
Zinc	E 478 (Titrimetric)

15.1.2 Test method(s) used for the determination of element(s) required by contractual or purchase order agreement shall be as agreed upon between the manufacturer and the purchaser.

15.2 *Other Tests:*

15.2.1 The product furnished shall conform to all other requirements when subjected to test in accordance with the following table:

Test	Test Method
Grain Size	E 112
Tensile Strength	E 8

15.2.1.1 *Grain Size*—In case of dispute, the intercept method of Test Methods E 112 shall be followed.

15.2.1.2 Yield strength shall be determined by the extension-under-load method of Test Methods E 8. When test results are obtained from both full size and machined specimens and they differ, the test results from the ~~full size~~ machined specimens shall prevail.

16. Significance of Numerical Limits

16.1 For purposes of determining compliance with the specified limits for requirements of the properties listed in the following table, an observed value or a calculated value shall be rounded as indicated in accordance with the rounding method of Practice E 29.

Property	Rounded Unit for Observed or Calculated Value
Chemical composition	Nearest unit in the last right-hand significant digit
Tensile strength	used in expressing the limiting value
Yield strength	nearest ksi (nearest 5 MPa)
Elongation	nearest ksi (nearest 5 MPa)
Grain size	nearest 1 %
	nearest multiple of 0.005 mm

17. Inspection

17.1 The manufacturer or supplier shall inspect and make tests necessary to verify that the product furnished conforms to the requirements specified.

17.2 Source inspection of the material by the purchaser may be agreed upon between the manufacturer or supplier and the purchaser as part of the purchase contract. In this case, the nature of the facilities needed to satisfy the inspector representing the purchaser that the product is being furnished in accordance with this specification shall be included in the agreement. All test and the inspection shall be conducted so as not to interfere unnecessarily with the operation of the works.

17.3 The manufacturer or supplier and the purchaser, by mutual agreement, may accomplish the final inspection simultaneously.

18. Rejection and Rehearing

18.1 *Rejection*

18.1.1 Product that fails to conform to the specification requirements when tested by the purchaser, or purchaser's agent, may be rejected.

18.1.2 Rejection shall be reported to the manufacturer, or supplier, promptly and in writing.

18.1.3 In case of dissatisfaction with results of the test upon which rejection was based, the manufacturer, or supplier, may make claim for a rehearing.

18.2 *Rehearing*

18.2.1 As a result of product rejection, the manufacturer or supplier may make claim for a retest to be conducted by the manufacturer, or supplier, and the purchaser.

18.2.2 Samples of the rejected product shall be taken in accordance with the product specification and tested by both parties using the test method(s) specified in the product specification, or, alternately, upon agreement of both parties, an independent laboratory may be selected for the test(s) using the test method(s) specified in the product specification.

19. Certification

19.1 When specified in the purchase order or contract, the purchaser shall be furnished certification that samples representing each lot have been either tested ~~and~~ or inspected as directed in this specification and the requirements have been met.

20. Test Report

20.1 When specified in the contract or purchase order, a report of the test results shall be furnished.

21. Packaging and Package Marking

21.1 *Packaging*—The product shall be separated by size, composition, and temper and prepared for shipment in such a manner as to ensure acceptance by a common carrier for transportation and to afford protection from the normal hazards of transportation.

21.2 *Package Marking*—Each shipping unit shall be legibly marked with the purchase order number, metal or alloy designation, temper, size, shape, gross and net weight, and name of supplier. The specification number shall be shown, when specified.

22. Keywords

22.1 brass strip; heat exchanger tubing; internal combustion engine; strip in light gage; strip in narrow width; UNS No. C23000; UNS No. C26000; UNS No. C26130

APPENDIX

(Nonmandatory Information)

X1. METRIC EQUIVALENTS

X1.1 The SI unit for strength properties now shown is in accordance with the International System of Units (SI). The derived SI unit for force is the newton (N), which is defined as that force which, when applied to a body having a mass of 1 kg, gives it an acceleration of 1 m/s² (N = kg·m/s²). The derived SI unit for pressure or stress is the newton per square metre (N/m²), which has been named the pascal (Pa) by the General Conference on Weights and Measures. Since 1 ksi = 6 894 757 Pa, the metric equivalents are expressed as megapascal (MPa), which is the same as MN/m² and M/mm².

SUMMARY OF CHANGES

~~The section identifies~~

Committee B05 has identified the location of selected changes to this specification that have been incorporated standard since the 1993 issue: last issue (B 569 – 98) that may impact the use of this standard. (Approved May 1, 2004.)

(1) This specification has been completely revised for better clarity of intent and conformance to comply with ASTM Committee B-5 policy for format. A significant revision the selected wording of the B05 *Outline of Form*.

(2) The term “edges” was added to Section 5, Manufacture.

(3) Section 21 has been made for the Tests and Retests section revised to address retest list both Packaging and Package Marking with subjection titles.

 **B 569 – 9804**

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