



# Standard Specification for Seamless Brass Tube<sup>1</sup>

This standard is issued under the fixed designation B135; 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 ( $\epsilon$ ) 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. 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. <sup>2</sup>	Previously Used Designation <sup>4</sup>	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	...	71.5	27.5	...	1.00

<sup>4</sup> Alloy Designations of Specification B135 – 63, which was published in the 1966 Book of ASTM Standards, Part 5.

1.2 This specification is the inch-pound companion to Specification B135M; therefore, no SI equivalents are presented in the specification.

1.3 **Warning**—Mercury has been designated by EPA and many state agencies as a hazardous material that can cause central nervous system, kidney, and liver damage. Mercury, or its vapor, may be hazardous to health and corrosive to materials. Caution should be taken when handling mercury and mercury-containing products. See the applicable product Material Safety Data Sheet (MSDS) for details and EPA’s website (<http://www.epa.gov/mercury/faq.htm>) for additional information. Users should be aware that selling mercury or mercury-

<sup>1</sup> 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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<sup>2</sup> The UNS system for copper and copper alloys (see Practice E527) is a simple expansion of the former standard designation system accomplished by the addition of a prefix “C” and a suffix “00.” The suffix can be used to accommodate composition variations of the base alloy.

containing products, or both, in your state may be prohibited by state law. (See 10.1.)<sup>2</sup>

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

## 2. Referenced Documents

2.1 *ASTM Standards:*<sup>3</sup>

[B153 Test Method for Expansion \(Pin Test\) of Copper and Copper-Alloy Pipe and Tubing](#)

[B154 Test Method for Mercurous Nitrate Test for Copper Alloys](#)

[B251 Specification for General Requirements for Wrought Seamless Copper and Copper-Alloy Tube](#)

[B601 Classification for Temper Designations for Copper and Copper Alloys—Wrought and Cast](#)

[E243 Practice for Electromagnetic \(Eddy-Current\) Examination of Copper and Copper-Alloy Tubes](#)

[E527 Practice for Numbering Metals and Alloys in the Unified Numbering System \(UNS\)](#)

## 3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

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

## 4. Ordering Information

4.1 Orders for material under the 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)),

<sup>3</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard’s Document Summary page on the ASTM website.

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

4.1.4 Dimensions: 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.

## 5. General Requirements

5.1 Material furnished under this specification shall conform to the applicable requirements of the current edition of Specification B251.

## 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 1—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 40 ksi and a minimum yield strength of 12 ksi 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 0.020 in. and for round tubes having an inside diameter under  $\frac{5}{16}$  in. and for rectangular including square tubes having a major distance between inside parallel surfaces under  $\frac{3}{16}$  in. 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 B153 an expansion of the outside diameter in the following amount:

**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	0.09 max	...	...	0.07	remainder
C27200	62.0–65.0	0.07 max	...	...	0.07	remainder
C27400	61.0–64.0	0.09 max	...	...	0.05	remainder
C28000	59.0–63.0	0.09 max	...	...	0.07	remainder
C33000	65.0–68.0	0.25 <sup>A</sup> –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

<sup>A</sup> In the case of Copper Alloy UNS No. C33000 on tube sizes greater than 5 in. in outside diameter, or distance between outside parallel surfaces, the lead content shall be 0.7 % maximum, no minimum is specified.