



Designation: **B453/B453M – 11 (Reapproved 2017) B453/B453M – 19**

Standard Specification for Copper-Zinc-Lead Alloy (Leaded-Brass) Rod, Bar, and Shapes¹

This standard is issued under the fixed designation B453/B453M; 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 U.S. Department of Defense.

1. Scope*

1.1 This specification establishes the requirements for copper-zinc-lead alloy (leaded-brass) rod, bar, wire, and shapes produced from Copper Alloys UNS Nos. C33500, C34000, C34500, C35000, C35300, C35330, C35350, and C35600. These alloys have nominal composition given in [Table 1](#).

1.1.1 This product is suitable for applications requiring extensive machining before such cold-forming operations as swaging, flaring, severe knurling, or thread rolling.

NOTE 1—Refer to [Appendix X1](#) for additional applications information.

1.1.2 Typically, product made to this specification is furnished as straight lengths. Sizes $\frac{1}{2}$ in. [12 mm] and under may be furnished as wire in coils or on reels when requested.

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be necessarily exact equivalents; therefore, to ensure conformance with the standard, each system shall be used independently of the other. ~~Combining other, and values from the two systems may result in non-conformance with the standard; shall not be combined.~~

NOTE 2—Refer to Specifications [B16/B16M](#) and [B140/B140M](#) for copper-zinc-lead (leaded-brass) rod and bar for screw machine applications.

1.3 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

- 2.1 *ASTM Standards:*²
- [B16/B16M](#) Specification for Free-Cutting Brass Rod, Bar and Shapes for Use in Screw Machines
 - [B140/B140M](#) Specification for Copper-Zinc-Lead (Red Brass or Hardware Bronze) Rod, Bar, and Shapes
 - [B249/B249M](#) Specification for General Requirements for Wrought Copper and Copper-Alloy Rod, Bar, Shapes and Forgings
 - [B250/B250M](#) Specification for General Requirements for Wrought Copper Alloy Wire
 - [B601](#) Classification for Temper Designations for Copper and Copper Alloys—Wrought and Cast
 - [E8/E8M](#) Test Methods for Tension Testing of Metallic Materials
 - [E18](#) Test Methods for Rockwell Hardness of Metallic Materials
 - [E62](#) Test Methods for Chemical Analysis of Copper and Copper Alloys (Photometric Methods) (Withdrawn 2010)³
 - [E478](#) Test Methods for Chemical Analysis of Copper Alloys

3. General Requirements

3.1 The following sections of Specifications [B249/B249M](#) and [B250/B250M](#) are a part of this specification:

3.1.1 Terminology,

¹ This specification is under the jurisdiction of ASTM Committee [B05](#) on Copper and Copper Alloys and is the direct responsibility of Subcommittee [B05.02](#) on Rod, Bar, Wire, Shapes and Forgings.

Current edition approved ~~Oct. 1, 2017~~ April 1, 2019. Published ~~October 2017~~ April 2019. Originally approved in 1967. Last previous edition approved in 2011 as [B453/B453M – 11](#) [B453/B453M^ε – 11](#) (2017). DOI: [10.1520/B0453_B0453M-11R17-10.1520/B0453_B0453M-19](#).

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* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on [www.astm.org](#).

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



TABLE 1 Nominal Composition, %

Copper Alloy UNS No.	Copper	Zinc	Lead
C33500	63.5	36.0	0.5
C34000	63.5	35.3	1.2
C34500	63.5	34.5	2.0
C35000	61.5	37.1	1.4
C35300	61.5	36.5	2.0
C35330	61.8	35.7	2.5
C35350	62.0	34.5	3.2
C35600	61.5	36.0	2.5

- 3.1.2 Materials and Manufacture,
- 3.1.3 Workmanship, Finish, and Appearance,
- 3.1.4 Sampling,
- 3.1.5 Number of Tests and Retests,
- 3.1.6 Specimen Preparation,
- 3.1.7 Test Methods,
- 3.1.8 Significance of Numerical Limits,
- 3.1.9 Inspection,
- 3.1.10 Rejection and Rehearing,
- 3.1.11 Certification,
- 3.1.12 Mill Test Report,
- 3.1.13 Packaging and Package Marking, and
- 3.1.14 Supplementary Requirements.

3.2 In addition, when a section with a title identical to one of those referenced in 3.1 appears in this specification, it contains additional requirements which supplement those appearing in Specifications B249/B249M and B250/B250M.

4. Ordering Information

- 4.1 Include the following information in orders for product:
 - 4.1.1 ASTM designation and year of issue (for example, B453/B453M – 05),
 - 4.1.2 Copper Alloy UNS Number designation,
 - 4.1.3 Product (rod, bar, wire, or shape),
 - 4.1.4 Cross section (round, hexagonal, square, and so forth),
 - 4.1.5 Temper (See Section 6),
 - 4.1.6 Dimensions (diameter or distance between parallel surfaces, width, thickness),
 - 4.1.7 How furnished: straight lengths, coils, or reels,
 - 4.1.8 Length,
 - 4.1.9 Total length or number of pieces of each size,
 - 4.1.10 Weight: total for each form, and size, and
 - 4.1.11 When product is purchased for agencies of the U.S. Government.

- 4.2 The following are options and should be specified in the ordering information when required:
 - 4.2.1 Tensile test for product ½ in. [12 mm] and over in diameter or distance between parallel surfaces,
 - 4.2.2 Certification,
 - 4.2.3 Mill test report, and
 - 4.2.4 Automatic screw machine use (9.1.4).

5. Chemical Composition

5.1 The material shall conform to the chemical composition requirements in Table 2 for the Copper Alloy UNS No. designation specified in the ordering information.

5.1.1 These composition limits do not preclude the presence of other elements. Limits may be established and analysis required for unnamed elements by agreement between the manufacturer and the purchaser. For copper alloys in which zinc is listed as the “remainder,” either copper or zinc may be taken as the difference between the sum of all elements determined and 100 %. When copper is so determined, that difference value shall conform to the requirements given in Table 2.

5.2 When all the named elements in Table 2 for the specified alloy are determined, the sum of results shall be as follows:

Copper Alloy UNS No.	Percent, min
C33500, C34000, C34500, C35000	99.6
C35300, C35330, C35350, C35600	99.5



TABLE 2 Chemical Requirements

Copper Alloy UNS No.	Composition, %			
	Copper	Lead	Iron	Zinc
C33500	62.0–65.0	0.25–0.7	0.15 max	remainder
C34000	62.0–65.0	0.8–1.5	0.15 max	remainder
C34500	62.0–65.0	1.5–2.5	0.15 max	remainder
C35000	61.0–63.0	0.8–2.0	0.15 max	remainder
C35300	61.0–63.0	1.5–2.5	0.15 max	remainder
C35330 ^A	59.5–64.0	1.5–3.5 ^B	...	remainder
C35350 ^C	61.0–63.0	2.0–4.5	0.40	remainder
C35350 ^C	61.0–63.0	2.0–4.5	0.4 max	remainder
C35600	60.0–63.0	2.0–3.0	0.15 max	remainder

^A 0.02–0.25 As^B Pb may be reduced to 1.0 % by agreement.^C Includes nickel 0.05–0.30, phosphorus 0.05–0.20, tin 0.300.3 % max, phosphorus 0.05–0.2, tin 0.6 max.

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

NOTE 3—Due to 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.

6. Temper

6.1 The standard tempers, as defined in Classification B601, for products described in this specification are given in Tables 3-6.

6.1.1 O60 (soft anneal),

6.1.2 H01 (¼ hard),

6.1.3 HR01 (¼ hard and Stress Relieved), and

6.1.4 H02 (½ hard) (UNS Alloy No. C35350 is available only in this temper).

6.2 Other tempers, and temper for other products including shapes, shall be subject to agreement between the manufacturer and the purchaser.

TABLE 3 Rockwell Hardness Requirements, Inch-Pound^A

NOTE 1—SI values are stated in Table 4.

Temper Designation		Diameter or Distance Between Parallel Surfaces, in.	Rockwell B Hardness Determined on the Cross Section Midway Between Surface and Center (All Alloys except C35350)	Rockwell Hardness Determined on the Cross Section Midway Between Surface and Center (Alloy C35350)
Code	Name			
Rod and Wire				
O60	soft anneal	½ and over	45 max	
H01	¼ hard	½ to 1, both incl	50–75	...
		over 1 to 2, incl	40–70	...
		over 2	35–65	...
HR01	¼ hard and Stress Relieved	½ to 1, both incl	50–75	...
		over 1 to 2, incl	40–70	...
		over 2	35–65	...
H02	½ hard	½ to 1, both incl	60–80	68–85
		over 1 to 2, incl	50–75	62–80
		over 2	40–70	53–70
Bar ^B				
O60	soft anneal	½ and over	35 max	...
H01	¼ hard	½ to 1, both incl	45–75	...
		over 1 to 2, incl	35–70	...
		over 2	35–65	...
H02	½ hard	½ to 1, both incl	45–85	68–85
		over 1 to 2, incl	40–80	62–80
		over 2	35–70	53–70

^A Rockwell hardness requirements are not established for diameters less than ½ in.

^B For rectangular bar, the Distance Between Parallel Surfaces refers to thickness.