



Designation: **B75/B75M—19** **B75/B75M – 20**

Standard Specification for Seamless Copper Tube¹

This standard is issued under the fixed designation B75/B75M; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

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

1. Scope*

1.1 This specification² establishes the requirements for seamless round, rectangular, and square copper tube suitable for general engineering applications.

1.1.1 Tubes made from any of the following Copper UNS No. designations shall be supplied unless otherwise specified in the contract or purchase order:

Copper UNS No.	Type of Copper
C10100	Oxygen-free electronic
C10200	Oxygen-free without residual deoxidants
C10300	Oxygen-free, extra low phosphorus
C10800	Oxygen-free, low phosphorus
C12000	Phosphorus deoxidized, low residual phosphorus
C12200	Phosphorus deoxidized, high residual phosphorus

1.2 *Units*—The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, SI units are shown in brackets. The values stated in each system are not necessarily exact equivalents; therefore, to ensure conformance with the standard, each system shall be used independently of the other, and values from the two systems shall not be combined.

1.3 The following safety hazard caveat pertains only to the test methods described in this specification: *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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *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:³

- [B153 Test Method for Expansion \(Pin Test\) of Copper and Copper-Alloy Pipe and Tubing](#)
- [B170 Specification for Oxygen-Free Electrolytic Copper—Refinery Shapes](#)
- [B193 Test Method for Resistivity of Electrical Conductor Materials](#)
- [B251/B251M Specification for General Requirements for Wrought Seamless Copper and Copper-Alloy Tube](#)
- [B577 Test Methods for Detection of Cuprous Oxide \(Hydrogen Embrittlement Susceptibility\) in Copper](#)
- [B601 Classification for Temper Designations for Copper and Copper Alloys—Wrought and Cast](#)
- [B846 Terminology for Copper and Copper Alloys](#)
- [E8/E8M Test Methods for Tension Testing of Metallic Materials](#)
- [E18 Test Methods for Rockwell Hardness of Metallic Materials](#)
- [E53 Test Method for Determination of Copper in Unalloyed Copper by Gravimetry](#)

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 For ASME Boiler and Pressure Vessel Code applications, refer to related Specification SB-75 in Section II of that Code.

³ 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.

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

[E62 Test Methods for Chemical Analysis of Copper and Copper Alloys \(Photometric Methods\) \(Withdrawn 2010\)](#)⁴

[E112 Test Methods for Determining Average Grain Size](#)

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

[E255 Practice for Sampling Copper and Copper Alloys for the Determination of Chemical Composition](#)

2.2 *ASME Standard*.⁵

[ASME Boiler and Pressure Vessel Code](#)

3. General Requirements

3.1 The following sections of Specification [B251/B251M](#) are a part of this specification.

3.1.1 Terminology, General;

3.1.2 Material and Manufacture;

3.1.3 Workmanship, Finish, and Appearance;

3.1.4 Significance of Numerical Limits;

3.1.5 Inspection;

3.1.6 Rejection and Rehearing;

3.1.7 Certification;

3.1.8 Mill Test Reports;

3.1.9 Packaging and Package Marking; and

3.1.10 Supplementary Requirements.

3.2 In addition, when a section with an identical title to those referenced in section 3.1 appears in this specification, and is in conflict with the section appearing in Specification [B251/B251M](#), the section in this specification shall prevail.

4. Terminology

4.1 *Definitions*—For definitions of terms related to copper and copper alloys, refer to Terminology [B846](#).

5. Ordering Information

5.1 Include the following specific choices when placing orders for product under this specification, as applicable.

5.1.1 ASTM designation and year of issue (for example, B75 – 02);

5.1.2 Copper UNS No. (for example, C10100);

5.1.3 Temper (Section 8);

5.1.4 Dimensions; diameter or distance between parallel surfaces, and wall thickness (Section 17);

5.1.5 How furnished; coils or straight lengths;

5.1.6 Number of pieces or footage; each size and type;

5.1.7 Total weight.

5.2 The following options are available but may not be included unless specified at the time of placing the order, when required:

5.2.1 Electrical mass resistivity test,

5.2.2 Hydrogen embrittlement test,

5.2.3 Hydrostatic test for pressures less than or equal to 1000 psi (21.2.8),

5.2.4 Hydrostatic test for pressures over 1000 psi (21.2.8.1),

5.2.5 Pneumatic test,

5.2.6 Certification,

5.2.7 Mill test report,

5.2.8 Expansion test,

5.2.9 When product is purchased for ASME Boiler and Pressure Vessel Code application,

5.2.10 When product is purchased for agencies of the U.S. Government.

6. Material and Manufacture

6.1 *Material*—The material of manufacture shall be billets, bars, or tube of Copper UNS No. C10100, C10200, C10300, C10800, C12000, or C12200, and shall be of such soundness as to be suitable for processing into the tubular products described.

6.2 *Manufacture*:

6.2.1 The tube shall be manufactured by such hot- and cold-working processes as to produce a uniform wrought structure in the finished product. It shall be cold drawn to the finished size and wall thickness.

⁴ The last approved version of this historical standard is referenced on www.astm.org.

⁵ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

6.2.2 When cold-drawn temper is required, the final drawing operation shall be such as to meet the specified temper. When annealed temper is required, the tube shall be annealed subsequent to the final cold draw.

7. Chemical Composition

7.1 The material shall conform to the requirements in **Table 1** for the specified Copper UNS No. designation.

7.1.1 These composition limits do not preclude the presence of other elements. By agreement between the manufacturer or supplier and the purchaser, limits may be established and analysis required for unnamed elements.

8. Temper

8.1 The requirements and size availability of tube in the cold-drawn tempers H55, H58, and H80, as defined in Classification **B601**, are specified in **Table 2** or **Table 3**.

8.1.1 Rectangular, including square, tube shall normally be supplied only in H58 temper. When requested by the manufacturer or supplier, and upon agreement with the purchaser, tube may be supplied in H55 temper.

8.1.1.1 For any combination of diameter and wall thickness not listed under H80 temper, the requirements specified for H58 temper shall apply.

8.2 The requirements and size availability of tube in the annealed tempers O50, O60, and O62 as defined in Classification **B601**, are specified in **Table 2** or **Table 3**.

NOTE 1—The purchaser shall confer with the manufacturer or supplier for the availability of product in a specific temper.

NOTE 2—Refer to **Appendix X1** for recommended applications based on temper.

9. Grain Size Requirements

9.1 Tube in the annealed temper shall conform to the grain size specified in **Table 2** or **Table 3**.

9.2 Acceptance or rejection based upon grain size shall depend only on the average grain size of a test specimen taken from each of two sample portions, and each specimen shall be within the limits prescribed in **Table 2** or **Table 3** when determined in accordance with Test Methods **E112**.

10. Physical Property Requirements

10.1 *Electrical Resistivity*—When specified in the contract or purchase order, tube ordered for electrical conductor application produced from Copper UNS No. C10100, C10200, C10300, or C12000 shall have an electrical mass resistivity, $\Omega \cdot \text{g}/\text{m}^2$, not to exceed the following limit for the specified copper and temper when tested in accordance with Test Method **B193**:

Temper	Copper UNS No.			
	C10100	C10200	C10300	C12000
O60, O50	0.151 76	0.153 28	0.156 14	0.170 31
H55, H58, H80	0.156 14	0.157 37	0.159 40	0.174 18

NOTE 3—Refer to **Appendix X2** for the International Annealed Copper Standard (IACS) electrical conductivity equivalents.

11. Mechanical Property Requirements

11.1 *Tensile and Yield Strength Requirements:*

11.1.1 The tube furnished under this specification shall conform to the requirements of **Table 2** or **Table 3** for the specified temper and wall thickness when tested in accordance with Test Methods **E8/E8M**.

11.1.2 For any combination of diameter and wall thickness not listed under H80, the requirements for H58 shall apply.

11.1.3 Alternative Tensile and Yield values to those listed in **Table 2** or **Table 3** are acceptable upon agreement between the purchaser and supplier.

11.2 *Rockwell Hardness Requirements:*

TABLE 1 Chemical Requirements

Element	Composition, %					
	Copper UNS No.					
	C10100 ^{A, B}	C10200 ^{B, C, D}	C10300	C10800	C12000	C12200
Copper, min	99.99	99.95	99.90	99.9
Copper + phosphorus, min	99.95	99.95
Phosphorus	0.001–0.005	0.005–0.012	0.004–0.012	0.015–0.040

^A Refer to Table 1, Chemical Requirements, Grade 1, of Specification **B170** for impurity limits for Copper UNS No. C10100.

^B Cu value not including Ag.

^C Refer to Table 1, Chemical Requirements, Grade 2, of Specification **B170** for impurity limits for Copper UNS No. C10200.

^D Cu value includes Ag.

TABLE 2 Mechanical Property Requirements of Drawn-Temper and Annealed-Temper Tube (inch-pound values)

Temper Designation		Outside Diameter, or Major Distance Between Outside Parallel Surfaces, in.	Wall Thickness, in.	Rockwell Hardness ^A		Average Grain Size, mm	Tensile Strength, ksi ^B	Yield Strength, min, ksi ^{B,C}
Code	Name			Scale	Hardness			
H55	light-drawn ^D	all	all	30T	30 to 60		36–47	30
H58	drawn (general purpose)	all	all	30T	30 min		36 min	30
H80	hard-drawn ^D	up to 4	0.020 to 0.250, incl	30T	55 min		45 min	40
O62	heavy anneal	all	0.015 to 0.035 0.035 and over	15T ^E F ^E	60 max 55 max	0.050 max 0.050 max	30 min 30 min	6.5 ^{F, G} 6.5 ^{F, G}
O60	soft anneal	all	0.015 to 0.035 0.035 and over	15T F	60 max 50 max	0.040 min 0.040 min	30 min 30 min	9 9
O50	light anneal	all	0.015 to 0.035 0.035 and over	15T F	65 max 55 max	0.040 max 0.040 max	30 min 30 min	9 9

^A 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 purchaser and supplier.

^B ksi = 1000 psi.

^C Yield strength to be determined at 0.5 % extension under load.

^D Light-drawn and hard-drawn tempers are normally available in round tubes only.

^E Rockwell hardness values shall apply only to tubes having a wall thickness of 0.015 in. or over, to round tubes having an inside diameter of $\frac{5}{16}$ in. or over, and to rectangular, including square, tubes having an inside major distance between parallel surfaces of $\frac{3}{16}$ in. or over. For all other tube, no Rockwell 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 purchaser and supplier.

^F Light-straightening operation is acceptable.

^G Alternative Tensile and Yield values to those listed in Table 2 are acceptable upon agreement between the purchaser and supplier.

TABLE 3 Mechanical Property Requirements of Drawn-Temper and Annealed-Temper Tube (SI Values)

Temper Designation		Outside Diameter, or Major Distance Between Outside Parallel Surfaces, mm	Wall Thickness, mm	Rockwell Hardness ^A		Average Grain Size, mm	Tensile Strength, ^B MPa	Yield Strength, ^B min, MPa
Standard	Former			Scale	Hardness			
H55	light-drawn ^C	all	all	30T	30 to 60		250–325	205
H58	drawn (general purpose)	all	all	30T	30 min		250 min	205
H80	hard-drawn ^C	up to 102	0.508 to 6.35, incl	30T	55 min		310 min	275
O62	heavy anneal	all	0.381 to 0.889 0.889 and over	15T ^D F ^D	60 max 55 max	0.050 max 0.050 max	205 min 205 min	45 ^{E, F} 45 ^{E, F}
O60	soft anneal	all	0.381 to 0.889 0.889 and over	15T F	60 max 50 max	0.040 min 0.040 min	205 min 205 min	62 62
O50	light anneal	all	0.381 to 0.889 0.889 and over	15T F	65 max 55 max	0.040 max 0.040 max	205 min 205 min	62 62

^A 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 purchaser and supplier.

^B Yield strength to be determined at 0.5 % extension under load.

^C Light-drawn and hard-drawn tempers are normally available in round tubes only.

^D Rockwell hardness values shall apply only to tubes having a wall thickness of 0.040 mm or over, to round tubes having an inside diameter of 8.0 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 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 purchaser and supplier.

^E Light-straightening operation shall be permitted.

^F Alternative Tensile and Yield values to those listed in Table 3 are acceptable upon agreement between the purchaser and supplier.

11.2.1 The tube shall conform to the Rockwell hardness requirements of Table 2 or Table 3 for the specified temper and wall thickness when tested in accordance with Test Methods E18.

11.2.1.1 The Rockwell Hardness values for tube in the H55, H58, and H80 temper shall apply only to the following:

- Tubes having a wall thickness of 0.020 in. [0.508 mm] and over,
- Round tubes having an inside diameter of $\frac{5}{16}$ in. [8.0 mm] and over,
- Rectangular and square tubes having major distances between parallel surfaces of $\frac{3}{16}$ in. [5 mm] and over.

11.2.1.2 The Rockwell Hardness values for tube in the O60 and O50 temper shall apply only to the following:

- (a) Tubes having a wall thickness of 0.015 in. [0.38 mm] and over;
- (b) Round tubes having an inside diameter of $\frac{5}{16}$ in. [8 mm] and over;
- (c) Rectangular and square tubes having inside major distances between parallel surfaces of $\frac{3}{16}$ in. [5 mm] and over.

11.3 *Straightening*—It shall not be prohibited to use light straightening for tube in the O60 and O50 temper.

11.4 When a discrepancy between tensile and Rockwell hardness exists, tensile always takes precedence for acceptance or rejection criteria.

12. Performance Requirements

12.1 *Expansion Test for Round Tube:*

12.1.1 When specified in the contract or purchase order, annealed tubes shall be capable of withstanding an expansion of the outside diameter of 40 % for tube $\frac{3}{4}$ in. [19.0 mm] and under and 30 % for tube over $\frac{3}{4}$ in. [19.0 mm] when tested in accordance with Test Method **B153**.

12.1.2 The expanded tube shall show no cracking or rupture visible to the unaided eye.

13. Microscopical Examination

13.1 Tubes furnished in Copper UNS No. C10100, C10200, C10300, and C12000 shall be essentially free of cuprous oxide as determined by Procedure A of Test Methods **B577**.

14. Hydrogen Embrittlement

14.1 When specified in the contract or purchase order, tubes produced in all designated copper material shall be capable of conforming to the requirements of Procedure B of Test Methods **B577**.

15. Nondestructive Test

15.1 The tubes shall be tested in drawn tempers or as drawn before the final-annealed temper unless otherwise agreed upon between the manufacturer and the purchaser.

15.2 *Electromagnetic (Eddy-Current) Test:*

15.2.1 Each tube up to and including $3\frac{1}{8}$ in. [79 mm] in outside diameter shall be subjected to test.

15.2.2 When tested in accordance with Practice **E243**, tubes which do not actuate the signaling device of the testing unit shall be considered as conforming to the requirements of the test.

15.3 *Hydrostatic Pressure Test*—When specified in the contract or purchase order, each tube shall be capable of withstanding an internal hydrostatic pressure sufficient to produce a fiber stress of 6000 psi [41 MPa] without leakage. The tube need not be subjected to a pressure gauge reading over 1000 psi [6.9 MPa] unless specifically stipulated in the contract or purchase order.

15.4 *Pneumatic Pressure Test*—When specified in the contract or purchase order, each tube shall be capable of withstanding an internal air pressure of 60 psi [400 kPa], minimum, for 5 s without leakage.

16. Purchases for U.S. Government Agencies

16.1 When the contract or purchase order stipulates that the purchase is for an agency of the U.S. Government, the tubes furnished shall conform to the conditions specified in the Supplementary Requirements of Specification **B251/B251M**.

17. Dimensions, Mass, and Permissible Variations

17.1 The dimensions and tolerances for product described by this specification shall be as specified in the following tables and related sections of the current edition of Specification **B251/B251M**:

17.1.1 *Wall Thickness Tolerances*—Refer to Tables 1 and 2.

17.1.2 *Tolerances for Diameter or Distance Between Parallel Surfaces*—Refer to Tables 3 and 4.

17.1.3 *Length Tolerances*—Refer to Tables 5 and 6.

17.1.4 *Straightness Tolerance*—Refer to Table 7.

17.1.5 *Corner Radius for Rectangular, including Square, Tube*—Refer to Table 8.

17.1.6 *Roundness, Squareness of Cut and Twist Tolerances for Rectangular and Square Tubes*—Refer to titled sections.

17.2 *Length Tolerances for Tube in Coils*—Refer to **Table 4, Table 5, Table 6, Table 7, Table 8** and **Table 9** of this specification.

18. Sampling

18.1 The lot size, portion size, and selection of sample portions shall be as follows:

18.1.1 *Lot Size*—An inspection lot shall be 10 000 lb [5000 kg] or fraction thereof,

18.1.2 *Portion Size*—Sample pieces shall be selected to be represented of the lot as follows:

TABLE 4 Coil Length Tolerances (Specific Lengths) Inch-Pound Values

Outside Diameter or Major Distance Between Parallel Surfaces, in.	Tolerances, in., All Plus, for Nominal Lengths, ft	
	Up to 50, incl	Over 50 to 100, incl
Up to 2, incl	12	24

TABLE 5 Coil Length Tolerances (Specific Lengths) SI Values

Outside Diameter or Major Distance Between Parallel Surfaces, mm	Tolerances, mm, All Plus, for Nominal Lengths, m	
	Up to 15, incl	Over 15 to 30, incl
Up to 50.8, incl	300	610

Number of Pieces in Lot	Number of Portions to Be Taken ^A
1 to 50	1
51 to 200	2
201 to 1500	3

^A Each test portion shall be taken from a separate tube.

18.2 Chemical Composition:

18.2.1 The composite sample shall be taken in approximate equal weights from each portion piece selected in 18.1.2 and in accordance with Practice E255. The minimum weight of the composite shall be 150 g.

18.2.2 The manufacturer shall have the option of sampling at the time the castings are poured or taken from the semifinished product. The number of samples taken during the course of manufacture shall be as follows:

18.2.2.1 When sampled at the time castings are poured, at least two samples shall be taken, one after the start and one near the end of the pour, for each group of castings poured simultaneously from the same source of molten metal.

18.2.2.2 When samples are taken from the semifinished product, a sample shall be taken to represent each 10 000 lb [5000 kg] or fraction thereof, except that not more than one sample per piece shall be required.

18.2.2.3 When composition is determined during the course of manufacture, sampling and analyses of the finished product is not required.

18.3 Other Tests—Specimens for all other tests shall be taken from two of the sample portions taken in 18.1.2. In the event only one sample portion is taken, all specimens shall be taken from the portion selected.

19. Number of Tests and Retests

19.1 Tests:

19.1.1 Chemical Analysis—Chemical composition shall be determined in accordance with the element mean of the results from at least two replicate analyses of the sample(s).

19.1.2 Grain Size, Electrical Resistivity, Tensile and Yield Strength, and Rockwell Hardness—Results shall be reported as the average obtained from two test specimens, each taken from a separate test piece, where possible.

19.1.3 Other Tests—At least two specimens shall be prepared for each of the other tests and each shall conform to test requirements.

19.2 Retests:

19.2.1 When requested by the manufacturer or supplier, a retest shall be permitted when results of tests obtained by the purchaser fail to conform to the requirements of the product specification.

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

19.2.3 All test specimens shall conform to the product specification requirement(s) in retest. Failure to conform shall be cause for rejection.

20. Specimen Preparation

20.1 Chemical Analysis—Preparation of the analytical specimens shall be the responsibility of the reporting laboratory.

20.2 Tensile and Yield Strength Test—The test specimens shall be of the full section of the tube and shall conform with the requirements of the Test Specimen section of Test Methods E8/E8M, unless the limitation of the testing machine precludes the use of such specimens in which case test specimens conforming to Type No. 1 of Fig. 13 in Test Methods E8/E8M shall be used.

20.3 Rockwell Hardness:

20.3.1 The test specimen shall be of a size and shape to permit testing by the available test equipment.