



Designation: B187/B187M – 20

Standard Specification for Copper, Bus Bar, Rod, and Shapes and General Purpose Rod, Bar, and Shapes¹

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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 copper conductor bar, rod, and shapes for electrical (bus) applications and rod, bar, and shapes for general applications.

1.1.1 The products for electrical (bus) applications shall be made from the following coppers:³

Copper UNS No. ³	Reference Designation
C10100	OFE
C10200	OF
C10300	OFXLP
C10400, C10500, C10700	OFS
C10920, C10930, C10940	—
C11000	ETP
C11020	FRHC
C11300, C11400, C11500, C11600	STP
C12000	DLP

1.1.1.1 The product may be furnished from any copper listed unless otherwise specified in the contract or purchase order.

1.2 The product for general applications shall be made from any of the coppers in 1.1.1 or the following coppers:

Copper UNS No. ³	Reference Designation
C10800	OFLP
C12200	DHP

1.2.1 The product may be furnished from any copper listed above unless otherwise specified in the contract or purchase order. Other coppers may be used upon agreement between the supplier and purchaser.

1.3 *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

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² For ASME Boiler and Pressure Vessel Code applications, see related Specification SB-187 in Section II of that Code.

³ Refer to Practice E527 for an explanation of the Unified Numbering System.

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.

NOTE 1—Material for hot forging will be found in Specification B124/B124M.

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:⁴

- B124/B124M Specification for Copper and Copper Alloy Forging Rod, Bar, and Shapes
- B170 Specification for Oxygen-Free Electrolytic Copper—Refinery Shapes
- B193 Test Method for Resistivity of Electrical Conductor Materials
- B216 Specification for Tough-Pitch Fire-Refined Copper—Refinery Shapes
- B224 Classification of Coppers
- B249/B249M Specification for General Requirements for Wrought Copper and Copper-Alloy Rod, Bar, Shapes and Forgings
- 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
- B900 Practice for Packaging of Copper and Copper Alloy Mill Products for U.S. Government Agencies
- E53 Test Method for Determination of Copper in Unalloyed Copper by Gravimetry

⁴ 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)⁵
E255 Practice for Sampling Copper and Copper Alloys for the Determination of Chemical Composition
E478 Test Methods for Chemical Analysis of Copper Alloys
E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)
E1004 Test Method for Determining Electrical Conductivity Using the Electromagnetic (Eddy Current) Method
E2575 Test Method for Determination of Oxygen in Copper and Copper Alloys by Inert Gas Fusion

2.2 Other Standard:

ASME Boiler and Pressure Vessel Code⁶

3. Terminology

3.1 For definitions of terms related to copper and copper alloys, refer to Terminology **B846**.

3.2 Definitions:

3.2.1 *bus bar, n*—includes material of solid rectangular or square cross section or a solid section with two plane parallel surfaces and round or other simple regularly shaped edges up to and including 12 in. in width and 0.090 in. and over in thickness.

3.2.2 *bus conductor stock, n*—a bar, rod, or shape of high conductivity copper used to make electrical conductors.

3.2.3 *bus rod, n*—includes solid round and regular polygons of six and eight sides.

3.2.4 *bus shapes, n*—a solid section other than regular rod, bar, plate, sheet, strip, or flat wire, that may be oval, half oval, half round, triangular, pentagonal, or of any special cross section furnished in straight lengths. Shapes shall not include tube and pipe or other hollow sections.

3.3 Definitions of Terms Specific to This Standard:

3.3.1 *orange peel, n*—the surface roughness resulting from working metal of large grain size. The surface is similar in texture to that of the outside surface of an orange.

4. General Requirements

4.1 The following sections of Specification **B249/B249M** are a part of this specification:

- 4.1.1 Terminology;
- 4.1.2 Materials and Manufacture;
- 4.1.3 Workmanship, Finish, and Appearance;
- 4.1.4 Sampling;
- 4.1.5 Number of Tests and Retests;
- 4.1.6 Test Methods;
- 4.1.7 Specimen Preparation;
- 4.1.8 Significance of Numerical Limits;
- 4.1.9 Inspection;
- 4.1.10 Rejection and Rehearing;
- 4.1.11 Certification;

⁵ The last approved version of this historical standard is referenced on www.astm.org.

⁶ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

- 4.1.12 Test Reports; and
- 4.1.13 Packaging and Package Marking.

4.2 Identical sections in this specification supplement the referenced section.

5. Ordering Information

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

- 5.1.1 ASTM specification designation and year of issue,;
- 5.1.2 Copper UNS No. (see **7.1** and **Table 1**);
- 5.1.3 Temper required (see **8.1** and **Table 2**);
- 5.1.4 Dimensions and form;
- 5.1.5 When product is ordered for *ASME Boiler and Pressure Vessel Code* applications (see Section **16**);
- 5.1.6 Shapes: dimensional tolerances required and agreed upon (see **13.3**);
- 5.1.7 Quantity: number of pounds, pieces, or footage required;
- 5.1.8 Length: stock or specific (see **13.5**); and
- 5.1.9 When material is purchased for agencies of the U.S. Government (see Section **12**).

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

- 5.2.1 Heat identification or traceability details required,
- 5.2.2 Hydrogen embrittlement test,
- 5.2.3 Bend test,
- 5.2.4 Certification,
- 5.2.5 Mill test reports,
- 5.2.6 Special packaging requirements,
- 5.2.7 Edges other than finished edges (see **6.2.1.2**),
- 5.2.8 Edge contours other than square edge (see **13.7**), and
- 5.2.9 Location for the determination of the Rockwell hardness (see **10.2.2**).

6. Materials and Manufacture

6.1 *Material:*

6.1.1 The materials shall conform to the published compositional requirements of the Copper or Copper Alloy UNS No. designation specified in the ordering information.

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

6.2 *Manufacture:*

6.2.1 *Edges:*

6.2.1.1 Bar shall be furnished with finished edges (see **13.7**) unless otherwise specified at the time of order placement.

6.2.1.2 Bar may be furnished with sawed edges and deburred corners upon agreement between the manufacturer or supplier and the purchaser (see **5.2.7**).

7. Chemical Composition

7.1 The specified copper shall conform to the chemical requirements prescribed in **Table 1**.

7.2 These specification limits do not preclude the possible presence of other elements. Limits for unnamed elements may be established and analysis required by agreement between the manufacturer or the supplier and the purchaser.

TABLE 1 Chemical Requirements

NOTE 1—If the type of silver-bearing copper is not specified (that is whether tough pitch, phosphorized, or oxygen-free), any one of the three types may be supplied at the option of the manufacturer.

Composition % Maximum (Unless shown as a range or minimum)						
Copper UNS No.	Copper (Incl. Silver)	Phosphorus	Silver	Oxygen	Tellurium	Tin
		<i>B</i>	<i>B</i>	<i>B</i>	<i>B</i>	<i>B</i>
C10100	99.99 ^A min
C10200	99.95 ^C min	0.0010
C10300	99.95 ^D min	0.001–0.005
C10400 ^E	99.95 ^C min	...	8 ^F	0.0010
C10500 ^E	99.95 ^C min	...	10 ^F	0.0010
C10700 ^E	99.95 ^C min	...	25 ^F	0.0010
C10800	99.95 ^D min	0.005–0.012
C10920	99.90 min	0.02
C10930	99.90 min	...	13 ^F	0.02
C10940	99.90 min	...	25 ^F	0.02
C11000	99.90 min	^G
C11020	99.90 min	^G
C11300 ^H	99.90 min	...	8 ^F	^G
C11400 ^H	99.90 min	...	10 ^F	^G
C11500 ^H	99.90 min	...	16 ^F	^G
C11600 ^H	99.90 min	...	25 ^F	^G
C12000	99.90 min	0.004–0.012
C12200	99.90 min	0.015–0.040

^A Copper value is determined by the difference between the impurity total and 100 %. The copper value is exclusive of Ag.
^B Impurity maximums in ppm of C10100 shall be: antimony 4, arsenic 5, bismuth 1, cadmium 1, iron 10, lead 5, manganese 0.5, nickel 10, oxygen 5, phosphorus 3, selenium 3, silver 25, sulfur 15, tellurium 2, tin 2, and zinc 1.
^C Copper value is determined by the difference between the impurity total and 100 %.
^D Copper (includes silver) + phosphorus, min.
^E C10400, C10500, and C10700 are oxygen-free coppers with the addition of a specified amount of silver. The compositions of these alloys are equivalent to C10200 plus the intentional addition of silver.
^F Values are minimum silver in Troy ounces per Avoirdupois ton (1 oz/ton is equivalent to 0.0034 %).
^G Oxygen and trace elements may vary depending on the process.
^H C11300, C11400, C11500, and C11600 are electrolytic tough-pitch copper with silver additions. The compositions of these alloys are equivalent to C11000 plus the intentional addition of silver.

8. Temper

8.1 Tempers available under this specification and as described in Classification **B601** are as follows:

Standard	Temper Designation	Former
O60	soft anneal	4d283b4-19fd-4
H02	half hard	
H04	hard	

9. Physical Property Requirements

9.1 *Electrical Resistivity*—Bar, rod, and shapes of alloys Copper UNS Nos. C10100, C10200, C10300, C10400, C10500, C10700, C10920, C10930, C10940, C11000, C11020, C11300, C11400, C11500, C11600, and C12000 shall conform to the electrical resistivity limits prescribed in **Table 2** for specified copper, temper, form, and size when determined in accordance with Test Method **B193**.

9.2 *Electrical Resistivity*—Unless otherwise specified in the contract or ordering information, the manufacturer has the option of using Test Method **E1004** to determine conformance to the electrical resistivity limits prescribed in **Table 2** for Copper UNS Nos. C10100, C10200, C10300, C10400, C10500, C10700, C10920, C10930, C10940, C11000, C11020, C11300, C11400, C11500, C11600, and C12000. In case of dispute, Test Method **B193** shall be used.

10. Mechanical Property Requirements

10.1 *Tensile Requirements:*

10.1.1 The bars and rod shall conform to the tensile, yield, and elongation requirements of **Table 2**.

10.1.1.1 For shapes, the tensile requirements (if any) shall be by agreement between the manufacturer and the purchaser.

10.2 *Rockwell Hardness:*

10.2.1 Rockwell hardness tests offer a quick and convenient method of checking copper of any temper for general conformity to the requirements of tensile strength. The approximate Rockwell hardness values for the specified tempers are given in **Table 2** for general information and assistance in testing.

10.2.2 When specified at the time of order and as agreed to by the purchaser and supplier or manufacturer, the location for the determination of the Rockwell hardness may be specified.

11. Performance Requirements

11.1 *Bending Requirements:*

11.1.1 When specified in the contract or purchase order, for bar, bus bar, flat wire, and rod, test specimens shall withstand being bent cold (right way bend) through an angle as specified in **Table 2** for the specified temper and size without fracture on the outside of the bent portion and with no evidence of slivers, cracks, orange peel, or similar surface defects being visible to the unaided eye.

11.1.2 The bend shall be made on a radius equal to the minimum cross-sectional dimension of the specimen, and this dimension shall be radial to the bend.

11.1.3 The axis of the bend shall be at an angle of 90° to the direction of rolling, drawing, or extrusion (right way bend).

TABLE 2 Mechanical (All Alloys) and Electrical Requirements^A (Conductor Alloys Only)

Temper Designation		Diameter or Distance Between Parallel Surfaces, in.	Tensile Strength, ksi, [MPa] ^B		Yield Strength, ksi, [MPa] Min ^C	Elongation in 4 × Diameter or Thickness of Specimen Min. % ^D	Bend Test Angle of Bend °	Electrical Resistivity, ^E Max. Ω·g/m ² at 20 °C [68 °F]				Rockwell Hardness F Scale, 60-kg Load, 1/16-in. Ball
Standard	Former		Min	Max	Min			C10100	C10200, C10400, C10500, C10700, C10920, C10930, C10940, C11000, C11020, C11300, C11400, C11500, C11600	C10300	C12000	
O60	Soft anneal	Rod and bar:										
		All sizes	28 [195]	37 [255]	8 [55] ^C	25	180	0.15176	0.153 28	0.156 14	0.16661	50 max
H04	Hard	Rod:										
		Up to 3/8 [10] incl.	45 [310]	60 [410]	—	12	120	0.15585	0.157 37	0.15940	0.17031	—
		Over 3/8 [10] to 1 [25] incl.	40 [275]	55 [380]	—	12	120	0.15585	0.15737	0.15940	0.17031	80 min
		Over 1 [25] to 2 [50] incl.	35 [240]	50 [345]	—	15	120	0.15585	0.15737	0.15940	0.17031	75 min
		Over 2 [50] to 3 [75] incl.	33 [230]	48 [330]	—	15	120	0.15425	0.15577	0.15940	0.17031	65 min
		Over 3 [75]	30 [205]	48 [330]	—	15	120	0.15425	0.15577	0.15940	0.17031	—
H02	Half Hard	Bar:										
		Up to 3/8 [10] incl. thickness and up to 4 [110] incl. in width	37.5 [260]	50 [345]	—	10	120	0.15585	0.15737	0.15940	0.17031	80 min
		All other sizes	33 [230]	50 [345]	—	15	120	0.15425	0.15577	0.15940	0.17031	65 min
		Channels, angles and shapes	Not established ^F	—	—	15	—	0.15425	0.15577	—	0.17031	—

^A See 9.1.
^B ksi = 1000 psi.
^C Light-straightening operation is permitted.
^D In any case, a minimum gage length of 1 in. shall be used.
^E See Appendix X1.
^F Special agreement shall be made between the manufacturer or supplier and the purchaser.

<https://standards.iteh.ai/catalog/standards/sist/b4d283b4-b9fd-44c4-9587-37bebc6cc5c3/astm-b187-b187m-20>

11.1.4 Edgewise and wrong way bend test requirements for bar or bus bar shall be by agreement between the manufacturer or supplier and the purchaser.

11.2 Microscopical Examination:

11.2.1 Copper UNS Nos. C10100, C10200, C10300, C10400, C10500, C10700, C10800, and C12000 shall be substantially free of cuprous oxide as determined by Procedure A, Microscopical Examination, of Test Methods B577.

11.2.2 In lieu of the Microscopic examination for copper C10100, C10200, C10300, C10400, C10500, C10700, C10800 the manufacturer has the option to determine the actual oxygen content of the copper in the final size. If the oxygen level is equal to or less than 10 ppm, then it is considered free of cuprous oxide. For Copper C12000 when phosphorus content is within the specification (0.004 and 0.012 %) it should be considered substantially free of cuprous oxide. In case of dispute, testing shall be in accordance with Test Method E2575.

11.2.3 In case of dispute, testing shall be in accordance with Procedure C, Closed Bend Test, of Test Methods B577.

11.3 Embrittlement Test:

11.3.1 When specified in the contract or purchase order, Copper UNS Nos. C10100, C10200, C10300, C10400, C10500, C10700, C10800, and C12000 shall pass the embrittlement test described in Procedure B, Microscopical Examination of Thermally Treated Specimens, in Test Methods B577.

11.3.2 In case of dispute, testing shall be in accordance with Procedure C, Closed Bend Test, of Test Methods B577.

12. Orders for U.S. Government Agencies

12.1 Orders for agencies of the U.S. Government shall conform to the special government requirements stipulated in the Supplemental Requirements section.

13. Dimensions, Mass, and Permissible Variations

13.1 The dimensions and tolerances for material manufactured under this specification shall be as specified in the following tables:

13.2 Diameter or Distance Between Parallel Surfaces:

13.2.1 Rod: Round, Hexagonal, Octagonal—See Table 3.

TABLE 3 Diameter Tolerances for Cold-Drawn Rod (H04 and O60 Tempers)

Diameter or Distance Between Parallel Surfaces, in. [mm]	Tolerances, Plus and Minus, ^A in. [mm]	
	Round	Hexagonal or Octagonal
Up to 0.150 [3.8] incl.	0.0013 [0.035]	0.0025 [0.06]
Over 0.150 [3.8] to 0.500 [12] incl.	0.0015 [0.04]	0.003 [0.08]
Over 0.500 [12] to 1.00 [25] incl.	0.002 [0.05]	0.004 [0.10]
Over 1.00 [25] to 2.00 [50] incl.	0.0025 [0.06]	0.005 [0.13]
Over 2.00 [50]	0.15 ^B	0.30 ^B

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

^B Percent of specified diameter or distance between parallel surfaces expressed to the nearest 0.001 in. [0.025 mm].

TABLE 4 Thickness Tolerances for Drawn or Rolled Rectangular and Square Bar Plus and Minus,^A in. [mm]

Thickness	Width, in. [mm]			
	2 [50] and Under	Over 2 [50] to 4 [100] incl.	Over 4 [100] to 8 [200] incl.	Over 8 [200] to 12 [300] incl.
Up to 0.500 [13], incl.	0.003 [0.08]	0.004 [0.10]	0.0045 [0.11]	0.0055 [0.14]
Over 0.500 [13] to 1.000 [25], incl.	0.004 [0.10]	0.0045 [0.11]	0.005 [0.13]	0.006 [0.15]
Over 1.000 [25] to 2.000 [50], incl.	0.0045 [0.11]	0.005 [0.13]	0.006 [0.15]	...

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

TABLE 5 Thickness Tolerances for Sawed Edge, Deburred Corner Rectangular and Square Bar, Plus and Minus,^A in. [mm] for Widths Given in Inches [mm]

Thickness	2 [50] and Under incl.	Over 2 [50] to 4 [100] incl.	Over 4 [100] to 8 [200] incl.	Over 8 [200] to 12 [300] incl.
Up to 0.250 [6], incl.	0.0025 [0.06]	0.003 [0.08]	0.0035 [0.09]	0.005 [0.13]
Over 0.250 [6] to 0.375 [10] incl.	0.003 [0.08]	0.004 [0.10]	0.0045 [0.11]	0.005 [0.13]
Over 0.375 [10] to 0.500 [13] incl.	0.0035 [0.09]	0.0045 [0.11]	0.005 [0.13]	0.006 [0.15]
Over 0.500 [13] to 0.750 [19] incl.	0.0055 [0.14]	0.0055 [0.14]	0.0055 [0.14]	0.007 [0.18]
Over 0.750 [19] to 1.000 [25] incl.	0.007 [0.18]	0.007 [0.18]	0.007 [0.18]	0.009 [0.23]
Over 1.000 [25] to 1.500 [38] incl.	0.015 [0.38]	0.020 [0.50]	0.022 [0.55]	0.025 [0.60]
Over 1.500 [38] to 2.000 [50] incl.	0.020 [0.50]	0.024 [0.60]	0.026 [0.65]	0.030 [0.75]

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

TABLE 6 Width Tolerances for Drawn or Rolled Rectangular and Square Bar

Width, in. [mm]	Tolerances, Plus and Minus, ^A in. [mm]
2 [50] and under	0.008 [0.2]
Over 2 [50] to 4 [100], incl.	0.012 [0.3]
Over 4 [100] to 12 [310] incl.	0.30 ^B

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

^B Percent of specified width expressed to the nearest 0.001 in. [0.01 mm].

TABLE 8 Length Tolerances for Rod, Bar, and Shapes (Full-Length Pieces Specific and Stock Lengths with or without Ends)

Length Classification	Tolerances, All Plus, in. [mm] (Applicable Only to Full-Length Pieces)
Specific lengths	
Up to 6 ft. [1800 mm]	1/8 [3]
Over 6 to 15 ft. [1800 to 4500 mm]	1/4 [6]
Over 15 ft. [4500 mm]	1/2 [13]
Specific lengths with ends	1 [25]
Stock lengths with or without ends	1 [25]

TABLE 7 Width Tolerances for Sawed Edge with Deburred Corner Rectangular and Square Bar, Plus and Minus, in. [mm]^A

Thickness	Width, in. [mm]	
	12 [300] and under incl.	Over 12 [300]
Up to 1.500 [40], incl.	1/32 [0.8]	1/16 [1.6]
Over 1.500 [40]	1/16 [1.6]	1/16 [1.6]

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

13.2.2 Bar: Rectangular and Square:

13.2.2.1 *Thickness Tolerances for Rectangular and Square Bar*—See **Table 4** for rolled or drawn edges and **Table 5** for sawed edges with deburred corners.

13.2.2.2 *Width Tolerances for Rectangular and Square Bar*—See **Table 6** for rolled or drawn edges and **Table 7** for sawed edges with deburred corners.

13.3 *Shapes*—The dimensional tolerances of shapes shall be as agreed upon by the manufacturer or supplier and the purchaser and shall be specified in the order.

13.4 *Coils*—The coil size shall be as agreed upon between the manufacturer or supplier and the purchaser and shall be specified in the order.