



Designation: **B101–12 (Reapproved 2019) B101 – 22**

Standard Specification for Lead-Coated Copper Sheet and Strip for Building Construction¹

This standard is issued under the fixed designation B101; 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 lead-coated copper sheet and strip in flat lengths (or in coils) in ounce-weight thicknesses for roofing, flashing, gutters, downspouts, and for the general sheet metalwork in-for outside building construction. The lead coating is applied by hot dipping.

1.1.1 Products produced to this specification are not intended for electrical applications.

1.1.2 This product is not designed to be used for decorative, ornamental, or wall panel applications.

1.2 Products produced to this specification are not intended for electrical applications.

1.2 *Units*—The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

NOTE 1—A companion specification for copper sheet and strip for building construction is Specification **B370**. <https://standards.iteh.ai/astm-b101-22>

1.3 The following hazard caveat pertains to the test method portion, Section 17, of 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:²

- B248** Specification for General Requirements for Wrought Copper and Copper-Alloy Plate, Sheet, Strip, and Rolled Bar
- B370** Specification for Copper Sheet and Strip for Building Construction
- B846** Terminology for Copper and Copper Alloys

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

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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.

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

- B950 Guide for Editorial Procedures and Form of Product Specifications for Copper and Copper Alloys
- E8/E8M Test Methods for Tension Testing of Metallic Materials
- E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- E37 Test Methods for Chemical Analysis of Pig Lead (Withdrawn 2020)³
- E46 Test Methods for Chemical Analysis of Lead- and Tin-Base Solder (Withdrawn 1994)³
- E62 Test Methods for Chemical Analysis of Copper and Copper Alloys (Photometric Methods) (Withdrawn 2010)³
- E112 Test Methods for Determining Average Grain Size
- E478 Test Methods for Chemical Analysis of Copper Alloys

3. General Requirements

3.1 The following sections of Specification B248 constitute a part of this specification:

- 3.1.1 Significance of numerical limits,
- 3.1.2 Inspection,
- 3.1.3 Rejection and reheating,
- 3.1.4 Certification,
- 3.1.5 ~~Mill test~~ Test reports, and
- 3.1.6 Packaging and package marking.

3.2 In addition, when a section with a title identical to that referenced in 3.1, above, appears in this specification, it contains additional requirements that supplement those appearing in Specification B248.

4. Terminology

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

ASTM B101-22

<https://standards.iteh.ai/catalog/standards/sist/980ce758-aae5-47ab-8bb6-b04e94a61d60/astm-b101-22>

TABLE 12 Mechanical Properties of Uncoated Sheet

Temper Designation		Tensile Strength, ksi ^A (MPa)		Yield Strength, at 0.5 % Extension Under Load, min, ksi (MPa)	Approximate Rockwell Hardness ^B (for Information Only)			
					F Scale		Superficial 30 T	
Standard	Former	Min	Max		Min	Max	Min	Max
O60	soft	30 (205)	38 (260)	65	...	31
H00	cold-rolled	32 (220)	40 (275)	20 (140)	54	82	15	49
H01	cold-rolled (high yield)	34 (235)	42 (290)	28 (195)	60	84	18	51

^A ksi = 100 psi.

^B Rockwell hardness values apply as follows: The F scale applies to metal 0.020 in. (0.508 mm) and over in thickness; the superficial 30T scale applies to metal 0.012 in. (0.305 mm) to 0.020 in. (0.508 mm) in thickness.

³ The last approved version of this historical standard is referenced on www.astm.org.

4.2 Definitions of Terms Specific to This Standard:

4.2.1 *coil*—a length of the product wound into a series of connected turns.

4.2.1.1 *Discussion*—

The unqualified term “coil” as applied to “flat product” usually refers to a coil in which the product is spirally wound, with the successive layers on top of one another. (Sometimes called a “roll.”)

4.2.2 *flashing, n*—an impervious lead-coated copper sheet or strip used in a building envelope to create a barrier to prevent water penetration or direct the flow of moisture.

4.2.2.1 *Discussion*—

This can include, but is not limited to, the heads of windows and doors, the edge components of roof systems, changes in building planes, around chimneys, roof vents, skylights, decks and other penetrations, and other conditions requiring a watertight or water-shedding solution.

4.2.3 *lead-coated copper sheet (for building construction), n*—a rolled flat product over 24 in. (610 mm) in width and of ounce-weight thickness from 8 oz (227 g) to 48 oz (1361 g).

4.2.4 *lead-coated strip (for building construction), n*—a rolled flat product up to and including 24 in. (610 mm) in width and of ounce-weight thickness from 8 oz (227 g) to 48 oz (1361 g).

4.2.5 *lengths, mill, n*—straight lengths, including ends, that are conveniently manufactured in the mills.

4.2.5.1 *Discussion*—

Full length pieces are usually 8, 10, or 12 ft (2.44, 3.05, or 3.66 m) 8 ft, 10 ft, or 12 ft (2.44 m, 3.05 m, or 3.66 m) and subject to established length tolerances.

4.2.6 *ounce-weight*—the weight of uncoated copper sheet or strip expressed in ounces per square foot.

4.2.7 *thickness, ounce-weight, n*—the metal thickness that corresponds to the ounce weight.

5. Ordering Information

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

5.1.1 ASTM designation and year of issue.

5.1.2 Temper (Section 8 and [Table 1](#)); [Table 2](#)),

5.1.3 How furnished: flat lengths or in coils,

5.1.4 Quantity: total weight or sheets of each size,

5.1.5 Ounce-weight or ounce-weight thickness of the uncoated copper sheet or strip ([Table 2](#)), [3](#)),

5.1.6 Dimensions: width and length (Section [12](#)),

TABLE 23 Sheet Weights

Nominal Weights and Thickness of Bare Copper Sheets		Minimum Weight of Lead-Coated Copper Sheet
Ounce-Weight, oz/ft ²	Ounce-Weight Thickness, ^A in. (mm)	oz/ft ² (g/m ²)
24	0.0323 (0.820)	25.0 (7625)
20	0.0270 (0.686)	21.2 (6466)
16	0.0216 (0.549)	17.3 (5276)
12	0.0162 (0.411)	13.2 (4026)

^A Based upon a density of 0.322 lb/in.³ (8.91 g/cm³).

~~5.1.7 Certification, where required (see 5.1.4);~~

~~5.1.8 Mill test report, where required (see 5.1.5), and~~

~~5.1.9 If the material being purchased is intended for use by agencies of the U.S. Government, refer to Section 11.~~

~~5.1.10 Other variations in coating or texture shall be furnished by agreement in writing between the purchaser and the manufacturer or supplier.~~

5.2 The following options are available and, when required, shall be specified at the time of placing of the order:

5.2.1 Heat identification or traceability details.

5.2.2 Certification, where required (see 5.1.4),

5.2.3 Test report, where required (see 5.1.5), and

5.2.4 If the material being purchased is intended for use by agencies of the U.S. government, refer to Section 11.

5.2.5 Other variations in coating or texture shall be furnished by agreement in writing between the purchaser and the manufacturer or supplier.

6. Materials and Manufacture

6.1 Materials:

6.1.1 The material of manufacture shall be in the form of copper strip or sheet that conforms to the requirements of Specification B370.

6.1.2 The lead coating shall conform to the chemical requirements of Table 31.

NOTE 2—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.

<https://standards.itcni.ai/catalog/standards/sist/980ce758-aac5-47ab-8bb6-b04e94a61d60/astm-b101-22>

~~6.1.2 The copper sheet or strip to be lead coated shall be manufactured by any process that provides a finished product that conforms to the requirements of Specification B370.~~

6.2 Manufacture:

~~6.2.1 The lead coating product shall be applied to manufactured by hot dipping the copper sheet or strip by hot dipping in a bath of molten lead:lead to produce the finished product.~~

6.2.2 Unless otherwise specified, the lead coating shall be applied to the copper sheet or strip after slitting and cutting to the specified length.

**TABLE 31 Chemical Requirements for Lead
Used to Coat Copper Sheet**

Element	Composition, % (Maximum unless shown as range or remainder)
Silver	0.02
Copper	0.08
Arsenic plus antimony	0.10
Zinc	0.005
Iron	0.01
Bismuth	0.08
Lead	remainder
Tin	3.0-4.0
Phosphorus	0.03

6.2.3 Unless otherwise specified, the lead coating shall be applied to the copper strip before slitting.

7. Chemical Composition

7.1 The copper sheet or strip shall have a minimum copper, including silver, content of 99.5 %.

7.2 Any copper that complies with 7.1 shall be acceptable.

7.3 If limits for unnamed elements are required, they shall be established and analysis required by agreement between the manufacturer or supplier and purchaser.

7.4 The lead coating shall conform to the chemical requirements of [Table 31](#).

8. Temper

8.1 The standard tempers of the uncoated copper sheet and strip described in this specification are given in [Table 42](#).

8.1.1 Annealed Temper O60.

8.1.2 Cold rolled tempers H00 (eighth hard, cold-rolled); and H01 (quarter hard, cold-rolled high yield).

9. ~~Physical Property Requirements~~ Grain Size for Annealed Temper

9.1 ~~Although no minimum grain size is specified for soft temper material, it shall be fully recrystallized.~~ *Grain Size Requirement:*

9.1.1 The soft annealed temper uncoated product furnished under this specification shall have a minimum grain size of 0.010 mm when tested to Test Methods [E112](#).

9.1.2 Acceptance or rejection for the soft temper based upon the physical properties shall depend on the grain size.

10. Mechanical Property Requirements

10.1 *Tensile and Yield Strength Requirements:*

10.1.1 The uncoated product furnished under this specification shall conform to the tensile and yield strength requirements prescribed in [Table 42](#) when tested in accordance with Test Methods [E8/E8M](#). Tension test specimens shall be taken so that the longitudinal axis of such specimens is parallel to the direction of rolling.

10.1.2 Acceptance or rejection based upon mechanical properties shall depend on the tensile and yield strength.

10.2 *Rockwell Hardness:*

10.2.1 The approximate Rockwell hardness values given in [Table 42](#) are for general information and assistance in testing and shall not be used as a basis for product rejection.

NOTE 3—The Rockwell hardness test offers a quick and convenient method of checking for general conformity to the specification requirements for temper and tensile strength.

11. Purchases for the U.S. Government

11.1 When specified in the contractor purchase order, product purchased for an agency of the U.S. Government shall conform to the special government requirements specified in the Supplementary Requirements section of Specification [B248](#).

12. Dimensions, Mass, and Permissible Variations

12.1 *Weight*—The weight of the lead-coated sheet and strip copper shall conform to the minimum requirements of [Table 23](#).

12.2 *Width*—The tolerances for width of sheets shall be as shown in **Table 4**.

12.3 *Length*—Sheets ordered to exact lengths shall be permitted to have a variation of +¼ in. (+6.5 mm) in length.

12.4 *Straightness*—The tolerances on straightness or edgewise curvature (depth of arc) in any 72 in. (2 m) portion of the total length shall be as specified in **Table 5** for slit metal and **Table 6** for square-sheared metal.

13. Workmanship, Finish, and Appearance

13.1 *Lead Coating:*

13.1.1 The lead coating shall cover both surfaces, edges, and ~~ends~~ ends for sheet product.

13.1.2 The lead coating shall cover at least both surfaces for strip products.

13.1.3 The coating shall be smooth and free from pinholes, voids, or unwetted areas, but blemishes of a nature that do not interfere with the intended application are acceptable.

13.1.4 The weight of the lead coating shall conform to the requirements of **Table 7**.

14. Sampling

14.1 Refer to Specification **B248** for chemical and mechanical properties.

14.2 *Weight of Coating Tests:*

14.2.1 *Method A*—Test ten sheets selected at random.

14.2.2 *Methods B and C*—Test four representative samples cut from the diagonal of one sheet selected at random.

15. Number of Tests and Retests

15.1 *Tests:*

15.1.1 Refer to the section of Specification **B248** for chemical and mechanical tests.

15.1.2 A test on each specimen taken in **14.2.1** or **14.2.2**, as applicable, shall be made for the determination of lead.

15.2 *Retests:*

15.2.1 When a specimen fails to meet the requirements of a test, one retest shall be made under the conditions of the original test.

15.2.2 All specimens must conform to test requirements when retested or the material may be rejected.

16. Specimen Preparation

16.1 Refer to Specification **B248** for the chemical and mechanical property test specimen preparation.

16.2 *Weight of Coating Tests:*

TABLE 4 Width Tolerances

Width, in. (mm)	Tolerances, in. (mm)
5 (125) and under	+0.025 (0.6)–0
Over 5–14 (125–355), incl	+0.050 (1.3)–0
Over 14 (355)	+0.125 (3.2)–0

TABLE 5 Straightness Tolerances for Slit Metal

Width, in. (mm)	Straightness Tolerance, in. (mm)
Over 4 to 24 (102 to 610), incl	1/2 (13)

TABLE 6 Straightness Tolerances for Square-Sheared Metal

NOTE 1—Maximum edgewise curvature (depth of arc) in any 72 in. (1.83 m) portion of the total length (not applicable to metal over 120 in. (3.05 m) in length.

	Straightness Tolerances, in. (mm)	
	Up to 10 in. (254 mm) incl. in Width	Over 10 in. (254 mm) in Width
All thicknesses	1/16 (1.6)	1/32 (0.8)

TABLE 7 Weight of Lead Coating, lb (kg)^A

Min	Max
12 (5.4)	15 (6.8)

^A The weight of coating specified is the total weight of lead applied to two sides of 100 ft² (9.3 m²) of copper sheet, approximately one half of the coating to be on each side of the sheet.

16.2.1 Refer to ~~17.4.1~~17.4.2 of this specification for Method A.

16.2.2 Refer to ~~17.4.2~~17.4.3 of this specification for Method B.

16.2.3 Refer to ~~17.4.3~~17.4.4 of this specification for Method C.

17. Test Methods

17.1 *Chemical Analysis:*

17.1.1 In case of disagreement, ~~determine the composition using the following methods:~~ test methods for chemical analysis shall be subject to agreement between the manufacturer or supplier and the purchaser. The following table is a list of published methods, some of which may no longer be viable, which along with others not listed, may be used subject to agreement. The methods listed are for both the lead coating and the copper substrate.

Element	Range, %	Test Method
Copper	99.0 min	E478
	0.001 to 0.1	E37
Lead	95.0 to 100	by difference
Tin	0.001 to 0.02	E37
	1 to 4	E46
Silver	0.001 to 0.03	E37
Arsenic	0.0005 to 0.02	E37
Antimony	0.001 to 0.03	E37
Zinc	0.001 to 0.005	E37
Iron	0.0005 to 0.005	E37
Bismuth	0.002 to 0.2	E37
Phosphorous	0.001 to 0.03	E62

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

17.2 ~~Grain Recrystallization—Physical Requirements:~~ Recrystallization shall be determined in accordance with Test Methods **E112**.

17.2.1 Grain Size—Grain size shall be determined in accordance with Test Methods **E112**.