



Designation: ~~B135-96~~ Designation: **B 135 - 02**

Standard Specification for Seamless Brass Tube¹

This standard is issued under the fixed designation B 135; 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 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. ²	Previously Used Designation ⁴	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

⁴ Alloy Designations of ASTM-Specification B 135 - 63, which was published in the 1966 Book of ASTM Standards, Part 5.

NOTE 1—A complete metric companion to Specification B 135 has been developed—B 135M; therefore, no metric equivalents are presented in this specification.

1.2 **Warning**—Mercury is a definite health hazard in use and disposal. (See 10.1.)²

1.3 *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 The following documents of the issue in effect on date of material purchase form a part of this specification to the extent referenced herein:

2.2 ASTM Standards:

B 153 Test Method for Expansion (Pin Test) of Copper and Copper-Alloy Pipe and Tubing³

B 154 Test Method for Mercurous Nitrate Test for Copper and Copper Alloys³

B 251 Specification for General Requirements for Wrought Seamless Copper and Copper-Alloy Tube³

B 601 Practice Classification for Temper Designations for Copper and Copper Alloys—Wrought and Cast³

E 243 Practice for Electromagnetic (Eddy-Current) Testing Examination of Seamless Copper and Copper-Alloy Tubes⁴

E 527 Practice for Numbering Metals and Alloys (UNS)⁵

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

¹ This specification is under the jurisdiction of ASTM Committee B-5B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.04 on Pipe and Tube.

Current edition approved April 10, 1996-2002. Published June 1996-November 2002. Originally published as B 135 - 40 T. Last previous edition B135-95-B 135 - 00.

² The UNS system for copper and copper alloys (see Practice E 527) 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.

³ Annual Book of ASTM Standards, Vol 02.01.

⁴ Annual Book of ASTM Standards, Vol 03.03.

⁵ Annual Book of ASTM Standards, Vol 01.01.

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

3.1.1 ~~capable of~~—as used in this specification, the ~~the~~ test need not be performed by the producer of the material. However, ~~should~~ if subsequent testing by the purchaser establishes that the material does not meet these requirements, the material shall be subject to ~~revision~~ 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)),
- 4.1.4 Dimensions: diameter or distance between parallel surfaces and wall thickness (see 11.2 and 11.3),
- ~~4.1.5 Length (see section 11.4),~~
- 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 B 251.

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 ~~permitted to 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

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	0.10 max	0.07	remainder
C27200	62.0–65.0	0.07 max	0.07	remainder
C27400	61.0–64.0	0.10 max	0.05	remainder
C28000	59.0–63.0	0.30 max	0.07	remainder
C33000	65.0–68.0	0.25 ^A –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

^A 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, it is permissible to furnish tube with a lead content less than 0.297 % maximum, no minimum is specified.

TABLE 2 Mechanical Property Requirements of Drawn Temper Tube

Copper Alloy UNS No.	Temper Designation ^A		Outside Diameter, in. or Major Distance Between Outside Parallel Surfaces, in.	Wall Thickness, in	Tensile Strength ksi ^B	Rockwell Hardness ^C 30T	
	Standard	Former					
		drawn (general purpose)	H58	drawn (general purpose)	40 min	38 min	
G22000			H58				
C22000	H58	drawn (general purpose)	H58		40 min	38 min	
G22000	H80	hard drawn ^D		- all - up to 1, incl { - over 1 to 2, incl - over 2 to 4, incl	all 0.020 to 0.120, incl 0.035 to 0.180, incl 0.060 to 0.250, incl	all — } 40 min 38 min	
C22000	H80	hard drawn ^D		all	all 0.020 to 0.120, incl 0.035 to 0.180, incl 0.060 to 0.250, incl	— } 40 min 55 min	
C22000	H80	hard drawn ^D	over 1 to 2, incl	0.035 to 0.180, incl	52 min	55 min	
G23000		H55	light drawn ^D		all	all 55 min	
C22000	H80	H55	light drawn ^D	over 2 to 4, incl	all	52 min 55 min	
	44-58	43-75 43-75					
C23000	H55	light drawn ^D	all	all	44-58 44-58	43-75	
C23000	H58	H58	drawn (general purpose)	all	all	all 44 min	
C23000	H80	hard drawn ^D	up to 1, incl		{ - up to 1, incl up to 1, incl	0.020 to 0.120, incl 57 min 65 min	
C23000	H80	H80	hard drawn ^D	over 1 to 2, incl	incl over 1 to 2, incl	0.035 to 0.180, incl 57 min	
C23000	H80	H80	hard drawn ^D	over 1 to 2, incl	incl over 2 to 4, incl	0.060 to 0.250, incl 57 min 65 min	
C26000, C27000, C27200, H58	H58	drawn (general purpose)		- all	all	54 min 53 min	
C26000, C27000, C27200, H58 and C33200 C27400, C33000	H58	drawn (general purpose)	all	all	all	54 min 53 min	
C26000, C27000, C27200, C27400, C33000 and C33200 and C33200	H80	hard drawn ^D	up to 1, incl		up to 1, incl	0.020 to 0.120, incl 66 min 70 min	
C26000, C27000, C27200, and C33200 H80	H80	hard drawn ^D		- over 1 to 2, incl	0.035 to 0.180, incl	} 66 min 70 min	
C26000, C27000, C27200, and C33200 H80	H80	hard drawn ^D	over 1 to 2, incl	over 1 to 2, incl	0.035 to 0.180, incl	} 66 min 70 min	
C26000, C27000, C27200, C27400, C33000, and C33200	H80	hard drawn ^D	over 2 to 4, incl		- over 2 to 4, incl over 2 to 4, incl	0.060 to 0.250, incl 66 min 70 min	
G28000 and C3700		H58	drawn (general purpose)		all	all 54 min	
C28000 and C3700	H58	H58	drawn (general purpose)	all	all	all 54 min	
G44300		drawn (general purpose)	H58	H80	drawn (ge	neral purpose)	
C44300	H58	drawn (general purpose)	H58	H80	54 min	53 min	
G44300	H80	hard drawn ^D		- all - all	all all	54 min 53 min 66 min 70 min	
C44300	H80	hard drawn ^D	all		all	54 min 70 min	
				all	all	66 min	

^A Standard designations defined in Part Classification B 601.

^B ksi = 1000 psi.

^C Rockwell hardness values shall apply only to tubes having a wall thickness of 0.012 in. or over and to round tubes having an inside diameter of 5/16 in. or over and to rectangular including square tubes having an inside major distance between parallel surfaces of 3/16 in. or over. Rockwell hardness 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 manufacturer and the purchaser.

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 2—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 B 153 an expansion of the outside diameter in the following amount:

Outside Diameter, in.	Expansion of Outside Diameter, %
$\frac{3}{4}$ and under	20
Over $\frac{3}{4}$	15

The expanded tube shall show no cracking or rupture visible to the unaided eye. Tube ordered in the drawn (H) condition is not subject to this test.

NOTE 3—The term “unaided eye,” as used herein, permits the use of corrective spectacles necessary to obtain normal vision.

9.2 As an alternative to the expansion test for tube over 4 in. in diameter in the annealed condition, a 4 in. in length shall be cut from the end of one of the lengths for a flattening test. This 4-in. test specimen shall be flattened so that a gage set at three times the wall thickness will pass over the tube freely throughout the flattened part. The tube so tested shall develop no cracks or flaws visible to the unaided eye (Note 3) as a result of this test. In making the flattening test the elements shall be slowly flattened by one stroke of the press.

9.3 Drawn temper tube shall not be required to withstand these tests.

10. Mercurous Nitrate Test

10.1 **Warning**—~~Mercury is a definite health hazard and therefore equipment for the detection and removal of mercury vapor produced in volatilization is recommended. The use of rubber gloves in testing is advisable.~~—Mercury is a definite health hazard. Use equipment for the detection and removal of mercury vapor. Wear rubber gloves when conducting the test.

10.2 When specifically required, test specimens 6 in. in length of both annealed and drawn tempers shall withstand, after proper cleaning, an immersion for 30 min without cracking in the standard mercurous nitrate solution prescribed in Test Method B 154. Immediately after removal from the solution, the specimen shall be wiped free of excess mercury and examined for cracks.

11. Nondestructive Testing

11.1 Unless nondestructive testing has been waived, tubes shall be subjected to a nondestructive test. The manufacturer shall ~~have the option of selecting~~select the nondestructive test that is most suitable for the tube size and the application.

11.1.1 Eddy-current testing is the standard nondestructive test, and all tubes of appropriate size shall be eddy-current tested in accordance with 11.2.

11.1.2 Tubes that are not of a size suitable for eddy-current test capabilities shall be tested by the hydrostatic test as described in 11.3.1, or by the pneumatic test as described in 11.3.2.

11.2 *Eddy-Current Test*—Each tube up to $3\frac{1}{8}$ in. in outside diameter shall be subjected to an eddy-current test. Testing shall follow the procedure of Practice E 243, except the determination of “end effect” is not required. Tubes shall be passed through an eddy-current test unit adjusted to provide information on the suitability of the tube for the intended application.

11.2.1 Notch-depth standards rounded to the nearest 0.001 in. shall be 22 % of the nominal wall thickness. The notch-depth tolerance shall be ± 0.0005 in. ~~Alternatively, at if the option of the manufacturer who uses speed-insensitive eddy-current units that are equipped so that a fraction of the maximum unbalance signal is able to be selected, the following percent maximum unbalance signals are permitted to shall~~ be used.