



Designation: B43 – 98 (Reapproved 2004)

Standard Specification for Seamless Red Brass Pipe, Standard Sizes¹

This standard is issued under the fixed designation B43; 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 specification² covers seamless red brass (Copper Alloy UNS No. C23000)³ pipe in all nominal pipe sizes, both regular and extra-strong. In the annealed temper (O61), the pipe is suitable for use in plumbing, boiler feed lines, and for similar purposes. In the drawn general purpose temper (H58), the pipe is suitable for architectural applications, such as guard railings and stair hand railings.

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are provided for information purposes only.

1.3 The following hazard caveat pertains only to the test method portion, Section 9, 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 and health practices and determine the applicability of regulatory limitations prior to use.*

1.4 **Warning**—Mercury is a definite health hazard in use and disposal. (See 9.1.)

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*:⁴

B153 Test Method for Expansion (Pin Test) of Copper and Copper-Alloy Pipe and Tubing

B154 Test Method for Mercurous Nitrate Test for Copper Alloys
B601 Classification for Temper Designations for Copper and Copper Alloys—Wrought and Cast
E8 Test Methods for Tension Testing of Metallic Materials
E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
E53 Test Method for Determination of Copper in Unalloyed Copper by Gravimetry
E62 Test Methods for Chemical Analysis of Copper and Copper Alloys (Photometric Methods)
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
E478 Test Methods for Chemical Analysis of Copper Alloys
E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

3. Terminology

3.1 *Definitions*:

3.1.1 *tube, seamless*—a tube produced with a continuous periphery in all stages of the operations.

3.1.1.1 *pipe*—a seamless tube conforming to the particular dimensions commercially known as nominal or standard pipe sizes.

3.1.2 *lengths*—straight pieces of the product.

3.1.2.1 *standard*—uniform lengths recommended in a Simplified Practice Recommendation or established as a Commercial Standard.

3.2 *Definition of Term Specific to This Standard*:

3.2.1 *capable of*—as used in this specification, the test need not be performed by the producer of the material. However, should subsequent testing by the purchaser establish that the material does not meet these requirements the material shall be subject to rejection.

4. Ordering Information

4.1 Orders for material under this specification shall include the following information:

4.1.1 Temper (see 6.1),

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 see related Specification SB-43 in Section II of that Code.

³ The system for copper and copper alloys (see Practice E527) 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.

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.

- 4.1.2 Pipe size, regular or extra-strong (see 11.2),
- 4.1.3 Length (see 11.3),
- 4.1.4 Total length of each size, and
- 4.1.5 If material is required to meet *ASME Boiler and Pressure Vessel Code* (see 6.1, 6.2, or 6.3),
- 4.1.6 Certification, if required (see 20.1),
- 4.1.7 Mill test report, if required (see 21.1),
- 4.1.8 Hydrostatic test, if required, and
- 4.1.9 Pneumatic test, if required.
- 4.1.10 Mercurous Nitrate Test, if required (Section 9).

5. Chemical Composition

5.1 The material shall conform to the following chemical requirements:

Copper, %	84.0 to 86.0
Lead, max, %	0.05
Iron, max, %	0.05
Zinc	remainder

5.2 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.

5.2.1 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 %.

5.2.1.1 When all the elements in the table in 5.1 are analyzed, their sum shall be 99.8 % minimum.

6. Temper

6.1 All pipe shall normally be furnished in the O61 (annealed) (see Classification B601) condition.

6.2 In the O61 (annealed) temper, the degree of annealing shall be sufficient to produce complete recrystallization with an average grain size not in excess of 0.050 mm. The surface of the test specimen for grain size determination shall approximate a radial longitudinal section and shall be prepared and examined in accordance with Test Methods E112.

6.3 The pipe is permitted to be furnished in the H58 (drawn general purpose) temper, if agreed upon between the manufacturer and the purchaser. (See Table 1.)

7. Mechanical Properties

7.1 Material in the O61 (annealed) temper specified to meet the requirements of the *ASME Boiler and Pressure Vessel Code* only shall have tensile properties as prescribed in Table 1.

7.2 All H58 (drawn general purpose) material shall have the tensile properties as prescribed in Table 1.

TABLE 1 Tensile Requirements

Temper Designation		Tensile Strength, min. ksi (MPa)	Yield Strength ^A min. ksi (MPa)	Elongation in 2-in. min. %
Standard	Former			
O61	Annealed	40.0 (276)	12.0 (83)	35
H58	Drawn general purpose	44.0 (303)	18.0 (124)	...

^A At 0.5 % extension under load.

8. Expansion Test

8.1 Specimens in the O61 (annealed) temper shall withstand an expansion of 25 % of the outside diameter when expanded in accordance with Test Method B153. The expanded pipe shall show no cracking or rupture visible to the unaided eye. Pipe ordered in the drawn (H) condition is not subject to this test.

NOTE 1—The term “unaided eye,” as used herein, permits the use of corrective spectacles necessary to obtain normal vision.

8.2 As an alternative to the expansion test for pipe over 4 in. (102 mm) in diameter in the O61 (annealed) condition, a section 4 in. in length shall be cut from the end of one of the lengths for a flattening test. This 4-in. specimen shall be flattened so that a gage set at three times the wall thickness will pass over the pipe freely throughout the flattened part. The pipe so tested shall develop no cracks or flaws visible to the unaided eye (see Note 1) as a result of this test. In making the flattening test the elements shall be slowly flattened by one stroke of the press.

9. Mercurous Nitrate Test

9.1 **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.

9.2 When the test is required to be performed, the test specimens, cut 6 in. (152 mm) in length, shall, after proper cleaning, withstand an immersion for 30 min without cracking in the standard mercurous nitrate solution prescribed in Test Method B154. Immediately after removal from the solution, the specimen shall be wiped free of excess mercury and examined for cracks.

9.3 Product of the O61 (annealed) temper shall pass the mercurous nitrate test when tested in accordance with Test Method B154.

9.3.1 The test need not be performed except when indicated in the contract or purchase order at the time of placing of the order.

10. Nondestructive Testing

10.1 The material shall be tested in the final size but is permitted to be tested prior to the final anneal or heat treatment, when these thermal treatments are required, unless otherwise agreed upon by the manufacturer or supplier and purchaser.

10.2 *Eddy-Current Test*—Each piece of material from 1/8 in. up to and including 2 1/2 in. nominal outside diameter or within the capabilities of the eddy-current tester, shall be subjected to an eddy-current test. Testing shall follow the procedures of Practice E243 except for determination of “end effect.” The material shall be passed through an eddy-current testing unit adjusted to provide information on the suitability of the material for the intended application.

10.2.1 Notch-depth standards rounded to the nearest 0.001 in. (0.025 mm) shall be 10 % of the nominal wall thickness. The notch depth tolerances shall be ±0.0005 in. (0.013 mm). Alternatively, when a manufacturer uses speed insensitive equipment that allows the selection of a maximum imbalance signal, a maximum imbalance signal of 0.3 % is permitted to be used.

10.2.2 Material that does not actuate the signaling device of the eddy-current test shall be considered as conforming to the requirements of this test. Material with discontinuities indicated by the testing unit is permitted to be reexamined or retested, at the option of the manufacturer, to determine whether the discontinuity is cause for rejection. Signals that are found to have been caused by minor mechanical damage, soil or moisture shall not be cause for rejection of the material provided the dimensions of the material are still within prescribed limits and the material is suitable for its intended application.

10.3 *Hydrostatic Test*—When specified, the material shall stand, without showing evidence of leakage, an internal hydrostatic pressure sufficient to subject the material to a fiber stress of 6000 psi (41 MPa), determined by the following equation for thin hollow cylinders under tension. The material need not be tested at a hydrostatic pressure of over 1000 psi (6.9 MPa) unless so specified.

$$P = 2St/(D - 0.8t)$$

where:

- P = hydrostatic pressure, psi (or MPa),
- t = wall thickness of the material, in. (or mm),
- D = outside diameter of the material in. (or mm), and
- S = allowable stress of the material, psi (or MPa).

10.3.1 For material less than 1/2 in. (12.7 mm) in outside diameter and less than 0.060 in. (1.5 mm) in wall thickness, the test is permitted to be made at the option of the manufacturer by pneumatically testing to the requirements of 10.4.

10.4 *Pneumatic Test*—When specified, the material shall be subjected to an internal air pressure of 60 psi (415 kPa) minimum for 5 s without showing evidence of leakage. The test method used shall permit easy visual detection of any leakage, such as by having the material under water or by the pressure-differential method. Any evidence of leakage shall be cause for rejection.

11. Dimensions and Permissible Variations

11.1 For the purpose of determining conformance with the dimensional requirements prescribed in this specification, any measured value outside the limiting values for any dimensions may be cause for rejection.

11.2 *Standard Dimensions, Wall Thickness, and Diameter Tolerances*—The standard dimensions, wall thickness, and diameter tolerances shall be in accordance with Table 2.

11.3 *Length and Length Tolerances*—The standard length of red brass pipe is 12 ft (3.66 m) with a tolerance of ±1/2 in. (13 mm).

11.4 *Squareness of Cut*—The departure from squareness of the end of any pipe shall not exceed the following:

Outside Diameter, in. (mm)	Tolerance
Up to 3/8 (15.9), incl	0.010 in. (0.25 mm)
Over 3/8 (15.9)	0.016 in./in. (0.016 mm/mm) of diameter

11.5 *Roundness*—The roundness tolerance for straight length tubes with a wall thickness to outside diameter ratio of 0.01 to 0.05 (inclusive) shall be 6 % of the nominal outside

diameter. For tubes with a wall thickness to outside diameter ratio over 0.05, the roundness tolerance shall be 3 % of the nominal outside diameter.

11.5.1 The measurement for roundness shall be made from the outside diameter. The deviation from roundness is measured as the difference between the major and minor diameters as determined at any one cross section of the tube. The major and minor diameters are the diameters of two concentric circles just enclosing the outside surface of the tube at the cross section.

11.6 *Straightness Tolerance*—For pipe of H58 (drawn general purpose) temper of Nominal Pipe Sizes from 1/4 to 12 in. inclusive, the maximum curvature (depth of arc) shall not exceed 1/2 in. (13 mm) in any 10-ft (3048-mm) portion of the total length. For H58 temper pipe of other sizes, and for the O61 (annealed) temper, no numerical values are established, however, the straightness of the pipe shall be suitable for the intended application.

12. Workmanship, Finish and Appearance

12.1 The material shall be free of defects of a nature that interfere with normal commercial applications. It shall be well cleaned and free of dirt.

13. Sampling

13.1 *Sampling*—The lot size, portion size, and selection of sample pieces shall be as follows:

13.1.1 *Lot Size*—The lot size shall be as follows:

Pipe Size, in.	Lot Weight, lb (kg)
Up to 1 1/2, incl	5 000 (2270) or fraction thereof
Over 1 1/2 to 4, incl	10 000 (4550) or fraction thereof
Over 4	40 000 (18 100) or fraction thereof

13.1.2 *Portion Size*—Sample pieces shall be taken for test purposes from each lot according to the following schedule:

Number of Pieces in Lot	Number of Sample Pieces to be Taken ^{A4}
1 to 50	1
51 to 200	2
201 to 1500	3
Over 1500	0.2 % of total number of pieces in the lot, but not to exceed 10 sample pieces

^A Each sample piece shall be taken from a separate tube.

13.1.3 *Sampling for Visual and Dimensional Examination*—Minimum sampling for visual and dimensional examination shall be as follows:

Lot size (Pieces/lot)	Sample size
2 to 8	Entire lot
9 to 90	8
91 to 150	12
151 to 280	19
281 to 500	21
501 to 1200	27
1201 to 3200	35
3201 to 100 000	38
10 001 to 350 000	46

In all cases, the acceptance number is zero and the rejection number is one. Rejected lots are permitted to be screened and