



Designation: B75M – 99 (Reapproved 2005)

Standard Specification for Seamless Copper Tube (Metric)¹

This standard is issued under the fixed designation 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 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 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 The values stated in SI units are the standard.

1.3 This specification is the companion to inch-pound Specification B75.

1.4 The following hazard statement pertains only to the test method described in Sections 20.5.2.1, 21.2.9, and 21.2.10 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.*

2. Referenced Documents

2.1 ASTM Standards:³

B75 Specification for Seamless Copper Tube

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

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.

B170 Specification for Oxygen-Free Electrolytic Copper—Refinery Shapes

B193 Test Method for Resistivity of Electrical Conductor Materials

B251M Specification for General Requirements for Wrought Seamless Copper and Copper-Alloy Tube (Metric)

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

E3 Guide for Preparation of Metallographic Specimens

E8M Test Methods for Tension Testing of Metallic Materials [Metric]⁴

E18 Test Methods for Rockwell Hardness of Metallic Materials

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)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

E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

3. Terminology, Specific

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *capable of*—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.

3.1.2 *unaided eye, n*—visual inspection without the use of special equipment or enhancement excepting the use of corrective lenses.

⁴ Withdrawn.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

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

4. Ordering Information

4.1 Include the following information in orders for products.

4.1.1 ASTM designation and year of issue (for example, B75M – 99),

- 4.2.4 Pneumatic test,
- 4.2.5 Certification, and
- 4.2.6 Test report.

5. Material and Manufacture

TABLE 1 Chemical Requirements

Element	Composition, %						
	Copper UNS No.						
	C10100	C10200 ^A	C10300	C10800	C12000	C12200	C14200
Copper ^B , min	99.99	99.95	99.90	99.9	99.40
Copper ^B + phosphorus, min	99.95	99.95
Phosphorus	0.001–0.005	0.005–0.012	0.004–0.012	0.015–0.040	0.015–0.040
Arsenic	0.15–0.50

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

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

4.1.2 Copper UNS No. (for example, C10100),

5.1 *Material*—The material of manufacture shall be billets,

TABLE 2 Mechanical Property Requirements of Drawn-Temper and Annealed-Temper Tube

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

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

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

^C Rockwell hardness values shall apply only to tubes having a wall thickness of 0.508 mm or over, to round tubes having an inside diameter of 8.0 mm or over, and to rectangular including square tubes having an inside major distance between parallel surfaces of 5.0 mm or over. 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 purchaser and supplier.

^DRockwell hardness values shall apply only to tubes having a wall thickness of 0.40 mm or over, to round tubes having an inside diameter of 8.0 mm 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 purchaser and supplier.

^E Light-straightening operation shall be permitted.

4.1.3 Temper (Section 7),

4.1.4 Dimensions; diameter or distance between parallel surfaces, and wall thickness (Section 14),

4.1.5 How furnished; coils or straight lengths,

4.1.6 Number of pieces or footage; each size and type,

4.1.7 Total weight,

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

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

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

4.2.1 Electrical mass resistivity test,

4.2.2 Hydrogen embrittlement test,

4.2.3 Hydrostatic test,

cast bars, or tube of Copper UNS⁵ 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.

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

⁵ Refer to Practice E527 for explanation of Unified Numbering System (UNS).

6. Chemical Composition

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

6.1.1 These specification limits do not preclude the presence of other elements. When included in the contract or purchase order, and agreed upon by the manufacturer or supplier and the purchaser, limits shall be established and analysis required for unnamed elements.

7. Temper

7.1 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**.

7.1.1 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 shall be supplied in H55 or H58 temper.

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

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

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.

8. Grain Size Requirements

8.1 Tube in the annealed temper shall conform to the grain size specified in **Table 2**.

9. Physical Property Requirements

9.1 *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.

10. Mechanical Property Requirements

10.1 Tensile and Yield Strength:

10.1.1 The tube shall conform to the requirements of **Table 2** for the specified temper and wall thickness.

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

10.2 Rockwell Hardness:

10.2.1 The tube shall conform to the requirements of **Table 2** for the specified temper and wall thickness.

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

(a) Tubes having a wall thickness of 0.508 mm and over,
 (b) Round tubes having an inside diameter of 8.0 mm and over,

(c) Rectangular and square tubes having major distances between parallel surfaces of 5 mm and over.

10.2.1.2 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 0.40 mm and over;

(b) Round tubes having an inside diameter of 8 mm and over;

(c) Rectangular and square tubes having inside major distances between parallel surfaces of 5 mm and over.

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

11. Performance Requirements

11.1 *Expansion Test for Round Tube*—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 19.0 mm and under and 30 % for tube over 19.0 mm. The tube shall show no cracking or rupture visible to the unaided eye.

12. Microscopical Examination

12.1 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**.

13. Hydrogen Embrittlement

13.1 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**.

14. Purchases for U.S. Government Agencies

14.1 When the contract or purchase order stipulates 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 **B251M**.

15. Nondestructive Test

15.1 The tubes shall be tested in the 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 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 41 MPa without leakage. The tube need not be subjected to a pressure gage reading over 6.9 MPa unless specifically stipulated in the contract or purchase order.