



Designation: B359/B359M – 02 (Reapproved 2006)

Standard Specification for Copper and Copper-Alloy Seamless Condenser and Heat Exchanger Tubes With Integral Fins¹

This standard is issued under the fixed designation B359/B359M; 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 copper and copper alloy tubing on which the external or internal surface, or both, has been modified by a cold-forming process to produce an integral enhanced surface for improved heat transfer.

1.2 *Units*—The values stated in either in-pound units or SI units are to be regarded separately as the standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems could result in nonconformance with the specification.

1.3 The tubes are typically used in surface condensers, evaporators, and heat exchangers.

1.4 The product shall be produced of the following coppers or copper alloys, as specified in the ordering information.

Copper or Copper Alloy UNS No.	Type of Metal
C10100	Oxygen-free electronic
C10200	Oxygen-free without residual deoxidants
C10300	Oxygen-free, extra low phosphorus
C10800	Oxygen-free, low phosphorus
C12000	DLP Phosphorized, low residual phosphorus (See Note 1)
C12200	DHP, Phosphorized, high residual phosphorus (See Note 1)
C14200	DPA Phosphorized arsenical (See Note 1)
C19200	Phosphorized, 1 % iron
C23000	Red Brass
C44300	Admiralty Metal Types B,
C44400	C, and
C44550	D
C60800	Aluminum Bronze
C68700	Aluminum Brass Type B
C70400	95-5 Copper-Nickel
C70600	90-10 Copper-Nickel

C70620	90-10 Copper-Nickel (Modified for Welding)
C71000	80-20 Copper-Nickel Type A
C71500	70-30 Copper-Nickel
C71520	70-30 Copper-Nickel (Modified for Welding)
C72200	Copper-Nickel

NOTE 1—Designations listed in Classification [B224](#).

1.5 The following safety hazard caveat pertains only to the test methods described in 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.*

1.6 Product produced in accordance with the Supplementary Requirements section for military applications shall be produced only to the inch-pound system of this specification.

2. Referenced Documents

2.1 ASTM Standards:³

- [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
- [B170](#) Specification for Oxygen-Free Electrolytic Copper—Refinery Shapes
- [B224](#) Classification of Coppers
- [B601](#) Classification for Temper Designations for Copper and Copper Alloys—Wrought and Cast
- [B846](#) Terminology for Copper and Copper Alloys
- [B858](#) Test Method for Ammonia Vapor Test for Determining Susceptibility to Stress Corrosion Cracking in Copper Alloys
- [B900](#) Practice for Packaging of Copper and Copper Alloy Mill Products for U.S. Government Agencies
- [D4727/D4727M](#) Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes
- [E3](#) Guide for Preparation of Metallographic Specimens

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.

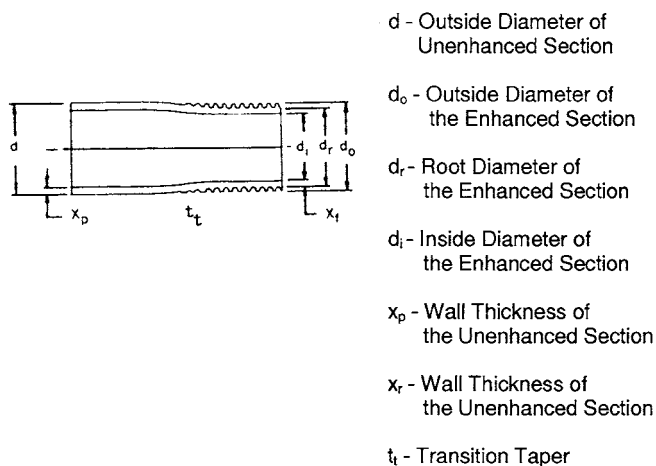
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² For ASME Boiler and Pressure Vessel Code applications see related Specification SB-359 in Section II of that Code.

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.

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

- E8 Test Methods for Tension Testing of Metallic Materials
- E8M Test Methods for Tension Testing of Metallic Materials [Metric]⁴
- 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)⁴
- E112 Test Methods for Determining Average Grain Size
- E118 Test Methods for Chemical Analysis of Copper-Chromium Alloys
- 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



- d - Outside Diameter of Unenhanced Section
- d_o - Outside Diameter of the Enhanced Section
- d_r - Root Diameter of the Enhanced Section
- d_i - Inside Diameter of the Enhanced Section
- x_p - Wall Thickness of the Unenhanced Section
- x_r - Wall Thickness of the Unenhanced Section
- t_t - Transition Taper

NOTE—The outside diameter over the enhanced section will not normally exceed the outside diameter of the unenhanced section.

FIG. 1 Outside Diameter Enhanced Tube Nomenclature

3. General Requirements

3.1 Product described by this specification shall typically be furnished with unenhanced ends, but may be furnished with enhanced ends or stripped ends from which the O.D. enhancement has been removed by machining.

3.1.1 The enhanced sections of the tube in the as-fabricated temper are in the cold-worked condition produced by the enhancing operation.

3.1.2 The unenhanced sections of the tube shall be in the annealed or light drawn temper, and shall be suitable for rolling-in operations.

4. Terminology

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

4.2 Definitions:

4.2.1 *flattening, v* —this term shall be interpreted as that condition which allows a micrometer caliper, set at three times the wall thickness, to pass over the tube freely throughout the flattened part, except at the points where the change in element of flattening takes place.

4.3 Definitions of Terms Specific to This Standard:

4.3.1 *tube condenser, n* —see *tube, heat exchanger* in Terminology B846.

5. Ordering Information

5.1 Include the following information when placing orders under this specification:

- 5.1.1 ASTM designation and year of issue,
- 5.1.2 Copper or Copper Alloy UNS No. designation (see 1.4 and Section 7),
- 5.1.3 Temper (see Section 8),
- 5.1.4 Dimensions: diameter, wall thickness, length and location of unenhanced surfaces and total tube length. Configuration of enhanced surfaces shall be as agreed upon between the manufacturer and the purchaser. (See Figs. 1-3).

5.1.5 Whether the product is to be subsequently welded for UNS Alloy C72200, UNS Alloys C7062 and C71520 are welding grades of C70600 and C71500,

5.1.6 Quantity, and

5.1.7 If product is for the U.S. government.

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

- 5.2.1 When heat identification or traceability is required,
- 5.2.2 When tubes are for Boiler and Pressure Vessel code application, which should then be ordered according to ASME SB 359,
- 5.2.3 Flattening test (see 11.2),
- 5.2.4 Certification (see Section 22), when required,
- 5.2.5 Mill test report (see Section 23), when required, and
- 5.2.6 Stress relief annealing (see 9.4), when required.

5.3 In addition, when material is purchased for agencies of the U.S. government, it shall conform to the requirements specified in the Supplementary Requirements section, when specified in the contract or purchase order.

6. Materials and Manufacture

6.1 Materials:

6.1.1 The material of manufacture shall be of such quality and purity that the finished product shall have the properties and characteristics prescribed in this specification for the applicable alloy and temper.

6.2 Manufacture:

6.2.1 The seamless copper and copper alloy tubing shall have the internal or external surface, or both, modified by a cold forming process to produce an integral enhanced surface for improved heat transfer.

6.2.2 The cut ends of the tubes shall be deburred.

6.2.3 Due to the discontinuous nature of the processing of castings into wrought products, it is not practical to identify specific casting analysis with a specific quantity of finished material.

6.2.4 When heat identification is required, the purchaser shall specify the details desired in the purchase order or contract.

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

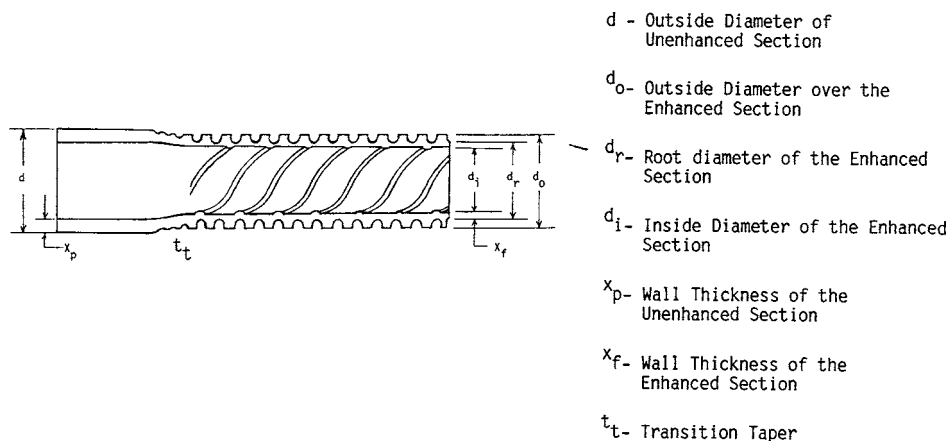


FIG. 2 Outside Diameter and Inside Diameter Enhanced Tube Nomenclature

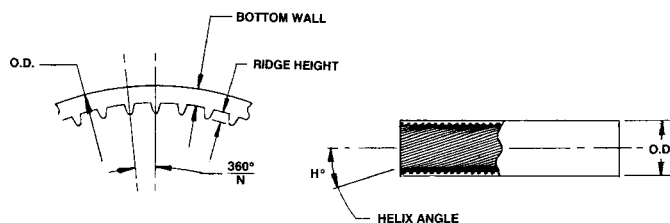


FIG. 3 Inside Diameter Enhanced Tube Nomenclature

7. Chemical Composition

7.1 The tubes shall conform to the chemical requirements specified in **Table 1** for copper or copper alloy specified in the ordering information.

7.2 These specification limits do not preclude the presence of unnamed elements. By agreement between the manufacturer, or supplier and purchaser, analysis may be required and limits established for elements not specified.

7.2.1 *Copper Alloy C19200*—Copper may be taken as the difference between the sum of results for all specified elements and 100 %. When all elements specified, including copper, are determined, their sum shall be 99.8 % minimum.

7.2.2 For alloys in which copper is specified as the remainder, copper may be taken as the difference between the sum of the results for all specified elements and 100 % for the particular alloy.

7.2.2.1 When analyzed, copper plus the sum of results for specified elements shall conform with the requirements shown in the following table:

Copper Alloy UNS No.	Copper Plus Named Elements, % min
C60800	99.5
C70400	99.5
C70600	99.5
C70620	99.5
C71000	99.5
C71500	99.5
C71520	99.5
C72200	99.8

7.2.3 For alloys in which zinc is specified as the remainder, either copper or zinc may be taken as the difference between the sum of the results of specified elements analyzed and 100 %.

7.2.3.1 When all specified elements are determined, the sum of results plus copper shall be as follows:

Copper Alloy UNS No.	Copper Plus Named Elements, % min
C23000	99.8
C44300, C44400, C44500	99.6
C68700	99.5

8. Temper

8.1 Tempers, as defined in Classification **B601** and this document, are as follows:

8.1.1 The tube, after enhancing, shall be supplied, as specified, in the annealed (O61) or as-fabricated temper.

8.1.1.1 The enhanced sections of tubes in the as-fabricated temper are in the cold-worked condition produced by the fabricating operation.

8.1.1.2 The unenhanced sections of tubes in the as-fabricated temper are in the temper of the tube prior to enhancing, annealed (O61), or light drawn (H55), and suitable for rolling-in operations.

8.1.1.3 Copper Alloy UNS Nos. C23000, C44300, C44400, C44500, C60800, and C68700, furnished in the as-fabricated temper, shall be stress relief annealed after enhancing and be capable of meeting the requirements of the stress-corrosion susceptibility requirement in Section 12. Stress-relief annealing of the copper and other copper alloys described by this specification is not required.

9. Grain Size of Annealed Temper

9.1 Samples of annealed-temper (O61) tubes selected for test shall be subjected to microscopical examination at a



TABLE 1 Chemical Requirements

Copper or Copper Alloy UNS No.	Composition, %												
	Copper	Tin	Aluminum	Nickel, incl Cobalt	Lead, max	Iron	Zinc	Manganese	Arsenic	Antimony	Phosphorus	Chromium	Other Named Elements
C10100	99.99 min ^{A,B}	0.0002 max	...	0.0010 max	0.0005	0.0010 max	0.0001 max	0.00005 max	0.0005 max	0.0004 max	0.0003 max	...	Te 0.0002
C10200	99.95 min ^{C,D,E}
C10300	99.95 min ^{C,F}	0.001–0.005
C10800	99.95 min ^{C,F}	0.005–0.012
C12000	99.90 min ^C	0.004–0.012
C12200	99.9 min ^C	0.015–0.040
C14200	99.4 min ^C	0.15–0.50	...	0.015–0.040
C19200	98.5 min ^G	0.8–1.2	0.20 max	0.01–0.04
C23000	84.0–86.0 ^G	0.05	0.05 max	remainder
C44300	70.0–73.0 ^H	0.9–1.2	0.07	0.06 max	remainder	...	0.02–0.06
C44400	70.0–73.0 ^H	0.9–1.2	0.07	0.06 max	remainder	0.02–0.10
C44500	70.0–73.0 ^H	0.9–1.2	0.07	0.06 max	remainder	0.02–0.10
C60800	remainder ^{C,I}	...	5.0–6.5	...	0.10	0.10 max	0.02–0.35
C68700	76.0–79.0 ^{C,I}	...	1.8–2.5	...	0.07	0.06 max	remainder	...	0.02–0.06
C70400	remainder ^{C,I}	4.8–6.2	0.05	1.3–1.7	1.0 max	0.30–0.8
C70600	remainder ^{C,I}	9.0–11.0	0.05	1.0–1.8	1.0 max	1.0 max
C70620	86.5 min ^{C,I}	9.0–11.0	0.02	1.0–1.8	0.5 max	1.0 max	0.02 max	...	0.05 C max 0.02 S max
C71000	remainder ^{C,I,J}	19.0–23.0	0.05	1.0 max	1.0 max	1.0 max
C71500	remainder ^{C,I}	29.0–33.0	0.05	0.40–1.0	1.0 max	1.0 max
C71520	65.0 min	29.0–33.0	0.02	0.40–1.0	0.50 max	1.0 max	0.02 max	...	0.05 C max 0.02 S max
C72200	remainder ^{C,G,J}	15.0–18.0	0.05	0.50–1.0	1.0 max	1.0 max	0.30–0.70	0.03 Si 0.03 Ti

^A This value is exclusive of silver and shall be determined by difference of "impurity total" from 100 %. "Impurity total" is defined as the sum of sulfur, silver, lead, tin, bismuth, arsenic, antimony, iron, nickel, zinc, phosphorus, selenium, tellurium, manganese, cadmium, and oxygen present in the sample.

^B Other impurity maximums for C10100 shall be: bismuth and cadmium 0.0001 each, oxygen 0.0005, selenium 0.0003, silver 0.0025, and sulfur 0.0015.

^C Copper (including silver).

^D Oxygen in C10200 shall be 0.0010 max.

^E Cu is determined by the difference in the impurity total and 100 %.

^F Copper plus sum of named elements shall be 99.95 % min.

^G Cu + Sum of Named Elements, 99.8 % min.

^H Cu + Sum of Named Elements, 99.6 % min.

^I Cu + Sum of Named Elements, 99.5 % min.

^J When the product is for subsequent welding applications, and so specified in the contract or purchase order, zinc shall be 0.50 % max, lead 0.02 % max, phosphorus 0.02 % max, sulfur 0.02 % max, and carbon 0.05 % max.

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magnification of 75 diameters and shall show uniform and complete recrystallation.

9.2 Average grain size shall be within limits agreed upon between the manufacturer and purchaser, when measured in the wall of the tube outside of the enhanced area.

9.3 The requirements of this section do not apply to product shipped in the as-fabricated temper.

9.4 Some annealed tubes, when subjected to aggressive environments, may be subject to stress-corrosion cracking failure because of the residual tensile stresses developed in straightening. For such applications, it is recommended that tubes of Copper Alloy UNS Nos. C23000, C44300, C44400, C44500, C60800, and C68700 be subjected to a stress relieving thermal treatment subsequent to straightening. When required, this must be specified on the purchase order or contract. Tolerance for roundness and length, and the condition for straightness, for tube so ordered, shall be to the requirements agreed upon between the manufacturer and purchaser.

10. Mechanical Property Requirements

10.1 *Tensile Property Requirements:*

10.1.1 Prior to the enhancing operation, the tube shall conform to the requirements for tensile properties prescribed in **Table 2**.

11. Performance Requirements

11.1 *Expansion Test*—The unenhanced sections of all tubes selected for test shall conform to the requirements prescribed in **Table 3** when tested in accordance with Test Method **B153**. The expanded tube shall show no cracking or rupture visible to the unaided eye.

11.2 *Flattening Test:*

11.2.1 When specified in the contract or purchase order, the flattening test described in the test method section in **18.4** shall be performed.

11.2.1.1 During inspection, the flattened areas of the test-specimen shall be free of defects, but blemishes of a nature that do not interfere with the intended application are acceptable.

12. Other Requirements

12.1 *Mercurous Nitrate Test or Ammonia Vapor Test:*

12.1.1 The mercurous nitrate or ammonia vapor test is required only for Copper Alloys UNS Nos. C23000, C44300, C44400, C44500, C60800, and C68700. (**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.)

TABLE 2 Tensile Requirements

Copper or Copper Alloy UNS No.	Temper Designation		Tensile Strength, min	Yield Strength, ^A min
	Standard	Former	ksi ^B [MPa]	ksi ^B [MPa]
C10100, C10200, C10300, C10800, C12000, C12200, C14200	O61	annealed	30 [205]	9 [62] ^C
C10100, C10200, C10300, C10800, C12000, C12200, C14200	H55	light-drawn	36 [250]	30 [205]
C19200	O61	annealed	38 [260]	12 [85]
C23000	O61	annealed	40 [275]	12 [85]
C44300, C44400, C44500	O61	annealed	45 [310]	15 [105]
C60800	O61	annealed	50 [345]	19 [130]
C68700	O61	annealed	50 [345]	18 [125]
C70400	O61	annealed	38 [260]	12 [85]
C70600	O61	annealed	40 [275]	15 [105]
C70620	O61	annealed	40 [275]	15 [105]
C71000	O61	annealed	45 [310]	16 [110]
C71500	O61	annealed	52 [360]	18 [125]
C71520	O61	annealed	52 [360]	18 [125]
C72200	O61	annealed	45 [310]	16 [110]

^A At 0.5 % extension under load.

^B ksi = 1000 psi.

^C Light straightening operation is permitted.

TABLE 3 Expansion Requirements

Temper Designation		Copper or Copper Alloy UNS No.	Expansion of Tube Outside Diameter in Percent of Original Outside Diameter
Standard	Former		
O61	annealed	C10100, C10200, C10300, C10800, C12000, C12200, C14200	30
H55	light-drawn	C10100, C10200, C10300, C10800, C12000, C12200, C14200	20
O61	annealed	C19200	30
O61	annealed	C23000	20
O61	annealed	C44300, C44400, C44500	20
O61	annealed	C60800	20
O61	annealed	C68700	20
O61	annealed	C70400	30
O61	annealed	C70600, C70620	30
O61	annealed	C71000	30
O61	annealed	C71500, C71520	30
O61	annealed	C72200	30

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12.1.2 The test specimens, cut 6 in. [150 mm] in length from the enhanced section shall withstand, without cracking, an immersion in the standard mercurous nitrate solution in Test Method **B154** or immersion in the ammonia vapor solution as defined in Test Method **B858**.

12.1.3 Unless otherwise agreed upon between the manufacturer, or supplier, and the purchaser, the manufacturer shall have the option of using either the mercurous nitrate test or the ammonia vapor test. If agreement cannot be reached, the mercurous nitrate test standard shall be utilized.

12.1.4 If the ammonia vapor test is selected, the appropriate risk level pH value for the test solution shall be agreed upon by the manufacturer and purchaser, or alternately, if the purchaser defers to the manufacturer's expertise for the selection of the test pH value, the minimum value selected shall be 9.8.

12.2 Non-Destructive Testing:

12.2.1 Each tube shall be subjected to a non-destructive test. Tubes shall normally be tested in the as-fabricated temper but, at the option of the manufacturer, may be tested in the annealed temper. Unless otherwise specified, the manufacturer shall have the option of testing the tubes by one of the following test methods:

12.2.1.1 Non-Destructive Examination for Defects:

(1) The tubes shall be passed through an eddy-current testing unit adjusted per the requirements of **18.3.3** to provide information on the suitability of the tube for the intended application.

(2) Tubes causing irrelevant signals because of moisture, soil, and like effects may be reconditioned and retested. Such tubes shall be considered to conform, should they not cause output signals beyond the acceptable limits.

(3) Tubes causing irrelevant signals because of visible and identifiable handling marks may be retested by the hydrostatic test prescribed in **12.2.1.2** or the pneumatic test prescribed in **12.2.1.3**.

(4) Unless otherwise agreed, tubes meeting the requirements of either test shall be considered to conform if the tube dimensions are within the prescribed limits.

12.2.1.2 **Hydrostatic Test**—Each tube, without showing evidence of leakage, shall withstand an internal hydrostatic pressure sufficient to subject the material in the unenhanced region of the tube to a fiber stress of 7000 psi [48 Mpa], as determined by the following equation for thin hollow cylinders under tension:

$$P = \frac{2St}{(D - 0.8t)} \quad (1)$$

where:

- P = hydrostatic pressure, psig, [Mpa],
- t = thickness of tube wall, in., [mm],
- D = outside diameter of tube, in., [mm], and
- S = allowable fiber stress of the material, psi [Mpa].

The tube need not be tested at a hydrostatic pressure over 1000 psi [6.9 MPa] unless so specified.

12.2.1.3 *Pneumatic Test*—Each tube, after enhancing, shall withstand a minimum internal air pressure of 250 psig [1.7 Mpa] for 5 s and any evidence of leakage shall be cause for rejection. The test method used shall permit easy visual detection of any leakage, such as having the tube under water, or by the pressure differential method.

12.2.2 *ASME Pressure Vessel Code:*

12.2.2.1 When tubes are specified to meet the requirements of the ASME Boiler and Pressure Vessel Code, a pressure test as described in 12.2.1.2 or 12.2.1.3 is required.

13. Dimensions, Mass, and Permissible Variations

13.1 *Tube Diameter:*

13.1.1 The outside diameter of the unenhanced sections shall not vary by more than the amount shown in Table 4 for the appropriate dimensional system, as measured by “go” and “no go” ring gages. The diameter over the enhanced sections shall not exceed the diameter of the plain sections involved, as determined by a “go” ring gage, unless otherwise specified.

13.2 *Wall Thickness*—No tube shall be less than the minimum thickness specified in the plain sections or in the enhanced sections.

13.3 *Length:*

13.3.1 The length of the tubes shall not be less than that specified when measured at a temperature of 68°F [20°C], but may exceed the specified value by the amounts shown in Table 5, for the appropriate dimensional system.

13.3.2 The length of the unenhanced end(s), as measured from the tube end to the first fin disk impression, shall not be less than that specified, but may exceed the specified value by ½ in. [13 mm].

13.4 *Squareness of Cut*—The departure from squareness of the end of any tube shall not exceed the tolerance stated in Table 6, for the appropriate dimensional system.

14. Workmanship, Finish and Appearance

14.1 Roundness, straightness, uniformity of wall thickness, and condition of inner and outer surfaces of the tube shall be such as to make it suitable for the intended application. Unless otherwise specified on the purchase order, the cut ends of the tubes shall be deburred by use of a rotating wire wheel or other suitable tool.

TABLE 4 Diameter Tolerances

Specified Diameter, in. [mm]	Tolerance, in. [mm]
0.500 [12.0] and under	±0.002 [0.050]
Over 0.500–0.740 [12.0–18.0], incl	±0.0025 [0.063]
Over 0.740–1.000 [18.0–25.0], incl	±0.003 [0.076]

TABLE 5 Length Tolerances

Specified Length, ft [mm]	Tolerance, all Plus, in. [mm]
Up to 20 [6000], incl	1/8 [3.2]
Over 20–30 [6000-10 000], incl	5/32 [4.0]
Over 30–60 [10 000-18 000], incl	1/4 [6.4]

TABLE 6 Squareness of Cut

Specified Outside Diameter, in. [mm]	Tolerance, in. [mm]
Up to 5/8 [16.0], incl	0.010 [0.25]
Over 5/8 [16.0]	0.016 in./in. [0.016 mm/mm] of diameter

14.2 Annealed-temper (O61) or stress-relieved tubes shall be clean and smooth, but may have a superficial, dull iridescent film on both the inside and outside surface. Tubes in the as-fabricated temper may have a superficial film of finning lubricant on the surfaces.

15. Sampling

15.1 The lot size, portion size, and selection of sample pieces shall be as follows:

15.1.1 *Lot Size*—600 tubes or 10 000 lb [4550 kg] or fraction of either, whichever constitutes the greater weight.

15.1.2 *Portion Size*—Sections from two individual lengths of finished product.

15.1.2.1 Samples taken for purposes of test shall be selected in a manner that will correctly represent the material furnished and avoid needless destruction of finished material when samples representative of the material are available from other sources.

15.2 *Chemical Composition:*

15.2.1 Samples for determining composition shall be taken in accordance with Practice E255. The minimum weight of the composite sample shall be 150 g.

15.2.2 Instead of sampling in accordance with Practice E255, the manufacturer shall have the option of sampling at the time castings are poured or sampling the semi-finished product. When samples are taken during the course of manufacture, sampling of the finished product is not required and the minimum number of samples to be taken shall be as follows:

15.2.2.1 When samples are taken at the time castings are poured, one sample shall be taken for each group of castings poured simultaneously from the same source of molten metal.

15.2.2.2 When samples are taken from the semi-finished product, one sample shall be taken to represent each 10 000 lb [4550 kg] or fraction thereof, except that not more than one sample shall be required per piece.

16. Number of Tests and Retest

16.1 *Tests:*

16.1.1 *Chemical Analysis*—Chemical composition shall be determined as the arithmetic mean of at least two replicate determinations of each specified element.

16.1.2 *Grain Size*—For annealed temper only, two tubes shall be selected from each lot and each tube shall be tested to verify the requirements of Section 9.