



Designation: ~~B505/B505M-08~~ Designation: B 505/B 505M – 08a

Standard Specification for Copper Alloy Continuous Castings¹

This standard is issued under the fixed designation B 505/B 505M; 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 establishes requirements for continuously cast rod, bar, tube, and shapes produced from copper alloys with nominal compositions as listed in Table 1.²

1.2 Castings produced to this specification may be manufactured for and supplied from stock. In such cases the manufacturer shall maintain heat traceability to specific manufacturing date and chemical analysis.

1.3 The values stated in either SI units or inch/pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the ~~specification~~ standard.

1.4 *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 in the current issue of the *Annual Book of ASTM Standards* form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards*:³

B 208 [Practice for Preparing Tension Test Specimens for Copper Alloy Sand, Permanent Mold, Centrifugal, and Continuous Castings](#)

B 824 [Specification for General Requirements for Copper Alloy Castings](#)

B 846 [Terminology for Copper and Copper Alloys](#)

E 8 [Test Methods for Tension Testing of Metallic Materials](#)

E 8M [Test Methods for Tension Testing of Metallic Materials \[Metric\]](#)

E 10 [Test Method for Brinell Hardness of Metallic Materials](#)

E 18 [Test Methods for Rockwell Hardness of Metallic Materials](#)

E 255 [Practice for Sampling Copper and Copper Alloys for the Determination of Chemical Composition](#)

E 527 [Practice for Numbering Metals and Alloys in the Unified Numbering System \(UNS\)](#)

3. Terminology

3.1 For definitions of terms related to copper and copper alloys, refer to Terminology B 846.

4. General Requirements

4.1 The following sections of Specification B 824 form a part of this specification. The definition of a casting lot as defined in Section 12, Sampling, takes precedence over Specification B 824.

4.1.1 Terminology (Section 3),

4.1.2 Other Requirements (Section 7),

4.1.3 Workmanship, Finish, and Appearance (Section 9),

4.1.4 Number of Tests and Retests (Section 11),

¹ This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.05 on Castings and Ingots for Remelting.

Current edition approved April 1, Oct. 15, 2008. Published April/November 2008. Originally approved in 1970. Last previous edition approved in 2007/2008 as B 505/B 505M – 078.

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 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.



TABLE 1 Nominal Composition

| Copper Alloy UNS No. | Designation | Composition, % | | | | | | | |
|----------------------|----------------------------------|----------------|-----|------|------|--------|----------|------|----------------------------|
| | | Copper | Tin | Lead | Zinc | Nickel | Aluminum | Iron | Manganese |
| C83600 | lead red brass | 85 | 5 | 5 | 5 | ... | ... | ... | ... |
| C83800 | lead red brass | 82.9 | 3.8 | 6 | 6.5 | ... | ... | ... | ... |
| C84200 | lead semi-red brass | 80 | 5 | 2.5 | 13 | ... | ... | ... | ... |
| C84400 | lead semi-red brass | 80 | 2.9 | 7 | 8.5 | ... | ... | ... | ... |
| C84800 | lead semi-red brass | 76 | 2.5 | 6.2 | 15 | ... | ... | ... | ... |
| C85700 | lead naval brass | 61 | 1 | 1.2 | 36 | ... | ... | ... | ... |
| C86200 | high-strength yellow brass | 63 | ... | ... | 25 | ... | 4 | 3 | 3.8 |
| C86300 | high-strength yellow brass | 63 | ... | ... | 25 | ... | 6.2 | 3 | 3.8 |
| C86500 | high-strength yellow brass | 57.5 | ... | ... | 39 | ... | 1 | 1.2 | 0.8 |
| C87850 ^A | silicon brass | 76 | ... | ... | 20.9 | ... | ... | ... | ... |
| C89320 ^B | bismuth tin bronze | 89 | 6 | ... | ... | ... | ... | ... | ... |
| C90300 | tin bronze | 87.5 | 8.2 | ... | 4 | ... | ... | ... | ... |
| C90500 | tin bronze | 87.5 | 10 | ... | 2 | ... | ... | ... | ... |
| C90700 | tin bronze | 89 | 11 | ... | ... | ... | ... | ... | ... |
| C91000 | tin bronze | 85 | 15 | ... | ... | ... | ... | ... | ... |
| C91300 | tin bronze | 80.5 | 19 | ... | ... | ... | ... | ... | ... |
| C92200 | lead tin bronze | 88 | 6 | 1.5 | 4 | ... | ... | ... | ... |
| C92300 | lead tin bronze | 87 | 8.2 | 0.6 | 3.8 | ... | ... | ... | ... |
| C92500 | nickel-phosphor bronze | 86.5 | 11 | 1.2 | ... | 1.2 | ... | ... | ... |
| C92700 | lead tin bronze | 87.5 | 10 | 1.8 | ... | ... | ... | ... | ... |
| C92800 | lead tin bronze | 80 | 16 | 5 | ... | ... | ... | ... | ... |
| C92900 | lead nickel-tin bronze | 84 | 10 | 2.6 | ... | 3.4 | ... | ... | ... |
| C93200 | high-lead tin bronze | 83 | 6.9 | 7 | 3 | ... | ... | ... | ... |
| C93400 | high-lead tin bronze | 83.5 | 8 | 8 | ... | ... | ... | ... | ... |
| C93500 | high-lead tin bronze | 84.5 | 5.2 | 9 | 1 | ... | ... | ... | ... |
| C93600 | high-lead tin bronze | 81 | 7 | 12 | ... | ... | ... | ... | ... |
| C93700 | high-lead tin bronze | 80 | 10 | 9.5 | ... | ... | ... | ... | ... |
| C93800 | high-lead tin bronze | 77 | 6.9 | 14.5 | ... | ... | ... | ... | ... |
| C93900 | high-lead tin bronze | 78 | 6 | 16 | ... | ... | ... | ... | ... |
| C94000 | high-lead tin bronze | 70.5 | 13 | 15 | ... | ... | ... | ... | ... |
| C94100 | high-lead tin bronze | 75.5 | 5.5 | 20 | ... | ... | ... | ... | ... |
| C94300 | high-lead tin bronze | 69.5 | 5.2 | 25 | ... | ... | ... | ... | ... |
| C94700 | nickel-tin bronze | 87.5 | 5.2 | 0 | 1.8 | 5.2 | ... | ... | ... |
| C94800 | lead nickel-tin bronze | 86.5 | 5.2 | 0.6 | 1.8 | 5.2 | ... | ... | ... |
| C95200 | aluminum bronze | 87.8 | ... | ... | ... | ... | 9 | 3.2 | ... |
| C95300 | aluminum bronze | 88.8 | ... | ... | ... | ... | 10 | 1.2 | ... |
| C95400 | aluminum bronze | 85.2 | ... | ... | ... | ... | 10.8 | 4 | ... |
| C95410 | aluminum bronze | 83.2 | ... | ... | ... | 2 | 10.8 | 4 | ... |
| C95500 | nickel-aluminum bronze | 81 | ... | ... | ... | 4.2 | 10.8 | 4 | ... |
| C95520 | nickel-aluminum bronze | 79.1 | ... | ... | ... | 5.1 | 11 | 4.8 | ... |
| C95700 | manganese nickel aluminum bronze | 74.8 | ... | ... | ... | 2.2 | 7.5 | 3 | 12.5 |
| C95800 | nickel-aluminum bronze | 81.3 | ... | ... | ... | 4.5 | 9 | 4 | 1.2 |
| C95900 | aluminum bronze | 83.2 | ... | ... | ... | ... | 12.8 | 4.0 | ... |
| C96400 | copper-nickel | 67 | ... | ... | ... | 30 | ... | 0.90 | ... |
| C96900 | copper-nickel | 76.8 | 8 | ... | ... | 15 | ... | ... | 0.20 |
| C96970 | copper-nickel-tin | 85 | 6 | ... | ... | 9.0 | ... | ... | ... |
| C97300 | lead nickel bronze | 55.5 | 2.2 | 9.5 | 21 | 12.5 | ... | ... | ... |
| C97600 | lead nickel bronze | 65 | 4 | 4 | 6 | 20.2 | ... | ... | ... |
| C97800 | lead nickel bronze | 65.5 | 4.8 | 1.8 | 2.5 | 25.5 | ... | ... | ... |
| C99500 ^C | special alloy | 89.1 | ... | ... | 1.2 | 4.5 | 1.2 | 4.0 | ...C96970 copper-nickel-ti |

^ASilicon 3, Phosphorus 0.12^BBismuth 5.0^CSilicon 1.3

- 4.1.5 Specimen Preparation (Section 12),
- 4.1.6 Test Methods (Section 13),
- 4.1.7 Significance of Numerical Limits (Section 14),
- 4.1.8 Inspection (Section 15),
- 4.1.9 Rejection and Rehearing (Section 16),
- 4.1.10 Certification (Section 17),
- 4.1.11 Test Report (Section 18),
- 4.1.12 Product Marking (Section 19),
- 4.1.13 Packaging and Package Marking (Section 20),
- 4.1.14 Keywords (Section 21), and
- 4.1.15 Supplementary Requirements.

5. Ordering Information

- 5.1 Include the following information in orders for product:

- 5.1.1 ASTM designation and year of issue (for example, B 505/B 505M – 04),
 - 5.1.2 Copper Alloy UNS No. (for example, C93200), including HT if heat treatment is required.
 - 5.1.3 Condition (Table 9) and (as cast, heat treated, and so forth),
 - 5.1.4 Dimensions: inside diameter, outside diameter, thickness and width,
 - 5.1.5 Form: cross-section, such as tube, round, hexagon, octagon, square, or rectangle,
 - 5.1.6 Tolerances, if different from Section 10 and Tables 2-8.
 - 5.1.7 Length (including length tolerance if other than mill lengths),
 - 5.1.8 Number of castings or total weight, for each size and form,
 - 5.1.9 *ASME Boiler and Pressure Vessel Code*⁴ requirements (if required see Section 9),
 - 5.1.10 When castings are purchased for agencies of the U.S. government, the Supplementary Requirements of Specification B 824 may be specified.
- 5.2 The following requirements are optional and should be specified in the purchase order when required:
- 5.2.1 Chemical analysis of residual elements (Section 7 and Specification B 824),
 - 5.2.2 Mechanical requirements, (Section 8 Test Methods E 8),
 - 5.2.3 Witness inspection (Specification B 824),
 - 5.2.4 Certification (Specification B 824),
 - 5.2.5 Foundry test report (Specification B 824),
 - 5.2.6 Product marking (Specification B 824),
 - 5.2.7 Castings for seawater service (Section 6), and
 - 5.2.8 Approval of weld repair and records of repair (Section 11).

6. Materials and Manufacture

6.1 For better corrosion resistance in seawater applications, castings in Copper Alloy UNS No. C95800 shall be given a temperature anneal heat treatment at $1250 \pm 50^\circ\text{F}$ ($675 \pm 10^\circ\text{C}$) for 6 h minimum. Cooling shall be by the fastest means possible that will not cause excessive distortion or cracking. Propeller castings shall be exempt from this requirement.

6.2 Copper Alloy UNS Nos. C95300, C95400, C95410, and C95500 may be supplied in the heat-treated condition to obtain the higher mechanical properties shown in Table 9. Suggested heat treatments for these alloys and Copper Alloy UNS No. C95520 are given in Table 2. Actual practice may vary by manufacturer.

6.3 Copper Alloy UNS No. C95520 is used only in the quench-hardened and tempered (TQ30) condition, see Table 2.

6.4 Copper Alloy UNS No. C96900 is normally supplied heat treated at 1520°F (825°C) for 1 h followed by a water quench, then aged at 800°F (425°C) for 4 h followed by a water quench.

6.5 If test bar coupons representing castings made in Copper Alloy UNS Nos. C94700HT, C95300HT, C95400HT, C95410HT, C95500HT, C95520HT, C95800 temper annealed, C95900 annealed, and C96900 are removed from the continuous castings before heat treatment, the coupons shall be heat treated with the continuous castings.

7. Chemical Composition

7.1 The continuous castings shall conform to the requirements for major elements shown in Table 10.

7.2 These specification limits do not preclude the presence of other elements. Limits may be established and analysis required for unnamed elements agreed upon between the manufacturer or supplier and the purchaser. Copper or zinc may be given as

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

TABLE 2 Suggested Heat Treatments

| Copper Alloy UNS No. | Solution Treatment (not less than 1 h followed by water quench), °F(°C) | Annealing Treatment (not less than 2 h followed by air cool), °F(°C) |
|---------------------------|---|--|
| C95300 | 1585–1635 (860–890) | 1150–1225 (620–660) |
| C95400, C95410, C95500 | 1600–1675 (870–910) | 1150–1225 (620–660) |
| C95520 | (2 h followed by water quench) 1600–1700 (870–925) | 925–1000 (495–540) |



TABLE 3 Finishing Allowances for Tube (Round Only)

| Finished Outside Diameter, in. (mm) | Finish Allowances Added to Finished or Print Dimensions of the Part, in. (mm) | |
|---|---|---------------------|
| | Inside Diameter | Outside Diameter |
| | All Alloys Except as Noted Below | |
| Up to 4 (102), excl | -0.031 (-0.79) | + 0.031 (0.79) |
| 4 (102)–5 (127), incl | -0.063 (-1.6) | + 0.063 (1.6) |
| Over 5 (127) | -0.094 (-2.4) | + 0.094 (2.4) |
| Copper Alloy UNS Nos. C86200, C86300, C86500, C87850, C95200, C95300, C95400, C95500, C95800, C95900, and C96400 | | |
| Up to 3 (76.2), incl | -0.125 (-3.2) | + 0.063 (1.6) |
| Over 3 (76.2)–4 (102), incl | -0.125 (-3.2) | + 0.094 (2.4) |
| Over 4 (102)–5½ (140), incl | -0.188 (-4.8) | + 0.125 (3.2) |
| Over 5½ (140) | -0.250 (-6.4) | + 0.188 (4.8) |

TABLE 4 Finishing Allowances for Rod and Bar

| Finished Outside Diameter or Distance Between Parallel Surfaces, in. (mm) | Rounds | Squares, Rectangles, Hexagons, Octagons |
|---|----------------------------------|--|
| | All Alloys Except as Noted Below | |
| Up to 4 (102), excl | + 0.031 (0.79) | + 0.031 (0.79) |
| 4 (102)–5 (127), incl | + 0.063 (1.6) | + 0.063 (1.6) |
| Over 5 (127) | + 0.094 (2.4) | + 0.094 (2.4) |
| Copper Alloy UNS Nos. C86200, C86300, C86500, C87850, C95200, C95300, C95400, C95500, C95800, C95900, C96400 | | |
| Up to 3 (76.2), incl | + 0.0625 (1.6) | + 0.0625 (1.6) |
| Over 3 (76.2)–4 (102), incl | + 0.093 (2.4) | + 0.093 (2.4) |
| Over 4 (102)–5½ (140), incl | + 0.125 (3.2) | + 0.125 (3.2) |
| Over 5½ (140) | + 0.188 (4.8) | + 0.188 (4.8) |

TABLE 5 Diameter Tolerances for Rod and Bar

| Diameter or Distance Be- tween Parallel Surfaces, in. (mm) | Tolerances, Plus ^A and Minus, ^A in. (mm) | |
|---|--|---|
| | Rounds | Squares, Rectangles, Hexagons, Octagons |
| All Alloys Except as Noted Below | | |
| Up to 4 (102), excl | 0.005 (0.13) | 0.016 (0.41) |
| 4 (102)–5 (127), incl | 0.008 (0.20) | 0.016 (0.41) |
| Over 5 (127) | 0.016 (0.41) | 0.016 (0.41) |
| Copper Alloy UNS Nos. C86200, C86300, C86500, C87850, C95200, C95300, C95400, C95500, C95800, C95900, and C96400 | | |
| Up to 3 (76.2), incl | 0.010 (0.25) | 0.020 (0.51) |
| Over 3 (76.2)–4 (102), incl | 0.015 (0.38) | 0.020 (0.51) |
| Over 4 (102)–5½ (140), incl | 0.020 (0.51) | 0.020 (0.51) |
| Over 5½ (140) | 0.025 (0.64) | 0.025 (0.64) |

^A When tolerances are specified as all plus or all minus, double the values given.

remainder and may be taken as the difference between the sum of all elements analyzed and 100 %. When all named elements in Table 10 are analyzed, their sum shall be as specified in Table 11.

7.3 It is recognized that residual elements may be present in cast copper-base alloys. Analysis shall be made for residual elements only when specified in the purchase order.

8. Mechanical Property Requirements

8.1 Reference should be made to Table 9 for minimum mechanical requirements.

8.2 Mechanical tests are required only when specified by the purchaser in the purchase order.

8.3 Exceptions to mechanical property requirements may be taken in the case of small diameter solids or castings having section thicknesses less than the ½-in. (12.7-mm) diameter of the standard tension test specimen. In these cases, mechanical property requirements shall be subject to agreement between the purchaser and the manufacturer. For suggested dimensions of substandard test bars, see Test Methods E 8, and E 8M.

9. ASME Requirements

9.1 When specified in the purchase order to meet *ASME Boiler and Pressure Vessel Code* requirements, continuous castings shall comply with the following: