



SLOVENSKI STANDARD
SIST EN 12735-2:2025

01-januar-2025

Baker in bakrove zlitine - Nevarjene okrogle bakrene cevi za hladilno in klimatsko tehniko - 2. del: Cevi za naprave in aparate

Copper and copper alloys - Seamless, round tubes for air conditioning and refrigeration - Part 2: Tubes for equipment

Kupfer und Kupferlegierungen - Nahtlose Rundrohre für die Kälte- und Klimatechnik - Teil 2: Rohre für Apparate

Cuivre et alliages de cuivre - Tubes ronds sans soudure pour l'air conditionné et la réfrigération - Partie 2: Tubes pour le matériel

Ta slovenski standard je istoveten z: EN 12735-2:2024

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Copper and copper alloys - Seamless, round tubes for air conditioning and refrigeration - Part 2: Tubes for equipment

Cuivre et alliages de cuivre - Tubes ronds sans soudure pour l'air conditionné et la réfrigération - Partie 2: Tubes pour le matériel

Kupfer und Kupferlegierungen - Nahtlose Rundrohre für die Kälte- und Klimatechnik - Teil 2: Rohre für Apparate

This European Standard was approved by CEN on 30 September 2024.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

Contents	Page
European foreword	4
Introduction	6
1 Scope.....	7
2 Normative references.....	7
3 Terms and definitions.....	8
4 Designations	9
4.1 Material	9
4.1.1 General.....	9
4.1.2 Symbol	9
4.1.3 Number	9
4.2 Material condition	9
4.3 Product	9
5 Ordering information.....	10
6 Requirements.....	11
6.1 Composition.....	11
6.2 Mechanical properties and grain size	11
6.3 Dimensions and tolerances for smooth tubes	12
6.3.1 General.....	12
6.3.2 Nominal dimensions	12
6.3.3 Tolerances on mean outside diameter	14
6.3.4 Tolerances on wall thickness	15
6.3.5 Tolerances on the mass for tubes supplied in coils.....	16
6.3.6 Tolerances on length for tubes supplied in straight lengths	16
6.3.7 Tolerances of form	17
6.4 Dimensions and tolerances for inner finned tubes	18
6.4.1 General.....	18
6.4.2 Dimensions for inner finned tubes.....	18
6.4.3 Tolerances on mean outside diameter	19
6.4.4 Tolerances on wall thickness	19
6.4.5 Tolerances on fin height, number of fins, shape of in and spiral pitch.....	19
6.4.6 Tolerances on mass for tubes supplied in coils	19
6.4.7 Tolerances on length for tubes supplied in straight lengths	19
6.4.8 Tolerances of form	19
6.5 Drift expanding.....	19
6.6 Freedom from defects	20
6.6.1 General.....	20
6.6.2 Straight tubes	20
6.6.3 Coiled tubes.....	20
6.7 Surface quality	21
7 Sampling.....	21
8 Test methods	21
8.1 Analysis	21
8.2 Tensile test.....	21

8.3	Hardness test.....	22
8.4	Estimation of average grain size	22
8.5	Drift expanding test.....	22
8.6	Carbon content test.....	22
8.7	Freedom from defects test.....	22
8.8	Retests	22
9	Certificate of compliance and inspection documentation	23
9.1	Certificate of compliance	23
9.2	Inspection documentation	23
10	Packaging, marking and form of delivery.....	23
10.1	Packaging and marking.....	23
10.2	Form of delivery.....	23
10.2.1	Coils	23
10.2.2	Straight lengths	24
	Annex A (normative) Freedom from defects test.....	25
	Annex ZA (informative) Relationship between this document and the essential requirements of Directive 2014/68/EU (Pressure Equipment Directive) aimed to be covered.....	27
	Bibliography	28

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EN 12735-2:2024 (E)

European foreword

This document (EN 12735-2:2024) has been prepared by Technical Committee CEN/TC 133 “Copper and copper alloys”, the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by May 2025 and conflicting national standards shall be withdrawn at the latest by May 2025.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 12735-2:2016.

EN 12735-2:2024 includes the following significant technical changes with respect to EN 12735-2:2016:

- a) NOTE in Scope modified;
- b) Normative references updated;
- c) Diameter added in Clause 5, Example 1 and Example 2;
- d) Table 1 modified;
- e) Conditions corrected in Table 3, footnote c;
- f) Tolerance on mean wall thickness in Table 5 (0,06 was 0,08) amended;
- g) Minimum diameter reduced to 3,97 in Table 8;
- h) 6.4.4 and 6.4.5 amended;
- i) 6.4.6, 6.4.7, 6.4.8 added;
- j) 6.5 and 6.6.1 amended;
- k) 8.4 amended;
- l) Coil mass range and nominal width range extended in Table 12;
- m) Annex ZA amended;
- n) Several editorial amendments.

This document has been prepared under a standardization request addressed to CEN by the European Commission. The Standing Committee of the EFTA States subsequently approves these requests for its Member States.

For the relationship with EU Legislation, see informative Annex ZA, which is an integral part of this document.

EN 12735, *Copper and copper alloys — Seamless, round tubes for air conditioning and refrigeration* is currently composed of the following parts:

- *Part 1: Tubes for piping systems*
- *Part 2: Tubes for equipment*

This is one of a series of European Standards for copper and copper alloy tubes. Other products are specified as follows:

- EN 1057, *Copper and copper alloys — Seamless, round copper tubes for water and gas in sanitary and heating applications*
- EN 12449, *Copper and copper alloys — Seamless, round tubes for general purposes*
- EN 12450, *Copper and copper alloys — Seamless, round copper capillary tubes*
- EN 12451, *Copper and copper alloys — Seamless, round tubes for heat exchangers*
- EN 12452, *Copper and copper alloys — Rolled, finned, seamless tubes for heat exchangers*
- EN 12735-1, *Copper and copper alloys — Seamless, round copper tubes for air conditioning and refrigeration — Part 1: Tubes for piping systems*
- EN 13348, *Copper and copper alloys — Seamless, round copper tubes for medical gases or vacuum*
- EN 13349, *Copper and copper alloys — Pre-insulated copper tubes with solid covering*
- EN 13600, *Copper and copper alloys — Seamless copper tubes for electrical purposes*

Any feedback and questions on this document should be directed to the users' national standards body. A complete listing of these bodies can be found on the CEN website.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.

EN 12735-2:2024 (E)**Introduction**

It is recommended that tubes manufactured in accordance with this document are certified as conforming to the requirements of this document based on continuing surveillance which should be coupled with an assessment of a supplier's quality management system.

NOTE It is advised to take appropriate precautions if applying insulating material because it could be detrimental to the copper tube.

For this harmonized supporting standard for materials, presumption of conformity to the Essential Requirements of the Directive is limited to technical data of the material in the standard and does not presume adequacy of the material to specific equipment. Consequently, the technical data stated in the material standard should be assessed against the design requirements of the specific equipment to verify that the essential requirements of the Pressure Equipment Directive (PED) are satisfied.

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1 Scope

This document specifies the requirements, sampling, test methods and conditions of delivery for seamless round copper tubes, smooth or inner finned, used for heat exchangers and their internal connecting pipes in the manufacturing of refrigeration and air conditioning equipment.

It is applicable to tubes with an outside diameter from 3,97 mm up to and including 219 mm.

NOTE The tubes are supplied in straight length or as coils.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 723:2009, *Copper and copper alloys — Combustion method for determination of the carbon content on the inner surface of copper tubes or fittings*

EN 764-5:2014, *Pressure equipment — Part 5: Inspection documentation of metallic materials and compliance with the material specification*

EN 1173:2008, *Copper and copper alloys — Material condition designation*

EN 1971-1:2019, *Copper and copper alloys — Eddy current test for measuring defects on seamless round copper and copper alloy tubes — Part 1: Test with an encircling test coil on the outer surface*

EN 1971-2:2019, *Copper and copper alloys — Eddy current test for measuring defects on seamless round copper and copper alloy tubes — Part 2: Test with an internal probe on the inner surface*

EN 10204:2004, *Metallic products — Types of inspection documents*

EN 16090:2019, *Copper and copper alloys — Estimation of average grain size by ultrasound*

EN 16117-2:2012, *Copper and copper alloys — Determination of copper content — Part 2: Electrolytic determination of copper in materials with copper content higher than 99,80 %*

EN ISO 2624:1995, *Copper and copper alloys — Estimation of average grain size (ISO 2624:1990)*

EN ISO 6507-1:2023, *Metallic materials — Vickers hardness test — Part 1: Test method (ISO 6507-1:2023)*

EN ISO 6892-1:2019, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature (ISO 6892-1:2019)*

EN ISO 8493:2004, *Metallic materials — Tube — Drift-expanding test (ISO 8493:1998)*

EN ISO/IEC 17050-1:2010, *Conformity assessment — Supplier's declaration of conformity — Part 1: General requirements (ISO/IEC 17050-1:2004, corrected version 2007-06-15)*

EN ISO/IEC 17050-2:2004, *Conformity assessment — Supplier's declaration of conformity — Part 2: Supporting documentation (ISO/IEC 17050-2:2004)*

ISO 4741:1984, *Copper and copper alloys — Determination of phosphorus content — Molybdovanadate spectrometric method*

EN 12735-2:2024 (E)

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp/>
- IEC Electropedia: available at <https://www.electropedia.org/>

3.1

seamless round copper tube

hollow semi-finished product, circular in cross-section, made of copper, having a uniform wall thickness, which at all stages of production has a continuous periphery

[SOURCE: EN 1057:2006+A1:2010, 3.1]

3.2

coil

winding in which the turns are either arranged into layers parallel to its axis such that successive turns in a given layer are next to one another (LWC, Level Wound Coil) or are spirally arranged (SWC, Spiral Wound Coil)

3.3

mean diameter

arithmetical mean of the maximum and minimum outside diameters through the same cross-section of the tube

[SOURCE: EN 1057:2006+A1:2010, 3.5]

3.4

deviation from circular form

difference between the maximum and minimum outside diameters measured at any one cross-section of the tube

[SOURCE: EN 1057:2006+A1:2010, 3.6]

3.5

deviation from concentricity

half of the difference between the maximum and minimum wall thicknesses at the same cross-section of the tube

[SOURCE: EN 1057:2006+A1:2010, 3.7]

3.6

production batch

definite quantity of products of the same form, the same material condition and the same cross-sectional dimensions manufactured during the same production sequence under uniform conditions

[SOURCE: EN 1057:2006+A1:2010, 3.8]

4 Designations

4.1 Material

4.1.1 General

The material is designated either by symbol or number (see 6.1).

4.1.2 Symbol

The material symbol designation is based on the designation system given in ISO 1190-1:1982.

4.1.3 Number

The material number designation is in accordance with the system given in EN 1412:2016.

4.2 Material condition

For the purposes of this document, the following designation, which is in accordance with the system given in EN 1173:2008, applies for the material condition (see Table 1):

R... Material condition designated by the minimum value of tensile strength requirement for the product with mandatory tensile strength and elongation requirements.

Y... Material condition designated by the minimum value of 0,2 % proof strength requirement for the product with mandatory 0,2 % proof strength, tensile strength, elongation and grain size requirements.

4.3 Product

The product designation provides a standardized pattern of designation from which a rapid and unequivocal description of a product is conveyed in communication. It provides mutual comprehension at the international level with regard to products which meet the requirements of the relevant European Standard.

The product designation is no substitute for the full content of the standard.

The product designation for products to this document shall consist of:

- denomination (Copper tube);
- number of this document (EN 12735-2);
- material condition designation (see Table 1);
- nominal cross-sectional dimensions in millimetres: outside diameter x wall thickness (see Table 2 and Table 9);
- inner surface type (the following designations shall be used as appropriate: **S** for smooth, **F** for finned).

The derivation of a product designation is shown in the following example.