



SLOVENSKI STANDARD
oSIST prEN 12735-2:2023
01-maj-2023

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: prEN 12735-2

ICS:

23.040.15	Cevi iz neželeznih kovin	Non-ferrous metal pipes
77.150.30	Bakreni izdelki	Copper products

oSIST prEN 12735-2:2023

en,fr,de

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

DRAFT
prEN 12735-2

March 2023

ICS 23.040.15

Will supersede EN 12735-2:2016

English Version

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

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This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 133.

If this draft becomes a European Standard, 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.

This draft European Standard was established by CEN 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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Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

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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	13
6.3.4 Tolerances on wall thickness	14
6.3.5 Tolerances on the mass for tubes supplied in coils.....	15
6.3.6 Tolerances on length for tubes supplied in straight lengths	15
6.3.7 Tolerances of form	16
6.4 Dimensions and tolerances for inner finned tubes	17
6.4.1 General.....	17
6.4.2 Dimensions for inner finned tubes.....	17
6.4.3 Tolerances on mean outside diameter	18
6.4.4 Tolerances on wall thickness	18
6.4.5 Tolerances on fin height, number of fins, shape of in and spiral pitch.....	18
6.4.6 Tolerances on mass for tubes supplied in coils	18
6.4.7 Tolerances on length for tubes supplied in straight lengths	18
6.4.8 Tolerances of form	18
6.5 Drift expanding.....	18
6.6 Freedom from defects	19
6.6.1 General.....	19
6.6.2 Straight tubes	19
6.6.3 Coiled tubes.....	19
6.7 Surface quality	20
7 Sampling.....	20
8 Test methods	20
8.1 Analysis	20
8.2 Tensile test.....	20

8.3	Hardness test.....	21
8.4	Estimation of average grain size	21
8.5	Drift expanding test.....	21
8.6	Carbon content test.....	21
8.7	Freedom from defects test.....	21
8.8	Retests	21
9	Declaration of conformity and inspection documentation	22
9.1	Declaration of conformity	22
9.2	Inspection documentation	22
10	Packaging, marking and form of delivery.....	22
10.1	Packaging and marking.....	22
10.2	Form of delivery.....	22
10.2.1	Coils	22
10.2.2	Straight lengths	23
A.1	Eddy current test	24
A.2	Hydrostatic test.....	25
A.3	Pneumatic test.....	25
	Bibliography	27

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prEN 12735-2:2023 (E)**European foreword**

This document (prEN 12735-2:2023) has been prepared by Technical Committee CEN/TC 133 “Copper and copper alloys”, the secretariat of which is held by DIN.

This document is currently submitted to the CEN Enquiry.

This document will supersede EN 12735-2:2016.

prEN 12735-2:2023 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 given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s) / Regulation(s).

For relationship with EU Directive(s) / Regulation(s), 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* consists of two 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*

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prEN 12735-2:2023 (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 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 6507-1:2018, *Metallic materials - Vickers hardness test - Part 1: Test method (ISO 6507-1:2018)*

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*

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, Definition 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, Definition 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, Definition 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, Definition 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, Definition 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.

EXAMPLE Copper tube conforming to this document, in material condition Y040 (light annealed), nominal outside diameter 16 mm, nominal wall thickness 0,5 mm, smooth inner surface (S), will be designated as follows: