



Designation: B432 – 09a

Standard Specification for Copper and Copper Alloy Clad Steel Plate¹

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1. Scope*

1.1 This specification establishes the requirements for plate of a carbon steel or low-alloy steel base to which is integrally and continuously bonded on one or both sides a layer of copper or copper-base alloy. The material is generally intended for pressure vessel use but may be used in other structural applications where corrosion resistance or conductivity of the alloy is of prime importance.

1.2 *Units*—The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

2. Referenced Documents

2.1 ASTM Standards:²

[A6/A6M Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling](#)

[A20/A20M Specification for General Requirements for Steel Plates for Pressure Vessels](#)

[A370 Test Methods and Definitions for Mechanical Testing of Steel Products](#)

[A578/A578M Specification for Straight-Beam Ultrasonic Examination of Rolled Steel Plates for Special Applications](#)

[B96/B96M Specification for Copper-Silicon Alloy Plate, Sheet, Strip, and Rolled Bar for General Purposes and Pressure Vessels](#)

[B152/B152M Specification for Copper Sheet, Strip, Plate, and Rolled Bar](#)

[B171/B171M Specification for Copper-Alloy Plate and Sheet for Pressure Vessels, Condensers, and Heat Exchangers](#)

[B846 Terminology for Copper and Copper Alloys](#)

[E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)

2.2 ASME Code:

[Boiler and Pressure Vessel Code, Section VIII³](#)

[Boiler and Pressure Vessel Code, Section IX, Welding Qualifications³](#)

3. Terminology

3.1 For definitions of terms related to copper and copper alloys, refer to Terminology [B846](#).

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *base metal (backing steel)*, *n*—component to which the cladding metal is applied, usually the greater percentage of the composite plate and usually consisting of carbon or low-alloy steel.

3.2.2 *blind flange*, *n*—same as a cover.

3.2.3 *bonding*, *n*—adhesion of one surface to another without the use of an adhesive as a bonding agent.

3.2.4 *cladding metal*, *n*—the copper or copper-base alloy component of the composite plate.

3.2.5 *cover*, *n*—a component with similar features to a tubesheet which is used as a closure and which typically requires surface machining over part of the face while maintaining minimum specified minimum thickness.

3.2.6 *double-clad*, *n*—material is considered as double-clad when both sides of the steel base metal are covered with copper cladding.

3.2.7 *interface*, *n*—of the clad product, is that region of the thickness in which the product transitions from essentially 100 % base metal to 100 % cladding metal, also referred to as the bond or bondzone.

3.2.8 *integrally and continuously bonded*, *adv*—a condition in which the cladding metal and base metal are brought together to form a metallurgical bond at essentially the entire interface of the two metals by means other than those processes that do not produce a homogeneous composite plate.

¹ This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.01 on Plate, Sheet, and Strip.

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² 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.

³ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

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

3.2.9 *plate, n*—the term plate as used in this specification applies to material 0.188 in. (4.78 mm) and over in thickness, and over 10 in. (254 mm) in width.

3.2.10 *single-clad, n*—material is considered as single-clad when only one side of the steel base metal is covered with copper cladding.

3.2.11 *tubesheet, n*—the term tubesheet as used in this specification applies to a clad plate, which is used in a heat exchanger to separate the tubeside and shell side components. Typically, but not necessarily, tubesheets are round, relatively thick, and require that the cladding and/or base be machined flat over part or all of the face while maintaining specified minimum thicknesses.

4. Ordering Information

4.1 Include the following information when placing orders for product under this specification, as applicable:

- 4.1.1 ASTM designation and year of issue,
- 4.1.2 Dimensions, including the thickness of the cladding alloy and the backing steel, or of the total composite plate, and if more or less restrictive thickness tolerances apply,
- 4.1.3 Quantity—total weight or number of pieces of each size.
- 4.1.4 Cladding metal specification (see Section 6),
- 4.1.5 Base metal specification (see Section 6),
- 4.1.6 Advise if the part is to be used as a tubesheet, cover, or blind flange,
- 4.1.7 Restrictions, if required, on repair by welding (see Section 11).

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

- 4.2.1 Shear testing requirements if any (see Sections 7 and 8).
- 4.2.2 Certification,
- 4.2.3 Test Report,
- 4.2.4 Options presented in the Supplementary Requirements Section of this specification,
- 4.2.5 Additions to the specification or special requirements,
- 4.2.6 The purchaser is referred to the listed supplementary requirements in this specification and to the detailed requirements in Specifications A20/A20M or A6/A6M as applicable. If the requirements of this specification are in conflict with the requirements of Specification A20/A20M or A6/A6M, the requirements of this specification shall prevail.

5. Materials and Manufacture

5.1 Materials:

5.1.1 The base metal shall be manufactured in accordance with all applicable requirements of the base metal specifications (see 4.1.5).

5.1.2 The cladding metal shall be manufactured in accordance with all applicable requirements of the cladding metal specifications (see 4.1.4).

5.2 Manufacture:

5.2.1 The cladding metal shall be bonded to the base metal by any cladding operation that will produce a clad product which will conform to the requirements of this specification.

Cladding methods are, but not limited to, explosion bonding, roll bonding, and weld overlay.

5.2.2 The cladding metal may be fabricated from multiple sheets or plates by edge butt welding prior to the cladding operation.

5.2.3 The cladding thickness may consist of multiple layers of the cladding metal.

5.3 *Heat Treatment*—Unless otherwise specified or agreed between the purchaser and the manufacturer, all heat treatments shall be performed as needed in the cladding operation to assure the following:

- 5.3.1 The cladding metal conforms to the applicable requirements of the cladding metal specification.
- 5.3.2 The base metal conforms to the applicable requirements of the base metal specification, and
- 5.3.3 The clad bond exhibits optimum resistance to disbonding during common fabrication processes.

6. Chemical Composition

6.1 The clad plate shall conform to any combination of base metal and cladding metal as described in 6.2 and 6.3, and as agreed upon between the purchaser and the manufacturer.

6.2 *Base Metal*—The base metal may be carbon steel or low-alloy steel conforming to the ASTM specifications for steels for either pressure vessels or general structural applications, or other, as agreed upon by the purchaser and manufacturer. The base metal shall conform to the chemical requirements of the specification to which it is ordered.

6.3 *Cladding Metal*—The copper or copper-base alloy cladding metal specified shall conform to the requirements as to chemical composition prescribed in the respective cladding metal Specifications B96/B96M, B152/B152M, or B171/B171M, or other copper-base alloy specification as agreed upon by the purchaser and manufacturer.

7. Mechanical Requirements

7.1 Tensile Property Requirements :

- 7.1.1 Tensile tests shall be performed on the base metal only.
- 7.1.2 Tensile tests shall conform to the requirements of the Base Metal Specification.

8. Performance Requirements

8.1 Bond Strength Requirements :

8.1.1 Shear Strength Test:

8.1.1.1 When specified in the contract or purchase order, the minimum shear strength of the interface shall be 12 000 psi (84 MPa). The shear test shall be made in the manner indicated in Fig. 1. The shear test is not applicable when the specified minimum cladding thickness is 0.075 in. (1.9 mm) or less.

8.1.2 Alternate Bond Strength Test:

8.1.2.1 As an alternative to the shear strength test provided in 8.1.1 or when agreed upon by the purchaser and the manufacturer, three bend tests shall be made with the alloy cladding in compression to determine the quality of the bond. These bend tests shall be made using 1.5 in (38 mm) wide by full thickness specimens and shall be bent through an angle of

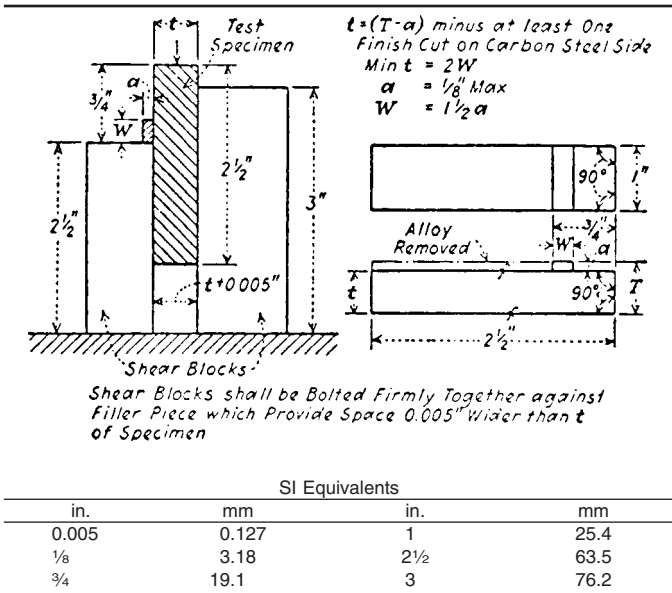


FIG. 1 Test Specimen and Method of Making Shear Test of Clad Plate

180° to the bend diameters provided for in either Specification A6/A6M or Specification A20/A20M, in Appendix X4 or equivalent, as applicable. At least two of the three tests shall show not more than 50 % separation on both edges of the bent portion. Greater separation shall be cause for rejection. The bond strength bend test is generally not recommended for cladding thicknesses where the shear test is applicable.

8.2 Additional mechanical tests may be performed. See Supplementary Requirements.

9. Dimensions and Permissible Variations

9.1 Unless otherwise specified herein, permissible variations except for thickness shall be in accordance with Specifications A20/A20M or A6/A6M as applicable based on the base metal specification.

9.2 Minimum thickness of the alloy cladding metal and of the backing steel, or of the total composite plate, shall be as required by purchase order documents when ordered to minimum thickness.

9.3 Permissible variation in thickness when ordered to nominal thicknesses shall be 0.01 in. (0.25 mm) under each for backing steel or total composite, and 0.03 in. (0.76 mm) under for the alloy cladding.

9.4 Permissible variations for excess thickness of the total composite shall be the greater of 0.125 in. (3.2 mm) or 10 % of the total composite thickness ordered and may occur in either backing steel, cladding, or both, provided the minimum for each is met.

9.5 When the product is specified for use as tubesheets, covers, or blind flanges in the ordering information, the flatness tolerances of Table 1 shall apply, otherwise flatness shall be in accordance with Specifications A20/A20M or A6/A6M as applicable based on the base metal specification.

9.6 When the product is specified for use as tubesheets, covers, or blind flanges in the ordering information and a machined edge condition is specified, the diameter tolerances of Table 2 shall apply.

9.7 More restrictive or less restrictive permissible variations may be agreed upon by the purchaser and the manufacturer.

10. Workmanship, Finish and Appearance

10.1 The product shall be free of defects, but blemishes of a nature that do not interfere with the intended application are acceptable.

10.2 Unless otherwise specified, the clad surface may be supplied as-rolled, ground, blasted (descaled by means of sand, grit, shot or wire followed by pickling), or 100 % conditioned.

10.3 The cladding metal shall be integrally and continuously bonded to the base metal.

11. Sampling

11.1 The lot size, portion size, and selection of sample pieces shall be taken according to the base metal specifications.

11.2 Chemical Analysis—A sample for chemical analysis from the finished clad product shall not be taken unless specified in the contract or purchase order. The copper sheet or strip that is used as the cladding for this product is to be sampled and tested as prescribed in its product specification (See 6.3). The steel plate that is used as the base metal in this product is to be sampled and tested as prescribed in either Specifications A20/A20M or A6/A6M.

12. Number of Tests and Retests

12.1 Test:

12.1.1 Chemical Analysis—When specified in the contract or purchase order that a chemical analysis shall be performed on the cladding metal, the base metal, or both, the tests shall be

TABLE 1 Flatness Tolerances for Tube Sheets, Clad One Side Only^A

Total Thickness, in. (mm)	Maximum Deviation from True Flatness ^B for a Given Diameter, Width, or Length, in. (mm)				
	To 48 (1219)	Over 48 (1219) to 72 (1829)	Over 72 (1829) to 96 (2438)	Over 96 (2438) to 120 (3048)	Over 120 (3048)
To 2 1/2 (63.5)	1/8 (3.18)	1/8 (3.18)	3/16 (4.76)	1/4 (6.35)	1/2 (12.7)
Over 2 1/2 (63.5) to 4 (102)	1/8 (3.18)	1/8 (3.18)	1/4 (6.35)	1/2 (12.7)	1/2 (12.7)
Over 4 (102) to 6 (152)	1/8 (3.18)	1/4 (6.35)	3/8 (9.52)	1/2 (12.7)	1/2 (12.7)
Over 6 (152) to 8 (203)	3/16 (4.76)	3/8 (9.52)	1/2 (12.7)	1/2 (12.7)	1/2 (12.7)

^A Two side clads by special arrangement.

^B Measured distance from an imaginary plane representing the best fit to the part surface. Measurement methods may include, but are not limited to, planar grids, planar radial wheels, setup on a machining table, or laser surveying.