



Designation: ~~B171/B171M-09~~ Designation: **B171/B171M – 09a**

Standard Specification for Copper-Alloy Plate and Sheet for Pressure Vessels, Condensers, and Heat Exchangers¹

This standard is issued under the fixed designation B171/B171M; 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 copper-alloy plate, sheet, and circles cut from plate and sheet for pressure vessels, condensers, and heat exchangers. The following alloys are covered:

Copper Alloy	Previously Used Designation
C36500	Leaded Muntz Metal
C44300	Admiralty, Arsenical
C44400	Admiralty, Antimonial
C44500	Admiralty, Phosphorized
C46400	Naval Brass, Uninhibited
C46500	Naval Brass, Arsenical
C61300	Aluminum Bronze
C61400	Aluminum Bronze D
C63000	10 % Aluminum-Nickel Bronze
C63200	9 % Aluminum-Nickel Bronze
C70600	90-10 Copper Nickel
C70620	90-10 Copper Nickel -(modified for welding)
C71500	70-30 Copper Nickel
C71520	70-30 Copper Nickel-(modified for welding)
C72200	

1.2 Units—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 standard.

2. Referenced Documents

2.1 ASTM Standards:³

- B248 Specification for General Requirements for Wrought Copper and Copper-Alloy Plate, Sheet, Strip, and Rolled Bar
- B248M Specification for General Requirements for Wrought Copper and Copper-Alloy Plate, Sheet, Strip, and Rolled Bar (Metric)
- B601 Classification for Temper Designations for Copper and Copper Alloys Wrought and Cast
- B846 Terminology for Copper and Copper Alloys
- E8 Test Methods for Tension Testing of Metallic Materials
- E8M Test Methods for Tension Testing of Metallic Materials [Metric]
- E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- E54 Test Methods for Chemical Analysis of Special Brasses and Bronzes
- E62 Test Methods for Chemical Analysis of Copper and Copper Alloys (Photometric Methods)
- E255 Practice for Sampling Copper and Copper Alloys for the Determination of Chemical Composition
- E478 Test Methods for Chemical Analysis of Copper Alloys
- E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

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.

Current edition approved April 1, 2009. Published May November 2009. Originally approved in 1942. Last previous edition approved in 2004 2009 as B171/B171M-04¹-B171/B171M-09. DOI: 10.1520/B0171_B0171M-09.

² For ASME Boiler and Pressure Vessel Code applications, see related Specification SB-171 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.

3. Terminology

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

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 Whether inch-pound or SI units are applicable (see 1.2),
- 4.1.3 Copper Alloy UNS. No. (see Section 6, Table 1),
- 4.1.4 Whether the alloy ordered will be used in applications requiring it to be welded (see Table 1, footnotes B and C for UNS Nos. C61300 and C72200, respectively, and UNS Nos. C70620 and C71520 in place of UNS Nos. C70600 and C71500),
- 4.1.5 Whether plate is to be machined (see 9.1.3),
- 4.1.6 How tolerance is specified (Table 2 Footnote A),
- 4.1.7 Certification, if required (Section 17),
- 4.1.8 Weight (total for each size),
- 4.1.9 Mill test report, if required (Section 18),
- 4.1.10 Special marking, if required (Section 19), and
- 4.1.11 Whether 0.2 yield offset strength is required.

5. Materials and Manufacture

5.1 *Material*—The material and manufacture shall be cast cake of the Copper Alloy UNS No. specified in the purchase order and shall be of such shape and soundness so as to be suitable for processing into the final product.

5.2 *Manufacture*—The product shall be manufactured by hot rolling or forging and finished by such cold working and annealing as may be necessary to achieve the required dimensions and properties.

6. Chemical Composition

6.1 The materials shall conform to the chemical compositional requirements specified in Table 1 for the copper alloy UNS designations specified in the ordering information..

6.2 These composition limits do not preclude the presence of other elements. Limits for unnamed elements may be established by agreement between manufacturer or supplier and purchaser.

6.3 For the alloys listed below, depending on analytical methodology, either copper or zinc, respectively, may be taken as the difference between the sum of all the elements analyzed and 100 %. When all the elements in Table 1 are analyzed their sum shall be as shown below:

TABLE 1 Chemical Requirements

Copper Alloy UNS No. ^A	Composition, % max (Unless Shown as a Range)									
	Copper, incl Silver	Tin	Nickel, incl Cobalt	Manganese, max	Lead	Iron	Zinc	Aluminum	Chromium	Other Named Elements
C36500	58.0-61.0	0.25	0.25-0.7	0.15	remainder
C44300	70.0-73.0	0.8-1.2	0.07	0.06	remainder	0.02-0.06 As
C44400	70.0-73.0	0.8-1.2	0.07	0.06	remainder	0.02-0.10 Sb
C44500	70.0-73.0	0.8-1.2	0.07	0.06	remainder	0.02-0.10 P
C46400	59.0-62.0	0.50-1.0	0.20	0.10	remainder
C46500	59.0-62.0	0.50-1.0	0.20	0.10	remainder	0.02-0.06 As
C61300 ^B	remainder	0.20-0.50	0.15	0.20	0.01	2.0-3.0	0.10 ^C	6.0-7.5	...	0.10 Si 0.015 P
C61400	remainder	1.0	0.01	1.5-3.5	0.20	6.0-8.0	...	0.015 P
C63000	remainder	0.20	4.0-5.5	1.5	...	2.0-4.0	0.30	9.0-11.0	...	0.25 Si
C63200	remainder	...	4.0-4.8 ^D	1.2-2.0	0.02	3.5-4.3 ^D	...	8.7-9.5	...	0.10 Si
C70600	remainder	...	9.0-11.0	1.0	0.05 ^C	1.0-1.8	1.0 ^C
C70620	86.5 min	...	9.0-11.0	1.0	0.02	1.0-1.8	0.50	0.05 C 0.02 P 0.02 S
C71500	remainder	...	29.0-33.0	1.0	0.05 ^C	0.40-1.0	1.0 ^C	0.05 C
C71520	65.0 min	...	29.0-33.0	1.0	0.02	0.40-1.0	0.50	0.02 P 0.02 S
C72200	remainder	...	15.0-18.0	1.0	0.05 ^C	0.50-1.0	1.0 ^C	...	0.03-0.70	0.03 Si 0.03 Ti ^C

^A Designation established in accordance with Practice E527.

^B When the product is for subsequent welding applications, and is so specified by the purchaser, chromium shall be 0.05 % max, cadmium 0.05 % max, zirconium 0.05 % max and zinc 0.05 % max.

^C When the product is for subsequent welding applications, and is so specified by the purchaser, zinc shall be 0.50 % max, lead 0.02 % max, phosphorus 0.02 % max, sulfur 0.02 % max, and carbon 0.05 % max.

^D Iron content shall not exceed the nickel content.



TABLE 2 Thickness Tolerances

Table with 5 columns: Thickness, in. [mm]; 36 in. [1000 mm] or Under, incl; Over 36 to 60 in. [1000 to 1500 mm], incl; Over 60 to 96 in. [1500 to 2500 mm], incl; Over 96 to 132 in. [2500 to 3500 mm], incl. Rows list thickness ranges and their corresponding tolerances.

A When tolerances are specified as all plus or all minus, double the values given.
B See 9.1.2 for specific alloys with a difference tolerance.

Table with 2 columns: Copper Alloy UNS No. and Copper Plus Named Elements, % min. Lists alloys C36500 through C46500 and their respective copper content percentages.

6.3.1 For the alloys listed below, copper may be taken as the difference between the sum of all the elements and 100 %. When all of the elements in Table 1 are analyzed, their sum shall be as shown below:

Table with 2 columns: Copper Alloy UNS No. and Copper Plus Named Elements, % min. Lists alloys C61300 through C72200 and their respective copper content percentages.

7. Temper

7.1 Tempers available under this specification, and as described in Classification B601, are As Hot Rolled (M20) and Hot Rolled and Annealed (O25) as given in, are As Hot Rolled (M20), Hot Rolled and Annealed (O25), Hot Forged and Annealed (O20), and As Hot Forged-Air Cooled (M10) as given in Table 3.

7.1.1 Products manufactured for ASME Boiler and Pressure Vessel Code applications must be certified to the O25 or O20 temper.

TABLE 3 Tensile Requirements—M20, M10, O20, and O25 Tempers

Table with 6 columns: Copper Alloy UNS No., Thickness, in. [mm], Tensile Strength, min, ksi^A [MPa], Yield Strength,^B min, ksi^A [MPa], Yield Strength^C 0.2 % Offset, min, ksi^A [MPa], and Elongation in 2 in. [50.0 mm], min, %. Rows list alloys and their tensile properties for different thicknesses.

A ksi = 1000 psi.

B Yield strength is determined as the stress producing an elongation of 0.5 % or under load, that is 0.01 in. [0.254 mm] in a gage length of 2 in. [50.0 mm].

C See 4.1.9.

7.1.2 Products manufactured for other than *ASME Boiler and Pressure Vessel Code* applications may be produced in either the M20, M10, O20, or O25 temper.

8. Mechanical Property Requirements

8.1 Tensile Strength Requirements :

8.1.1 Product furnished under this specification shall conform to the tensile property requirements prescribed in Table 3, when tested in accordance with Test Method E8 [E8M][E8M].

9. Dimensions, Mass, and Permissible Variations

9.1 Thickness:

9.1.1 The thickness tolerances for plates of Copper Alloy UNS Nos. C36500, C44300, C44400, C44500, C46400, and C46500 shall be as prescribed in Table 2.

9.1.2 The thickness tolerances for plates of Copper Alloy UNS Nos. C61300, C61400, C63000, C63200, C71500, C70620, C71520, and C72200 shall be 25 % greater than those prescribed in Table 2.

9.1.3 If plates are machined, the thickness tolerances shall apply to the machined portion only.

9.1.4 Closer thickness tolerances than those prescribed in Table 2 can be furnished by surface machining. This is a special product and is subject to agreement between the manufacturer and the purchaser. This special product shall apply only when specified by the purchaser in the contract or order.

9.1.5 Unless otherwise agreed to by the manufacturer and the purchaser, the thickness of plate to this specification shall be determined by measuring along the length of the plate up to a distance of 7 in. [180 mm] from the edge.

9.2 *Diameters, Lengths, or Widths*—The diameters, lengths, or widths of plates shall be not less than those specified. The diameters, lengths, or widths of plates may exceed those specified by the amounts shown in Table 4.

NOTE 1—For the purpose of determining conformance with the dimensional requirements prescribed in this specification, any measured value outside the specified limiting values for any dimension may be cause for rejection.

9.3 *Flatness*—The flatness tolerances of individual plates shall not exceed those prescribed in Table 5. The tolerances shown are the total permissible variations for plates as ordered, and do not apply to the 7-in. [180-mm] marginal area at the edge of the plate. Inspection for flatness shall be made by placing the plate on a flat surfaced table with the side marked “Straight Side” up, applying a 72-in. [2-m] straightedge when the size permits, or a shorter one equal to the dimensions to be inspected, and measuring the depth of arc between the straightedge and the plate.

9.4 *Plate and Sheet Lot Weight for Pressure Vessels*—When plate or sheet of Copper Alloy UNS Nos. C70600, C70620, C71500, C71520, or C72200 are ordered for pressure vessels exclusively, the maximum lot weight restriction in Table 6 shall apply in addition to the thickness tolerance requirement of Table 2. The weight of each lot of five or more plates or sheets shall not exceed the nominal weight by more than the amount prescribed in Table 6. Plate and sheet of lots of less than five shall be governed solely by the thickness tolerances of Table 2. For purposes of calculating weights, the densities used shall be as listed in Table 7.

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.

11. Sampling

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

11.1.1 *Lot Size*—10 000 lbs [4550 kg] or less material of the same mill form, alloy, temper, and thickness, subject to inspection at one time.

11.1.2 *Portion Size*—Four individual sample pieces shall be selected as representative of each lot. If the lot consists of less than four pieces, samples shall be selected so as to be representative of each piece.

11.2 *Chemical Analysis*—A sample for chemical analysis shall be taken and prepared in accordance with Practice E255. Drillings, millings, and so forth, shall be taken in approximately equal weight from each of the sample pieces selected in accordance with 11.1.2 and combined into one composite sample. The minimum weight of the composite sample that is to be divided into three equal parts shall be 150 g.

TABLE 4 Diameter, Length, or Width Tolerances

Diameter, Length, or Width in. [mm]	Permissible Excess in Diameter, Length, or Width, in. [mm]
36 [1000] or under	$\frac{3}{64}$ [1.2]
Over 36 to 60 [1000 to 1500], incl	$\frac{1}{16}$ [1.6]
Over 60 to 96 [1500 to 2500], incl	$\frac{3}{32}$ [2.4]
Over 96 to 132 [2500 to 3500], incl	$\frac{7}{64}$ [2.8]