Designation: B111/B111M – 16

Standard Specification for Copper and Copper-Alloy Seamless Condenser Tubes and Ferrule Stock[1]

This standard is issued under the fixed designation B111/B111M; 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 U.S. Department of Defense.

1. Scope*

1.1 This specification[2] establishes the requirements for seamless tube and ferrule stock of copper and various copper alloys up to 3⅛ in. [80 mm] inclusive, in diameter, for use in surface condensers, evaporators, and heat exchangers. The following coppers and copper alloys are specified:[3]

Copper or Copper Alloy UNS No.	Previously Used Designation	Description
C10100	OFE	Oxygen-free electronic
C10200	OF[A]	Oxygen-free without residual deoxidants
C10300	...	Oxygen-free, extra low phosphorus
C10800	...	Oxygen-free, low phosphorus
C12000	DLP[A]	Phosphorized, low residual phosphorus
C12200	DHP[A]	Phosphorized, high residual phosphorus
C14200	DPA[A]	Phosphorized, arsenical
C19200	...	Phosphorized, 1 % iron
C23000	...	Red Brass
C28000	...	Muntz Metal
C44300	...	Admiralty Metals, B, C, and D
C44400	...	...
C44500	...	...
C60800	...	Aluminum Bronze
C61300	...	...
C61400	...	Aluminum Bronze, D
C68700	...	Aluminum Brass, B
C70400	...	95-5 Copper-Nickel
C70600	...	90-10 Copper-Nickel
C70620	...	90-10 Copper-Nickel—Welding Grade
C71000	...	80-20 Copper-Nickel
C71500	...	70-30 Copper-Nickel
C71520	...	70-30 Copper-Nickel—Welding Grade
C71640	...	Copper-nickel-iron-manganese
C72200	...	...

[A] Designations listed in Classification B224.

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.

1.3 The following safety hazards caveat pertains only to the test methods portion, Section 19, of this specification: *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.* (**Warning—**Mercury has been designated by many regulatory agencies as a hazardous substance that can cause serious medical issues. Mercury, or its vapor, has been demonstrated to be hazardous to health and corrosive to materials. Caution should be taken when handling mercury and mercury containing products. See the applicable product Safety Data Sheet (SDS) for additional information. Users should be aware that selling mercury and/or mercury containing products in your state or country may be prohibited by law.)

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:*[4]

B153 Test Method for Expansion (Pin Test) of Copper and Copper-Alloy Pipe and Tubing

B154 Test Method for Mercurous Nitrate Test for Copper Alloys

B170 Specification for Oxygen-Free Electrolytic Copper—Refinery Shapes

B224 Classification of Coppers

B846 Terminology for Copper and Copper Alloys

B858 Test Method for Ammonia Vapor Test for Determining Susceptibility to Stress Corrosion Cracking in Copper Alloys

[1] This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.04 on Pipe and Tube.

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[2] For *ASME Boiler and Pressure Vessel Code* applications, see related Specification SB-111 in Section II of the Code.

[3] The UNS system for copper and copper alloys (see Practice E527) 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.

[4] 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**

B968/B968M Test Method for Flattening of Copper and Copper-Alloy Pipe and Tube
E8/E8M Test Methods for Tension Testing of Metallic Materials
E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
E53 Test Method for Determination of Copper in Unalloyed Copper by Gravimetry
E54 Test Methods for Chemical Analysis of Special Brasses and Bronzes (Withdrawn 2002)[5]
E62 Test Methods for Chemical Analysis of Copper and Copper Alloys (Photometric Methods) (Withdrawn 2010)[5]
E75 Test Methods for Chemical Analysis of Copper-Nickel and Copper-Nickel-Zinc Alloys (Withdrawn 2010)[5]
E76 Test Methods for Chemical Analysis of Nickel-Copper Alloys (Withdrawn 2003)[5]
E112 Test Methods for Determining Average Grain Size
E118 Test Methods for Chemical Analysis of Copper-Chromium Alloys (Withdrawn 2010)[5]
E243 Practice for Electromagnetic (Eddy Current) Examination of Copper and Copper-Alloy Tubes
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)
E2575 Test Method for Determination of Oxygen in Copper and Copper Alloys

3. Terminology

3.1 *Definitions:*

3.1.1 For definitions of terms relating to copper and copper alloys, refer to Terminology B846.

4. Ordering Information

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

4.1.1 ASTM Designation and year of issue;

4.1.2 Copper or Copper Alloy UNS No. Designation (see Table 1);

4.1.3 Temper (Section 7);

4.1.4 Dimensions, outside diameter, and wall thickness, whether minimum or nominal (Section 14);

4.1.5 How furnished (tube or ferrule stock);

4.1.6 Quantity—total weight or total length or number of pieces of each size; and

4.1.7 Intended application.

4.2 The following options are available but may not be included unless specified at the time of placing of the order when required:

4.2.1 Tension Test per ASME Boiler and Pressure Vessel Code (see Section 8).

4.2.2 Hydrostatic or pneumatic test as an alternative to eddy current test (Section 13).

4.2.3 If the cut ends of the tubes do not need to be deburred (Section 15).

4.2.4 If the product is to be subsequently welded (Table 1, Footnotes G and H).

4.2.5 Residual Stress Test—Ammonia Vapor Test or Mercurous Nitrate Test (Section 12).

4.2.6 For Ammonia Vapor Test, risk level (pH value) if other than 10.

4.2.7 Heat identification or traceability details.

4.2.8 Certification (Section 23).

4.2.9 Test Report (Section 24).

4.2.10 If a subsequent thermal treatment after straightening is required (Section 7).

4.2.11 If product is purchased for agencies of the U.S. Government (see Supplementary Requirements section of this specification for additional requirements, if required).

5. Materials and Manufacture

5.1 *Materials:*

5.1.1 The material of manufacture shall be a form of such purity and soundness as to be suitable for processing into the products prescribed herein.

5.1.2 When specified in the contract or purchase order that heat identification or traceability is required, the purchaser shall specify the details desired.[6]

5.2 *Manufacture:*

5.2.1 The product shall be manufactured by such hot-working, cold-working, annealing, straightening, trimming, and other processes as to produce a uniform seamless tube in the finished product.

5.2.2 The product shall be hot- or cold-worked to the finished size, and subsequently annealed, when required, to meet the temper properties specified.

6. Chemical Composition

6.1 The product shall conform to the chemical composition requirements specified in Table 1.

6.2 These composition limits do not preclude the presence of other elements. By agreement between the manufacturer and purchaser, limits may be established and analysis required for unnamed elements.

6.2.1 *Copper Alloy UNS No. C19200*—Copper is the difference between the sum results of all the elements determined and 100 %. When all the elements in Table 1 are determined, their sum shall be 99.8 % minimum.

6.2.2 For alloys in which copper is listed as "remainder," copper is the difference between the sum results of all the elements determined and 100 %. When all elements in Table 1 are determined, the sum of the results shall be as follows:

[5] The last approved version of this historical standard is referenced on www.astm.org.

[6] Due to the discontinuous nature of the processing of castings into wrought products, it is not always practical to identify a specific casting analysis with a specific quantity of finished material.

TABLE 1 Chemical Requirements

Copper or Copper Alloy UNS No.	Composition, %												
	Copper	Tin	Aluminum	Nickel, incl Cobalt	Lead, max	Iron	Zinc	Manganese	Arsenic	Antimony	Phosphorus	Chromium	Other Named Elements
C10100	99.99 min[A]	0.0002 max	. . .	0.0010 max[B]	0.0005 max	0.0010 max	0.0001 max	0.00005 max	0.0005 max	0.0004 max	0.0003 max	0.0001 max	[C]
C10200[C]	99.95 min[D]	. . .	. . .	. . .	. . .	. . .	. . .	. . .	. . .	. . .	. . .	. . .	[C]
C10300	99.95 min[D]	. . .	. . .	. . .	. . .	. . .	. . .	. . .	. . .	. . .	0.001–0.005	. . .	. . .
C10800	99.95 min[D]	. . .	. . .	. . .	. . .	. . .	. . .	. . .	. . .	. . .	0.005–0.012	. . .	. . .
C12000[E]	99.90 min[D]	. . .	. . .	. . .	. . .	. . .	. . .	. . .	. . .	. . .	0.004–0.012	. . .	. . .
C12200	99.9 min[D]	. . .	. . .	. . .	. . .	. . .	. . .	. . .	. . .	. . .	0.015–0.040	. . .	. . .
C14200	99.4 min[D]	. . .	. . .	. . .	. . .	. . .	. . .	. . .	0.15–0.50	. . .	0.015–0.040	. . .	. . .
C19200	98.5 min	. . .	. . .	. . .	. . .	0.8–1.2	0.20 max	. . .	. . .	. . .	0.01–0.04	. . .	. . .
C23000	84.0–86.0	. . .	. . .	. . .	0.05	0.05 max	remainder	. . .	. . .	. . .	. . .	. . .	. . .
C28000	59.0–63.0	. . .	. . .	. . .	0.09	0.07 max	remainder	. . .	. . .	. . .	. . .	. . .	. . .
C44300	70.0–73.0	0.9–1.2	. . .	. . .	0.07	0.06 max	remainder	. . .	0.02–0.06	. . .	. . .	. . .	. . .
C44400	70.0–73.0	0.9–1.2	. . .	. . .	0.07	0.06 max	remainder	. . .	. . .	0.02–0.10	. . .	. . .	. . .
C44500	70.0–73.0	0.9–1.2	. . .	. . .	0.07	0.06 max	remainder	. . .	. . .	. . .	0.02–0.10	. . .	. . .
C60800	remainder[D]	. . .	5.0–6.5	. . .	0.10	0.10 max	. . .	. . .	0.02–0.35	. . .	. . .	. . .	. . .
C61300	remainder[D]	0.20–0.50	6.0–7.5	0.15 max	0.01	2.0–3.0	0.10 max	0.20 max	. . .	. . .	0.015 max	. . .	[F, G]
C61400	remainder[D]	. . .	6.0–8.0	. . .	0.01	1.5–3.5	0.20 max	1.0 max	. . .	. . .	0.015 max	. . .	. . .
C68700	76.0–79.0[D]	. . .	1.8–2.5	. . .	0.07	0.06 max	remainder	. . .	0.02–0.06	. . .	. . .	. . .	. . .
C70400	remainder[D]	. . .	. . .	4.8–6.2	0.05	1.3–1.7	1.0 max	0.30–0.8	. . .	. . .	. . .	. . .	. . .
C70600	remainder[D]	. . .	. . .	9.0–11.0	0.05	1.0–1.8	1.0 max	1.0 max	. . .	. . .	. . .	. . .	. . .
C70620	86.5 min[D]	. . .	. . .	9.0-11.0	0.02	1.0-1.8	0.50 max	1.0 max	. . .	. . .	0.02 max	. . .	C.05 max S.02 max
C71000	remainder[D]	. . .	. . .	19.0–23.0	0.05[H]	0.50–1.0	1.0 max[H]	1.0 max	. . .	. . .	[H]	. . .	[H]
C71500	remainder[D]	. . .	. . .	29.0–33.0	0.05	0.40–1.0	1.0 max	1.0 max	. . .	. . .	. . .	. . .	. . .
C71520	65.0 min[D]	. . .	. . .	29.0-33.0	0.02	0.40-1.0	0.50 max	1.0 max	. . .	. . .	0.02 max	. . .	C.05 max S.02 max
C71640	remainder[D]	. . .	. . .	29.0–32.0	0.05[H]	1.7–2.3	1.0 max[H]	1.5–2.5	. . .	. . .	[H]	. . .	C.06 max S.03 max[H]
C72200	remainder[D]	. . .	. . .	15.0–18.0	0.05[H]	0.50–1.0	1.0 max[H]	1.0 max	. . .	. . .	[H]	0.30–0.70	Si.03 max Ti.03 max[H]

[A] This value is exclusive of silver and shall be determined by difference of "impurity total" from 100 %. "Impurity total" is defined as the sum of sulfur, silver, lead, tin, bismuth, arsenic, antimony, iron, nickel, mercury, zinc, phosphorus, selenium, tellurium, manganese, cadmium, and oxygen present in the sample.

[B] Not including Cobalt.

[C] Additional impurity maximums in percent for alloy C10100 shall be: bismuth 0.0001, cadmium 0.0001, oxygen 0.0005, selenium 0.0003, sulfur 0.0015, tellurium 0.0002, mercury 0.0001. For C10200, oxygen should be 0.0010 max.

[D] Copper (including silver).

[E] This includes oxygen-free Cu which contains P in an amount agreed upon.

[F] Silicon shall be 0.10 % max.

[G] 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, zinc 0.05 % max, and zirconium 0.05 % max.

[H] When the product is for subsequent welding applications, and 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.

Copper Alloy UNS No.	Copper Plus Named Elements, % min
C60800	99.5
C61300	99.8
C61400	99.5
C70400	99.5
C70600 & C70620	99.5
C71000	99.5
C71500 & C71520	99.5
C71640	99.5
C72200	99.8

6.2.3 For alloys in which zinc is listed as the remainder, either copper or zinc may be taken as the difference between the sum of all the elements determined and 100 %. When all elements in Table 1 are determined, the sum of the results shall be as follows:

Copper Alloy UNS No.	Copper Plus Named Elements, % min
C23000	99.8
C28000	99.7
C44300	99.6
C44400	99.6
C44500	99.6
C68700	99.5

7. Temper

7.1 Tubes shall be furnished in the temper designations identified in Tables 2 and 3.

7.1.1 Drawn tempers H55 and H80.

7.1.2 Annealed temper O61.

7.1.3 Drawn and stress-relieved temper HR50.

7.2 Tubes for ferrule stock shall be annealed sufficiently to be fully recrystallized.

7.3 *Optional Post-Straightening Thermal Treatment*—Some tubes, when subjected to aggressive environments, may have the potential for stress-corrosion cracking failure due to the residual stresses induced during straightening processing. For such applications, it is suggested that tubes of Copper Alloy UNS Nos. C23000, C28000, C44300, C44400, C44500, C60800, C61300, C61400, and C68700 be subjected to a stress-relieving thermal treatment subsequent to straightening. If required, this must be specified on the purchase order or contract. Tolerances for roundness and length, and the condition of straightness, for tube so ordered, shall meet the requirements agreed upon by the manufacturer and the purchaser.

8. Mechanical Properties

8.1 Material specified to meet the requirements of the *ASME Boiler and Pressure Vessel Code* shall have tensile properties as prescribed in Table 2 or Table 3.

9. Grain Size for Annealed Tempers

9.1 Grain size shall be the standard requirement for all product in the annealed (O61) temper.

9.1.1 Other than Copper Alloy UNS No. C19200, acceptance or rejection for all annealed products shall depend only on average grain size of the test specimen within the limits of 0.010 to 0.045 mm taken from each of two sample portions, and each specimen shall be within the limits prescribed herein when determined in accordance with Test Methods E112.

TABLE 2 Tensile Requirements—Inch-Pound Values

NOTE 1—See Table 3 for tensile requirements—SI values.

Copper or Copper Alloy UNS No.	Temper Designation		Tensile Strength, min ksi[A]	Yield Strength,[B] min ksi[A]	Elongation in 2 in., min %
	Code	Name			
C10100, C10200, C10300, C10800, C12000, C12200, C14200	H55	light-drawn	36	30	. . .
C10100, C10200, C10300, C10800, C12000, C12200, C14200	H80	hard-drawn	45	40	. . .
C19200	H55	light-drawn	40	35	. . .
C19200	H80	hard-drawn	48	43	. . .
C19200	O61	annealed	38	12	. . .
C23000	O61	annealed	40	12	. . .
C28000	O61	annealed	50	20	. . .
C44300, C44400, C44500	O61	annealed	45	15	. . .
C60800	O61	annealed	50	19	. . .
C61300, C61400	O61	annealed	70	30	. . .
C68700	O61	annealed	50	18	. . .
C70400	O61	annealed	38	12	. . .
C70400	H55	light-drawn	40	30	. . .
C70600, C70620	O61	annealed	40	15	. . .
C70600, C70620	H55	light-drawn	45	35	. . .
C71000	O61	annealed	45	16	. . .
C71500, C71520	O61	annealed	52	18	. . .
C71500, C71520					
Wall thicknesses up to 0.048 in., incl	HR50	drawn and stress-relieved	72	50	12
Wall thicknesses over 0.048 in.	HR50	drawn and stress-relieved	72	50	15
C71640	O61	annealed	63	25	. . .
C71640	HR50	drawn and stress relieved	81	58	. . .
C72200	O61	annealed	45	16	. . .
C72200	H55	light-drawn	50	45	. . .

[A] ksi = 1000 psi.

[B] At 0.5 % extension under load.

TABLE 3 Tensile Requirements—SI Values

NOTE 1—See Table 2 for tensile requirements—inch-pound values.

Copper or Copper Alloy UNS No.	Temper Designation		Tensile Strength, min MPa	Yield Strength,[A] min MPa	Elongation in 50 mm, min %
	Code	Name			
C10100, C10200, C10300, C10800, C12000, C12200, C14200	H55	light-drawn	250	205	. . .
C10100, C10200, C10300, C10800, C12000, C12200, C14200	H80	hard-drawn	310	275	. . .
C19200	H55	light-drawn	275	240	. . .
C19200	H80	hard-drawn	330	295	. . .
C19200	O61	annealed	260	85	. . .
C23000	O61	annealed	275	85	. . .
C28000	O61	annealed	345	140	. . .
C44300, C44400, C44500	O61	annealed	310	105	. . .
C60800	O61	annealed	345	130	. . .
C61300, C61400	O61	annealed	480	205	. . .
C68700	O61	annealed	345	125	. . .
C70400	O61	annealed	260	85	. . .
C70400	H55	light-drawn	275	205	. . .
C70600, C70620	O61	annealed	275	105	. . .
C70600, C70620	H55	light-drawn	310	240	. . .
C71000	O61	annealed	310	110	. . .
C71500, C71520	O61	annealed	360	125	. . .
C71500, C71520:					
Wall thicknesses up to 1.2 mm incl	HR50	drawn and stress-relieved	495	345	12
Wall thicknesses over 1.2 mm.	HR50	drawn and stress-relieved	495	345	15
C71640	O61	annealed	435	170	. . .
C71640	HR50	drawn and stress relieved	560	400	. . .
C72200	O61	annealed	310	110	. . .
C72200	H55	light-drawn	345	310	. . .

[A] At 0.5 % extension under load.

10. Performance Requirements

10.1 *Expansion Test:*

10.1.1 Tube specimens selected for test shall withstand the expansion shown in Table 4 when expanded in accordance with Test Method B153. The expanded tube shall show no cracking or rupture visible to the unaided eye.

10.2 Hard-drawn tubes not end annealed are not subject to this test. When tubes are specified end annealed, this test is required and shall be performed on the annealed ends of the sampled tubes.

10.3 Tubes for ferrule stock are not subject to the expansion test.

TABLE 4 Expansion Requirements

Temper Designation		Copper or Copper Alloy UNS No.	Expansion of Tube Outside Diameter, in Percent of Original Outside Diameter
Code	Name		
O61	annealed	C19200	30
		C23000	20
		C28000	15
		C44300, C44400, C44500	20
		C60800	20
		C61300, C61400	20
		C68700	20
		C70400	30
		C70600, C70620	30
		C71000	30
		C71500, C71520	30
		C71640	30
		C72200	30
H55	light-drawn	C10100, C10200, C10300, C10800, C12000, C12200	20
		C14200	20
		C19200	20
		C70400	20
		C70600, C70620	20
		C72200	20
HR50	drawn and stress relieved	C71500, C71520	20
		C71640	20
. . .	hard-drawn and end annealed	C10100, C10200, C10300, C10800, C12000, C12200, C14200	30

11. Flattening Test

11.1 *Test Method*—Each test specimen shall be inspected per Test Method B968/B968M.

11.2 During inspection, the flattened areas of the test-specimen shall be free of defects, but blemishes of a nature that do not interfere with the intended application are acceptable.

11.3 Tubes for ferrule stock are not subject to flattening test.

12. Residual Stress Test

12.1 A residual stress test, when specified in the purchase order, is required only for Copper Alloy UNS Nos. C23000, C28000, C44300, C44400, C44500, C60800, C61300, C61400, and C68700 and when not supplied in an annealed temper.

12.2 Unless otherwise specified, the producer shall have the option of testing the product to either the mercurous nitrate test, Test Method B154, or the ammonia vapor test, Test Method B858, as prescribed below.

12.2.1 *Mercurous Nitrate Test:*

12.2.1.1 **Warning—**Mercury is a definite health hazard and therefore equipment for the detection and removal of mercury vapor produced in volatilization is recommended. The use of rubber gloves in testing is advisable.

12.2.1.2 The test specimens, cut 6 in. [150 mm] in length, shall withstand without cracking, an immersion in the standard mercurous nitrate solution prescribed in Test Method B154. The test specimen shall include the finished tube end.

12.2.2 *Ammonia Vapor Test:*

12.2.2.1 The test specimens, cut 6 in. [150 mm] in length, shall withstand without cracking, the ammonia vapor test as prescribed in Test Method B858. For the purposes of this specification, unless otherwise agreed between purchaser and supplier, the risk level identified in the Annex of Method B858, shall be specified as risk level (pH value) of 10.

13. Nondestructive Testing

13.1 Each tube shall be subjected to the eddy-current test in 13.1.1. Tubes may be tested in the final drawn, annealed, or heat-treated temper or in the drawn temper before the final anneal or heat treatment unless otherwise agreed upon by the supplier and the purchaser. The purchaser may specify either of the tests in 13.1.2 or 13.1.3 as an alternative to the eddy-current test.

13.1.1 *Eddy-Current Test*—Each tube shall be passed through an eddy-current testing unit adjusted to provide information on the suitability of the tube for the intended application. Testing shall follow the procedures of Practice E243.

13.1.1.1 The depth of the round-bottom transverse notches or the diameters of the drilled holes in the calibrating tube used to adjust the sensitivity of the test unit are shown in Tables 5 and 6, and Tables 7 and 8, respectively. Notches of less depth and smaller diameter drilled holes are acceptable to meet this requirement.

13.1.1.2 Tubes that do not actuate the signaling device of the eddy-current tester shall be considered to conform to the requirements of this test. Tubes causing irrelevant signals because of moisture, soil, and like effects may be reconditioned and retested. Such tubes, when retested to the original test parameters, shall be considered to conform if they do not cause output signals beyond the acceptable limits. Tubes causing irrelevant signals because of visible and identifiable handling marks may be retested by the hydrostatic test prescribed in 13.1.2, or the pneumatic test prescribed in 13.1.3. Tubes meeting requirements of either test shall be considered to conform if the tube dimensions are within the prescribed limits, unless otherwise agreed upon between the manufacturer and the purchaser.

13.1.2 *Hydrostatic Test*—Each tube shall stand, without showing evidence of leakage, an internal hydrostatic pressure

TABLE 5 Notch Depth—Inch-Pound Values

NOTE 1—See Table 6 for notch depth—SI values.

Tube Wall Thickness, in.	Tube Outside Diameter, in.		
	Over 1/4 to 3/4, incl	Over 3/4 to 1 1/4, incl	Over 1 1/4 to 3 1/8, incl
Over 0.017–0.032	0.005	0.006	0.007
Incl 0.032–0.049	0.006	0.006	0.0075
Incl 0.049–0.083	0.007	0.0075	0.008
Incl 0.083–0.109	0.0075	0.0085	0.0095
Incl 0.109–0.120	0.009	0.009	0.011

TABLE 6 Notch Depth—SI Values

NOTE 1—See Table 5 for notch depth—inch-pound values.

Tube Wall Thickness, mm	Tube Outside Diameter, mm		
	Over 6 to 19, incl	Over 19 to 32, incl	Over 32 to 80, incl
Over 0.4–0.8	0.13	0.15	0.18
Incl 0.8–1.3	0.15	0.15	0.19
Incl 1.3–2.1	0.18	0.19	0.20
Incl 2.1–2.8	0.19	0.22	0.24
Incl 2.8–3.0	0.23	0.23	0.28

TABLE 7 Diameter of Drilled Holes—Inch-Pound Values

NOTE 1—See Table 8 for diameter of drilled holes—SI values.

Tube Outside Diameter, in.	Diameter of Drilled Holes, in.	Drill No.
1/4 –3/4 , incl	0.025	72
Over 3/4 –1, incl	0.031	68
Over 1–1 1/4, incl	0.036	64
Over 1 1/4 –1 1/2 , incl	0.042	58
Over 1 1/2 –1 3/4 , incl	0.046	56
Over 1 3/4 –2, incl	0.052	55

TABLE 8 Diameter of Drilled Holes—SI Values

NOTE 1—See Table 7 for diameter of drilled holes—inch-pound values.

Tube Outside Diameter, mm	Diameter of Drilled Holes, mm	Drill No.
6.0–19.0, incl	0.65	72
Over 19.0–25.4, incl	0.80	68
Over 25.4–31.8, incl	0.92	64
Over 31.8–38.1, incl	1.1	58
Over 38.1–44.4, incl	1.2	56
Over 44.4–50.8, incl	1.3	55