



Designation: B280 – 18

Standard Specification for Seamless Copper Tube for Air Conditioning and Refrigeration Field Service¹

This standard is issued under the fixed designation B280; 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 establishes the requirements for seamless copper tube intended for use in the connection, repairs, or alternations of air conditioning or refrigeration units in the field.

NOTE 1—Fittings used for soldered or brazed connections in air conditioning and refrigeration systems are described in ASME Standard B16.22.

NOTE 2—The assembly of copper tubular systems by soldering is described in Practice B828.

NOTE 3—Solders for joining copper tubular systems are described in Specification B32. The requirements for acceptable fluxes for these systems are described in Specification B813.

1.2 The tube shall be produced from the following coppers, and the manufacturer has the option to supply any one of them, unless otherwise specified:

Copper UNS No.	Previously Used Designation	Description
C10200	OF	Oxygen free without residual deoxidants
C12000	DLP	Phosphorus deoxidized, low residual phosphorus
C12200	DHP	Phosphorus deoxidized, high residual phosphorus

1.3 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.

1.4 The following hazard statement pertains only to the test method described in 18.2.4 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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

- 2.1 *ASTM Standards:*²
- B32 Specification for Solder Metal
 - B153 Test Method for Expansion (Pin Test) of Copper and Copper-Alloy Pipe and Tubing
 - B577 Test Methods for Detection of Cuprous Oxide (Hydrogen Embrittlement Susceptibility) in Copper
 - B601 Classification for Temper Designations for Copper and Copper Alloys—Wrought and Cast
 - B813 Specification for Liquid and Paste Fluxes for Soldering of Copper and Copper Alloy Tube
 - B828 Practice for Making Capillary Joints by Soldering of Copper and Copper Alloy Tube and Fittings
 - B900 Practice for Packaging of Copper and Copper Alloy Mill Products for U.S. Government Agencies
 - E3 Guide for Preparation of Metallographic Specimens
 - 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
 - E62 Test Methods for Chemical Analysis of Copper and Copper Alloys (Photometric Methods) (Withdrawn 2010)³
 - E112 Test Methods for Determining Average Grain Size
 - E243 Practice for Electromagnetic (Eddy Current) Examination of Copper and Copper-Alloy Tubes

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

E255 Practice for Sampling Copper and Copper Alloys for the Determination of Chemical Composition

2.2 ASME Standard:⁴

B1622 Wrought Copper and Copper Alloy Solder Joint Pressure Fittings

3. Terminology

3.1 Definitions:

3.1.1 *average diameter (for round tubes only), n*—the average of the maximum and minimum outside diameters, or maximum and minimum inside diameters, whichever is applicable, as determined at any one cross section of the tube.

3.1.2 *bright anneal, n*—a thermal treatment carried out in a controlled atmosphere so that surface oxidation is reduced to a minimum and the surface remains relatively bright.

3.1.3 *coil, n*—a length of the product wound into a series of connected turns. The unqualified term “coil” as applied to tube usually refers to a bunched coil.

3.1.3.1 *bunched, n*—a coil in which the turns are bunched and held together such that the cross section of the bunched turns is approximately circular.

3.1.3.2 *level or traverse wound, n*—a coil in which the turns are wound into layers parallel to the axis of the coil such that successive turns in a given layer are next to one another. (Sometimes called “helical coil.”)

3.1.3.3 *single layer flat, n*—a coil in which the product is spirally wound into a single disc-like layer. (Sometimes called “pancake coil” or “single layer spirally wound coil.”)

3.1.3.4 *double layer flat, n*—a coil in which the product is spirally wound into two connected disc-like layers such that one layer is on top of the other. (Sometimes called “double layer pancake coil” or “double layer spirally wound coil.”)

3.1.4 *lengths, n*—straight pieces of the product.

3.1.4.1 *specific, n*—straight lengths that are uniform in length, as specified, and subject to established length tolerances.

3.1.4.2 *standard, n*—uniform lengths recommended in a Simplified Practice Recommendation or established as a Commercial Standard.

3.1.5 *tube, seamless, n*—a tube produced with a continuous periphery in all stages of the operations.

3.1.5.1 *tube, air conditioning, n*—a seamless copper tube conforming to a standard series of sizes (Table 1) and to specified internal cleanliness requirements, normally furnished in drawn temper straight lengths with the ends capped or sealed.

3.1.5.2 *tube, refrigeration service, n*—a seamless copper tube conforming to a standard series of sizes (Table 2) and to special internal cleanliness and dehydration requirements, normally furnished in soft temper coils and with ends capped or sealed.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *capable of*—the test need not be performed by the producer of the material. However, if subsequent testing by the purchaser establishes that the material does not meet these requirements, the material shall be subject to rejection.

4. Ordering Information

4.1 Include this information for contracts or purchase orders for products furnished to this specification:

4.1.1 ASTM designation and year of issue (for example, B280 – 03),

4.1.2 Copper UNS No. (not necessary unless a specific copper is desired),

4.1.3 Dimensions; wall thickness, diameter, and so forth (Section 13),

4.1.4 How furnished: coils or straight lengths,

4.1.5 Temper (for example, O60 or H58),

4.1.6 Size (Tables 1 and 2),

4.1.7 Length (Section 13),

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

TABLE 1 Standard Dimensions and Weights, and Tolerances in Diameter and Wall Thickness for Straight Lengths

NOTE 1—Applicable to drawn temper tube only.

Standard Size, in.	Outside Diameter, in. (mm)	Wall Thickness, in. (mm)	Weight, lb/ft (kg/m)	Tolerances	
				Average ^A Outside Diameter, Plus and Minus, in. (mm)	Wall ^B Thickness, Plus and Minus, in. (mm)
1/4	0.250 (6.35)	0.025 (0.635)	0.068 (0.102)	0.001 (0.025)	0.0025 (0.06)
3/8	0.375 (9.52)	0.030 (0.762)	0.126 (0.187)	0.001 (0.025)	0.003 (0.08)
1/2	0.500 (12.7)	0.035 (0.889)	0.198 (0.295)	0.001 (0.025)	0.004 (0.10)
5/8	0.625 (15.9)	0.040 (1.02)	0.285 (0.424)	0.001 (0.025)	0.004 (0.10)
3/4	0.750 (19.1)	0.042 (1.07)	0.362 (0.539)	0.001 (0.025)	0.004 (0.10)
7/8	0.875 (22.3)	0.045 (1.14)	0.455 (0.677)	0.001 (0.025)	0.004 (0.10)
1 1/8	1.125 (28.6)	0.050 (1.27)	0.655 (0.975)	0.0015 (0.038)	0.004 (0.10)
1 3/8	1.375 (34.9)	0.055 (1.40)	0.884 (1.32)	0.0015 (0.038)	0.006 (0.15)
1 5/8	1.625 (41.3)	0.060 (1.52)	1.14 (1.70)	0.002 (0.051)	0.006 (0.15)
2 1/8	2.125 (54.0)	0.070 (1.78)	1.75 (2.60)	0.002 (0.051)	0.007 (0.18)
2 5/8	2.625 (66.7)	0.080 (2.03)	2.48 (3.69)	0.002 (0.051)	0.008 (0.20)
3 1/8	3.125 (79.4)	0.090 (2.29)	3.33 (4.96)	0.002 (0.051)	0.009 (0.23)
3 5/8	3.625 (92.1)	0.100 (2.54)	4.29 (6.38)	0.002 (0.051)	0.010 (0.25)
4 1/8	4.125 (105)	0.110 (2.79)	5.38 (8.01)	0.002 (0.051)	0.011 (0.28)

^A The average outside diameter of a tube is the average of the maximum and minimum outside diameters as determined at any one cross section of the tube.

^B The tolerances listed represent the maximum deviation at any point.

TABLE 2 Standard Dimensions and Weights, and Tolerances in Diameter and Wall Thickness for Coil Lengths

Standard Size, in.	Outside Diameter, in. (mm)	Wall Thickness, in. (mm)	Weight, lb/ft (kg/m)	Tolerances	
				Average ^A Outside Diameter, Plus and Minus, in. (mm)	Wall ^B Thickness, Plus and Minus, in. (mm)
1/8	0.125 (3.18)	0.030 (0.762)	0.0347 (0.0516)	0.002 (0.051)	0.003 (0.08)
3/16	0.187 (4.75)	0.030 (0.762)	0.0575 (0.0856)	0.002 (0.051)	0.003 (0.08)
1/4	0.250 (6.35)	0.030 (0.762)	0.0804 (0.120)	0.002 (0.051)	0.003 (0.08)
5/16	0.312 (7.92)	0.032 (0.813)	0.109 (0.162)	0.002 (0.051)	0.003 (0.08)
3/8	0.375 (9.52)	0.032 (0.813)	0.134 (0.199)	0.002 (0.051)	0.003 (0.08)
1/2	0.500 (12.7)	0.032 (0.813)	0.182 (0.271)	0.002 (0.051)	0.003 (0.08)
5/8	0.625 (15.9)	0.035 (0.889)	0.251 (0.373)	0.002 (0.051)	0.004 (0.11)
3/4	0.750 (19.1)	0.035 (0.889)	0.305 (0.454)	0.0025 (0.064)	0.004 (0.11)
7/8	0.875 (22.3)	0.045 (1.14)	0.455 (0.677)	0.003 (0.076)	0.004 (0.11)
1 1/8	1.125 (28.6)	0.050 (1.27)	0.655 (0.975)	0.0035 (0.089)	0.005 (0.13)
1 3/8	1.375 (34.9)	0.055 (1.40)	0.884 (1.32)	0.004 (0.10)	0.006 (0.15)
1 5/8	1.625 (41.3)	0.060 (1.52)	1.14 (1.70)	0.0045 (0.11)	0.006 (0.15)

^A The average outside diameter of a tube is the average of the maximum and minimum outside diameters as determined at any one cross section of the tube.

^B The tolerances listed represent the maximum deviation at any point.

- 4.1.8 Quantity (total pieces of each size and type),
- 4.1.9 When product purchased for agencies of the U.S. Government (Section 12).
- 4.2 The following options are available and shall be specified in the contract or purchase order when required:
 - 4.2.1 Tensile test (Section 9),
 - 4.2.2 Expansion test (Section 10.1),
 - 4.2.3 Cleanness test (Sections 10.2 and 18.2.4),
 - 4.2.4 Microscopical Examination for Hydrogen Embrittlement, Procedure B (10.3.2),
 - 4.2.5 Certification (Section 22), and
 - 4.2.6 Test report (Section 23).

5. Materials and Manufacture

5.1 *Materials*—The material of manufacture shall be billets, bars, or tube and shall be of such soundness as to be suitable for processing into the tubular products described.

5.2 Manufacture:

5.2.1 The tube shall be manufactured by such hot or cold working processes as to produce a homogeneous uniform wrought structure in the finished product. The tube shall be cold drawn to the finished size and wall thickness.

5.2.2 Coiled lengths specified O60, soft annealed temper, shall be bright annealed after coiling, then dehydrated, and capped, plugged, crimped, or otherwise closed at both ends so as to maintain the internal cleanness of the tubing under normal conditions of handling and storage.

5.2.3 Straight lengths specified H58 drawn general purpose shall be cleaned and capped, plugged, or otherwise closed at both ends so as to maintain the internal cleanness of the tubing under normal conditions of handling and storage.

6. Chemical Composition

6.1 The chemical composition shall conform to the chemical requirements in Table 3 for the specific type of copper.

6.1.1 These limits do not preclude the presence of other elements. When included in the contract or purchase order, and agreed upon by the manufacturer or supplier and the purchaser, limits shall be established and analysis required for unnamed elements.

TABLE 3 Chemical Composition—Weight %

Element	Copper UNS No.		
	C10200 ^A	C12000	C12200
Copper, ^B min	99.95	99.90	99.9
Phosphorus	...	0.004–0.012	0.015–0.040

^A Oxygen shall be 10 ppm max.

^B Copper + silver.

TABLE 4 Tensile Requirements

Form	Temper Designation		Tensile Strength, min		Elongation in 2 in. (50.8 mm), min, %
	Standard	Former	ksi ^A	MPa ^B	
Coiled lengths	O60	soft annealed	30	205	40
Straight lengths	H58	drawn general purpose	36	250	...

^A ksi = 1000 psi.

^B See Appendix X1.

7. Temper

7.1 Product under this specification shall be furnished in either O60 (soft annealed) or H58 (drawn general purpose) temper, as specified in the contract or purchase order and defined in Classification B601.

7.1.1 Coils are normally furnished in O60 temper and straight lengths in H58 temper.

8. Grain Size

8.1 Coiled lengths shall be furnished in the O60 temper and shall have a recrystallized grain size of 0.040 mm minimum when determined in accordance with Test Methods E112.

9. Tensile Requirements

9.1 The tube shall conform to the tensile requirements prescribed in Table 4.

9.2 Tensile tests need not be performed except when specified in the contract or purchase order.

10. Performance Requirements

10.1 *Expansion Test:*

10.1.1 Tube furnished in the O60 soft annealed temper shall be capable of being expanded in accordance with Test Method B153 to the following extent:

10.1.1.1 The expanded tube shall show no cracking or other defects visible to the unaided eye.

10.1.2 Unless specified in the contract or purchase order, this test is not required to be performed by the manufacturer.

10.2 *Cleanness of Interior Surface:*

10.2.1 When specified in the contract or purchase order, this test shall be performed by the manufacturer.

10.2.2 After evaporation of the cleaning solvent, the residue weight shall not exceed 0.0035 g/ft² (0.038 g/m²) of the interior surface. The maximum amount of residue in grams per tube shall not exceed the limits specified in Table 5 and Table 6.

10.3 *Microscopical Examination for Susceptibility to Hydrogen Embrittlement:*

10.3.1 Tubes furnished in Copper UNS No. C10200 and C12000 shall be essentially free of cuprous oxide as determined by Procedure A of Test Methods B577. When Copper UNS No. C12200 is supplied, examination is not required. In case of a dispute, Procedure C of Test Methods B577 shall be used as the referee method.

10.3.2 Tubes furnished in all coppers shall be capable of passing the embrittlement test specified in Procedure B of Test Methods B577. The actual performance of the test is not required unless specifically requested in the ordering document. In case of a dispute, Procedure C of Test Methods B577 shall be used as the referee method.

11. **Nondestructive Testing**

11.1 *Electromagnetic (Eddy-Current) Examination:*

11.1.1 Each straight length of tube up to and including 3 1/8 in. (79.4 mm) in outside diameter, shall be subjected to examination.

11.1.2 Tubes that do not actuate the signaling device on the testing unit, after having been adjusted to provide information on the suitability of the tube for the intended application, shall conform to the requirements of this test. Testing shall be in accordance with Practice E243.

TABLE 5 Interior Surface Residue Limits of Soft Coiled Lengths

Standard Size, in.	Wall Thickness, in. (mm)	Internal Area per Length of Tube, ft ² (m ²)		Residue ^A Limit per 50-ft (15.2-m) Coil, g
		1 ft (0.305 m)	50 ft (15.2 m)	
1/8	0.030 (0.762)	0.0171 (0.001 59)	0.85 (0.0795)	0.0030
3/16	0.030 (0.762)	0.0333 (0.003 09)	1.67 (0.155)	0.0058
1/4	0.030 (0.762)	0.0498 (0.004 67)	2.49 (0.234)	0.0087
5/16	0.032 (0.813)	0.0605 (0.006 04)	3.25 (0.302)	0.0114
3/8	0.032 (0.813)	0.0815 (0.007 57)	4.08 (0.379)	0.0143
1/2	0.032 (0.813)	0.1142 (0.0106)	5.71 (0.530)	0.0200
5/8	0.035 (0.889)	0.1453 (0.0135)	7.26 (0.675)	0.0254
3/4	0.035 (0.889)	0.1780 (0.0165)	8.90 (0.827)	0.0312
7/8	0.045 (1.14)	0.2055 (0.0191)	10.28 (0.955)	0.0360
1 1/8	0.050 (1.27)	0.2683 (0.0249)	13.42 (1.24)	0.0470
1 3/8	0.055 (1.40)	0.3312 (0.0308)	16.56 (1.54)	0.0580
1 5/8	0.060 (1.52)	0.3940 (0.0366)	19.70 (1.83)	0.0690

^A Residue limit 0.0035-g/ft² (0.038-g/m²) inside area.

TABLE 6 Interior Surface Residue Limits of Straight Lengths

Standard Size, in.	Wall Thickness, in. (mm)	Internal Area per Length of Tube, ft ² (m ²)		Residue ^A Limit per 20-ft (6.10-m) Straight Length, g
		1 ft (0.305 m)	20 ft (6.10 m)	
1/4	0.025(0.635)	0.0524(0.00486)	1.04(0.097)	0.0037
3/8	0.030 (0.762)	0.0824 (0.007 65)	1.65 (0.153)	0.0058
1/2	0.035 (0.889)	0.1126 (0.0105)	2.25 (0.210)	0.0079
5/8	0.040 (1.02)	0.1427 (0.0133)	2.85 (0.266)	0.0100
3/4	0.042 (1.07)	0.1744 (0.0162)	3.49 (0.324)	0.0122
7/8	0.045 (1.14)	0.2055 (0.0191)	4.11 (0.382)	0.0144
1 1/8	0.050 (1.27)	0.2683 (0.0249)	5.37 (0.498)	0.0188
1 3/8	0.055 (1.40)	0.3312 (0.0308)	6.62 (0.616)	0.0232
1 5/8	0.060 (1.52)	0.3940 (0.0366)	7.88 (0.732)	0.0276
2 1/8	0.070 (1.78)	0.5197 (0.0423)	10.39 (0.846)	0.0364
2 5/8	0.080 (2.03)	0.6453 (0.0599)	12.91 (1.120)	0.0453
3 1/8	0.090 (2.29)	0.7710 (0.0716)	15.42 (1.43)	0.0540
3 5/8	0.100 (2.54)	0.8966 (0.0833)	17.93 (1.67)	0.0628
4 1/8	0.110 (2.79)	1.0220 (0.0949)	20.44 (1.90)	0.0717

^A Residue limit 0.0035-g/ft² (0.038-g/m²) inside area.

11.1.3 Testing of coiled lengths shall be subject to negotiation between the manufacturer and the purchaser.

11.1.4 For tubes too large for the testing unit, the test method to be used shall be by agreement between the manufacturer and the purchaser.

12. **Purchases for Agencies of the U.S. Government**

12.1 When specified in the contract or purchase order, product purchased for agencies of the U.S. Government shall conform to the requirements stipulated in the Supplementary Requirements.

13. **Dimensions, Mass, and Permissible Variations**

13.1 The standard dimensions and weights per foot for the various nominal sizes are given in Table 1 and Table 2.

13.2 *Wall Thickness and Diameter*—The tolerances for wall thickness and diameter shall conform to the requirements specified in Table 2 and Table 1.

13.3 *Lengths and Tolerances:*

13.3.1 *Standard Lengths and Tolerances*—The standard length for coils shall be 50 ft (15.2 m). The length tolerances for 50-ft coils shall be +12 in. (305 mm) and –0 in. The standard length for straight lengths shall be 20 ft (6.1 m). The length tolerances for 20-ft lengths shall be +1 in. (25 mm) and –0 in.

13.3.2 Tubes supplied in other than standard lengths and tolerances shall be in accordance with requirements established by agreement between the manufacturer or supplier and the purchaser.

13.4 *Roundness*—For drawn unannealed tube in straight lengths, the roundness tolerance as specified in Table 7. The deviation from roundness is measured as the difference between major and minor diameters as determined at any one cross section of the tube. Roundness tolerance has not been established for annealed tube in straight lengths nor for tubes furnished in coils.

13.5 *Squareness of Cut*—For tube in straight lengths, the departure from squareness of the end of any tube shall not

TABLE 7 Roundness Tolerance

NOTE 1—Applicable to drawn unannealed straight length tube only.

<i>t/D</i> (Ratio of Wall Thickness to Nominal Outside Diameter)	Roundness Tolerance Percent of Nominal Outside Diameter (Expressed to Nearest 0.001 in. or 0.010 mm)
0.01 to 0.03, incl	1.5
Over 0.03 to 0.05, incl	1.0
Over 0.05 to 0.10, incl	0.8

exceed more than 0.010 in. (0.25 mm) for tube up to and including 5/8-in. (15.9-mm) standard size; and not more than 0.016 in./in. (0.016 mm/mm) of outside diameter, for tube larger than 5/8-in. standard size.

13.6 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 shall be subject to rejection.

14. Workmanship, Finish, and Appearance

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

15. Sampling

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

15.1.1 *Lot Size*—The lot size shall be 10 000 lbs (4500 kg) or fraction thereof.

15.1.2 *Portion Size*—Sample pieces shall be selected to be representative of the lot as shown in **Table 8**.

15.1.2.1 In the case of tube furnished in coils, a length sufficient for all necessary tests shall be cut from each coil selected for purpose of test. The remaining portion of these coils shall be included in the shipment, and the permissible variations in length on such coils shall be waived.

15.2 Chemical Composition:

15.2.1 The sample shall be taken in approximately equal weight from each piece selected in **15.1.2** and prepared in accordance with Practice **E255**. The minimum weight of the composite sample shall be 150 g.

15.2.2 Instead of sampling in accordance with Practice **E255**, the manufacturer shall have the option of sampling at the time castings are poured or from the semifinished product. When the composition is determined during the course of manufacture, sampling of the finished product is not required.

15.2.3 The number of samples taken during the course of manufacture shall be as follows:

TABLE 8 Sampling Schedule

NOTE 1—Each sample piece shall be taken from a separate tube.

Number of Pieces in Lot	Number of Sample Pieces to be Taken
1 to 50	1
51 to 200	2
201 to 1500	3
Over 1500	0.2 % of total number of pieces in the lot, but not to exceed 10 pieces

15.2.3.1 When samples are taken at the time the castings are poured, at least one sample shall be taken for each group of castings poured simultaneously from the same source of molten metal.

15.2.3.2 When samples are taken from the semifinished product, a sample shall be taken to represent each 10 000 lbs (4500 kg) or fraction thereof, except that not more than one sample per piece shall be required.

15.3 *Other Tests*—Specimens for all other tests shall be taken from two of the sample pieces selected in **15.1.2**. In the event only one sample piece is selected, all specimens shall be taken from that piece.

16. Number of Tests and Retests

16.1 Tests:

16.1.1 Chemical composition shall be reported as the average of results from at least two replicate determinations for each specified element and each determination must meet specification requirement.

16.1.2 Tensile and grain size shall be reported as the average of results from the specimens tested and all specimens must conform to specification requirements.

16.1.3 Specimens for all other tests must meet specification requirements.

16.2 Retest:

16.2.1 When test results obtained by the purchaser fail to conform with the product specification requirement(s), the manufacturer or supplier shall have the option to perform a retest.

16.2.2 Retesting shall be as directed in the product specification for the initial test except for the number of test specimens which shall be twice that normally required for the test. Test results for all specimens shall conform to the product specification requirement(s) in retest and failure to comply shall be cause for lot rejection.

17. Specimen Preparation

17.1 *Chemical Analysis*—Preparation of the analytical specimens for the determination of chemical composition shall be the responsibility of the reporting laboratory.

17.2 Grain Size and Microscopical Examination:

17.2.1 The specimen(s) shall be prepared in accordance with Guide **E3**.

17.2.2 The surface of the specimen shall approximate a radial longitudinal section of the tube.

17.3 *Tensile*—Tensile test specimens shall be of the full section of the tube and shall conform with the requirements of the Test Specimen section of Test Methods **E8/E8M**, unless the limitation of the testing machine precludes the use of such specimen in which case test specimen conforming to Type No. 1 of Fig. 13 in Test Methods **E8/E8M** shall be used.

17.4 *Electromagnetic (Eddy-Current) Test*—Tubes for this test require no special preparation.

17.5 *Expansion Test*— Test specimens shall be prepared in accordance with the Test Specimen section of Test Method **B153**.

18. Test Methods

18.1 Chemical Composition:

18.1.1 Chemical composition, in case of disagreement, shall be determined as follows:

Element	Test Method
Copper	E53
Phosphorus	E62

18.1.2 The test method(s) to be followed for the determination of element(s) required by contractual or purchase order agreement shall be as agreed upon between the manufacturer and the purchaser.

18.2 The tubes shall conform with the physical and mechanical properties and other requirements in this specification when tested in accordance with the following appropriate test method or practice:

Test	Test Method
Grain size	E3, E112
Tensile	E8/E8M
Expansion (pin test)	B153
Electromagnetic (eddy-current) test	E243
Cleanness	Section 18.2.4
Microscopical Examination, Procedure A	E3, B577
Microscopical Examination, Procedure B	E3, B577

18.2.1 Grain size, in case of dispute, shall be determined by the intercept method.

18.2.2 Tensile strength shall be determined in accordance with Test Methods E8/E8M.

18.2.2.1 Whenever test results are obtained from both full-size and machined specimens and they differ, the test results from the full-size specimens shall prevail.

18.2.2.2 Test results are not seriously affected by variations in speed of testing. It is not prohibited to use a considerable range of testing speeds, however, the rate of stressing to the yield strength shall not exceed 100 ksi/min. Above the yield strength the movement per minute of the testing machine head under load shall not exceed 0.5 in./in. of gage length (or distance between grips for full-section specimens).

18.2.3 Electromagnetic (Eddy-Current) Test—Each tube up to and including 3 1/8 in. (79.4 mm) in outside diameter, shall be subjected to an eddy-current test. Testing shall follow the procedures in Practice E243. Tubes shall be passed through an eddy-current test unit adjusted to provide information on the suitability of the tube for the intended application.

18.2.3.1 Either notch depth or drilled hole standards shall be used.

(a) Notch depth standards, rounded to the nearest 0.001 in. shall be 22 % of the wall thickness. The notch depth tolerance shall be ±0.0005 in.

(b) Drilled holes shall be drilled radially through the wall using a suitable drill jig that has a bushing to guide the drill, care being taken to avoid distortion of the tube while drilling. The diameter of the drilled hole shall be in accordance with the following and shall not vary by more than +0.001, -0.000 in. of the hole diameter specified.

Tube Outside Diameter, in.	Diameter of Drilled Holes, in.	Drill Number
1/4 to 3/4, incl	0.025	72
Over 3/4 to 1, incl	0.031	68
Over 1 to 1 1/4, incl	0.036	64
Over 1 1/4 to 1 1/2, incl	0.042	58
Over 1 1/2 to 1 3/4, incl	0.046	56
Over 1 3/4 to 2, incl	0.052	55

Tube Outside Diameter, mm	Diameter of Drilled Holes, mm	Drill Number
6.0 to 19.0, incl	0.635	72
Over 19.0 to 25, incl	0.785	68
Over 25 to 32, incl	0.915	64
Over 32 to 38, incl	1.07	58
Over 38 to 45, incl	1.17	56
Over 45 to 50, incl	1.322	55

18.2.3.2 Alternatively, at the option of the manufacturer, using speed-insensitive eddy-current units that are equipped to select a fraction of the maximum imbalance signal, the following percent maximum imbalance signals shall be used:

Standard Tube Size, in.	Maximum Percent Imbalance Signal Magnitude
Up to 3/8, incl	0.2
1/2 to 2, incl	0.3
Over 2 to 3, incl	0.4

Standard Tube Size, mm	Maximum Percent Imbalance Signal Magnitude
Up to 9, incl	0.2
13 to 50, incl	0.3
Over 50 to 76, incl	0.4

18.2.3.3 Tubes that do not activate the signaling device of the eddy-current tester shall be considered as conforming to the requirements of this test. At the option of the manufacturer, tubes with discontinuities indicated by the testing unit are not prohibited from being reexamined or retested to determine whether the discontinuity is cause for rejection. Signals that are found to have been caused by minor mechanical damage, soil or moisture, shall not be cause for rejection of the tubes provided the tube dimensions are still within prescribed limits and the tube is suitable for its intended application.

18.2.4 Cleanness Test:

18.2.4.1 In performing this test, care must be exercised to clean the outside surface of the end of the sample to be immersed in the solvent. The sample must be prepared in such a manner as to prevent the inclusion in the residue of copper chips or dust, resulting from cutting of the sample. Testing may be performed on less than full lengths, minimum of 5 ft (1524 mm), with a corresponding reduced maximum permissible residue limit based upon 0.0035 g/ft² (0.038 g/m²) of sample interior surface.

18.2.4.2 Cap, or plug, one end of the tube and fill with solvent to one eighth of its capacity. Cap, or plug, the filling end and roll tube on horizontal supports to thoroughly wash the inside surface. A minimum quantity of 100 mL shall be used for diameters up to 1/2 in. (12.7 mm) and shall be increased proportionally for the larger sizes.

18.2.4.3 Remove a cap, or plug, and pour the solvent into a suitable clean weighed container. With adequate exhaust, the solvent in the container shall be evaporated to near dryness at a low temperature on a hot plate or sand bath. (**Warning**—Overheating is likely to cause charring of the residue.)

18.2.4.4 Place the container in a drying oven with the temperature set at 105 ± 5 °C for 10 min to complete the drying process. When dry, remove the container, cool in a desiccator, and weigh.

18.2.4.5 A blank determination with the same volume of solvent as that poured from the cleaned tube shall be made.

18.2.4.6 Subtract the weight of the blank residue from the weight of the tube cleaning solvent residue. The corrected weight shall then be calculated to grams of residue per internal area of the tube as follows:

$$C = A - B \quad (1)$$

where:

- A = weight of blank container plus residue,
- B = net weight of empty container, and
- C = weight of solvent residue from blank, g.

$$G = [(E - F) - C]/D \quad (2)$$

where:

- E = weight of container plus residue from tube,
- F = net weight of container,
- C = weight of residue from solvent blank,
- D = internal area of sample tube, ft² (see [Tables 5 and 6](#)),
- G = weight of residue from tube, g.

19. Significance of Numerical Limits

19.1 For purposes of determining compliance with the specified limits for requirements of the properties listed in the following table, an observed value or a calculated value shall be rounded as indicated in accordance with the rounding method of Practice [E29](#):

Property	Rounded Unit for Observed or Calculated Value
Chemical composition	nearest unit in the last right-hand place of figures of the specified limit
Tensile strength	nearest ksi (5 MPa)
Elongation	nearest 1 %
Grain size:	
Up to 0.055 mm, incl	nearest multiple of 0.005 mm
Over 0.055 to 0.160 mm, incl	nearest 0.01 mm

20. Inspection

20.1 The manufacturer, or supplier, shall inspect and make tests necessary to verify the product furnished conforms to specification requirements.

20.2 Source inspection of the product by the purchaser shall be agreed upon between the manufacturer, or supplier, and the purchaser as part of the purchase order. In such case, the nature of the facilities needed to satisfy the inspector representing the purchaser that the product is being furnished in accordance with the specification shall be included in the agreement. All testing and inspections shall be conducted so as not to interfere unnecessarily with the operations of the works.

20.3 When mutually agreed upon, the manufacturer or supplier and purchaser shall conduct the final inspection simultaneously.

21. Rejection and Rehearing

21.1 Rejection:

21.1.1 Product that fails to conform to the requirements of the product specification when inspected or tested by the purchaser, or purchaser's agent, is subject to rejection.

21.1.2 Rejection shall be reported to the manufacturer or supplier promptly and in writing.

21.1.3 The manufacturer or supplier has the option of making a claim for a rehearing in case of dissatisfaction with the results of the test.

21.2 *Rehearing*—As a result of product rejection, the manufacturer or supplier has the option to make claim for retest to be conducted by the manufacturer or supplier and the purchaser. Samples of the rejected product shall be taken in accordance with the product specification and tested by both parties as directed in the product specification, or, alternatively, upon agreement by both parties, an independent laboratory shall be selected for the tests using the test methods prescribed in the product specification.

22. Certification

22.1 When specified in the contract or purchase order, the purchaser shall be furnished certification that samples representing each lot have been either tested or inspected as directed in this specification and requirements have been met.

23. Test Report (Mill)

23.1 When specified in the contract or purchase order, a report of test results shall be furnished.

24. Product Identification

24.1 *Coils*—The name or trademark of the manufacturer and ACR shall be permanently incised on each tube, 1/4-in. diameter and larger, at intervals not greater than 1 1/2 ft (0.455 m).

24.1.1 *UNS Copper Designation*—On annealed tubing produced from C10200 and C12000, the UNS copper designation shall be identified with ink or some other permanent mark that is repeated at intervals not greater than 3 ft.

24.2 Hard Straight Lengths:

24.2.1 The name or trademark of the manufacturer and the mark indicative of Type L or ACR shall be permanently incised on each tube at intervals not greater than 1 1/2 ft (0.455 m). Tube in the hard temper straight lengths shall be further identified throughout its length by means of a blue-colored legend repeated at intervals not greater than 3 ft (0.910 m). The legend shall include ACR, name or trademark of the manufacturer, or both, the outside diameter, and country of origin.

24.2.2 Such color marking is not applicable to tube furnished in coils.

NOTE 4—Other information is not prohibited from inclusion in either incise mark or ink marking at the option of the manufacturer.

24.2.3 *UNS Copper Designation*—For hard straight tubing produced from C10200 and C12000, the UNS copper designation shall be identified with blue ink at intervals not greater than 3 ft.

25. Packaging and Package Marking

25.1 *Packaging*—The product shall be separated by size, composition, and temper. The product shall be prepared for shipment in such a manner as to ensure acceptance by common carrier for transportation at the lowest rate applicable and to afford protection from normal hazards of transportation.

25.2 *Package Marking*—Each shipping unit shall be legibly marked with the purchase order number, UNS copper designation, temper, size, total length or piece count, or both, and name of the supplier. The specification number shall be shown when specified.

26. Keywords

26.1 air conditioning tube; field service tube; refrigeration tube; seamless copper tube; UNS No. C10200; UNS No. C12000; UNS No. C12200

SUPPLEMENTARY REQUIREMENTS

The following supplementary requirements shall apply only when specified by the purchaser in the inquiry, contract, or order, for agencies of the U.S. Government.

S1. Referenced Documents

S1.1 The following documents of the issue in effect on date of material purchase form a part of this specification to the extent referenced herein:

S1.1.1 *Federal Standards*:⁵

Fed. Std. No. 102 Preservation, Packaging and Packing Levels

Fed Std. No. 123 Marking for Shipment (Civil Agencies)

Fed Std. No. 185 Identification Marking of Copper and Copper-Base Alloy Mill Products

S1.2 *Military Standard*:⁵

MIL-STD-129 Marking for Shipment and Storage

S1.1.3 *Military Specification*:⁵

Practice **B900** Packaging of Copper and Copper Alloy Mill Products for U.S. Government Agencies

S2. Quality Assurance

S2.1 *Responsibility for Inspection*—Unless otherwise specified in the contract or purchase order, the manufacturer is responsible for the performance of all inspection and test requirements specified. Except as otherwise specified in the contract or purchase order, the manufacturer has the option to use his own or any other suitable facilities for the performance of the inspection and test requirements unless disapproved by

the purchaser at the time the order is placed. The purchaser shall have the right to perform any of the inspections or tests set forth when such inspections and tests are deemed necessary to ensure that the material conforms to prescribed requirements.

S3. Identification Marking

S3.1 All material shall be properly marked for identification in accordance with Fed. Std. No. 185 except that the ASTM specification number and the alloy number shall be used.

S4. Preparation for Delivery

S4.1 *Preservation, Packaging, Packing*:

S4.1.1 *Military Agencies*—The material shall be separated by size, composition, grade, or class and shall be preserved and packaged, Level A or C, packed, Level A, B, or C as specified in the contract or purchase order, in accordance with the requirements of Practice **B900**.

S4.1.2 *Civil Agencies*—The requirements of Fed. Std. No. 102 shall be referred for definitions of the various levels of packaging protection.

S4.2 *Marking*:

S4.2.1 *Military Agencies*—In addition to any special marking required by the contract or purchase order, marking for shipment shall be in accordance with MIL-STD-129.

S4.2.2 *Civil Agencies*—In addition to any special marking required by the contract or purchase order, marking for shipment shall be in accordance with Fed. Std. No. 123.

⁵ Available from DLA Document Services, Bldg. 4/D, 700 Robbins Ave., Philadelphia, PA 19111-5094, <http://quicksearch.dla.mil>.

APPENDIX**(Nonmandatory Information)****X1. METRIC EQUIVALENTS**

X1.1 The SI unit for strength properties now shown is in accordance with the International System of Units (SI). The derived SI unit for force is the newton (N), which is defined as that force which when applied to a body having a mass of one kilogram gives it an acceleration of one metre per second squared ($N = kg \cdot m/s^2$). The derived SI unit for pressure or

stress is the newton per square metre (N/m^2), which has been named the pascal (Pa) by the General Conference on Weights and Measures. Since $1 \text{ ksi} = 6\,894\,757 \text{ Pa}$, the metric equivalents are expressed as megapascal (MPa), which is the same as MN/m^2 and N/mm^2 .

SUMMARY OF CHANGES

Committee B05 has identified the location of selected changes to this standard since the last issue (B280 – 16) that may impact the use of this standard. (Approved March 1, 2018.)

(1) Revised language in Section 14 (Workmanship, Finish, and Appearance) to make it consistent with Guide B950.

Committee B05 has identified the location of selected changes to this standard since the last issue (B280 – 13) that may impact the use of this standard. (Approved April 1, 2016.)

(1) Edited 5.2.3 to agree with temper classification in Classification B601.

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