Standard Specification for Seamless Copper Water Tube¹

This standard is issued under the fixed designation B 88; 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 specification covers seamless copper water tube suitable for general plumbing, similar applications for the conveyance of fluids, and commonly used with soldered, flared, or compression-type fittings. The type of copper water tube suitable for any particular application is determined by the internal or external fluid pressure, by the installation and service conditions, and by local requirements. Means of joining or bending are also factors which affect the selection of the type of tube to be used.²

NOTE 1—Annealed tube is suitable for use with flared or compression fittings, and with solder-type fittings, provided rounding and sizing of the tube ends is performed where needed.

NOTE 2—Drawn temper tube is suitable for use with solder-type fittings. Types K and L tube, in the drawn temper, are suitable for use with certain types and sizes of compression fittings.

NOTE 3—A complete metric companion to Specification B 88 has been developed—B 88M; therefore, no metric equivalents are presented in this specification.

NOTE 4—Fittings used for soldered or brazed connections in plumbing systems are described in ASME B16.18 and ASME B16.22.

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.

<table>
<thead>
<tr>
<th>Copper UNS No.</th>
<th>Previously Used Designation</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>C10200</td>
<td>OF</td>
<td>Oxygen free without residual deoxidants</td>
</tr>
<tr>
<td>C12000</td>
<td>DLP</td>
<td>Phosphorus deoxidized, low residual phosphorus</td>
</tr>
<tr>
<td>C12200</td>
<td>DHP</td>
<td>Phosphorus deoxidized, high residual phosphorus</td>
</tr>
</tbody>
</table>

1.3 The assembly of copper plumbing or fire sprinkler systems by soldering is described in Practice B 828.

1.4 Solders for joining copper potable water or fire sprinkler systems are covered by Specification B 32. The requirements for acceptable fluxes for these systems are covered by Specification B 813.

1.5 The following safety hazards caveat pertains only to the test methods portion, Section 15, 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.

2. Referenced Documents

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

<table>
<thead>
<tr>
<th>ASTM Standard</th>
<th>Title</th>
</tr>
</thead>
<tbody>
<tr>
<td>B 32</td>
<td>Specification for Solder Metal</td>
</tr>
<tr>
<td>B 88M</td>
<td>Specification for Seamless Copper Water Tube [Metric]</td>
</tr>
<tr>
<td>B 153</td>
<td>Test Method for Expansion (Pin Test) of Copper and Copper-Alloy Pipe and Tubing</td>
</tr>
<tr>
<td>B 557</td>
<td>Test Methods for Detection of Cuprous Oxide (Hydrogen Embrittlement Susceptibility) in Copper</td>
</tr>
<tr>
<td>B 601</td>
<td>Classification for Temper Designations for Copper and Copper Alloys—Wrought and Cast</td>
</tr>
<tr>
<td>B 813</td>
<td>Specification for Liquid and Paste Fluxes for Soldering Applications of Copper and Copper Alloy Tube</td>
</tr>
<tr>
<td>B 828</td>
<td>Practice for Making Capillary Joints by Soldering of Copper and Copper Alloy Tube and Fittings</td>
</tr>
<tr>
<td>E 2</td>
<td>Methods of Preparation of Micrographs of Metals and Alloys</td>
</tr>
<tr>
<td>E 3</td>
<td>Guide for Preparation of Metallographic Specimens</td>
</tr>
<tr>
<td>E 8</td>
<td>Test Methods for Tension Testing of Metallic Materials</td>
</tr>
<tr>
<td>E 18</td>
<td>Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials</td>
</tr>
<tr>
<td>E 29</td>
<td>Practice for Using Significant Digits in Test Data</td>
</tr>
</tbody>
</table>

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.


² The UNS system for copper and copper alloys (see Practice E 527) is a simple expansion of the former standard designation system accomplished by the addition of a prefix “C” and a suffix “00.” The suffix is permitted to be used to accommodate composition variations of the base alloy.

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.
Determine Conformance with Specifications
E 53 Test Methods for Determination of Copper in Unalloyed Copper by Gravimetry
E 62 Test Methods for Chemical Analysis of Copper and Copper Alloys (Photometric Methods)
E 112 Test Methods for Determining the Average Grain Size
E 243 Practice for Electromagnetic (Eddy-Current) Examination of Copper and Copper-Alloy Tubes
E 255 Practice for Sampling Copper and Copper Alloys for the Determination of Chemical Composition
E 527 Practice for Numbering Metals and Alloys (UNS)
3.2 ASME Standards:
ASME B16.18 Cast Copper Alloy Solder Joint Pressure Fittings
ASME B16.22 Wrought Copper and Copper Alloy Solder Joint Pressure Fittings

3. Terminology
3.1 Definitions:
3.1.1 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.
3.1.1.1 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.
3.1.1.2 double layer flat, n—a coil in which the product is spirally wound into two connected disk-like layers such that one layer is on top of the other. (Sometimes called “double layer pancake coil” or “double layer spirally wound coil.”)
3.1.1.3 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.”)
3.1.1.4 single layer flat, n—a coil in which the product is spirally wound into a single disk-like layer. (Sometimes called “pancake coil” or “single layer spirally wound coil.”)
3.1.2 lengths, n—straight pieces of the product.
3.1.2.1 standard, n—uniform lengths recommended in a simplified practice recommendation or established as a commercial standard.
3.1.3 tube, seamless, n—a tube produced with a continuous periphery in all stages of the operations.
3.1.3.1 tube, copper service, n—a bendable copper water tube for underground water service.
3.1.3.2 tube, copper water, n—a seamless copper tube conforming to the particular dimensions commercially known as Copper Water Tube and designated as Types K, L, and M.
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 the following information for material ordered under this specification.
4.1.1 ASTM designation and year of issue (for example, B 88 – 03),
TABLE 2 Chemical Composition—Weight %

<table>
<thead>
<tr>
<th>Element</th>
<th>Copper UNS No.</th>
<th>C10200*</th>
<th>C12200</th>
<th>C12200</th>
</tr>
</thead>
<tbody>
<tr>
<td>Copper, min</td>
<td>99.95</td>
<td>99.90</td>
<td>99.9</td>
<td></td>
</tr>
<tr>
<td>Phosphorus</td>
<td>...</td>
<td>0.004–0.012</td>
<td>0.015–0.040</td>
<td></td>
</tr>
</tbody>
</table>

*Oxygen shall be 10 ppm max.
* Copper + silver.

4.1.2 Copper UNS No. (not necessary unless a specific copper is desired),
4.1.3 Nominal or standard size (Column 1 of Table 1) and whether Type K, L, or M (Sections 3 and 11),
4.1.4 Temper (Sections 5 and 7),
4.1.5 Length (see 11.5),
4.1.6 How furnished: straight or coils, and
4.1.7 Quantity (pieces) of each size and type.
4.1.8 In addition, when material is purchased for agencies of the U.S. Government, it shall conform to the Supplementary Requirements as defined herein when specified in the contract or purchase order.
4.2 The following options are available and shall be specified in the contract or purchase order when required:
4.2.1 Tension test (Section 8),
4.2.2 Grain size determination (Section 8),
4.2.3 Expansion test (9.1), and
4.2.4 Microscopical Examination for Hydrogen Embrittlement, Procedure B (9.3.2).

5. Materials and Manufacture
5.1 The material shall be of such quality and purity that the finished product shall have the properties and characteristics prescribed in this specification, and shall be cold drawn to size.
5.2 The tube shall be finished by such cold-working and annealing operations as are necessary to produce the required temper and surface finish.
5.3 Tube when furnished in coils shall be annealed after coiling.
5.4 Tube when furnished in straight lengths shall normally be in the drawn temper. Upon agreement between the manufacturer or supplier and the purchaser, the manufacturer shall have the option to supply annealed straight length tubing.

6. Chemical Composition
6.1 The material shall conform to the chemical requirements in Table 2 for the specific type of copper.
6.2 These specification 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.

7. Temper
7.1 Seamless copper water tube shall be furnished in the tempers designated below. Current designations as defined in Classification B 601 are shown.
   Annealed—O
   Drawn—H

8. Mechanical Properties
8.1 The tube shall conform to the mechanical property requirements prescribed in Table 3. Tension tests and grain-size determinations need not be made except when indicated by the purchaser at the time of placing the order. A convenient method of indicating that these tests are to be made is to state that “Test Procedure ‘T’ is required” (see 4.2.1). Where agreement on the Rockwell hardness tests cannot be reached, the tensile strength and grain-size requirements of Table 3 shall be the basis for acceptance or rejection.

9. Performance Requirements
9.1 Expansion Test:
9.1.1 The annealed (O) tube shall be capable of being expanded in accordance with Test Method B 153 with an expansion of the outside diameter in the following amount:

<table>
<thead>
<tr>
<th>Expansion of Outside Diameter, %</th>
</tr>
</thead>
<tbody>
<tr>
<td>% and under</td>
</tr>
<tr>
<td>Over %</td>
</tr>
<tr>
<td></td>
</tr>
<tr>
<td>40</td>
</tr>
<tr>
<td>30</td>
</tr>
</tbody>
</table>

The expanded tube shall show no cracking or rupture visible to the unaided eye.
9.2 Flattening Test:
9.2.1 As an alternative to the expansion test for tube standard sizes 4 in. and over in the annealed condition, a section 4 in. in length shall be cut from the end of one of the lengths for a flattening test. This 4-in. test specimen shall be flattened so that a gage set at three times the wall thickness will pass over the tube freely throughout the flattened part. The tube so tested shall develop no cracks or flaws visible to the unaided eye as a result of this test. In making the flattening test the elements shall be slowly flattened by one stroke of the press.
9.3 Microscopical Examination for Susceptibility to Hydrogen Embrittlement:
9.3.1 Tubes furnished in Copper UNS No. C10200 and C12000 shall be essentially free of cuprous oxide as determined by Procedure A of Test Methods B 577. When Copper UNS No. C12200 is supplied, examination is not required. In case of a dispute, Procedure C of Test Methods B 577 shall be used as the referee method.
9.3.2 Tubes furnished in all coppers shall be capable of passing the embrittlement test specified in Procedure B of Test Methods B 577. 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 B 577 shall be used as the referee method.

10. Nondestructive Testing
10.1 Each tube up to and including 3½ in. in outside diameter shall be subjected to an eddy-current test. Testing shall follow the procedures of Practice E 243, except for the determination of “end effect.” Tubes shall be passed through an eddy-current test unit adjusted to provide information on the suitability of the tube for the intended application.
10.1.1 Notch-depth standards, rounded to the nearest 0.001 in., shall be 22% of the wall thickness. The notch-depth tolerance shall be plus and minus 0.0005 in. Alternatively, at
the option of the manufacturer using speed insensitive eddy-current testers shall be considered as conforming to the requirements of this test. Tubes with discontinuities indicated by the testing unit shall, at the option of the manufacturer, be 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.

10.2 Tube made to this specification shall be capable of withstanding the pressure test of 10.2.1 or 10.2.2. On subsequent testing by the purchaser, failure to meet the requirements of 10.2.1 or 10.2.2 are grounds for rejection of the material by the purchaser.

10.2.1 The tube shall stand, without showing evidence of leakage, an internal hydrostatic pressure sufficient to subject the material to a fiber stress of 6000 psi, calculated from the following equation for thin hollow cylinders under tension:

\[ P = 2St/(D - 0.8t) \]

where:
- \( P \) = hydrostatic pressure, psi;
- \( t \) = wall thickness, in.;
- \( D \) = outside diameter of the tube, in.; and
- \( S \) = allowable stress of the material, psi.

10.2.2 The tube shall stand an internal air pressure of 60 psig for 5 s without showing evidence of leakage. The test method used shall permit easy visual detection of any leakage, such as by having the tube under water or by the pressure differential method.

11. Dimensions, Mass, and Permissible Variations

11.1 For the purpose of determining conformance with the dimensional requirements prescribed in this specification, any measured value outside the specified limiting values for any dimensions shall make the tube subject to rejection at the option of the purchaser.

11.2 Standard Dimensions, Wall Thickness, and Diameter Tolerances—The standard dimensions, wall thickness, and diameter tolerances shall be in accordance with Table 1.

11.3 Mass—For purposes of calculating weights, cross sections, and so forth, the density of the copper shall be taken as 0.323 lb/in.\(^3\). The theoretical weight per foot is given in Table 1.

11.4 Roundness—For drawn annealed tube in straight lengths, the roundness tolerance shall be as prescribed in Table 4. The deviation from roundness is measured as the difference between major and minor diameters as determined at any one cross section of the tube. No roundness tolerance has been established for annealed tube in straight lengths or for tubes furnished in coils.

11.5 Lengths and Tolerances:
11.5.1 Standard Lengths and Tolerances—The standard lengths and tolerances shall be as specified in Table 5.
11.5.2 Tube 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.

11.6 Squareness of Cut—For tube in straight lengths, the departure from squareness of the end of any tube shall not exceed more than 0.010 in. for tube up to and including 1⁄2-in. standard size; and not more than 0.016 in./in. of outside diameter for tube larger than 1⁄2-in. standard size.

12. Workmanship, Finish, and Appearance

12.1 The material shall be clean, free of dirt and defects of a nature that interfere with normal commercial applications.

13. Sampling

13.1 Sample pieces shall be selected for test purposes from each lot of 5000 lbs or fraction thereof, of each size and type, in accordance with the schedule of Table 6.

14. Number of Tests and Retests

14.1 Chemical Analysis—Samples for chemical analysis shall be taken in accordance with Practice E 255. Drillings, millings, and so forth shall be taken in approximately equal weight from each of the sample pieces selected in accordance with 13.1 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.

14.1.1 Instead of sampling in accordance with Practice E 255, the manufacturer shall have the option of determining conformance to chemical composition as follows: Conformance shall be determined by the manufacturer by analyzing samples taken at the time the castings are poured or samples taken from the semifinished product. If the manufacturer determines the chemical composition of the material during the course of manufacture, he shall not be required to sample and
14.4 In the case of tube furnished in coils, a length sufficient for all necessary tests shall be cut from each coil selected for the purpose of tests. The remaining portion of these coils shall be included in the shipment, and the permissible variations in length of such coils shall be waived.

14.5 Retests:

14.5.1 If any test specimen shows defective machining or develops flaws, it shall be discarded and another specimen substituted.

14.5.2 If the results of any test for microscopical examination or mechanical properties fail to meet the specified requirements, two additional specimens shall be taken from different sample pieces and tested. The results of the tests on both of these specimens shall meet the specified requirements. Failure of more than one specimen to meet the specified requirements for a particular property shall be the cause for rejection of the entire lot.

14.5.3 If the chemical analysis fails to conform to the specified limits, analysis shall be made on a new composite sample prepared from additional pieces selected in accordance with 13.1. The results of this retest shall comply with the specified requirements.

15. Test Methods

15.1 The properties enumerated in this specification shall, in case of disagreement, be determined in accordance with the ASTM methods listed in Table 7.

15.2 Tension Test:

15.2.1 Tension test specimens shall be of the full section of the tube and shall conform to the requirements of the section, Specimens for Pipe and Tube, of Test Methods E 8, unless the limitations of the testing machine preclude the use of such a specimen. Use test specimens conforming to type No. 1 of Fig. 13, Tension Test Specimens for Large-Diameter Tubular Products, of Test Methods E 8 when a full-section specimen cannot be tested.

15.2.2 Whenever different tension test results are obtained from both full-size and from machined test specimens, the results obtained from full-size test specimens shall be used to determine conformance to the requirements of this specification.

15.2.3 Tension test results on material covered by this specification 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).

15.3 Grain Size and Microscopical Examination:
15.3.1 The specimen(s) shall be prepared in accordance with Guide E3.
15.3.2 The surface of the test specimen shall approximate a radial longitudinal section of the tube.

16. Significance of Numerical Limits
16.1 For purposes of determining compliance with the specified limits for requirements of the properties listed in Table 8, an observed value or calculated value shall be rounded as indicated in accordance with the rounding method of Practice E29.

17. Inspection
17.1 The manufacturer shall afford the inspector representing the purchaser, all reasonable facilities, without charge, to satisfy him that the tubes are being furnished in accordance with the specified requirements.

18. Rejection and Rehearing
18.1 Material that fails to conform to the requirements of this specification is subject to rejection at the option of the purchaser. Rejection shall be reported to the manufacturer or supplier promptly and in writing. When requested by the manufacturer or supplier, a rehearing shall be granted.

19. Packaging and Package Marking
19.1 The material shall be separated by size, composition, and temper, and 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 the normal hazards of transportation.
19.2 Each shipping unit shall be legibly marked with the purchase order number, metal or alloy designation, temper, size, total length or piece count, or both, and name of supplier. The specification number shall be shown, when specified.

19.3 Product Identification:
19.3.1 The name or trademark of the manufacturer and the mark indicative of the type shall be permanently (incised) marked on each tube at intervals not greater than 1½ ft. Tube in straight lengths shall be further identified throughout its length by means of a colored stripe, symbol, or logo not less than ⅜ in. in height, including a legend repeated at intervals not greater than 3 ft. The legend shall include the type of the tube, name or trademark of the manufacturer, or both, and the country of origin. The manufacturer has the option to include other information.

19.3.2 Colors used are: green for Type K, blue for Type L, and red for Type M. Such color marking is not applicable to tube furnished in annealed straight lengths or coils.

19.4 UNS Copper Designation:
19.4.1 Hard Drawn Tubing—On hard drawn tubing produced from C10200 and C12000, the UNS copper designation shall be identified at intervals not greater than 3 ft with color coded ink per 19.3.2.

19.4.2 Annealed Tubing—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. Color marking to distinguish Type K from Type L is not required.

20. Keywords
20.1 copper tube; seamless; water 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:
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
S1.1.2 Military Standard:
MIL-STD-129 Marking for Shipment and Storage
S1.1.3 Military Specification:
MIL-C-3993 Packaging of Copper and Copper-Base Alloy Mill Products

S2. Quality Assurance
S2.1 Responsibility for Inspection:
S2.1.1 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 assure 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 MIL-C-3993.

S4.1.2 Civil Agencies—The requirements of Fed. Std. No. 102 shall be referenced 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.