



Designation: B140/B140M – 12 (Reapproved 2017)

Standard Specification for Copper-Zinc-Lead (Red Brass or Hardware Bronze) Rod, Bar, and Shapes¹

This standard is issued under the fixed designation B140/B140M; 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 copper-zinc-lead (leaded red brass or hardware bronze) rod, bar, and shapes of UNS Copper Alloy Nos. C31400, C31600, and C32000 available for general and screw machine applications.

1.2 *Units*—Values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, SI units are shown in brackets. The values 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 nonconformance with the specification.

1.3 *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

[B249/B249M Specification for General Requirements for Wrought Copper and Copper-Alloy Rod, Bar, Shapes and Forgings](#)

[B601 Classification for Temper Designations for Copper and Copper Alloys—Wrought and Cast](#)

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

[E8/E8M Test Methods for Tension Testing of Metallic Materials](#)

[E62 Test Methods for Chemical Analysis of Copper and](#)

[Copper Alloys \(Photometric Methods\) \(Withdrawn 2010\)](#)³
[E478 Test Methods for Chemical Analysis of Copper Alloys](#)

3. General Requirements

3.1 The following sections of Specification [B249/B249M](#) constitute a part of this specification:

- 3.1.1 Terminology ([B846](#)),
- 3.1.2 Materials and Manufacture,
- 3.1.3 Workmanship, Finish, and Appearance,
- 3.1.4 Sampling,
- 3.1.5 Number of Tests and Retests,
- 3.1.6 Specimen Preparation,
- 3.1.7 Test Methods,
- 3.1.8 Significance of Numerical Limits,
- 3.1.9 Inspection,
- 3.1.10 Rejection and Rehearing,
- 3.1.11 Certification,
- 3.1.12 Test Report,
- 3.1.13 Product Marking,
- 3.1.14 Packaging and Package Marking, and
- 3.1.15 Supplementary Requirements.

3.2 In addition, when a section with a title identical to one of those referenced in 3.1 appears in this specification, it contains additional requirements which supplement those appearing in Specification [B249/B249M](#).

4. Ordering Information

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

- 4.1.1 ASTM designation and year of issue,
- 4.1.2 Copper Alloy UNS No. designation (Scope),
- 4.1.3 Temper designation (Temper Section),
- 4.1.4 Dimensions—diameter, distance between parallel surfaces,
- 4.1.5 How furnished; length, specific or stock, with or without ends,
- 4.1.6 Quantity; total weight or length, or number of pieces of each temper, form, and alloy, and

¹ This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.02 on Rod, Bar, Wire, Shapes and Forgings.

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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.

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

4.1.7 Intended application, general use or automatic screw machine use (Straightness Tolerance).

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 Certification (Specification **B249/B249M**),
- 4.2.2 Mill Test Reports (Specification **B249/B249M**), and
- 4.2.3 If product is purchased for agencies of the U.S. Government (Specification **B249/B249M**).

5. Material and Manufacture

5.1 Material:

5.1.1 The material of manufacture shall be a form (cast billets, logs, or rods) of Copper Alloy UNS Nos. C31400, C31600, or C32000 of such purity and soundness as to be suitable for processing into the products prescribed herein.

5.2 Manufacture:

5.2.1 The product shall be manufactured by such hot working, cold working, straightening, and annealing processes as to produce a uniform wrought structure in the finished product.

6. Chemical Composition

6.1 The material shall conform to the chemical composition requirements in **Table 1** for the Copper Alloy UNS No. designation specified in the ordering information.

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

6.2 For alloys in which zinc is listed as the “remainder,” either copper or zinc may be taken as the difference between the sum of results of all other elements determined and 100 %. When copper is so determined, that difference value shall conform to the requirements given in **Table 1**.

6.3 When all elements in **Table 1** are determined, the sum of the results shall be 99.6 % minimum.

TABLE 1 Chemical Requirements

| Element | Composition, % | | |
|------------|----------------------|--------------|--------------|
| | Copper Alloy UNS No. | | |
| | C31400 | C31600 | C32000 |
| Copper | 87.5 to 90.5 | 87.5 to 90.5 | 83.5 to 86.5 |
| Lead | 1.3 to 2.5 | 1.3 to 2.5 | 1.5 to 2.2 |
| Iron, max | 0.10 | 0.10 | 0.10 |
| Nickel | 0.7 max | 0.7 to 1.2 | 0.25 max |
| Zinc | remainder | remainder | remainder |
| Phosphorus | ... | 0.04 to 0.10 | ... |

7. Temper

7.1 The standard tempers, as defined in Classification **B601**, for products described in this specification are O60 (soft anneal), H02 (half-hard), and H04 (hard).

8. Mechanical Property Requirements

8.1 Tensile Strength Requirements:

8.1.1 Product furnished under this specification shall conform to the tensile requirements prescribed in **Table 2** (inch-pound units) or **Table 3** (SI units) when tested in accordance with Test Methods **E8/E8M**.

9. Dimensions, Mass and Permissible Variations

9.1 The dimensions and tolerances for product described by this specification shall be as specified in Specification **B249/B249M** with particular reference to the following tables and related paragraphs:

9.2 Diameter or Distance Between Parallel Surfaces:

9.2.1 *Rod*—Refer to Table 1 for round, hexagonal and octagonal rod.

9.2.2 *Bar*—Refer to Table 8 for thickness and Table 10 for width.

9.3 Length—Refer to Tables 13 and 14.

9.4 *Straightness*—Refer to Table 16. General use or automatic screw machine use as chosen in the purchase order.

9.5 *Shapes*—The dimensional tolerances for shapes shall be agreed upon between the manufacturer or supplier and the purchaser and shall be specified in the order or purchase contract.

10. Test Methods

10.1 Chemical Analysis:

10.1.1 In cases of disagreement, test methods for chemical analysis shall be subject to agreement between the manufacturer or supplier and the purchaser.

10.1.2 The following table is a list of published test methods, some of which are considered by ASTM as no longer viable. These and others not listed may be used subject to agreement.

| Element | ASTM Test Method |
|------------|---------------------------------|
| Copper | E478 |
| Lead | E478 , atomic absorption |
| Iron | E478 |
| Nickel | E478 , photometric |
| Phosphorus | E62 |
| Zinc | E478 , Titrimetric |

11. Keywords

11.1 C31400; C31600; C32000; hardware bronze; hardware bronze rod; hardware bronze shapes; leaded brass shapes; leaded red brass bar; leaded red brass rod

TABLE 2 Tensile Requirements (Inch-Pound Units)

| Copper Alloy UNS No. | Temper Designation | | Diameter or Distance Between Parallel Surfaces, in. | Width, in. | Tensile Strength, min, ksi | Yield Strength at 0.5 % Extension Under Load, min, ksi | Elongation in 4 × Diameter or Thickness of Specimen min, % ^A | |
|---------------------------|--------------------|-------------|--|-----------------------|----------------------------------|--|---|-----------------------|
| | Code | Name | | | | | | |
| C31400, C31600, C32000 | O60 | soft anneal | all forms | all sizes | ... | 35 | 10 | 25 |
| C31400, C31600, C32000 | HO2 | half hard | rod: | ½ and under | ... | 50 | 30 | 7 |
| | | | | over ½ to 1 | ... | 45 | 27 | 10 |
| | | | bar: | over 1 | ... | 40 | 25 | 12 |
| | | | | 1 and under over 1 | 2 and under over 2 | 40 40 ^B | 25 25 ^B | 12 12 ^B |
| C31400 | H04 | hard | rod | 2 and under | ... | 53 | 40 | 6 |
| C31600, C32000 | H04 | hard | rod | 2 and under | ... | 60 | 50 | 6 |
| | | | bar | 1 and under | 2 and under | 60 | 50 | 6 |

^A In any case, a minimum gage length of 1 in. shall be used.

^B In the case of bars either over 1 in. in thickness or over 2 in. in width, or both, these values shall apply.

TABLE 3 Tensile Requirements (SI Units)

| Copper Alloy UNS No. | Temper Designation | | Diameter or Distance Between Parallel Surfaces, mm | Width, mm | Tensile Strength, min MPa | Yield Strength at 0.5 % Extension Under Load, min, MPa | Elongation ^A min, % | |
|---------------------------|--------------------|-------------|---|-------------------------|---------------------------------|--|-----------------------------------|-----------------------|
| | Code | Name | | | | | | |
| C31400, C31600, C32000 | O60 | Soft anneal | all forms | all sizes | ... | 240 | 70 | 25 |
| C31400, C31600, C32000 | HO2 | half hard | rod: | 12 and under | ... | 345 | 205 | 7 |
| | | | | over 12 to 25 | ... | 310 | 185 | 10 |
| | | | bar: | over 25 | ... | 275 | 170 | 12 |
| | | | | 25 and under over 25 | 50 and under over 50 | 275 275 ^B | 170 170 ^B | 12 12 ^B |
| C31400 | H04 | hard | rod | 50 and under | ... | 365 | 275 | 6 |
| C31600, C32000 | H04 | hard | rod | 50 and under | ... | 415 | 345 | 6 |
| | | | bar | 25 and under | 50 and under | 415 | 345 | 6 |

^A Elongation values are based on a gage length of 5.65 times the square root of the area for dimensions greater than 2.5 mm.

^B In the case of bars either over 25 mm in thickness or over 50 mm in width, or both, these values shall apply.

SUMMARY OF CHANGES

Committee B05 has identified the principal changes to this specification that have been incorporated since the 2007 issue as follows:

(1) Changes made to conform to the *ASTM Form and Style* and B950 guidelines.

 **B140/B140M – 12 (2017)**

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