



Standard Specification for Aluminum and Aluminum-Alloy Drawn Seamless Tubes for Condensers and Heat Exchangers¹

This standard is issued under the fixed designation B234; 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.

1. Scope*

1.1 This specification² covers aluminum-alloy (Note 1) drawn seamless round tube in straight lengths designated as shown in Table 2, for use in surface condensers, evaporators, and heat exchangers.

NOTE 1—Throughout this specification use of the term *alloy* in the general sense includes aluminum as well as aluminum alloy.

NOTE 2—For drawn seamless tubes used in general applications, see Specifications B210 and B210M; for extruded tubes see Specifications B221 and B221M; for seamless pipe and seamless extruded tube used in pressure applications see Specification B241/B241M; and for structural pipe and tube see Specification B429/B429M.

1.2 Alloy and temper designations are in accordance with ANSI H35.1/H35.1(M). The equivalent Unified Numbering System alloy designations are those of Table 1 preceded by A9, for example, A91060 for aluminum 1060, in accordance with Practice E527.

1.3 For acceptance criteria for inclusion of new aluminum and aluminum alloys in this specification, see Annex A2.

1.4 This specification is the inch-pound companion to Specification B234M; therefore, no SI equivalents are presented in the specification.

1.5 *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:

2.2 ASTM Standards:³

- B210 Specification for Aluminum and Aluminum-Alloy Drawn Seamless Tubes
- B210M Specification for Aluminum and Aluminum-Alloy Drawn Seamless Tubes (Metric)
- B221 Specification for Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes
- B221M Specification for Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes (Metric)
- B241/B241M Specification for Aluminum and Aluminum-Alloy Seamless Pipe and Seamless Extruded Tube
- B429/B429M Specification for Aluminum-Alloy Extruded Structural Pipe and Tube
- B557 Test Methods for Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products
- B660 Practices for Packaging/Packing of Aluminum and Magnesium Products
- B666/B666M Practice for Identification Marking of Aluminum and Magnesium Products
- B881 Terminology Relating to Aluminum- and Magnesium-Alloy Products
- B918 Practice for Heat Treatment of Wrought Aluminum Alloys
- E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- E34 Test Methods for Chemical Analysis of Aluminum and Aluminum-Base Alloys
- E215 Practice for Standardizing Equipment for Electromagnetic Testing of Seamless Aluminum-Alloy Tube
- E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)
- E607 Test Method for Atomic Emission Spectrometric Analysis Aluminum Alloys by the Point to Plane Technique Nitrogen Atmosphere (Withdrawn 2011)⁴
- E716 Practices for Sampling and Sample Preparation of Aluminum and Aluminum Alloys for Determination of

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² For ASME Boiler and Pressure Vessel Code applications see related Specification SB-234 in Section II of that Code.

³ For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

⁴ 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

TABLE 1 Chemical Composition Limits^{A,B,C}

Alloy	Silicon	Iron	Copper	Manganese	Magnesium	Chromium	Zinc	Titanium	Other Elements ^D		Aluminum
									Each	Total ^E	
1060	0.25	0.35	0.05	0.03	0.03	...	0.05	0.03	0.03 ^F	...	99.60 min ^G
3003	0.6	0.7	0.05–0.20	1.0–1.5	0.10	...	0.05	0.15	remainder
Alclad 3003	3003 alloy clad with 7072 alloy										
5052	0.25	0.40	0.10	0.10	2.2–2.8	0.15–0.35	0.10	...	0.05	0.15	remainder
5454	0.25	0.40	0.10	0.50–1.0	2.4–3.0	0.05–0.20	0.25	0.20	0.05	0.15	remainder
6061	0.40–0.8	0.7	0.15–0.40	0.15	0.8–1.2	0.04–0.35	0.25	0.15	0.05	0.15	remainder
7072 ^H	0.7 Si + Fe		0.10	0.10	0.10	...	0.8–1.3	...	0.05	0.15	remainder

^A Limits are in percent maximum unless shown as a range or otherwise stated.

^B Analysis shall be made for the elements for which limits are shown in this table.

^C For purposes of determining conformance to these limits, an observed value or a calculated value attained from analysis shall be rounded to the nearest unit in the last right-hand place of figures used in expressing the specified limit, in accordance with the rounding-off method of Practice E29.

^D Others includes listed elements for which no specific limit is shown as well as unlisted metallic elements. The producer may analyze samples for trace elements not specified in this specification. However, such analysis is not required and may not cover all metallic Others elements. Should any analysis by the producer or the purchaser establish that an Others element exceeds the limit of Each or that the aggregate of several Others elements exceeds the limit of Total, the material shall be considered nonconforming.

^E Other Elements—Total shall be the sum of unspecified metallic elements 0.010 % or more, rounded to the second decimal before determining the sum.

^F Vanadium 0.05 max.

^G The aluminum content shall be calculated by subtracting from 100.00 % the sum of all the metallic elements present in amounts of 0.010 % or more, rounded to the second decimal before determining the sum.

^H Composition of cladding alloy as applied during the course of manufacture. The sample from finished tube shall not be required to conform to these limits.

TABLE 2 Tensile Property Limits^{A,B}

Alloy	Temper	Wall Thickness, in.	Tensile Strength, min, ksi	Yield Strength, (0.2 % offset), min, ksi	Elongation in 2 in., or 4 × Dia, ^C min, %	
					Full-Section Specimen	Cut-Out Specimen
1060	H14	0.010–0.200	12.0	10.0
3003	H14	0.010–0.024	20.0	17.0	3	...
		0.025–0.049	20.0	17.0	5	3
	0.050–0.200	20.0	17.0	8	4	
	H25	0.010–0.200	22.0	19.0
Alclad 3003	H14	0.010–0.024	19.0	16.0
		0.025–0.049	19.0	16.0	5	3
		0.050–0.200	19.0	16.0	8	4
	H25	0.010–0.200	21.0	18.0
	
5052	H32	0.010–0.200	31.0	23.0
	H34	0.010–0.200	34.0	26.0
5454	H32	0.010–0.050	36.0	26.0	...	5
		0.051–0.200	36.0	26.0	...	8
	H34	0.010–0.050	39.0	29.0	...	4
		0.051–0.200	39.0	29.0	...	6
6061	T4	0.025–0.049	30.0	16.0	16	14
		0.050–0.200	30.0	16.0	18	16
	T6	0.025–0.049	42.0	35.0	10	8
		0.050–0.200	42.0	35.0	12	10

^A To determine conformance to this specification, each value for ultimate strength and for yield strength shall be rounded to the nearest 0.1 ksi and each value for elongation to the nearest 0.5 %, both in accordance with the rounding-off method of Practice E29.

^B The basis for establishment of mechanical property limits is shown in Annex A1.

^C Elongation of full-section and cut-out sheet-type specimens is measured in 2 in., of cut-out round specimens, in 4 × specimen diameter.

Chemical Composition by Spectrochemical Analysis
E1251 Test Method for Analysis of Aluminum and Aluminum Alloys by Spark Atomic Emission Spectrometry
 2.3 *ANSI Standards*:⁵
H35.1/H35.1(M) Alloy and Temper Designation Systems for Aluminum

H35.2 Dimensional Tolerances for Aluminum Mill Products
 2.4 *Federal Standard*:⁶
Fed. Std. No. 123 Marking for Shipment (Civil Agencies)
 2.5 *Military Standard*:⁶
MIL-STD-129 Marking for Shipment and Storage

⁵ Available from Aluminum Association, Inc., 1525 Wilson Blvd., Suite 600, Arlington, VA 22209, <http://www.aluminum.org>.

⁶ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098.

2.6 AMS Specification:⁷

AMS 2772 Heat Treatment of Aluminum Alloy Raw Materials

2.7 EN Standard:⁸

CEN EN 14242 Aluminum and Aluminum Alloys, Chemical Analysis, Inductively Coupled Plasma Optical Emission Spectral Analysis

3. Terminology

3.1 Refer to Terminology **B881** for definitions of product terms used in this specification.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *capable of*—the term *capable of* as used in this specification means that the test need not be performed by the producer of the material. However, should testing by the purchaser establish that the material does not meet these requirements, the material shall be subject to rejection.

4. Ordering Information

4.1 Orders for material to this specification shall include the following information:

4.1.1 This specification designation (which includes the number, the year, and the revision letter, if applicable),

4.1.2 Quantity in pieces or pounds,

4.1.3 Alloy (Section 7),

4.1.4 Temper (Section 8),

4.1.5 Outside or inside diameter, wall thickness, and length,

4.1.6 For alloy Alclad 3003, state clad inside or outside (12.1).

4.2 Additionally, orders for material to this specification shall include the following information when required by the purchaser:

4.2.1 Whether heat treatment in accordance with Practice **B918** is required (9.2),

4.2.2 Whether cut ends of tube are to be deburred (Section 14),

4.2.3 Whether inspection or witness of inspection and tests by the purchaser's representative is required prior to material shipment (Section 15),

4.2.4 Whether certification of the material is required (Section 17),

4.2.5 Whether marking for identification is required (Section 18), and

4.2.6 Whether Practices **B660** applies and, if so, the level of preservation, packaging, and packing required (19.3).

5. Manufacture

5.1 The tube shall be produced by drawing an extruded tube made from hollow extrusion ingot (cast in hollow form or pierced) and extruded by use of the die and mandrel method.

6. Responsibility for Quality Assurance

6.1 *Responsibility for Inspection and Tests*—Unless otherwise specified in the contract or purchase order, the producer is

responsible for the performance of all inspection and test requirements specified herein. The producer may use his own or any other suitable facilities for the performance of the inspection and test requirements specified herein, unless disapproved by the purchaser in the order or at the time of contract signing. The purchaser shall have the right to perform any of the inspections and tests set forth in this specification where such inspections are deemed necessary to assure that material conforms to prescribed requirements.

6.2 *Lot Definition*—An inspection lot shall be defined as follows:

6.2.1 For heat-treated tempers, an inspection lot shall consist of an identifiable quantity of material of the same mill form, alloy, temper, and thickness traceable to a heat-treat lot or lots, and subjected to inspection at one time.

6.2.2 For nonheat-treated tempers, an inspection lot shall consist of an identifiable quantity of material of the same mill form, alloy, temper, and thickness subjected to inspection at one time.

7. Chemical Composition

7.1 *Limits*—The tube shall conform to the chemical composition limits in **Table 1**. Conformance shall be determined by the producer by analyzing samples taken at the time the ingots are poured in accordance with **E716** and analyzed in accordance with **E607**, **E1251**, **E34** or EN 14242. At least one sample shall be taken for each group of ingots poured from the same source of molten metal. If the producer has determined the chemical composition of the material during the course of manufacture, he shall not be required to sample and analyze the finished product.

NOTE 3—It is standard practice in the United States aluminum industry to determine conformance to the chemical composition limits prior to further processing of ingots into wrought products. Due to the continuous nature of the process, it is not practical to keep a specific ingot analysis identified with a specific quantity of finished material.

7.2 If it becomes necessary to analyze the finished or semifinished product for conformance to chemical composition limits, the method used to sample the finished or semifinished product for the determination of chemical composition shall be as agreed between the buyer and seller. Analysis shall be performed in accordance with **E716**, **E607**, **E1251**, **E34**, or EN 14242 (ICP method). The number of samples shall be as follows:

7.2.1 When samples are taken from the finished or semifinished product, a sample shall be taken to represent each 4000 lb or fraction thereof, of material in the lot, except that not more than one sample shall be required per piece.

7.2.2 Other methods of analysis, in the case of dispute, may be used by agreement between the producer and purchaser.

NOTE 4—It is difficult to obtain a reliable analysis of each of the components of clad materials using material in its finished state. A reasonably accurate determination of the core composition can be made if the cladding is substantially removed prior to analysis. The cladding composition is more difficult to determine because of the relatively thin layer and because of diffusion of core elements to the cladding. The correctness of cladding alloy used can usually be verified by a combination of metallographic examination and spectrochemical analysis of the surface at several widely separated points.

⁷ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001.

⁸ Available from European Committee for Standardization Central Secretariat (CEN), rue de Stassart 36, B1050 Brussels, Belgium, <http://www.cen.eu/eseach>.

8. Tensile Properties of Material as Supplied

8.1 *Limits*—The tube shall conform to the tensile property requirements in [Table 2](#).

8.2 *Number of Specimens*:

8.2.1 For material having a nominal weight of less than 1 lb/linear ft, one tension test specimen shall be taken for each 1000 lb, or fraction thereof, in the lot.

8.2.2 For material having a nominal weight of 1 lb or more/linear ft one tension test specimen shall be taken for each 1000 ft, or fraction thereof, in the lot.

8.2.3 Other procedures for selecting samples may be employed if agreed upon by the producer and the purchaser.

8.3 *Test Methods*—The tension tests shall be made in accordance with Test Methods [B557](#).

9. Heat Treatment

9.1 Unless otherwise specified in [9.2](#), producer or supplier heat treatment for the applicable tempers in [Table 2](#) shall be in accordance with AMS 2772.

9.2 When specified, heat treatment of applicable tempers in [Table 2](#) shall be in accordance with Practice [B918](#).

10. Leak Test

10.1 Each length of tube 1.5 in. or less in diameter shall be tested by either of the following methods, at the option of the producer or supplier, consistent with the size limitations indicated:

10.1.1 *Method 1*—Applicable to tube with a wall thickness of 0.200 in. max. Each tube shall be subjected to an internal air gage pressure of 250 psi for 5 s while immersed in a suitable liquid. Any evidence of leakage shall be cause for rejection.

10.1.2 *Method 2*—Applicable to tube with a wall thickness of 0.083 in. maximum, as covered by Practice [E215](#). Each tube shall be subjected to an eddy current test in accordance with the procedures described in Practice [E215](#). Reference standards described in [Annex A1](#) and [Annex A2](#) shall be used to standardize the equipment. These same reference standards or secondary standards having equivalent eddy current response shall also serve to define acceptance-rejection limits. Tubes that produce eddy current indications less than those from the 2A holes of the applicable reference standard or an equivalent secondary standard shall be acceptable. Any tube having a discontinuity that produces an eddy current indication equal to or greater than those from the 2A holes of the applicable reference standard or an equivalent secondary standard shall be rejected.

11. Expansion Test

11.1 The tube ends shall be capable of being flared, without showing cracks or ruptures visible to the unaided eye when corrected for normal vision, by forcing a steel pin having a taper of 1.5 in./ft into the tube until the inside diameter has been increased 20 %.

12. Cladding

12.1 The aluminum alloy cladding of Alclad 3003 tube shall, as specified, comprise either the inside surface (only) and

its thickness shall be approximately 10 % of the total wall thickness, or the outside surface (only) in which case its thickness shall be approximately 7 % of the total wall thickness.

12.2 When the thickness of the cladding is to be determined on finished tube, transverse cross sections of at least three tubes from the lot shall be polished for examination with a metal-lurgical microscope. Using a magnification of 100×, the cladding thickness at four points, 90° apart, in each sample shall be measured and the average of all measurements shall be taken as the thickness. In the case of tubes having a diameter larger than can properly be mounted for polishing and examination, the portions of the cross section polished for examination may consist of an arc about ½ in. in length.

13. Dimensional Tolerances

13.1 Variations from the specified wall thickness, length, outside diameter, straightness, and squareness of cut ends shall not exceed the tolerances specified in the tables of ANSI H35.2 (see [Table 3](#)).

13.2 *Sampling for Inspection*—Examination for dimensional conformance shall be made to ensure conformance to the tolerance specified.

14. General Quality

14.1 Unless otherwise specified, the material shall be supplied in the mill finish and shall be uniform as defined by the requirements of this specification and shall be commercially sound. Any requirement not so covered is subject to negotiation between producer and purchaser.

14.2 Grinding to remove minor surface imperfections shall not be cause for rejection, provided the repaired area is within dimensional tolerances.

14.3 When so specified on the purchase order, the cut ends of each tube shall be deburred by the use of a wire wheel, file, or other suitable tool or device.

14.4 Each tube shall be examined to determine conformance to this specification with respect to general quality and identification marking. On approval of the purchaser however, the producer may use a system of statistical quality control for such examinations.

15. Source Inspection

15.1 If the purchaser desires that his representative inspect or witness the inspection and testing of the material prior to

TABLE 3 Tables of ANSI H35.2

Table No.	Title
12.36	Heat-Exchanger Tube Wall Thickness
12.37	Heat-Exchanger Tube Length
12.34	Heat-Exchanger Tube Outside Diameter, Heat-Treatable Tube
12.35	Heat-Exchanger Tube Outside Diameter, Non-Heat-Treatable Tube
12.38	Heat-Exchanger Tube Straightness
12.39	Heat-Exchanger Tube Squareness of Cut Ends

shipment, such agreement shall be made by the purchaser and producer as part of the purchase contract.

15.2 When such inspection or witness of inspection and testing is agreed upon, the producer shall afford the purchaser's representative all reasonable facilities to satisfy him that the material meets the requirements of this specification. Inspection and tests shall be conducted so there is no unnecessary interference with the producer's operations.

16. Retest and Rejection

16.1 If any material fails to conform to all of the applicable requirements of this specification, it shall be cause for rejection of the inspection lot.

16.2 When there is evidence that a failed specimen was not representative of the inspection lot and when no other sampling plan is provided or approved by the purchaser through the contract or purchase order, at least two additional specimens shall be selected to replace each test specimen that failed. All specimens so selected for retest shall meet the requirements of the specification or the lot shall be subject to rejection.

16.3 Material in which defects are discovered subsequent to inspection may be rejected.

16.4 If material is rejected by the purchaser, the producer or supplier is responsible only for replacement of the material to the purchaser. As much as possible of the rejected material shall be returned to the producer or supplier by the purchaser.

17. Certification

17.1 The producer or supplier shall, on request, furnish to the purchaser a certificate stating that each lot has been sampled, tested, and inspected in accordance with this specification, and has met the requirements.

18. Identification Marking of Product

18.1 When specified in the contract or purchase order all material shall be marked in accordance with Practice **B666/B666M**.

18.2 The foregoing requirements are minimum; marking systems which involve added information, large characteristics, and greater frequencies are acceptable under this specification.

19. Packaging and Package Marking

19.1 The material shall be packaged to provide adequate protection during normal handling and transportation, and each package shall contain only one alloy, temper, and size of material unless otherwise agreed. The type of packaging and gross weight of containers shall, unless otherwise agreed upon, be at the producer's or supplier's discretion, provided that they are such as to ensure acceptance by common or other carriers for safe transportation at the lowest rate to the delivery point.

19.2 Each shipping container shall be marked with the purchase order number, material size, specification number, alloy and temper, gross and net weights, and the producer's name or trademark.

19.3 When specified in the contract or purchase order, material shall be preserved, packaged, and packed in accordance with the requirements of Practices **B660**. The applicable levels shall be as specified in the contract or order. Marking for shipment of such material shall be in accordance with Fed. Std. No. 123 for civil agencies and MIL-STD-129 for Military agencies.

20. Keywords

20.1 aluminum alloy; drawn seamless tubes; heat exchangers

ANNEXES

(Mandatory Information)

A1. BASIS FOR INCLUSION OF PROPERTY LIMITS

A1.1 Mechanical property limits are established in accord with Section 6, Standards Section, of the most current edition of the Aluminum Standards and Data and the latest edition of the Aluminum Association publication "Tempers for Aluminum and Aluminum Alloy Products (Yellow and Tan Sheets)."

A1.1.1 Limits are based on a statistical evaluation of the data indicating that at least 99 % of the population obtained from all standard material meets the limit with 95 % confidence. For the products described, mechanical property limits are based on the statistical analyses of at least 100 tests from at least 5 cast lots of standard production material with no more than 10 observations from a given heat treat or inspection lot. Mechanical properties limits for press solution heat treated

products have specific additional requirements which are provided in the "Tempers for Aluminum and Aluminum Alloy Products."

A1.1.2 Limits denoted as "Tentative" by the Aluminum Association may be included. Requirements for tentative property registrations are defined in the latest edition of the Aluminum Association publication "Tempers for Aluminum and Aluminum Alloy Products." Tentative property limits are established at levels at which at least 99 % of the data conform at a confidence level of 95 %. Tentative property limits, which are subject to revision, shall be based on a statistical analysis of at least 30 tests from at least 3 cast lots of standard production material with no more than 10 observations from a given heat

treat or inspection lot. Where tentative property limits are listed, they shall be shown in italics and footnoted as Tentative in the standard.

A1.1.3 All tests are performed in accordance with the appropriate ASTM test methods.

A2. ACCEPTANCE CRITERIA FOR INCLUSION OF NEW ALUMINUM AND ALUMINUM ALLOYS IN THIS SPECIFICATION

A2.1 Prior to acceptance for inclusion in this specification, the composition of wrought or cast aluminum or aluminum alloy shall be registered in accordance with ANSI H35.1/H35.1(M). The Aluminum Association⁵ holds the Secretariat of ANSI H35 Committee and administers the criteria and procedures for registration.

A2.2 If it is documented that the Aluminum Association could not or would not register a given composition, an alternative procedure and the criteria for acceptance shall be as follows:

A2.2.1 The designation submitted for inclusion does not utilize the same designation system as described in ANSI H35.1/H35.1(M). A designation not in conflict with other designation systems or a trade name is acceptable.

A2.2.2 The aluminum or aluminum alloy has been offered for sale in commercial quantities within the prior twelve months to at least three identifiable users.

A2.2.3 The complete chemical composition limits are submitted.

A2.2.4 The composition is, in the judgment of the responsible subcommittee, significantly different from that of any other aluminum or aluminum alloy already in the specification.

A2.2.5 For codification purposes, an alloying element is any element intentionally added for any purpose other than grain

refinement and for which minimum and maximum limits are specified. Unalloyed aluminum contains a minimum of 99.00 % aluminum.

A2.2.6 Standard limits for alloying elements and impurities are expressed to the following decimal places:

Less than 0.001 %	0.000X
0.001 to but less than 0.01 %	0.00X
0.01 to but less than 0.10 %	
Unalloyed aluminum made by a refining process	0.0XX
Alloys and unalloyed aluminum not made by a refining process 0.10 through 0.55 %	0.0X
(It is customary to express limits of 0.30 through 0.55 % as 0.X0 or 0.X5.)	0.XX
Over 0.55 %	0.X, X.X, and so forth.

(except that combined Si + Fe limits for 99.00 % minimum aluminum must be expressed as 0.XX or 1.XX)

A2.2.7 Standard limits for alloying elements and impurities are expressed in the following sequence: Silicon; Iron; Copper; Manganese; Magnesium; Chromium; Nickel; Zinc (**Note A2.1**); Titanium; Other Elements, Each; Other Elements, Total; Aluminum (**Note A2.2**).

NOTE A2.1—Additional specified elements having limits are inserted in alphabetical order of their chemical symbols between zinc and titanium, or are specified in footnotes.

NOTE A2.2—Aluminum is specified as *minimum* for unalloyed aluminum and as a *remainder* for aluminum alloys.

APPENDIX

(Nonmandatory Information)

X1. GENERAL INFORMATION

X1.1 The following information does not constitute a part of this specification but is intended to assist in the proper selection and use of the materials.

X1.2 Alloys 1060, 3003, alclad 3003, 5052, and 5454 are supplied in a strain-hardened temper to meet the specified tensile and yield strengths. Alloy 6061 is supplied in the heat-treated temper (-T4) and in the heat-treated and aged temper (-T6): the -T4 temper is more workable, and after forming work is completed may be aged to the stronger -T6 temper. A typical aging treatment would be to hold the material at 340°F for 6 to 10 h in a suitable furnace and allow to cool at room temperature.

X1.3 Aluminum heat-exchanger tubes are resistant to most petroleum products and a large number of organic and inorganic chemicals. Aluminum is very resistant to hydrogen sulfide and carbon dioxide. Alloy alclad 3003 tubes are generally recommended in those heat-exchanger services where salt or fresh cooling waters within a pH range of 5 to 8 pass through the tubes. Waters with a pH outside of this range may or may not be corrosive, depending on what compounds present in the water contribute to the acidity or alkalinity.

SUMMARY OF CHANGES

Committee B07 has identified the location of selected changes to this standard since the last issue (B234 – 04) that may impact the use of this standard. (Approved Nov. 1, 2010.)

- (1) Made editorial changes to Note 2.
- (2) Section 2, Referenced Documents; added B210M, B221M and CEN EN 14242, deleted E55.
- (3) Section 7, Chemical Composition; revised this section extensively to make it consistent with changes to other ASTM B07 extrusion specifications.
- (4) ANNEX A1; Revised to add current wording used in other ASTM B07 specifications.

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