



Standard Specification for Welded Copper-Alloy Pipe¹

This standard is issued under the fixed designation B608; 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 specification establishes the requirements for arc-welded pipe for use in brackish water or seawater piping systems.

1.2 *Units*—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.

1.3 The following hazard statement pertains only to the test method described in 8.2 and 14.3.2 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 *ASTM Standards*:²

[B169/B169M Specification for Aluminum Bronze Sheet, Strip, and Rolled Bar](#)

[B171/B171M Specification for Copper-Alloy Plate and Sheet for Pressure Vessels, Condensers, and Heat Exchangers](#)

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

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

[E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)

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

[E76 Test Methods for Chemical Analysis of Nickel-Copper Alloys](#)

[E190 Test Method for Guided Bend Test for Ductility of Welds](#)

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.

[E255 Practice for Sampling Copper and Copper Alloys for the Determination of Chemical Composition](#)

[E478 Test Methods for Chemical Analysis of Copper Alloys](#)

2.2 *AWS Standards*:³

[A 5.6 Covered Copper-Alloy Arc-Welding Electrodes](#)

[A 5.7 Copper and Copper-Alloy Welding Rods](#)

2.3 *ASME Standards*:⁴

[Boiler and Pressure Vessel Code, Nuclear Power Plant Components, Section III, Division I](#)

[Boiler and Pressure Vessel Code, Nondestructive Examination, Section V](#)

[Boiler and Pressure Vessel Code, Pressure Vessels, Section VIII, Division I](#)

[Boiler and Pressure Vessel Code, Welding Qualifications, Section IX](#)

3. Terminology

3.1 For definitions of terms related to copper and copper alloys, refer to Terminology [B846](#).

4. Ordering Information

4.1 Include the following information in contracts or purchase orders for product furnished under this specification:

4.1.1 ASTM specification designation and year of issue, (for example, B608 – 02),

4.1.2 Copper alloy UNS No. required (Section 5 and Table 1),

4.1.3 Dimensions required; diameter and wall thickness (Section 10),

4.1.4 Unit length required, and

4.1.5 When purchased for *ASME Boiler and Pressure Vessel Code* application (section 19.2).

4.2 The following options are available:

4.2.1 Determination of chemical composition (Section 6.1.1),

4.2.2 Transverse Guided-Bend bend test (Section 8.1),

4.2.3 Hydrostatic test (Section 8.2),

4.2.4 Radiographic examination (Section 8.3),

³ Available from American Welding Society (AWS), 550 NW LeJeune Rd., Miami, FL 33126, <http://www.aws.org>.

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

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

TABLE 1 Chemical Requirements

Copper Alloy UNS Number	Composition, %											
	Copper ^A	Nickel incl Cobalt	Aluminum	Lead, max	Iron	Zinc, max	Manganese, max	Sulfur, max	Phosphorus, max	Carbon, max	Tin	Si
C61300 ^B	remainder	0.15 max	6.0–7.5	0.01	2.0–3.0	0.10	0.20	...	0.015	...	0.20–0.50	0.10
C61400	remainder	...	6.0–8.0	0.01	1.5–3.5	0.20	1.0	...	0.015
C70620	86.5 % min	9.0–11.0	...	0.02	1.0–1.8	0.50	1.0	0.02	0.02	0.05
C71520	65.0 % min	29.0–33.0	...	0.02	0.40–1.0	0.50	1.0	0.02	0.02	0.05

^A Silver counting as copper.

^B When the product is for subsequent welding applications and is so specified by the purchaser, chromium shall be 0.05 % max, cadmium 0.05 % max, zinc 0.05 % max, and zirconium 0.05 % max.

- 4.2.4.1 The number of pipe lengths to be examined,
- 4.2.5 Liquid Penetrant examination (Section 8.4),
- 4.2.6 Weld reinforcement removal, (Section 9),
- 4.2.7 Certification (Section 18), and (Section 19)
- 4.2.8 Test Report (Section 20).

5. Material and Manufacture

5.1 Material:

5.1.1 The pipe shall be made from annealed copper alloy sheet or plate that conforms to the requirements of Specification **B169/B169M** for Copper Alloys UNS Nos. C61300 and C61400 or Specification **B171/B171M** for Copper Alloys UNS Nos. C70620 and C71520. These specifications reference Test Methods **E62**, **E76**, and **E478** for the appropriate chemical analysis.

5.2 Manufacture:

5.2.1 Welded joints shall be made either manually or automatically by an arc-welding process.

5.2.2 Filler metal, if used in an arc-welding process, shall conform to one of the following specifications and classifications shown for each base metal:

Base Metal Copper Alloy UNS Number	Filler Metal AWS Specification	
	A5.6	A5.7
C61300	ECuAl-A2	ERCuAl-A2
C61400	ECuAl-A2	ERCuAl-A2
C70620	ECuNi	ERCuNi
C71520	ECuNi	ERCuNi

5.2.3 Welding procedures and welding operators shall be qualified in accordance with the *ASME Boiler and Pressure Vessel Code*, Section IX.

5.2.4 Each length of pipe may contain more than one longitudinally welded joint.

5.2.4.1 The welded joint shall be a full-penetration weld and may have a reinforcing bead on each side; such reinforcement shall not be more than 1/16 in. (1.6 mm) per side measured in the radial direction.

5.2.4.2 At no place shall the thickness of the weld section be less than the thickness of the adjacent base metal.

5.2.4.3 The contour of the weld bead shall be smooth, having no sharp valley or groove at the weld center or edges.

5.2.4.4 Smooth concavity of the weld bead contour is acceptable, provided the minimum weld bead thickness is not less than the thickness of the adjacent base metal.

5.2.4.5 Any offset of base metal edges at a weld that is not within the tolerance of 10.2.7 shall be flared at a 3 to 1 minimum taper over the width of the finished weld, or if

necessary, by adding additional weld metal beyond what would otherwise be the edge of the weld. Such build-up welding shall be performed in accordance with the requirements of 5.2.3.

5.2.4.6 Weld reinforcement may be removed at the option of the manufacturer or when specified by the purchaser.

5.2.5 Weld defects shall be repaired by removal to sound metal and re-welding. A repaired weld shall meet all requirements of an original weld.

5.2.6 Base metal defects such as slivers, inclusions, or laps shall be repaired by removal to sound metal. Build-up welding shall be performed when such removal reduces the wall thickness below the minimum allowed by the specification. Such build-up welding shall be performed in accordance with the requirements of 5.2.3. The thickness of the repaired section shall meet the requirements of a welded joint.

5.2.7 Pipe shall be furnished in the as-welded condition (Section 3).

NOTE 1—Although no restriction is placed on the size of pipe that may be furnished under this specification, usage is normally limited to nominal sizes 4 in. and larger in diameter.

6. Chemical Composition

6.1 The pipe material shall conform to the chemical compositional requirements of **Table 1** for the specified alloy.

6.1.1 When the material of manufacturer has been certified to conform to the requirements of the strip specification to which it was ordered, the determination of composition is not required of the tube manufacturer or supplier unless specified in the contract or purchase order.

6.2 These composition limits do not preclude the presence of other elements. When required, limits shall be established and analysis required for unnamed elements by agreement between the manufacturer or supplier and the purchaser.

6.3 When determining composition, copper may be taken as the difference between the sum of results for specified elements and 100 %.

6.4 When all elements in **Table 1** for the specified alloy are determined the sum of results shall be as follows:

Copper Alloy UNS No.	Copper Plus Specified Elements, Percent, %, Minimum
C61300	99.8
C61400, C70620, C71520	99.5

7. Mechanical Property Requirements

7.1 Transverse Tensional Strength:

7.1.1 With the test taken across any weld, the pipe shall be capable of conforming to the value given in **Table 2** for the particular alloy.

8. Performance Requirements

8.1 *Transverse Guided-Bend Test:*

8.1.1 The transverse-face and root-guided bend test shall be taken with the weld in the center of the test specimen and there shall be no open defects exceeding 0.125 in. (3.18 mm) measured in any direction on the convex surface of the specimen when tested in accordance with Test Methods **E190**. Cracks originating from corners of the specimen shall not be considered.

8.1.2 This test is not required unless specified in the contract or purchase order.

8.2 *Hydrostatic Test:*

8.2.1 Each length of pipe shall be capable of withstanding an internal hydrostatic pressure sufficient to produce a fiber stress of 7 000 psi (48 MPa) without showing evidence of weakness, defects, or leakage. (See **15.3.2**.)

8.2.1.1 This requirement is not recommended for pipe with an outside diameter greater than 24 in. (610 mm).

8.2.2 No pipe size need be tested at a hydrostatic pressure greater than 1 000 psi (6 900 kPa).

8.2.3 This test is not required unless specified in the contract or purchase order.

8.3 *Radiographic Examination:*

8.3.1 When specified in the contract or purchase order, pipe shall be examined in accordance with the procedure and acceptance criteria of the *ASME Boiler and Pressure Vessel Code*, Section III, Division 1, or Section VIII, Division 1, as specified.

8.3.1.1 The number of pipe lengths to be examined shall be specified by the purchaser.

8.3.2 All welded joints in any individual length of pipe shall be radiographed completely.

8.4 *Liquid Penetration Examination:*

8.4.1 When specified in the contract or purchase order, all welded joints in all lengths of pipe shall be examined, both the inside and outside surfaces, in accordance with the procedure and acceptance criteria of the *ASME Boiler and Pressure Vessel Code*, Section III, Division 1, or Section VIII, Division 1, as specified.

9. Weld Reinforcement Removal

9.1 When specified in the contract or purchase order, weld reinforcement shall be removed completely from the inside surface and outside surface longitudinal welded joints.

9.2 Weld thickness shall conform to wall-thickness requirements after removal of reinforcement.

10. Dimensions, Mass, and Permissible Variations

10.1 *Dimensions:*

10.1.1 Pipe diameter shall be specified as a nominal diameter as shown in **Table 3**, **Table 4**, or **Table 5**.

10.1.2 Pipe wall thickness shall be that shown in **Table 3**, **Table 4**, or **Table 5** for the diameter and pressure class specified.

10.1.3 If a pipe outside-diameter or wall-thickness not specified in **Table 3**, **Table 4**, or **Table 5** is desired, the diameter and the wall thickness shall be specified in decimal fractions of an inch. (See section **21.1.1**.)

10.1.4 Pipe shall be furnished in 12 ft (3660 mm) lengths unless otherwise specified.

10.1.5 Circumferential welds, of the same quality as the longitudinal welds, may be used to create pipe lengths that are ordered longer than 12 ft (3660 mm).

10.2 *Permissible Variations:*

10.2.1 *Outside Diameter*—The average outside-diameter shall not vary from the specified outside-diameter by more than the tolerances specified in **Table 6**.

10.2.2 *Roundness*—The difference between the major and minor outside-diameter at any pipe cross section shall not be greater than the differences specified in **Table 7**.

10.2.3 *Wall Thickness*—The wall thickness at any point of the pipe shall not vary from the specified wall-thickness by more than the tolerances specified in **Table 8**.

10.2.4 *Length*—The length of any pipe shall be the specified length plus or minus 0.500 in. (13 mm).

10.2.5 *Straightness*—The maximum curvature (depth of arc), when measured as a deviation from a straightedge 10 ft (3.05 m) in length, shall not exceed 0.5 in. (13 mm).

10.2.6 *Squareness of Cut*—The departure from squareness of the end of any pipe shall not exceed 0.016 in./in. (0.016 mm/mm) of outside diameter.

10.2.7 *Offset*—Radial misalignment of two edges to be butt welded shall not exceed the offset tolerances specified in **Table 9**.

11. Workmanship, Finish, and Appearance

11.1 *Workmanship*—Roundness, straightness, ovality, and uniformity of contour shall be such as to make the product suitable for the intended application.

11.2 *Finish*—The inner and outer surfaces shall be such as to make the product suitable for the intended application. Repaired areas conforming to the requirements of this specification shall be acceptable.

12. Sampling

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

12.1.1 *Lot Size*—A lot shall consist of the following quantity, or fraction thereof, of pipe of the same alloy UNS No., diameter, and wall thickness manufactured at the same time:

TABLE 2 Transverse Tensile Strength

Copper Alloy UNS Number	Tensile Strength, min, ksi (MPa) ^A
C61300	70 (485)
C61400	70 (485)
C70620	40 (275)
C71520	50 (345)

^A See **Appendix X1**.

TABLE 3 Standard Sizes and Wall Thickness
Copper Alloy UNS Nos. C61300 and C61400

Inch-Pound Units, in. (SI Units, mm)						
Nominal Size	Outside Diameter, in.	Pressure Class, psi (kPa) ^A				
		50 (345)	75 (517)	100 (689)	150 (1034)	200 (1379)
4	4.50 (114.30)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)
5	5.563 (141.30)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)
6	6.625 (168.28)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)
8	8.625 (219.08)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)
10	10.75 (273.05)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.125 (3.18)	0.125 (3.18)
12	12.75 (323.85)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.125 (3.18)	0.165 (4.19)
14	14.00 (355.60)	0.125 (3.18)	0.125 (3.18)	0.125 (3.18)	0.125 (3.18)	0.165 (4.19)
16	16.00 (406.40)	0.125 (3.18)	0.125 (3.18)	0.125 (3.18)	0.134 (3.40)	0.187 (4.76)
18	18.00 (457.20)	0.125 (3.18)	0.125 (3.18)	0.125 (3.18)	0.165 (4.19)	0.187 (4.76)
20	20.00 (508.00)	0.125 (3.18)	0.125 (3.18)	0.125 (3.18)	0.165 (4.19)	0.250 (6.35)
24	24.00 (609.60)	0.125 (3.18)	0.125 (3.18)	0.134 (3.40)	0.187 (4.76)	0.250 (6.35)
30	30.00 (762.00)	0.134 (3.40)	0.134 (3.40)	0.165 (4.19)	0.250 (6.35)	0.312 (7.94)
36	36.00 (914.40)	0.134 (3.40)	0.165 (4.19)	0.187 (4.76)	0.312 (7.94)	0.375 (9.53)
42	42.00 (1066.80)	0.187 (4.76)	0.187 (4.76)	0.250 (6.35)	0.312 (7.94)	0.437 (11.1)
48	48.00 (1219.20)	0.187 (4.76)	0.187 (4.76)	0.250 (6.35)	0.375 (9.53)	0.437 (11.1)

^A Pressure ratings apply to any design temperature not exceeding 350°F (176°C). Pressure ratings are calculated for each size and pressure class based on a corrosion allowance of 0.020 in. (0.508 mm), a weld joint efficiency of 70 %, and the thickness tolerances shown in Table 8.

TABLE 4 Standard Sizes and Wall Thickness
Copper Alloy UNS No. C70620

Inch-Pound Units, in. (SI Units, mm)						
Nominal Size	Outside Diameter, in.	Pressure Class, psi (kPa) ^A				
		50 (345)	75 (517)	100 (689)	150 (1034)	200 (1379)
4	4.50 (114.30)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.109 (2.77)
5	5.563 (141.30)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.125 (3.18)
6	6.625 (168.28)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.109 (2.77)	0.134 (3.40)
8	8.625 (219.08)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.148 (3.76)	0.165 (4.19)
10	10.75 (273.05)	0.094 (2.38)	0.094 (2.38)	0.125 (3.18)	0.165 (4.19)	0.250 (6.35)
12	12.75 (323.85)	0.094 (2.38)	0.125 (3.18)	0.134 (3.40)	0.187 (4.76)	0.250 (6.35)
14	14.00 (355.60)	0.125 (3.18)	0.125 (3.18)	0.148 (3.76)	0.250 (6.35)	0.250 (6.35)
16	16.00 (406.40)	0.125 (3.18)	0.125 (3.18)	0.165 (4.19)	0.250 (6.35)	0.312 (7.94)
18	18.00 (457.20)	0.125 (3.18)	0.148 (3.76)	0.187 (4.76)	0.250 (6.35)	0.312 (7.94)
20	20.00 (508.00)	0.125 (3.18)	0.148 (3.76)	0.187 (4.76)	0.312 (7.94)	0.375 (9.53)
24	24.00 (609.60)	0.134 (3.40)	0.187 (4.76)	0.250 (6.35)	0.312 (7.94)	0.437 (11.1)
30	30.00 (762.00)	0.148 (3.76)	0.250 (6.35)	0.312 (7.94)	0.437 (11.1)	0.500 (12.7)
36	36.00 (914.40)	0.187 (4.76)	0.250 (6.35)	0.312 (7.94)	0.500 (12.7)	0.625 (15.9)
42	42.00 (1066.80)	0.250 (6.35)	0.312 (7.94)	0.375 (9.53)	0.562 (14.3)	0.687 (17.5)
48	48.00 (1219.20)	0.250 (6.35)	0.312 (7.94)	0.437 (11.1)	0.625 (15.9)	0.812 (20.6)

^A Pressure ratings apply to any design temperature not exceeding 150°F (65°C). Pressure ratings are calculated for each size and pressure class based on a corrosion allowance of 0.020 in. (0.508 mm), a weld joint efficiency of 70 %, and the thickness tolerances shown in Table 8.

Outside Diameter, in. (mm)	Lot Size, ft (m)
Up to 10.750 (273) incl	1000 (305)
Over 10.75 to 24 (273 to 610) incl	500 (152)
Over 24 to 36 (610 to 914)	200 (61)
Over 36 to 48 (914 to 1220)	100 (30.5)
Over 48 (1220)	50 (15.2)

12.1.2 *Portion Size*—The number of lengths to be selected shall be as agreed upon between the manufacturer or supplier and the purchaser.

12.1.3 *Selection of Samples*—The sample piece(s) shall be randomly selected.

12.2 *Chemical Analysis*—When determination of the alloy composition is specified in the contract or purchase order, the sample shall be taken and prepared in accordance with Practice E255 from the length(s) selected in 12.1.2.

12.3 *Other Tests*—Test specimens shall be taken from the length(s) selected in 12.1.2.

13. Number of Tests and Retests

13.1 Tests:

13.1.1 *Chemical Analysis*—Composition shall be determined as the average of results from at least two replicate analysis for each specified element.

13.1.2 *Transverse Tensile Strength*—Conformance with test requirements shall be determined by the test result of one specimen.

13.1.3 *Transverse-Guided Bend Test*—Conformance with test requirements shall be determined by the test result of one transverse-root bend test and one transverse-face bend test.

13.2 Retests:

13.2.1 In the event only one sample piece was selected in 12.1.2, retest shall not be permitted.

13.2.2 *Chemical Analysis*—If one, or more, of the elements with specified limits fail to meet the composition requirement

TABLE 5 Standard Sizes and Wall Thicknesses
Copper Alloy UNS No. C71520

Inch-Pound Units, in. (SI Units, mm)						
Nominal Diameter	Outside Diameter, in.	Pressure Class, psi (kPa) ^A				
		50 (345)	75 (517)	100 (689)	150 (1034)	200 (1379)
4	4.50 (114.30)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)
5	5.563 (141.30)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.109 (2.77)
6	6.625 (168.28)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.125 (3.18)
8	8.625 (219.08)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.125 (3.18)	0.148 (3.76)
10	10.75 (273.05)	0.094 (2.38)	0.094 (2.38)	0.094 (2.38)	0.125 (3.18)	0.165 (4.19)
12	12.75 (323.85)	0.094 (2.38)	0.094 (2.38)	0.125 (3.18)	0.165 (4.19)	0.250 (6.35)
14	14.00 (355.60)	0.125 (3.18)	0.125 (3.18)	0.125 (3.18)	0.187 (4.76)	0.250 (6.35)
16	16.00 (406.40)	0.125 (3.18)	0.125 (3.18)	0.148 (3.76)	0.187 (4.76)	0.250 (6.35)
18	18.00 (457.20)	0.125 (3.18)	0.125 (3.18)	0.125 (3.18)	0.250 (6.35)	0.312 (7.94)
20	20.00 (508.00)	0.125 (3.18)	0.134 (3.40)	0.165 (4.19)	0.250 (6.35)	0.312 (7.94)
24	24.00 (609.60)	0.125 (3.18)	0.165 (4.19)	0.187 (4.76)	0.312 (7.94)	0.375 (9.53)
30	30.00 (762.00)	0.134 (3.40)	0.187 (4.76)	0.250 (6.35)	0.375 (9.53)	0.437 (11.1)
36	36.00 (914.40)	0.165 (4.19)	0.250 (6.35)	0.312 (7.94)	0.437 (11.1)	0.500 (12.7)
42	42.00 (1066.80)	0.187 (4.76)	0.250 (6.35)	0.312 (7.94)	0.437 (11.1)	0.625 (15.9)
48	48.00 (1219.20)	0.187 (4.76)	0.312 (7.94)	0.375 (9.53)	0.500 (12.7)	0.687 (17.5)

^A Pressure ratings apply to any design temperature not exceeding 150°F (65°C). Pressure ratings are calculated for each size and pressure class based on a corrosion allowance of 0.020 in. (0.508 mm), a weld joint efficiency of 70 %, and the thickness tolerances shown in Table 8.

TABLE 6 Average Outside Diameter Tolerances, in. (mm)^A

Specified Outside Diameter	Tolerance, plus and minus
Up to 8.625 (219), incl	0.031 (0.79)
Over 8.625 to 18 (219 to 457), incl	0.063 (1.6)
Over 18 to 30 (457 to 762), incl	0.094 (2.4)
Over 30 to 48 (762 to 1220), incl	0.125 (3.2)
Over 48 (1220)	0.3 %

^A The average outside diameter of a pipe is the outside circumference at any one cross section of the pipe divided by 3.1416.

TABLE 7 Roundness Requirements, in. (mm)^A

Specified Outside Diameter	Roundness, % ^A
Up to 8.625 (219), incl	3.0
Over 8.625 to 18 (219 to 457), incl	2.5
Over 18 to 24 (457 to 610), incl	2.0
Over 24 to 48 (610 to 1220), incl	1.5
Over 48 (1220)	1.0

^A The roundness of a pipe is the difference between the major and minor outside pipe diameter, as determined at any one cross section, divided by the specified outside diameter and expressed in percent.

TABLE 8 Wall Thickness Tolerances, in. (mm)^A

Specified Wall Thickness	Tolerance, plus and minus
Up to 0.094 (2.38), incl	0.010 (0.25)
Over 0.094 to 0.134 (2.38 to 3.40), incl	0.014 (0.36)
Over 0.134 to 0.250 (3.40 to 6.35), incl	0.016 (0.41)
Over 0.250 to 0.500 (6.35 to 12.7), incl	0.023 (0.58)
Over 0.500 to 0.750 (12.7 to 19.1), incl	0.029 (0.74)
Over 0.750 to 1.000 (19.1 to 25.4), incl	0.037 (0.94)
Over 1.000 (25.4)	0.045 (1.10)

^A Maximum deviation at any point.

of the product specification, a retest may be permitted from a new composite sample prepared as directed in 12.1.2, and the number of replicate determinations shall be doubled.

13.2.3 *Other Tests*—Should a test specimen fail to conform to a test requirement of the product specification, a retest may be permitted with specimens prepared from the remaining pieces of the finished product selected in 12.1.2, and the number of test specimens shall be doubled.

TABLE 9 Weld Offset Tolerances, in. (mm)

Specified Wall Thickness (t)	Radial Offset
	Longitudinal
	Weld
Up to 0.125 (3.18), incl	¼ t
Over 0.125 to 0.250 (3.18 to 6.35), incl	0.032 (0.81)
Over 0.250 to 0.375 (6.35 to 9.53), incl	0.047 (1.20)
Over 0.375 to 0.500 (9.53 to 12.7), incl	0.063 (1.60)
Over 0.500 to 0.750 (12.7 to 19.1), incl	0.063 (1.60)
Over 0.750 (19.1)	0.094 (2.40)

13.2.4 All test specimens shall conform to specification requirements in retest, and failure to comply shall be cause for lot rejection.

13.2.5 *Umpire Test:*

13.2.5.1 In the case where the retest does not settle the dispute, a test may be permitted by a qualified laboratory agreeable to manufacturer or supplier and the purchaser.

13.2.5.2 The sample shall be taken and test specimens prepared as directed in this specification.

13.2.5.3 The test method to be followed shall be as specified in this specification.

14. Specimen Preparation

14.1 *Chemical Analysis:*

14.1.1 Preparation of the analytical test specimen shall be the responsibility of the reporting laboratory.

14.2 *Transverse Tensile Test:*

14.2.1 The test specimen shall conform to the requirements of Test Specimens section and Fig. 13, Standard Test Specimen for Cast Iron, of Test Methods E8.

14.2.2 The test specimen shall be of the full thickness of the base metal and shall be taken from the end of the finished pipe and flattened cold and machined to test-specimen dimensions.

14.2.3 Alternatively, the test specimen may be taken from a test plate of the same material as the pipe which has been attached to the end of the pipe and welded as a prolongation of the longitudinal seam.

14.3 *Transverse-Guided Bend Test:*

14.3.1 The test specimens shall be taken from the pipe with the weld joint in the approximate center of the specimens.

14.3.2 The test specimens shall be of the full thickness of the base metal and shall be taken from the end of the finished pipe and flattened cold and cut to test specimen size as described in Test Method **E190**.

15. Test Methods

15.1 Test methods used for production control or quality control, or both, for determining conformance with product property requirements are discretionary.

15.1.1 Test methods used to obtain data for preparation of certification and test report shall be made available to the purchaser upon request.

15.2 *Chemical Analysis:*

15.2.1 The test methods used for determining chemical composition shall, in case of dispute, be as specified in the specification under which the manufacturing material was ordered.

15.2.2 Test methods used for the determination of elements required by contractual or purchase-order agreement shall be as agreed upon between the manufacturer and the purchaser.

15.3 *Other Tests:*

15.3.1 The product furnished shall conform with the mechanical and other requirements enumerated in this specification, when tested in accordance with the following appropriate method:

Test	Method
Tension	E8
Transverse Guided-Bend Test	E190
Hydrostatic	Section 15.3.2

15.3.1.1 Tensile strength shall be determined in accordance with Test Methods **E8**. Test results are not seriously affected by variations in speed of testing. However, the rate of stressing to the yield strength should not exceed 50 ksi/min. Above the yield strength the movement per minute of the testing machine head under load should not exceed 0.5 in./in. (0.5 mm) of gage length (or distance between grips for full section specimens).

15.3.2 *Hydrostatic Test:*

15.3.2.1 The internal hydrostatic pressure necessary to produce the required fiber stress shall be determined by the following equation:

$$P = 2St/(D - 0.8t) \quad (1)$$

where:

- P = hydrostatic pressure, psi (or MPa),
- t = thickness of tube wall, in. (or mm),
- D = outside diameter of tube, in. (or mm), and
- S = allowable fiber stress of the material, psi (or MPa).

16. Significance of Numerical Limits

16.1 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 significant digit used in expressing the limiting value
Tensile strength	nearest ksi (5 MPa)

17. Inspection

17.1 The manufacturer shall inspect and make necessary tests to verify that the pipe furnished conforms to the requirements of this specification.

17.2 If, in addition, the purchaser elects to perform his own inspection, the manufacturer shall afford the inspector all reasonable facilities to satisfy him that the pipe furnished conforms to the requirements of this specification. All tests and inspections shall be made at the place of manufacture prior to shipment, unless otherwise specified, and shall be so conducted as not to interfere with the operation of the works. When automated finishing and inspection equipment is available at a facility, purchaser and manufacturer or supplier may by mutual agreement accomplish the final inspection simultaneously.

18. Rejection and Rehearing

18.1 *Rejection:*

18.1.1 Material that fails to conform to the requirements of this specification, when tested by the purchaser or purchaser's agent, shall be subject to rejection.

18.1.2 Rejection shall be reported to the manufacturer, or supplier, promptly. In addition, a written notification shall follow.

18.1.3 In case of dissatisfaction with the results of the test upon which rejection is based, the manufacturer, or supplier, may make claim for a rehearing.

18.1.4 Radiographic or liquid penetrant examinations by the purchaser shall not be a basis for rejection unless those examinations were specified in the contract or purchase order at the time of ordering.

18.2 *Rehearing:*

18.2.1 As a result of product rejection, the manufacturer, or supplier, may make claim for a retest to be conducted by the manufacturer, or supplier, and the purchaser. Samples of the rejected product shall be taken in accordance with the specification and subjected to test by both parties using the test method(s) specified in the specification, or, alternately, upon agreement of both parties, an independent laboratory may be selected for the test(s) using the test method(s) specified in the specification.

19. Certification

19.1 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 the requirements have been met.

19.2 Certification is mandatory when the product is for *ASME Boiler and Pressure Vessel Code* application. For such application, an *ASME Form U-2 Manufacturer's Partial Data Report* is required.

20. Test Report

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

21. Product Marking

21.1 Each length of pipe shall be marked with the specification number, alloy UNS No., nominal size, pressure class, and the trademark of the manufacturer.

21.1.1 When a nonstandard size or wall thickness has been specified, the markings shall contain the exact outside diameter and wall thickness in inches instead of the nominal diameter.

22. Packaging and Package Marking

22.1 *Packaging*—The product 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 and to afford protection from the normal hazards of transportation.

22.2 *Package Marking*—Each shipping unit shall be legibly marked with the purchase-order number, metal or alloy designation, temper, size, shape, gross and net weight, and name of supplier. The specification number shall be shown when specified.

23. Keywords

23.1 copper-alloy pipe; welded copper-alloy pipe; welded pipe; UNS No. C61300; UNS No. C61400; UNS No. C70620; UNS No. C71520

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 ($N = \text{kg}\cdot\text{m}/\text{s}^2$). 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 (B608 – 07), that may impact the use of this standard. (Approved Oct. 1, 2011)

(1) Minor changes to conform to Outline of Form.

(2) Change of AWS document to A 5.6.

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