Designation: B747 – 15

Standard Specification for Copper-Zirconium Alloy Sheet and Strip [1]

This standard is issued under the fixed designation B747; 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 Copper Alloy UNS C15100 sheet and strip.

1.2 *Units*—Values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units, which are provided for information only and are not considered standard.

2. Referenced Documents

2.1 *ASTM Standards:*[2]

B193 Test Method for Resistivity of Electrical Conductor Materials

B248 Specification for General Requirements for Wrought Copper and Copper-Alloy Plate, Sheet, Strip, and Rolled Bar

B601 Classification for Temper Designations for Copper and Copper Alloys—Wrought and Cast

B846 Terminology for Copper and Copper Alloys

E3 Guide for Preparation of Metallographic Specimens

E8/E8M Test Methods for Tension Testing of Metallic Materials

E53 Test Method for Determination of Copper in Unalloyed Copper by Gravimetry

E112 Test Methods for Determining Average Grain Size

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

E478 Test Methods for Chemical Analysis of Copper Alloys

3. General Requirements

3.1 The following sections of Specification B248 constitute a part of this specification:

3.1.1 Terminology,
3.1.2 Workmanship, Finish, and Appearance,
3.1.3 Sampling,
3.1.4 Number of Tests and Retests,
3.1.5 Specimen Preparation,
3.1.6 Significance of Numerical Limits,
3.1.7 Inspection,
3.1.8 Rejection and Rehearing,
3.1.9 Certification,
3.1.10 Test Report,
3.1.11 Packaging and Package Marking, and
3.1.12 Supplementary Requirements.

4. Terminology

4.1 For definition of terms related to copper and copper alloys, refer to Terminology B846.

5. Ordering Information

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

5.1.1 ASTM designation number and year of issue,
5.1.2 Copper [Alloy] UNS No. designation,
5.1.3 Temper,
5.1.4 Dimensions (thickness, width, length, if applicable),
5.1.5 How furnished (rolls, specific lengths with or without ends, stock lengths with or without ends),
5.1.6 Quantity–total weight or total length or number of pieces of each size,
5.1.7 Type of edge, if required (slit, sheared, sawed, square corners, rounded corners, rounded edges, or full-rounded edges),
5.1.8 Type of width and straightness tolerances, if required (slit metal tolerances, square sheared metal tolerances, sawed metal tolerances, straightened or edge-rolled metal tolerances), and
5.1.9 Intended application.

5.2 The following options are available but may not be included unless specified at the time of placing of the order when required:

5.2.1 Heat identification or traceability details,
5.2.2 Certification,
5.2.3 Test Report,
5.2.4 If product specification number must be shown on package marking, and
5.2.5 If product is purchased for agencies of the U.S. Government (See Supplemental Requirements section of Specification B248 for additional requirements).

[1] This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.01 on Plate, Sheet, and Strip.

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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.

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

6. Materials and Manufacture

6.1 *Materials:*

6.1.1 The material of manufacture shall be a form (cast bar, cake, slab, etcetera) of Copper Alloy UNS No. C15100 of such purity and soundness as to be suitable for processing into the products prescribed herein.

6.1.2 When specified in the contract or purchase order, that heat identification or traceability is required, the purchaser shall specify the details desired.

NOTE 1—Due to the discontinuous nature of the processing of castings into wrought products, it is not always practical to identify a specific casting analysis with a specific quantity of finished material.

6.2 *Manufacture:*

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

6.2.2 The product shall be hot- or cold-worked to the finished size, and subsequently annealed when required, to meet the temper properties specified.

6.3 *Edges:*

6.3.1 Slit edges shall be furnished unless otherwise specified in the contract or purchase order.

7. Chemical Composition

7.1 The material shall conform to the chemical composition requirements in Table 1.

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

7.3 When all elements in Table 1 are determined, the sum of the results shall be 99.9 % min.

8. Temper

8.1 The standard tempers for products described in this specification are given in Table 2.

8.1.1 Cold rolled tempers H01 to H08.

8.1.2 Annealed temper OS015.

9. Grain Size for Annealed Temper

9.1 Grain size shall be the standard requirement for all product in the annealed tempers.

9.2 Acceptance or rejection based upon grain size shall depend only on the average grain size of a test specimen taken from each of two sample portions, and each specimen shall be within the limits prescribed in Table 2 when determined in accordance with Test Methods E112.

TABLE 1 Chemical Requirements

Element	Composition, %
	Copper Alloy UNS No. C15100
Copper (including Ag)	99.80 % min
Zirconium	0.05–0.15
Cu + sum of named elements	99.9 % min

TABLE 2 Tensile Strength and Grain Size Requirements

Temper Designation[A]		Tensile Strength, ksi[B] (MPa)[C]		Grain Size, mm[D]
Code	Name	Min	Max	
OS015	annealed	...	...	0.030 max
H01	quarter hard	40 (275)	45 (310)	...
H02	half hard	43 (295)	51 (350)	...
H03	three-quarter hard	47 (325)	56 (385)	...
H04	hard	53 (365)	62 (425)	...
H06	extra hard	59 (405)	65 (450)	...
H08	spring	64 (440)	71 (490)	...

[A] Standard designations defined in Classification B601.
[B] ksi = 1000 psi.
[C] See Appendix X1.
[D] Although no minimum grain size is required, this material must be fully recrystallized.

10. Physical Property Requirements

10.1 *Electrical Resistivity Requirement:*

10.1.1 The product furnished shall conform to the electrical mass resistivity requirement prescribed in Table 3 when tested in accordance with Test Method B193.

11. Mechanical Property Requirements

11.1 *Tensile Strength Requirements:*

11.1.1 Product furnished under this specification shall conform to the tensile requirements prescribed in Table 2, when tested in accordance with Test Methods E8/E8M.

11.1.2 Acceptance or rejection based upon mechanical properties shall depend only on tensile strength.

12. Dimensions, Mass, and Permissible Variation

12.1 The dimensions and tolerances for product described by this specification shall be as specified in Specification B248 with particular reference to the following tables and related paragraphs as noted to Specification B747 in the table title:

12.1.1 *Thickness.*

12.1.2 *Width:*

12.1.2.1 *Slit Metal and Slit Metal with Rolled Edges.*

12.1.2.2 *Square Sheared Metal.*

12.1.2.3 *Sawed Metal.*

12.1.3 *Length:*

12.1.3.1 *Length Tolerance for Straight Lengths.*

12.1.3.2 *Schedule for Minimum Lengths and Maximum Weights of Ends for Specific Lengths with Ends, and Stock Lengths with Ends.*

12.1.3.3 *Length Tolerance for Square Sheared Metal.*

12.1.3.4 *Length Tolerance for Sawed Metal.*

12.1.4 *Straightness:*

12.1.4.1 *Slit Metal or Slit Metal Either Straightened or Edge Rolled.*

TABLE 3 Electrical Resistivity

Temper	Electrical Resistivity at 20°C (68°F), max, Ω·g/m^2	Equivalent Conductivity at 20°C (68°F), % IACS, min
Annealed (OS015)	0.16136	95
Rolled (H01, H02, H03, H04, H06, H08)	0.17031	90

12.1.4.2 *Square Sheared Metal.*
12.1.4.3 *Sawed Metal.*
12.1.5 *Edges Contours:*
12.1.5.1 *Square Corners.*
12.1.5.2 *Rounded Corners.*
12.1.5.3 *Rounded Edges.*
12.1.5.4 *Full-Rounded Edges.*

13. Workmanship, Finish, and Appearance

13.1 The product shall be free of defects, but blemishes of a nature that do not interfere with the intended application are acceptable. It shall be well-cleaned and free of dirt. A superficial film of residual light lubricant is normally present and is acceptable unless otherwise specified.

13.2 The surface finish and appearance shall be the normal commercial quality for the alloy, thickness, and temper ordered. When application information is provided with the purchase order, the surface shall be that commercially producible for the application. Superficial films of discoloration, or lubricants, or tarnish inhibitors are permissible unless otherwise specified.

14. Sampling

14.1 *Sampling*—The lot size, portion size, and selection of sample pieces shall be as follows:

14.1.1 *Lot Size*—An inspection lot shall be 40 000 lb (18 144 kg) or less, of the same mill form, alloy, temper, and nominal dimensions, subject to inspection at one time.

14.1.2 *Portion Size*—The portion shall be eight or more pieces selected as to be representative of each lot. Should the lot consist of less than eight pieces, representative samples shall be taken from each piece.

14.2 *Chemical Analysis:*

14.2.1 The sample for chemical analysis shall be taken in accordance with Practice E255 for product in its final form from the pieces selected in 14.1.2 and combined into one composite sample. The minimum weight of the composite sample shall be 150 g.

14.2.2 Instead of sampling as directed in 14.2.1, the manufacturer shall have the option of sampling at the time castings are poured or from the semifinished product. When samples are taken during the course of manufacture, sampling of the finished product by the manufacturer is not required. The number of samples taken for the determination of composition shall be as follows:

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

14.2.2.2 When samples are taken from semifinished product, a sample shall be taken to represent each 10 000 lbs (5000 kg) or fraction thereof, except that not more than one sample shall be required per piece.

14.2.2.3 Only one sample need be taken from the semifinished product of one cast bar from a single melt charge continuously processed.

14.3 *Samples for all Other Tests*—Samples for all other tests shall be taken from the sample portions selected in 14.1.2 and be of a convenient size to accommodate the test and comply with the requirements of the appropriate product specification and test method.

15. Number of Tests and Retests

15.1 *Test:*

15.1.1 *Chemical Analysis*—Chemical composition shall be determined in accordance with the element mean of the results from at least two replicate analyses of the sample(s).

15.2 *Other Tests:*

15.2.1 *Mechanical Properties and Grain Size*—Unless otherwise provided in the product specification, test specimens shall be taken from two of the sample pieces selected in accordance with 14.1.2. The required tests shall be made on each of the specimens so selected.

15.2.2 *Electrical Resistivity*—Results shall be reported from four of the sample pieces selected in accordance with 14.1.2. The required tests shall be made on each of the specimens so selected.

15.3 *Retest:*

15.3.1 When requested by the manufacturer or supplier, a retest shall be permitted when results of tests obtained by the purchaser fail to conform to the requirements of the products specification.

15.3.2 The retest shall be as directed in the product specification for the initial test, except the number of test specimens shall be twice that normally required for the specified test.

15.3.3 All test specimens shall conform to the products specification requirement(s) in retest. Failure to conform shall be cause for rejection.

16. Specimen Preparation

16.1 *Grain Size*—All specimens shall be prepared as specified in Guide E3.

16.2 *Mechanical Tests*—All samples of strip less than ¾ in. wide shall be pulled in full size when practicable. Machined test specimens shall be as specified in Test Methods E8/E8M, Fig. 1 for sheet type specimens.

16.3 *Chemical Composition*—The composite sample for laboratory analysis shall, in case of disagreement, be prepared in accordance with Practice E255.

17. Test Methods

17.1 *Chemical Analyses:*

17.1.1 In cases of disagreement, test methods for chemical analysis shall be subject to agreement between the manufacturer or supplier and the purchaser. The following table is a list of published methods, some of which may no longer be viable, which along with others not listed, may be used subject to agreement:

Test	Method
Copper	E53
Silver	E478

17.1.2 Test method(s) to be followed for the determination of element(s) resulting from contractual or purchase order agreement shall be as agreed upon between the manufacturer or supplier and the purchaser.

17.1.3 Since no recognized test method is known to be published, the determination of zirconium shall be subject to the agreement between the manufacturer and purchaser.

17.2 *Other Tests:*

17.2.1 The product furnished shall conform to specified requirements when subjected to test in accordance with the following table:

Test	Method
Grain Size	E112
Electrical Resistivity	B193
Tensile Strength	E8/E8M

18. Significance of Numerical Limits

18.1 For the purpose of determining compliance with the specified limits for requirements of the properties listed in the following table and for dimensional tolerances, 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)
Grain Size:	
Under 0.060 mm	Nearest multiple of 0.005 mm
0.060 mm and over	Nearest 0.01 mm

19. Inspection

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

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

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

20. Rejection and Rehearing

20.1 *Rejection:*

20.1.1 Product that fails to conform to the specification requirements when tested by the purchaser or purchaser's agent shall be subject to rejection.

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

20.1.3 In case of dissatisfaction with results of the test upon which rejection is based, the manufacturer, or supplier, shall have the option to make claim for a rehearing.

20.2 *Rehearing:*

20.2.1 As a result of product rejection, the manufacturer, or supplier, shall have the option to 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 product specification and subjected to test by both parties using the test method(s) specified in the product 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 product specification.

21. Certification

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

22. Test Report

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

23. Packaging and Package Marking

23.1 *Packaging:*

23.1.1 The product shall be separated by size, composition, and temper, and prepared for shipment by common carrier, in such a manner to afford protection from the normal hazards of transportation.

23.2 *Package Marking:*

23.2.1 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.

23.2.2 When specified in the contract or purchase order, the product specification number shall be shown.

24. Keywords

24.1 copper-zirconium; sheet and strip; UNS No. C15100

APPENDIX

(Nonmandatory Information)

X1. METRIC EQUIVALENTS

X1.1 The SI unit for strength properties now shown is in accordance with the International System of Units (SI). The derived SI unit for force is the newton (N), which is defined as that force which when applied to a body having a mass of one kilogram gives it an acceleration of one metre per second squared ($N = kg\ m/s^2$). The derived SI unit for pressure or stress is the newton per square metre (N/m^2), which has been named the pascal (Pa) by the General Conference on Weights and Measures. Since 1 ksi = 6 894 757 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 principal changes to this specification that have been incorporated since the 2011 issue, as follows:

(1) Made editorial corrections to the standard to ensure it conforms to proper form and style.