

BRITISH STANDARD

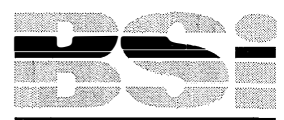
**BS EN
12451:1999**

Copper and copper alloys — Seamless, round tubes for heat exchangers

The European Standard EN 12451:1999 has the status of a British Standard

ICS 77.150.30

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National foreword

This British Standard is the English language version of EN 12451:1999. It supersedes BS 2871-3:1972 which is withdrawn.

The UK participation in its preparation was entrusted by Technical Committee NFE/34, Copper and copper alloys, to Subcommittee NFE/34/1, Wrought and unwrought copper and copper alloys, which has the responsibility to:

- aid enquirers to understand the text;
- present to the responsible European committee any enquiries on the interpretation, or proposals for change, and keep the UK interests informed;
- monitor related international and European developments and promulgate them in the UK.

A list of organizations represented on this subcommittee can be obtained on request to its secretary.

Cross-references

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Summary of pages

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EUROPEAN STANDARD

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English version

Copper and copper alloys — Seamless, round tubes for heat exchangers

Cuivre et alliages de cuivre — Tubes ronds sans soudure
pour échangeurs thermiques

Kupfer und Kupferlegierungen — Nahtlose Rundrohre für
Wärmeaustauscher

This European Standard was approved by CEN on 14 June 1999.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
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Contents

	Page		Page
Foreword	3	9 Declaration of conformity and inspection documentation	12
1 Scope	4	9.1 Declaration of conformity	12
2 Normative references	4	9.2 Inspection documentation	12
3 Definitions	4	10 Marking, packaging, labelling	12
4 Designations	5	Table 1: Composition of copper and copper alloys	13
4.1 Material	5	Table 2: Mechanical properties of copper and copper alloys	14
4.2 Material condition	5	Table 3: Tolerances on diameter	15
4.3 Product	5	Table 4: Tolerances on length	15
5 Ordering information	6	Table 5: Tolerances on squareness of cut	15
6 Requirements	7	Table 6: Sampling rate	15
6.1 Composition	7	Table 7: Drill sizes for production of reference standard tubes	16
6.2 Mechanical properties	7	Annex A (informative) Bibliography	17
6.3 Dimensions and tolerances	7	Annex B (normative) U-bend seamless copper and copper alloy heat exchanger tubes	18
6.4 Surface quality	8	Annex ZA (informative) Clauses of this European Standard addressing essential requirements or other provisions of EU Directives	20
6.5 Technological requirements	8		
7 Sampling	9		
7.1 General	9		
7.2 Analysis	9		
7.3 Mechanical tests and stress corrosion resistance test	9		
8 Test methods	9		
8.1 Analysis	9		
8.2 Tensile test	10		
8.3 Hardness test	10		
8.4 Technological tests	10		
8.5 Freedom from defects tests	10		
8.6 Retests	11		
8.7 Rounding of results	11		

Foreword

This European Standard has been prepared by Technical Committee CEN/TC 133 "Copper and copper alloys", the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by January 2000, and conflicting national standards shall be withdrawn at the latest by January 2000.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of this standard.

Within its programme of work, Technical Committee CEN/TC 133 requested CEN/TC 133/WG 3.2 "Tubes for general purposes" to prepare the following standard:

EN 12451

Copper and copper alloys – Seamless, round tubes for heat exchangers

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association and supports essential requirements of EU Directives.

For relationship with EU Directives, see annex ZA (informative) which is an integral part of this standard.

This is one of a series of European Standards for copper and copper alloy tubes. Other products are, or will be, specified as follows:

EN 1057

Copper and copper alloys – Seamless, round copper tubes for water and gas in sanitary and heating applications

EN 12449

Copper and copper alloys – Seamless, round tubes for general purposes

EN 12450

Copper and copper alloys – Seamless, round copper capillary tubes

EN 12452

Copper and copper alloys – Rolled, finned, seamless tubes for heat exchangers

prEN 12735-1

Copper and copper alloys – Seamless, round copper tubes for air conditioning and refrigeration – Part 1: Tubes for piping systems

prEN 12735-2

Copper and copper alloys – Seamless, round copper tubes for air conditioning and refrigeration – Part 2: Tubes for equipment

prEN 13348

Copper and copper alloys – Seamless, round copper tubes for medical gases

prEN 13349

Copper and copper alloys – Pre-insulated copper tubes with solid covering

prEN 13600

Copper and copper alloys – Seamless copper tubes for electrical purposes

According to CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard:

1 Scope

This European Standard specifies the composition, property requirements and tolerances on dimensions and form for seamless round drawn copper and copper alloy tubes for heat exchangers, condensers, evaporators and desalination equipment, supplied in the size range from 6 mm up to and including 76 mm outside diameter and from 0,5 mm up to and including 3 mm wall thickness.

The sampling procedures and the methods of test for verification of conformity to the requirements of this standard are also specified.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 1655

Copper and copper alloys – Declarations of conformity

EN 1971

Copper and copper alloys – Eddy current test for tubes

EN 10002-1

Metallic materials – Tensile testing – Part 1: Method of test (at ambient temperature)

EN 10204

Metallic products – Types of inspection documents

EN 10234

Metallic materials – Tube – Drift expanding test

EN ISO 196

Wrought copper and copper alloys – Detection of residual stress – Mercury(I) nitrate test (ISO 196 : 1978)

EN ISO 2624

Copper and copper alloys – Estimation of average grain size (ISO 2624 : 1990)

EN ISO 6507-1

Metallic materials – Vickers hardness test – Part 1: Test method (ISO 6507-1:1997)

ISO 6957

Copper alloys – Ammonia test for stress corrosion resistance

NOTE: Informative references to documents used in the preparation of this standard, and cited at the appropriate places in the text, are listed in a bibliography, see annex A.

3 Definitions

For the purposes of this standard, the following definitions apply:

3.1 seamless round tube

Hollow semi-finished product, circular in cross section, having a uniform wall thickness which at all stages of production has a continuous periphery.

3.2 mean wall thickness

Arithmetical mean of the maximum and minimum wall thicknesses at the same cross section of the tube.

3.3 deviation from circular form

Difference between the maximum and minimum outside diameters measured at any one cross section of the tube.

4 Designations

4.1 Material

4.1.1 General

The material is designated either by symbol or number (see table 1).

4.1.2 Symbol

The material symbol designation is based on the designation system given in ISO 1190-1.

NOTE: Although material symbol designations used in this standard might be the same as those in other standards using the designation system given in ISO 1190-1, the detailed composition requirements are not necessarily the same.

4.1.3 Number

The material number designation is in accordance with the system given in EN 1412.

4.2 Material condition

For the purposes of this standard, the following designations, which are in accordance with the system given in EN 1173, apply for the material condition:

R... Material condition designated by the minimum value of tensile strength requirement for the product with mandatory tensile property requirements;

H... Material condition designated by the minimum value of hardness requirement for the product with mandatory hardness requirements.

NOTE 1: Products in the H... condition can be specified to Vickers or Brinell hardness. The condition designation H... is the same for both hardness test methods.

S (suffix) Material condition for a product which is stress relieved.

NOTE 2: Products in the R... or H... condition can be specially processed (i.e. mechanically or thermally stress relieved) in order to lower the residual stress level to improve the resistance to stress corrosion (see 6.5.2).

Exact conversion between material conditions designated R... and H... is not possible.

Except when the suffix S is used, material condition is designated by only one of the above designations.

4.3 Product

The product designation provides a standardized pattern of designation from which a rapid and unequivocal description of a product is conveyed in communication. It provides mutual comprehension at the international level with regard to products which meet the requirements of the relevant European Standard.

The product designation is no substitute for the full content of the standard.

The product designation for products to this standard shall consist of:

- denomination (tube);
- number of this European Standard (EN 12451);
- material designation, either symbol or number (see table 1);

- material condition designation (see table 2);
- nominal cross-sectional dimensions (outside diameter × wall thickness).

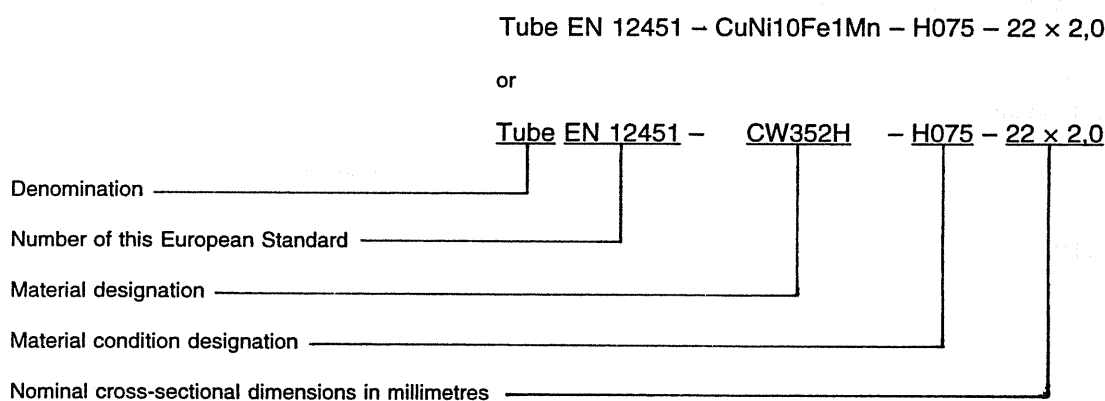
The derivation of a product designation is shown in the following example.

EXAMPLE:

Tube conforming to this standard, in material designated either CuNi10Fe1Mn or CW352H, in material condition H075, nominal outside diameter 22 mm, nominal wall thickness 2,0 mm, shall be designated as follows:

5 Ordering information

In order to facilitate the enquiry, order and confirmation of order procedures between the purchaser and the supplier, the purchaser shall state on his enquiry and order the following information:



1

NOTE 1: Heat exchanger tube can also be supplied as U-bend tube. For specific product and ordering information, see annex B.

- a) quantity of product required (number of pieces, length or mass);
- b) denomination (tube);
- c) number of this European Standard (EN 12451);
- d) material designation (see table 1);
- e) material condition designation (see 4.2 and table 2);
- f) nominal cross-sectional dimensions (outside diameter × wall thickness);
- g) nominal length (see 6.3.4);

NOTE 2: It is recommended that the product designation, as described in 4.3, is used for items b) to f).

In addition, the purchaser shall also state on the enquiry and order any of the following if required:

- h) whether minimum wall thickness is required (see 6.3.3.2);
- i) whether the tubes in alloy CuNi10Fe1Mn (CW352H) are for sea water application (see table 1). If so, the composition limits required;
- j) whether the tubes are required to pass a stress corrosion resistance test (see 6.5.2);

- k) whether the tubes in hard condition are required with annealed ends;
- l) whether the tubes are required to pass freedom from defects tests (see 6.5.4). If so, which test method is to be used (see 8.5) if the choice is not to be left to the discretion of the supplier and the acceptance criteria if they are not to be left to the discretion of the supplier;
- m) whether the tubes are for subsequent welding application (see table 1);
- n) whether special surface quality is required (see 6.4);
- o) whether a declaration of conformity is required (see 9.1);
- p) whether an inspection document is required, and if so, which type (see 9.2);
- q) whether there are any special requirements for marking, packaging or labelling (see clause 10).

EXAMPLE:

Ordering details for 1 000 m tube conforming to EN 12451, in material designated either CuNi10Fe1Mn or CW352H, in material condition H075, nominal outside diameter 22 mm, nominal wall thickness 2,0 mm, nominal length 3 000 mm:

1 000 m Tube EN 12451 – CuNi10Fe1Mn – H075 – 22 × 2,0
– nominal length 3 000 mm

or

1 000 m Tube EN 12451 – CW352H – H075 – 22 × 2,0
– nominal length 3 000 mm

6 Requirements

6.1 Composition

The composition shall conform to the requirements for the appropriate material given in table 1.

6.2 Mechanical properties

The properties shall conform to the appropriate requirements given in table 2. The tests shall be carried out in accordance with either 8.2 (tensile test) or 8.3 (hardness test).

Products in stress relieved condition shall conform to the same mechanical property requirements as for non stress relieved material.

6.3 Dimensions and tolerances

6.3.1 General

The geometrical properties of the tubes are defined by outside diameter, wall thickness and length.

The dimensional tolerances are applied on the outside diameter and wall thickness, if not otherwise agreed between the purchaser and the supplier.

6.3.2 Outside diameter

The diameter of the tubes shall conform to the tolerances given in table 3.

6.3.3 Wall thickness

6.3.3.1 General

The wall thickness, measured at any point, shall conform to $\pm 10\%$ of the specified nominal wall thickness.

6.3.3.2 Minimum wall thickness

When minimum wall thickness is specified [see 5 h)], the wall thickness measured at any point shall be neither less than the nominal thickness nor more than 15 % greater than the nominal thickness and the mean wall thickness at any cross section shall not be more than 10 % greater than the nominal thickness.

6.3.4 Length

Tubes ordered as "fixed lengths" shall conform to the tolerances given in table 4.

6.3.5 Tolerances of form

6.3.5.1 Deviation from circular form

For tubes in straight lengths the deviation from circular form is included in the tolerance on diameter given in table 3.

6.3.5.2 Straightness

The depth of arc measured in any one metre portion of length shall be not greater than 3 mm.

6.3.5.3 Squareness of cut

The deviation from squareness of the ends of the tubes shall not exceed the tolerances given in table 5.

6.4 Surface quality

The external and internal surfaces shall be clean and smooth.

The tubes may have a superficial film of drawing lubricant or, if annealed or thermally stress relieved, a superficial, dull, iridescent oxide film, securely adherent on both the internal and external surfaces.

Discontinuous irregularities on the external and internal surfaces of the tubes are permitted if they are within the dimensional tolerances.

Special requirements (e.g. pickling, degreasing, etc.) relating to the surface quality shall be agreed between the purchaser and the supplier [see 5 n)].

The cut ends of the tubes shall be deburred unless otherwise specified.

6.5 Technological requirements

6.5.1 Drift expanding

No crack shall be visible to the unaided eye, corrected for normal vision if necessary, when tubes in the annealed or end annealed condition are tested in accordance with 8.4.1.

6.5.2 Residual stress level

No crack shall be visible to the unaided eye, corrected for normal vision if necessary when tubes in the stress relieved condition and when requested by the purchaser [see 5 j)] are tested in accordance with 8.4.2.

6.5.3 Grain size

The average grain size of tubes in the annealed condition shall be in the range 0,010 mm to 0,050 mm. The test shall be carried out in accordance with 8.4.3.

6.5.4 Freedom from defects

When requested by the purchaser [see 5 l)], tubes shall be tested in accordance with 8.5 and the acceptance criteria, unless otherwise agreed between the purchaser and the supplier, shall be at the discretion of the supplier.

7 Sampling

7.1 General

When required (e.g. if necessary in accordance with specified procedures of a supplier's quality system, or when the purchaser requests inspection documents with test results, or for use in cases of dispute), an inspection lot shall be sampled in accordance with 7.2 and 7.3.

7.2 Analysis

The sampling rate shall be in accordance with table 6. A test sample, depending on the analytical technique to be employed, shall be prepared from each sampling unit and used for the determination of the composition.

NOTE 1: When preparing the test sample, care should be taken to avoid contaminating or overheating the test sample. Carbide tipped tools are recommended; steel tools, if used, should be made of magnetic material to assist in the subsequent removal of extraneous iron. If the test samples are in finely divided form (e.g. drillings, millings), they should be treated carefully with a strong magnet to remove any particles of iron introduced during preparation.

NOTE 2: In cases of dispute concerning the results of analysis, the full procedure given in ISO 1811-2 should be followed.

Results may be used from analyses carried out at an earlier stage of manufacturing the product, e.g. at the casting stage, if the material identity is maintained and if the quality system of the manufacturer is certified as conforming to EN ISO 9001 or EN ISO 9002.

7.3 Mechanical tests and stress corrosion resistance test

The sampling rate shall be in accordance with table 6. Sampling units shall be selected from the finished products. The test samples shall be cut from the sampling units. Test samples, and test pieces prepared from them, shall not be subjected to any further treatment, other than any machining operations necessary in the preparation of the test pieces.

8 Test methods

8.1 Analysis

Analysis shall be carried out on the test pieces, or test portions, prepared from the test samples obtained in accordance with 7.2. Except in cases of dispute, the analytical methods used shall be chemical or spectrographic according to ISO standards in force. For expression of results, the rounding rules given in 8.7 shall be used.

NOTE: In cases of dispute concerning the results of analysis, the method of analysis to be used should be chemical.

8.2 Tensile test

The tensile properties shall be determined in accordance with EN 10002-1 on test pieces obtained in accordance with 7.3.

8.3 Hardness test

Hardness shall be determined on the test pieces prepared from the test samples obtained in accordance with 7.3. The test shall be carried out in accordance with EN ISO 6507-1 and the indentation made on the outside surface, unless otherwise agreed.

8.4 Technological tests

8.4.1 Drift expanding test

The drift expanding test shall be carried out in accordance with EN 10234. The outside diameter of the tube end shall be expanded by the values for the appropriate material given in table 2 using a conical mandrel with an angle of 45°.

8.4.2 Stress corrosion resistance test

When required, the test method given in either EN ISO 196 or ISO 6957 shall be used on the test pieces prepared from the test samples obtained in accordance with 7.3. The choice of which of these tests is used shall be at the discretion of the supplier.

8.4.3 Average grain size determination

The estimation of average grain size shall be carried out in accordance with EN ISO 2624.

8.5 Freedom from defects tests

8.5.1 General

Each tube shall be subjected to one of the following tests:

- Eddy current test;
- Hydrostatic test;
- Pneumatic test.

If not otherwise agreed between the purchaser and the supplier the eddy current test shall be carried out. The method of testing shall be in accordance with 8.5.2.

8.5.2 Eddy current test

The eddy current test shall be carried out in accordance with EN 1971 and calibration determined by the use of a reference standard tube containing holes in accordance with the requirements given in table 7.

Eddy current testing systems are generally not able to detect discontinuities adjacent to the ends of the tube. The eddy current test shall be supplemented with a visual examination of the untested length at each end to establish freedom from harmful defects, or the untested length shall be removed.

8.5.3 Hydrostatic test

Each tube shall be subjected for at least 5 s to an internal hydrostatic pressure, which shall be calculated from the following equation:

$$P = \frac{2 \times S \times t}{D}$$

where:

P is the internal hydrostatic pressure, in megapascals;

t is the nominal wall thickness of the tube, in millimetres;

D is the nominal outside diameter of the tube, in millimetres;

S is half of the minimum 0,2% proof strength indicated in table 2 for the appropriate alloy and material condition, in megapascals.

The tube need not be tested at hydrostatic pressure of over 6,9 MPa unless otherwise agreed between the purchaser and the supplier.

NOTE: Hydrostatic tests are intended to determine the soundness of the tube wall and should not be regarded as an indication of the strength or safe working pressure.

8.5.4 Pneumatic test

Each tube shall be subjected for at least 5 s to an internal air pressure of at least 0,4 MPa.

The test method used shall permit detection of any leakage, such as having the tube under water or by the pressure differential method.

Any tube which shows signs of leakage during the test shall be deemed to have failed the test.

NOTE: Pneumatic tests are intended to determine the soundness of the tube wall and should not be regarded as an indication of the strength or safe working pressure.

8.6 Retests

8.6.1 Analysis, tensile, hardness, drift expanding and grain size tests

If there is a failure of one, or more than one, of the tests in 8.1, 8.2, 8.3, 8.4.1 or 8.4.3, two test samples from the same inspection lot shall be permitted to be selected for retesting the failed property (properties). One of these test samples shall be taken from the same sampling unit as that from which the original failed test piece was taken, unless that sampling unit is no longer available, or has been withdrawn by the supplier.

If the test pieces from both test samples pass the appropriate test(s), then the inspection lot represented shall be deemed to conform to the particular requirement(s) of this standard. If a test piece fails a test, the inspection lot represented shall be deemed not to conform to this standard.

8.6.2 Stress corrosion resistance test

If a test piece fails the test, the inspection lot represented by the failed test piece shall be permitted to be subjected to a stress relieving treatment. A further test sample shall then be selected in accordance with 7.3.

If a test piece from the further test sample passes the test, the stress relieved material shall be deemed to conform to the requirements of this standard for residual stress level and shall then be subjected to all the other tests called for on the purchase order, except for analysis. If the test piece from the further test sample fails the test, the stress relieved material shall be deemed not to conform to this standard.

8.7 Rounding of results

For the purpose of determining conformity to the limits specified in this standard, an observed or a calculated value obtained from a test shall be rounded in accordance with the following procedure, which is based upon the guidance given in annex B of ISO 31-0 : 1992. It shall be rounded in one step to the same number of figures used to express the specified limit in this standard, except that for tensile strength and 0,2 % proof strength where the rounding interval shall be 10 N/mm², and for elongation the value shall be rounded to the nearest 1 %.

The following rules shall be used for rounding:

a) if the figure immediately after the last figure to be retained is less than 5, the last figure to be retained shall be kept unchanged;

b) if the figure immediately after the last figure to be retained is equal to or greater than 5, the last figure to be

retained shall be increased by one.

9 Declaration of conformity and inspection documentation

9.1 Declaration of conformity

When requested by the purchaser [see 5 o)] and agreed with the supplier, the supplier shall issue the appropriate declaration of conformity for the products in accordance with EN 1655.

9.2 Inspection documentation

When requested by the purchaser [see 5 p)] and agreed with the supplier, the supplier shall issue the appropriate inspection document for the products in accordance with EN 10204.

10 Marking, packaging, labelling

Unless otherwise specified by the purchaser and agreed by the supplier, the marking, packaging and labelling shall be left to the discretion of the supplier [see 5 q)].

Table 1: Composition of copper and copper alloys

Material designation		Composition in % (m/m)															Density ¹⁾ g/cm ³ approx.
Symbol	Number	Element	Cu	Al	As	C	Co	Fe	Mn	Ni	P	Pb	S	Sn	Zn	Others total	
Cu-DHP	CW024A	min. max.	99,90 ²⁾ -	- -	- -	- -	- -	- -	- -	- -	0,015 0,040	- -	- -	- -	- -	- -	8,9
CuAl5As ³⁾	CW300G ³⁾	min. max.	Rem. -	4,0 6,5	0,1 0,4	- -	- -	- 0,2	- 0,2	- 0,2	- -	- 0,02	- -	- 0,05	- 0,3	- 0,3	8,2
CuNi10Fe1Mn ³⁾	CW352H ³⁾	min. max.	Rem. -	- -	- -	- 0,05	- 0,1 ⁴⁾	1,0 ⁵⁾ 2,0 ⁵⁾	0,5 1,0	9,0 11,0	- 0,02	- 0,02	- 0,05 ⁶⁾	- 0,03	- 0,5 ⁶⁾	- 0,2	8,9
CuNi30Fe2Mn2 ³⁾	CW353H ³⁾	min. max.	Rem. -	- -	- -	- 0,05	- 0,1 ⁴⁾	1,5 2,5	1,5 2,5	29,0 32,0	- 0,02	- 0,02	- 0,05 ⁶⁾	- 0,05	- 0,5 ⁶⁾	- 0,2	8,9
CuNi30Mn1Fe ³⁾	CW354H ³⁾	min. max.	Rem. -	- -	- -	- 0,05	- 0,1 ⁴⁾	0,4 1,0	0,5 1,5	30,0 32,0	- 0,02	- 0,02	- 0,05 ⁶⁾	- 0,05	- 0,5 ⁶⁾	- 0,2	8,9
CuZn20Al2As ³⁾	CW702R ³⁾	min. max.	76,0 79,0	1,8 2,3	0,02 0,06	- -	- -	- 0,07	- 0,1	- 0,1	- 0,01	- 0,05	- -	- -	Rem. -	- 0,3	8,4
CuZn28Sn1As	CW706R	min. max.	70,0 72,5	- -	0,02 0,06	- -	- -	- 0,07	- 0,1	- 0,1	- 0,01	- 0,05	- -	0,9 1,3	Rem. -	- 0,3	8,5
CuZn30As	CW707R	min. max.	69,0 71,0	- 0,02	0,02 0,06	- -	- -	- 0,05	- 0,1	- -	- 0,01	- 0,07	- -	- 0,05	Rem. -	- 0,3	8,5

¹⁾ For information only.

²⁾ Including Ag, up to a maximum of 0,015 %.

³⁾ These alloys may be used for sea water application.

⁴⁾ Co max. 0,1 % is counted as Ni.

⁵⁾ For sea water applications, the composition limits shall be agreed between the purchaser and the supplier [see 5 i)].

⁶⁾ When the product is for subsequent welding applications and so specified by the purchaser [see 5 m)], Zn shall be max. 0,2 % and S max. 0,02 %.

Table 2: Mechanical properties of copper and copper alloys

Designations		Material condition	Tensile strength	0,2% proof strength	Elongation	Drift expansion	Hardness	
Material			R_m	$R_{p0,2}$	A		HV	
Symbol	Number		N/mm ²	N/mm ²	%	%	min.	max.
Cu-DHP	CW024A	R250	250	150	20	20	-	-
		H075	-	-	-	20	75	100
		R290	290	250	5	-	-	-
		H100	-	-	-	-	100	-
CuAl5As	CW300G	R350 ¹⁾	350	110	50	30	-	-
		H075 ¹⁾	-	-	-	30	75	110
CuNi10Fe1Mn	CW352H	R290 ¹⁾	290	90	30	30	-	-
		H075 ¹⁾	-	-	-	30	75	105
		R310	310	220	12	20	-	-
		H105	-	-	-	20	105	150
		R480	480	400	8	8	-	-
CuNi30Fe2Mn2	CW353H	R420 ¹⁾	420	150	30	30	-	-
		H090 ¹⁾	-	-	-	30	90	125
CuNi30Mn1Fe	CW354H	R370 ¹⁾	370	120	35	30	-	-
		H090 ¹⁾	-	-	-	30	90	120
		R480	480	300	12	20	-	-
		H120	-	-	-	20	120	-
CuZn20Al2As	CW702R	R340 ¹⁾	340	120	55	30	-	-
		H070 ¹⁾	-	-	-	30	70	100
		R390 ¹⁾	390	150	45	30	-	-
		H085 ¹⁾	-	-	-	30	85	110
CuZn28Sn1As	CW706R	R320 ¹⁾	320	100	55	30	-	-
		H060 ¹⁾	-	-	-	30	60	90
		R360 ¹⁾	360	140	45	30	-	-
		H080 ¹⁾	-	-	-	30	80	110
CuZn30As	CW707R	R340 ¹⁾	340	130	45	30	-	-
		H075 ¹⁾	-	-	-	30	75	105

¹⁾ Annealed condition.
NOTE: 1 N/mm² is equivalent to 1 MPa.

Table 3: Tolerances on diameter

Nominal outside diameter		Values in millimetres Tolerances on diameter including deviation from circular form
over	up to and including	
6 ¹⁾	14	0 - 0,12
14	26	0 - 0,20
26	76	0 - 0,30
¹⁾ Including 6.		

Table 4: Tolerances on length

Nominal length mm		Tolerances
over	up to and including	
—	2 000	+ 2 0 mm
2 000	8 000	+ 1 0 ‰ ¹⁾
8 000	—	+ 0,7 0 ‰
¹⁾ But not more than 5 mm.		

Table 5: Tolerances on squareness of cut

Nominal outside diameter		Values in millimetres Tolerances
over	up to and including	
6 ¹⁾	35	0,50
35	51	0,80
51	—	1,1
¹⁾ Including 6.		

Table 6: Sampling rate

Number of tubes in the inspection lot	Number of tubes required for testing
up to and including 2 000	0,4 %, but at least 2
over 2 000 up to and including 4 000	0,25 %, but at least 8
over 4 000	0,2 %, but at least 10

Table 7: Drill sizes for production of reference standard tubes

Nominal outside diameter		Values in millimetres	
over	up to and including	Diameter of drilled holes	Tolerance on diameter
—	19	0,6	± 0,05
19	25	0,8	
25	32	0,9	
32	38	1,05	
38	45	1,15	
45	50	1,3	
50	—	by agreement	

Annex A (informative)

Bibliography

In the preparation of this European Standard, use was made of a number of documents for reference purposes. These informative references are cited at the appropriate places in the text and the publications are listed hereafter.

EN 1173

Copper and copper alloys – Material condition or temper designation

EN 1412

Copper and copper alloys – European numbering system

EN ISO 9001

Quality systems – Model for quality assurance in design/development, production, installation and servicing (ISO 9001 : 1994)

EN ISO 9002

Quality systems – Model for quality assurance in production, installation and servicing (ISO 9002 : 1994)

ISO 31-0 : 1992

Quantities and units – Part 0: General principles

ISO 1190-1

Copper and copper alloys – Code of designation – Part 1: Designation of materials

ISO 1811-2

Copper and copper alloys – Selection and preparation of samples for chemical analysis – Part 2: Sampling of wrought products and castings

Annex B (normative)

U-bend seamless copper and copper alloy heat exchanger tubes

B.1 General

U-bend heat exchanger tubes shall be manufactured using straight tubes that conform to this standard.

Tubes after U-bending operation shall conform to requirements for residual stress level (see 6.5.2) on the U-bend portion and if agreed between the purchaser and the supplier shall be subjected to a hydrostatic test (see 8.5.3) or a pneumatic test (see 8.5.4).

If not otherwise requested by the purchaser the U-bend tubes shall conform to the dimensional requirements in B.3 to B.6.

B.2 Ordering information

In addition to the relevant ordering information given in clause 5 of this standard, the purchaser shall also state on his enquiry and order the following information:

- a) centreline bend radius;
- b) length of tube legs.

B.3 Diameter of tube in the U-bend section

The outside diameter of the tube at any cross section included within the points of tangency of the bend shall not deviate from the nominal diameter prior to the bending by more than $\pm 10\%$.

B.4 Wall thickness in U-bend section

The wall thickness of the tube at the apex of the U-bend section shall be not less than the value determined by the following equation:

$$t_f = \frac{t \times 2R}{2R + D}$$

where:

- t_f is the thickness after bending, in millimetres;
- t is the wall thickness obtained from nominal wall thickness in millimetres minus its tolerance (see 6.3.3.1) or the minimum wall thickness, in millimetres (see 6.3.3.2);
- R is the centreline bend radius, in millimetres;
- D is the nominal outside diameter of the tube, in millimetres.

The centreline bend radius of tubes in annealed condition shall be not less than two times the tube outside diameter, otherwise the bend radius shall be agreed between the purchaser and the supplier.

B.5 Leg spacing of U-bend section

The leg spacing shall not vary from the value $2R - D$ by more than 1,6 mm, where R is the specified centreline bend radius and D is the specified tube outside diameter.

B.6 Length of U-bend tube legs

The length of the tube legs measured from the point of tangency of the bend to the end of the tube leg shall not vary from the specified length by more than the amount of tolerance given in table 4.

The difference in length of the tube legs shall be not greater than 3 mm unless otherwise specified.

Annex ZA (informative)

Clauses of this European Standard addressing essential requirements or other provisions of EU Directives

This European Standard has been prepared under a Mandate given to CEN by the European Commission and the European Free Trade Association and supports essential requirements of the EU Directive 97/23/EC.

WARNING: Other requirements and other EU Directives may be applicable to the product(s) falling within the scope of this standard.

Relevant clauses of this standard are likely to support the essential requirements in clause 4 "Materials" of Annex I of the "Pressure equipment Directive" 97/23/EC.

Compliance with these clauses of this standard provides one means of conforming with the specific essential requirements of the Directive concerned and associated EFTA requirements.

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