



Designation: B903 – 15 (Reapproved 2022)

Standard Specification for Seamless Copper Heat Exchanger Tubes With Internal Enhancement¹

This standard is issued under the fixed designation B903; 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 seamless, internally enhanced copper tube, in straight lengths or coils, suitable for use in refrigeration and air-conditioning products or other heat exchangers.

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 Tubes for this application are manufactured from the following copper:

Copper UNS No.	Type of Metal
C12200	Phosphorized, high residual phosphorus (DHP)

1.4 The following pertains to the test method described in **15.2.4** of this specification: *This standard does not purport to address all the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards*:²

B153 Test Method for Expansion (Pin Test) of Copper and Copper-Alloy Pipe and Tubing

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.

B251 Specification for General Requirements for Wrought Seamless Copper and Copper-Alloy Tube (Metric) B0251_B0251M

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

B846 Terminology for Copper and Copper Alloys

B950 Guide for Editorial Procedures and Form of Product Specifications for Copper and Copper Alloys

E3 Guide for Preparation of Metallographic Specimens

E8/E8M Test Methods for Tension Testing of Metallic Materials

E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E53 Test Method for Determination of Copper in Unalloyed Copper by Gravimetry (Withdrawn 2022)³

E62 Test Methods for Chemical Analysis of Copper and Copper Alloys (Photometric Methods) (Withdrawn 2010)³

E112 Test Methods for Determining Average Grain Size

E243 Practice for Electromagnetic (Eddy Current) Examination of Copper and Copper-Alloy Tubes

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

3. General Requirements

3.1 The following sections of Specification **B251** constitute a part of this specification:

3.1.1 Workmanship, Finish, and Appearance.

3.1.2 Sampling.

3.1.3 Number of Tests and Retests.

3.1.4 Specimen Preparation.

3.2 In addition, when a section with a title identical to those referenced in **3.1** appears in this specification, it contains additional information which supplements those appearing in Specification **B251**. In case of conflict, this specification shall prevail.

4. Terminology

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

³ The last approved version of this historical standard is referenced on www.astm.org.

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

4.2 Definitions of Terms Specific to This Standard:

4.2.1 *bottom wall, n*—the wall thickness measured from the base of the enhancement to the outside surface.

4.2.2 *enhancement, adj*—a geometrical feature intentionally formed on a tube I.D. surface to improve heat transfer.

5. Ordering Information

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

5.1.1 ASTM Designation number and the year of issue.

5.1.2 Temper (Section 8).

5.1.3 Length, diameter, wall thickness, and enhancement dimensions. Configuration of the enhanced surface shall be as agreed upon between the manufacturer, or supplier, and purchaser.

5.1.4 How furnished: straight lengths or coils.

5.1.5 Quantity—total weight or total length or number of pieces of each size.

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 Certification, if required (see Section 19).

5.2.2 Mill test report, if required (see Section 20).

6. Materials and Manufacture

6.1 Material:

6.1.1 The material of manufacture shall be cast billet, bar, tube, or so forth of Copper UNS No. C12200 of such purity and soundness as to be suitable for processing into the tubular product prescribed herein.

6.2 Manufacture:

6.2.1 The tube 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 internal enhancement shall be produced by cold forming.

6.2.2.1 When annealed temper is required, the tube shall be annealed subsequent to the final cold-forming operation.

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.

8. Temper

8.1 *As-Fabricated Temper*—The tube is in the cold-worked condition produced by the enhancing operation.

8.2 *O (Annealed) Temper*—The temper of annealed tube shall be designated as O50 (light-anneal) or O60 (soft-anneal) (see **Table 2**). Tempers are defined in Classification **B601**.

NOTE 1—By agreement between the purchaser and manufacturer, product in special tempers may be supplied with properties as agreed upon between the purchaser and the manufacturer.

9. Grain Size for Annealed Tempers

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

9.2 Samples of annealed temper tubes shall be examined at a magnification of 75 diameters. The grain size shall be determined in the wall beneath the ridges. The microstructure shall show complete recrystallization and shall have an average grain size within the limits specified in **Table 2**, when tested in accordance with Test Methods **E112**.

10. Mechanical Property Requirements

10.1 Tensile and Yield Strength Requirements:

10.1.1 As-fabricated and O (annealed) temper tube shall conform to the mechanical properties specified in **Table 3**, when tested in accordance with Test Methods **E8/E8M**.

11. Performance Requirements

11.1 Expansion Test:

11.1.1 Specimens of annealed product shall withstand the expansion shown in **Table 4** when expanded in accordance with Test Method **B153**.

11.1.2 The expanded tube shall show no cracking or other defects visible to the unaided eye.

12. Other Requirements

12.1 Nondestructive Examination for Defects:

12.1.1 Each tube shall be subjected to an eddy-current test.

12.1.2 Electromagnetic (Eddy-Current) Test:

12.1.2.1 Tubes shall be tested normally in the as-fabricated temper; however, they may be tested in the annealed temper at the option of the manufacturer.

12.1.2.2 The testing shall follow the procedures specified in Practice **E243**. Unless otherwise agreed upon between the manufacturer, or supplier, and the purchaser, the manufacturer shall have the option of calibrating the test equipment using either notches or drilled holes. If agreement cannot be reached, drilled holes shall be used. Notch depth standards rounded to the nearest 0.001 in. (0.025 mm) shall be 22 % of the nominal bottom wall thickness. Drilled-hole standards shall be 0.025 in. (0.635 mm) diameter for tubes up to and including ¾ in. specified diameter and 0.031 in. (0.785 mm) diameter for tubes over ¾ in. specified diameter.

TABLE 1 Chemical Requirements, UNS C12200

Element	Composition, wt %
Copper (including silver)	99.9, min
Phosphorus	0.015–0.040

TABLE 2

Temper Designation	Average Grain Size, mm
As fabricated	—
O60	0.040 min
O50	0.040 max