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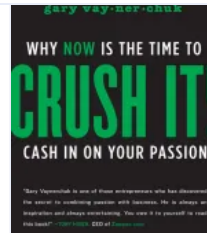
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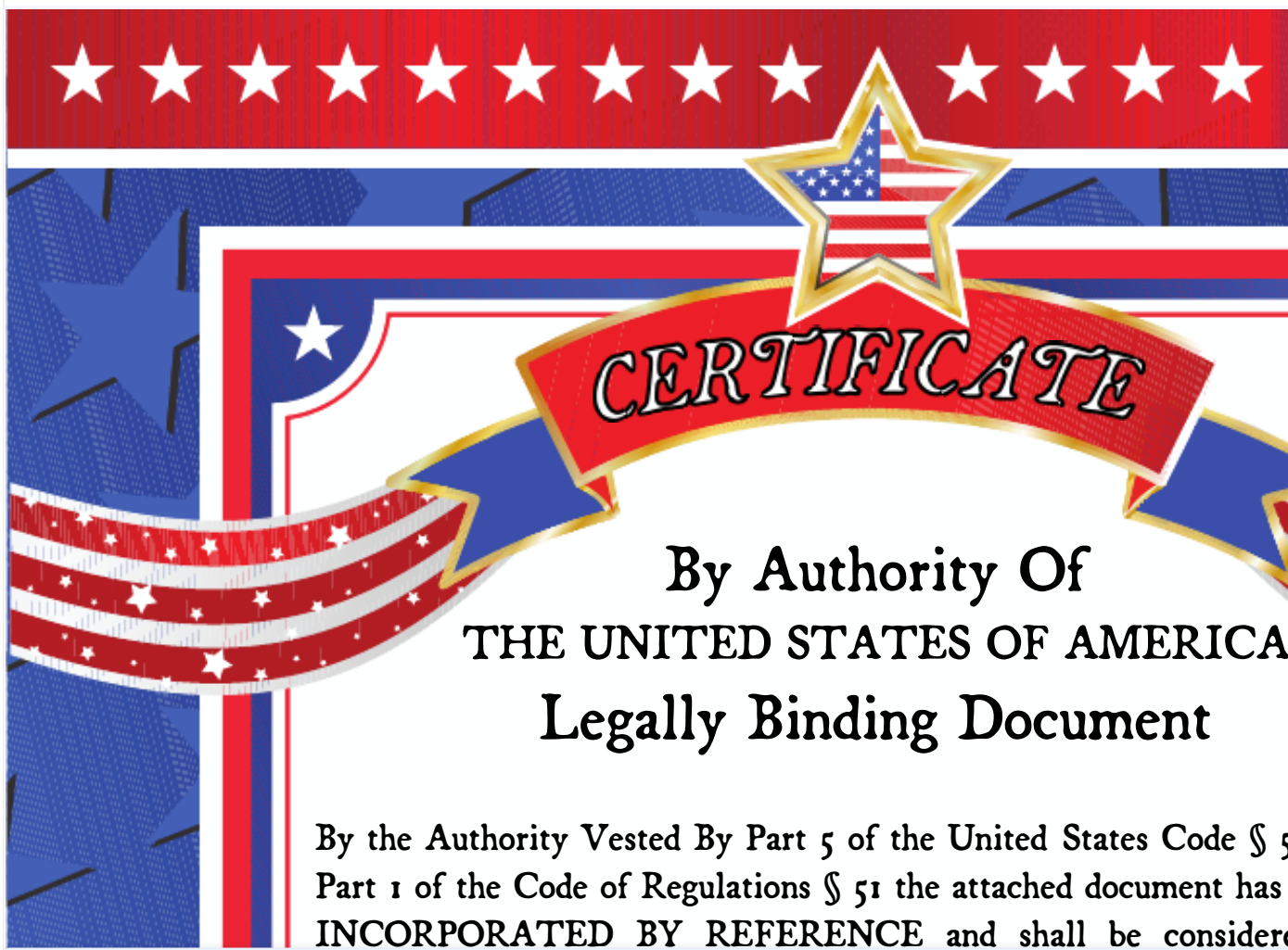


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Designation: A 106/A 106M – 04b

## Standard Specification for Seamless Carbon Steel Pipe for High-Temperature S

This standard is issued under the fixed designation A 106/A 106M; the number immediately following the designation of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last revision. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

*This standard has been approved for use by agencies of the Department of Defense.*

### 1. Scope\*

1.1 This specification<sup>2</sup> covers seamless carbon steel pipe for high-temperature service (Note 1) in NPS 1/8 to NPS 48 [DN 6 to DN 1200] (Note 2) inclusive, with nominal (average) wall thickness as given in ASME B 36.10M. It shall be permissible to furnish pipe having other dimensions provided such pipe complies with all other requirements of this specification. Pipe ordered under this specification shall be suitable for bending, flanging, and similar forming operations, and for welding. When the steel is to be welded, it is presupposed that a welding procedure suitable to the grade of steel and intended use or service will be utilized.

NOTE 1—It is suggested, consideration be given to possible graphitization.

### 2. Referenced Documents

#### 2.1 ASTM Standards:<sup>3</sup>

A 530/A 530M Specification for Seamless Carbon and Alloy Steel Specialized Carbon and Alloy Steel Tubing  
E 213 Practice for Ultrasonic Examination of Seamless and Welded Tubing  
E 309 Practice for Eddy-Current Examination of Seamless and Welded Tubular Products Using Magnetic Particle Inspection  
E 381 Method of Macroetching of Steel Blooms, and Forgings  
E 570 Practice for Flux Leakage Testing of Seamless and Welded Austenitic Steel Tubular Products

#### 2.2 ASME Standard:

ASME B 36.10M Welded and Seamless Carbon Steel Pipe

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Fitting test method portion, Sections 11, 12, 13, 14, and 15 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.*

3.1 The inclusion of the following the desired material adequately specification:  
 3.1.1 Quantity (feet, metres, or

<sup>1</sup> This specification is under the jurisdiction of Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.09 on Carbon Steel Tubular Products.

Current edition approved Oct. 1, 2004. Published October 2004. Originally approved in 1926. Last previous edition in 2004 as A 106/A 106M – 04a.

<sup>2</sup> For ASME Boiler and Pressure Vessel Code applications see related Specifications SA-106 in Section II of that Code.

<sup>3</sup> For referenced ASTM standards, visit [www.astm.org](#) or contact ASTM Customer Service at service@astm.org. For all other standards referenced in this specification, refer to the standard's individual Standard Specification volume information, refer to the standard's individual Specification page on the ASTM website.

<sup>4</sup> Available from American Society of Mechanical Engineers, International Headquarters, Three Park Avenue, New York, NY 10017-2400.

<sup>5</sup> Available from Standardization Documents International Secretariat, Section D, 700 Robbins Avenue, Philadelphia, PA 19106-1500.

<sup>6</sup> Available from Steel Structures Painting Council, 1000 North Dearborn Street, Pittsburgh, PA 15222-4656.

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

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- 3.1.2 Name of material (seamless carbon steel pipe),
- 3.1.3 Grade (Table 1),
- 3.1.4 Manufacture (hot-finished or cold-drawn),
- 3.1.5 Size (NPS [DN] and weight class or schedule number, or both; outside diameter and nominal wall thickness; or inside diameter and nominal wall thickness),

### 6. General Requirements

6.1 Material furnished to this specification shall meet the applicable requirements of Specification A 530/A 530M unless otherwise specified.

### 7. Chemical Composition

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### 3.1.14 Special requirements

## 4. Process

4.1 The steel shall be killed steel, with the primary melting process being open-hearth, basic-oxygen, or electric-furnace, possibly combined with separate degassing or refining. If secondary melting, using electroslag remelting or vacuum-arc remelting is subsequently employed, the heat shall be defined as all of the ingots remelted from a single primary heat.

4.2 Steel cast in ingots or strand cast is permissible. When steels of different grades are sequentially strand cast, identification of the resultant transition material is required. The producer shall remove the transition material by any established procedure that positively separates the grades.

4.3 For pipe NPS 1½ [DN 40] and under, it shall be permissible to furnish hot finished or cold drawn.

4.4 Unless otherwise specified, pipe NPS 2 [DN 50] and over shall be furnished hot finished. When agreed upon between the manufacturer and the purchaser, it is permissible to furnish cold-drawn pipe.

## 5. Heat Treatment

5.1 Hot-finished pipe need not be heat treated. Cold-drawn pipe shall be heat treated after the final cold draw pass at a temperature of 1200 °F (650 °C) or higher.

**TABLE 1 Chemical Requirements**

	Composition, %		
	Grade A	Grade B	Grade C
Carbon, max <sup>A</sup>	0.25	0.30	0.35
Manganese	0.27–0.93	0.29–1.06	0.29–1.06
Phosphorus, max	0.035	0.035	0.035
Sulfur, max	0.035	0.035	0.035
Silicon, min	0.10	0.10	0.10
Chrome, max <sup>B</sup>	0.40	0.40	0.40
Copper, max <sup>B</sup>	0.40	0.40	0.40
Molybdenum, max <sup>B</sup>	0.15	0.15	0.15
Nickel, max <sup>B</sup>	0.40	0.40	0.40
Vanadium, max <sup>B</sup>	0.08	0.08	0.08

be reported to the purchaser or t  
and shall conform to the require

## 9. Product Analysis

9.1 At the request of the purchaser from each lot (Note 3) of 400 lengths each size up to, but not including each lot of 200 lengths or fractional lengths [DN 150] and over, shall be made finished pipe. The results of these analyses shall be reported to the purchaser or the purchaser shall verify that the pipe conforms to the requirements specified.

9.2 If the analysis of one of the lots does not conform to the requirements, additional analyses shall be made on additional lengths from the same lot until the lot conforms to requirements specified.

**Note 3**—A lot shall consist of the pipe of Sections 9 and 21 of the same size and grade of steel.

## 10. Tensile Requirements

10.1 The material shall conform to the tensile properties given in Table 1.

## 11. Bending Requirements

11.1 For pipe NPS 2 [DN 50] and over, the pipe shall stand being bent over a cylindrical mandrel, the diameter of which shall be not less than 20% of the outside diameter (as shown in Appendix A) without developing cracks. When the pipe shall stand being bent over a cylindrical mandrel, the diameter of which shall be not less than 20% of the outside diameter (as shown in Appendix A) without failure.

11.2 Subject to the approval of the purchaser, the pipe shall stand being bent over a cylindrical mandrel, the diameter of which shall be not less than 20% of the outside diameter (as shown in Appendix A) without failure.

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	Grade A		Grade B	
	Longitu-dinal	Transverse	Longitu-dinal	Transv
Tensile strength, min, psi [MPa]	48 000 [330]		60 000 [415]	
Yield strength, min, psi [MPa]	30 000 [205]		35 000 [240]	
Elongation in 2 in. [50 mm], min, %:				
Basic minimum elongation transverse strip tests, and for all small sizes tested in full section	35	25	30	16.
When standard round 2-in. [50-mm] gage length test specimen is used	28	20	22	12
For longitudinal strip tests	A		A	
For transverse strip tests, a deduction for each 1/32-in. [0.8-mm] decrease in wall thickness below 5/16 in. [7.9 mm] from the basic minimum elongation of the following percentage shall be made		1.25		1.0

<sup>A</sup> The minimum elongation in 2 in. [50 mm] shall be determined by the following equation:

$$e = 625 000A^{0.2} / U^{0.9}$$

for SI units, and

$$e = 1 940A^{0.2} / U^{0.9}$$

for inch-pound units,

where:

- e = minimum elongation in 2 in. [50 mm], %, rounded to the nearest 0.5 %,
- A = cross-sectional area of the tension test specimen, in.<sup>2</sup> [mm<sup>2</sup>], based upon specified outside diameter or nominal specimen rounded to the nearest 0.01 in.<sup>2</sup> [1 mm<sup>2</sup>]. (If the area thus calculated is equal to or greater than 0.75 in.<sup>2</sup> [500 mm<sup>2</sup>], then be used.), and
- U = specified tensile strength, psi [MPa].

the bend being 1 in. [25 mm], without cracking on the outside portion of the bent portion.

11.3 For pipe whose diameter exceeds 25 in. [635 mm] and whose diameter to wall thickness ratio is 7.0 or less, the bend test described in 11.2 shall be conducted instead of the flattening test.

NOTE 4—Diameter to wall thickness ratio = specified outside diameter/nominal wall thickness.

Example: For 28 in. [711 mm] diameter 5.000 in. [127 mm] thick pipe the diameter to wall thickness ratio = 28/5 = 5.6 [711/127 = 5.6].

shall be permissible for the full b with a nondestructive electric tes

13.3 Where specified in the permissible for pipe to be furnishe and without the nondestructive e this case, each length so furnishec marking of the letters "NH." It s meeting the requirements of 13.1 pipe without either the hydrostat

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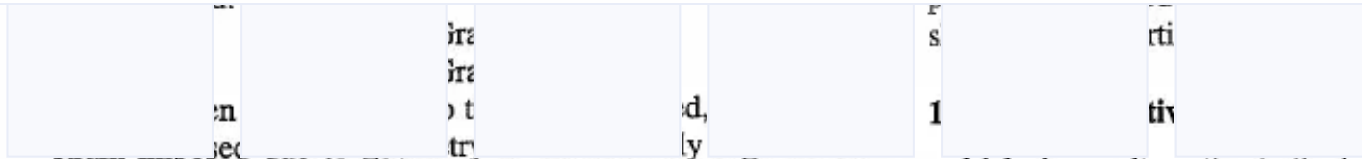
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inside surface on both sides and twelve block locations, cracks at these locations shall be the cause for rejection if the depth is less than ten.


**13. Hydrostatic Test**

13.1 Except as allowed by 13.2, 13.3, and 13.4, each length of pipe shall be subjected to the hydrostatic test without leakage through the pipe wall.

13.2 As an alternative to the hydrostatic test at the option of the manufacturer or where specified in the purchase order, it

14.1 As an alternative to the hydrostatic test, the manufacturer or where specified in the purchase order, each pipe shall be tested with a nondestructive electric test in accordance with Practice E 213, E 214, or E 215, the marking of each length of pipe shall include the letters "NDE." It is the intent of this test to reject pipe with imperfect welds equal to or greater than that specified in the calibration standard.

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 **A 106/A 106M – 04b**

14.2 Where the nondestructive electric test is performed, the lengths shall be marked with the letters "NDE." The certification, where required, shall state "Nondestructive Electric Tested" and shall indicate which of the tests was applied. Also, the letters "NDE" shall be appended to the product specification number and material grade shown on the certification.

14.3 The following information is for the benefit of the user of this specification:

14.3.1 The reference standards defined in 14.4 through 14.6 are convenient standards for calibration of nondestructive testing equipment. The dimensions of such standards are not to be construed as the minimum sizes of imperfections detectable by such equipment.

14.3.2 The ultrasonic testing referred to in this specification

NPS	DN
≤ ½	≤ 15
> ½ ≤ 1¼	> 15 ≤ 32
> 1¼ ≤ 2	> 32 ≤ 50
> 2 ≤ 5	> 50 ≤ 125
> 5	> 125

14.5.2 *Transverse Tangential* file with a ¼-in. [6-mm] diameter milled tangential to the surface of the pipe along the longitudinal axis of the pipe. The nondestructive electric test shall be performed on the milled surface.

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#### 14.7.2.7 Pipe reducer ripple.

14.8 The test methods described in this section are not necessarily capable of inspecting the end portion of pipes, a condition referred to as “end effect.” The length of such end effect shall be determined by the manufacturer and, when specified in the purchase order, reported to the purchaser.

### 15. Nipples

15.1 Nipples shall be cut from pipe of the same dimensions and quality described in this specification.

### 16. Dimensions, Mass, and Permissible Variations

16.1 *Mass*—The mass of any length of pipe shall not vary more than 10 % over and 3.5 % under that specified. Unless otherwise agreed upon between the manufacturer and the purchaser, pipe in NPS 4 [DN 100] and smaller may be weighed in convenient lots; pipe larger than NPS 4 [DN 100] shall be weighed separately.

16.2 *Diameter*—The tolerances for diameter shall be in accordance with the following:

16.2.1 Except for pipe ordered as special outside diameter tolerance pipe or as inside diameter tolerance pipe, variations in outside diameter shall not exceed those given in Table 3.

16.2.2 For pipe over 10 in. [250 mm] OD ordered as special outside diameter tolerance pipe, the outside diameter shall not vary more than 1 % over or 1 % under the specified outside diameter.

16.2.3 For pipe over 10 in. [250 mm] ID ordered as inside diameter tolerance pipe, the inside diameter shall not vary more than 1 % over or 1 % under the specified inside diameter.

16.3 *Thickness*—The minimum wall thickness at any point shall not be more than 12.5 % under the specified wall thickness.

17.1.3 If definite lengths are ordered in single random lengths with 5 % 12 to 16 ft [3.7 to 4.8 m], with a minimum average of 35 ft length of 22 ft [6.7 m] with 5 %

### 18. Workmanship, Finish and A

18.1 The pipe manufacturer shall provide assurance that they have been provided to depth. Exploration of all surface imperfections required but consideration should be given to exploring all surface imperfections.

18.2 Surface imperfections that of the nominal wall thickness or wall thickness shall be considered defects shall be given one of the

18.2.1 The defect shall be repaired so that the remaining wall thickness in 16.3.

18.2.2 Repaired in accordance with provisions of 18.6.

18.2.3 The section of pipe containing the defect shall be removed off within the limits of requirements.

18.2.4 Rejected.

18.3 To provide a workmanlike appearance conforming with 18.2 the pipe shall be ground to remove by grinding the following

18.3.1 Mechanical marks, abrasions, and other surface imperfections of which imperfections are deeper than 0.005 in. [0.127 mm]

18.3.2 Visual imperfections consisting of seams, laps, tears, or slivers from

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Over 1 1/2 to 4 [40 to 100], incl	1/32 (0.031)	0.8	1/32 (0.031)
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Over 8 to 18 [200 to 450], incl	3/32 (0.093)	2.4	1/32 (0.031)
Over 18 to 26 [450 to 650], incl	1/8 (0.125)	3.2	1/32 (0.031)
Over 26 to 34 [650 to 850], incl	5/32 (0.156)	4.0	1/32 (0.031)
Over 34 to 48 [850 to 1200], incl	3/16 (0.187)	4.8	1/32 (0.031)

permitted to be reduced by the a  
 18.5.1 Wall thickness measure  
 mechanical caliper or with a prop  
 testing device of appropriate acc  
 measurement determined by use o  
 govern.  
 18.6 Weld repair shall be pe  
 approval of the purchaser and in a  
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 18.7 The finished pipe shall b  
 NOTE 5—Marks and abrasions are de  
 marks, roll marks, ball scratches, score

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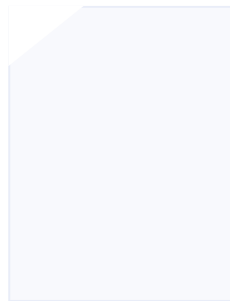
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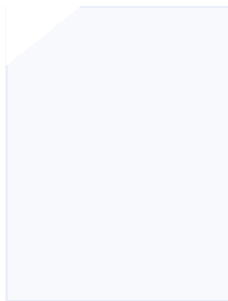
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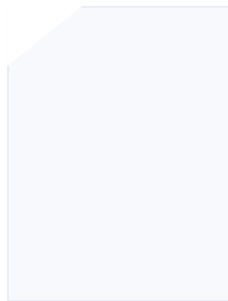
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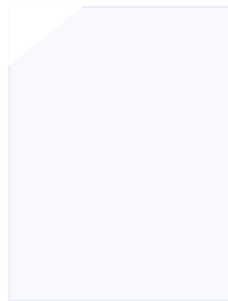
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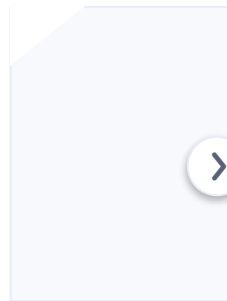
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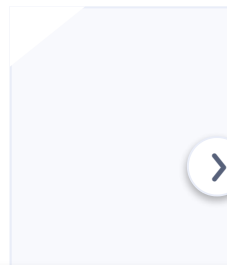
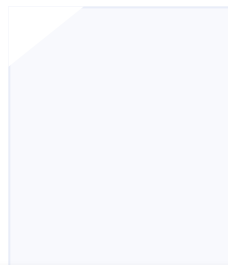
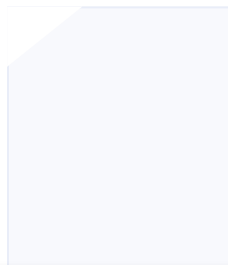
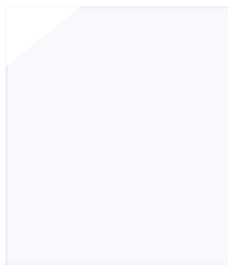
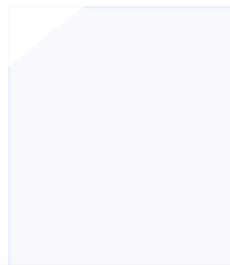
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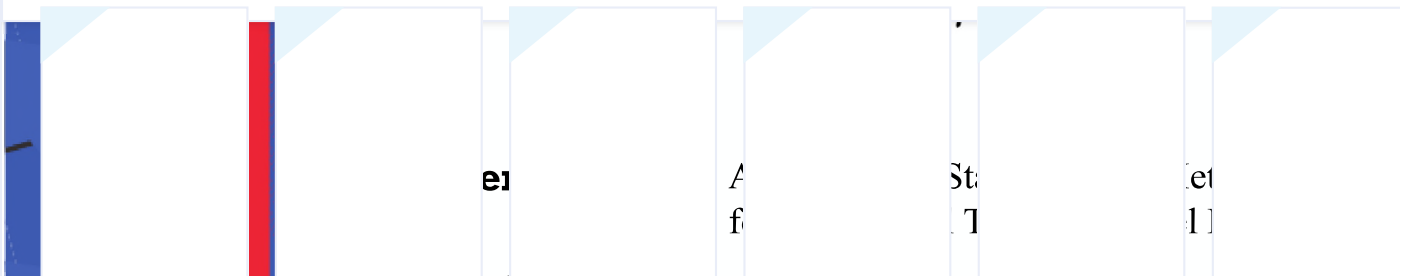


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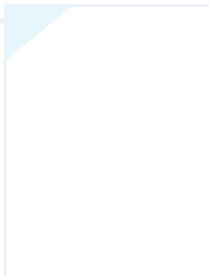
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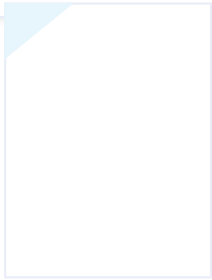
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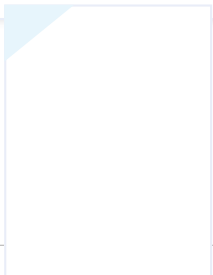





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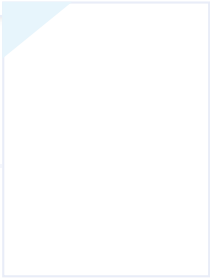





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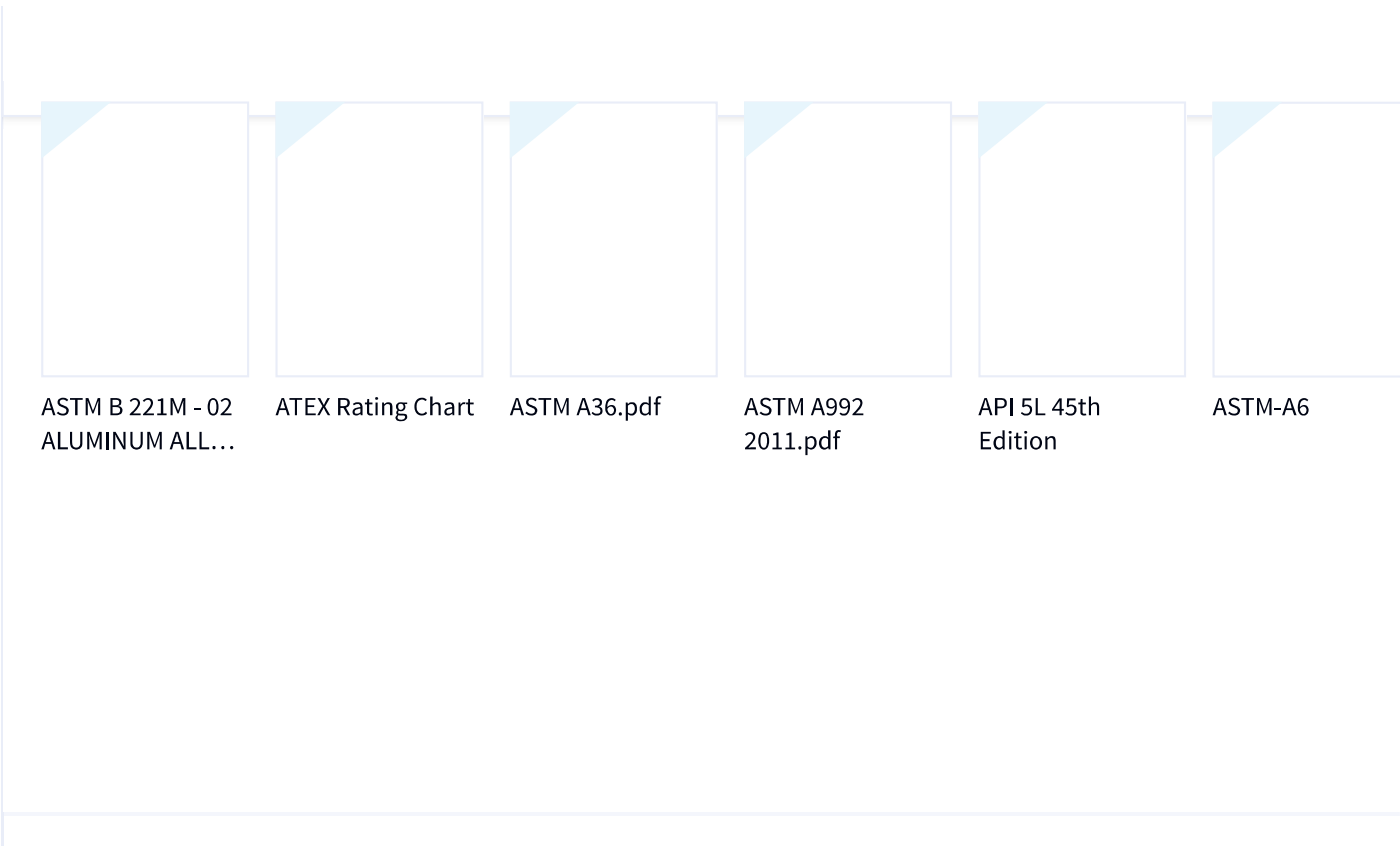
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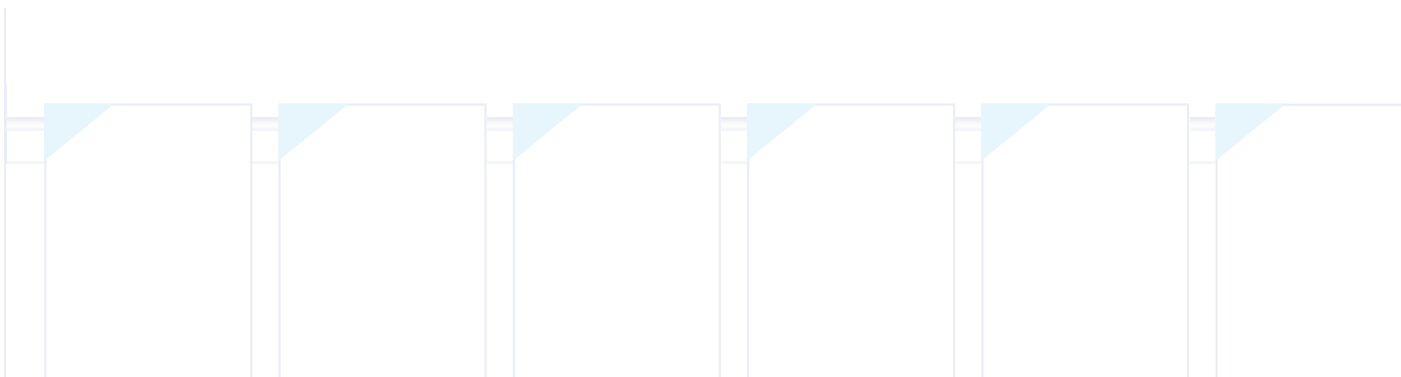
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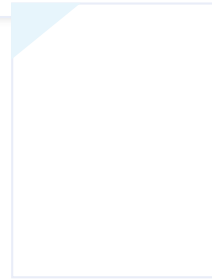
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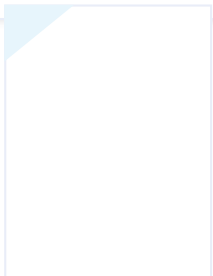


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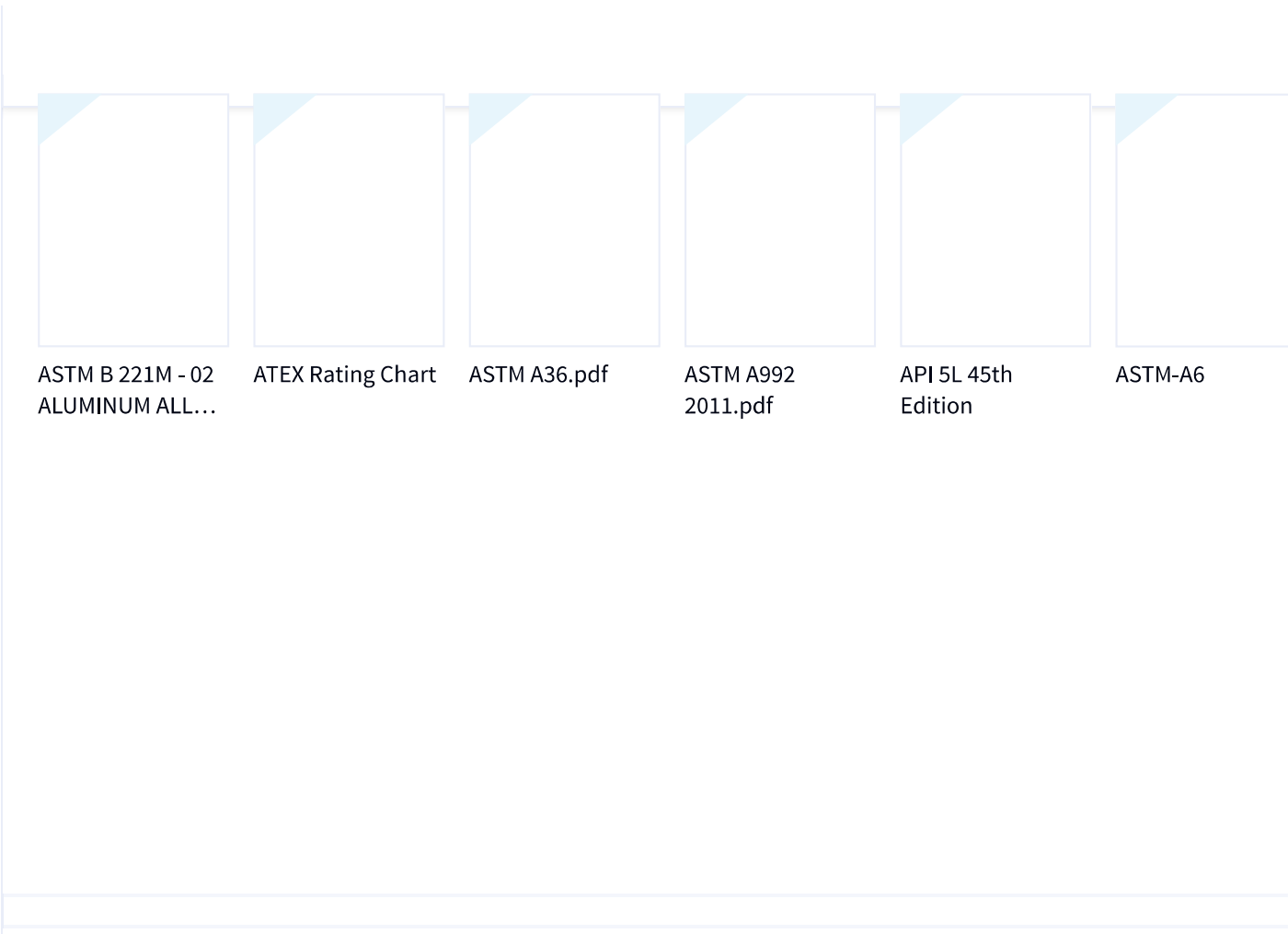
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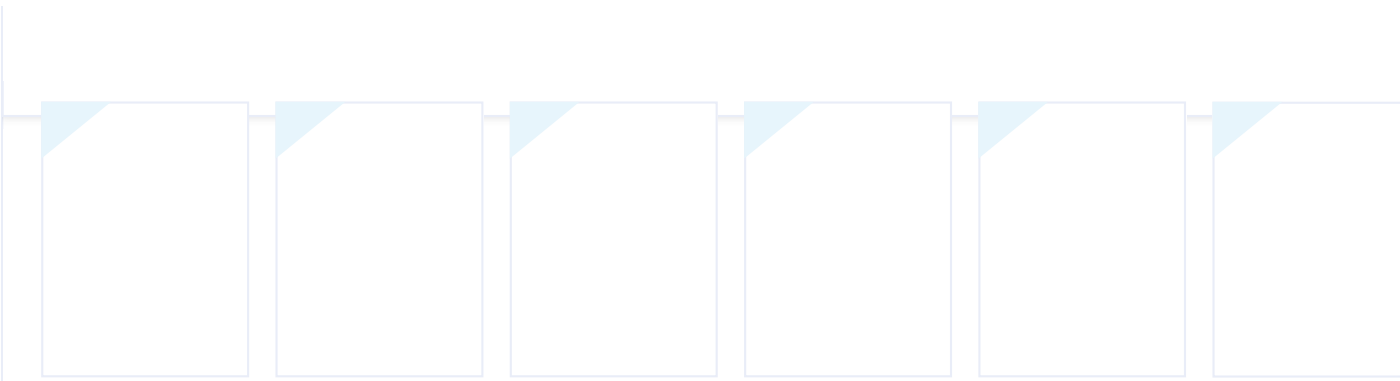
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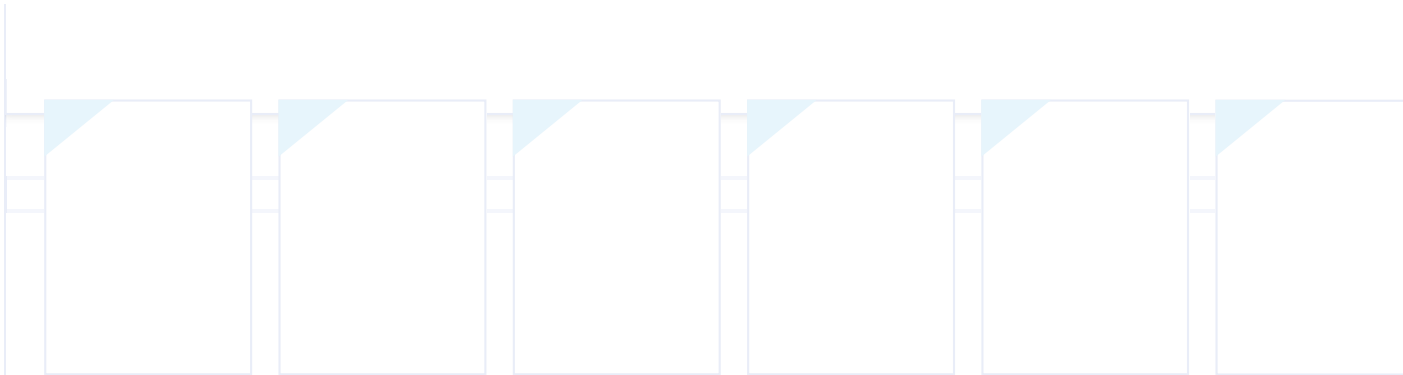
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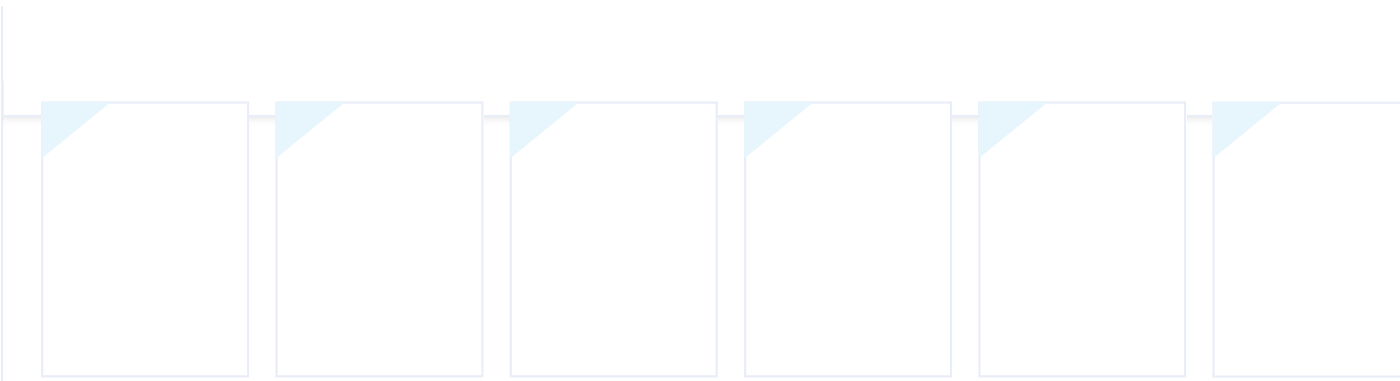
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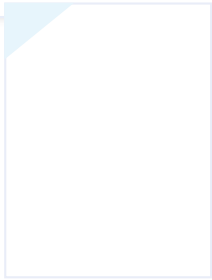
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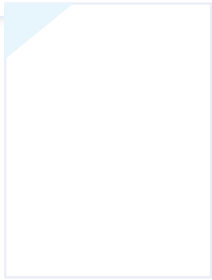
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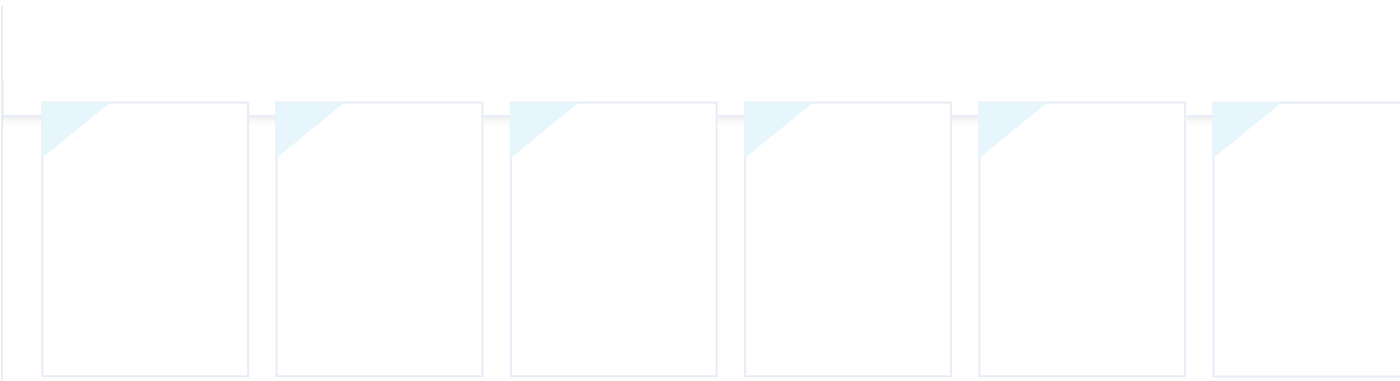
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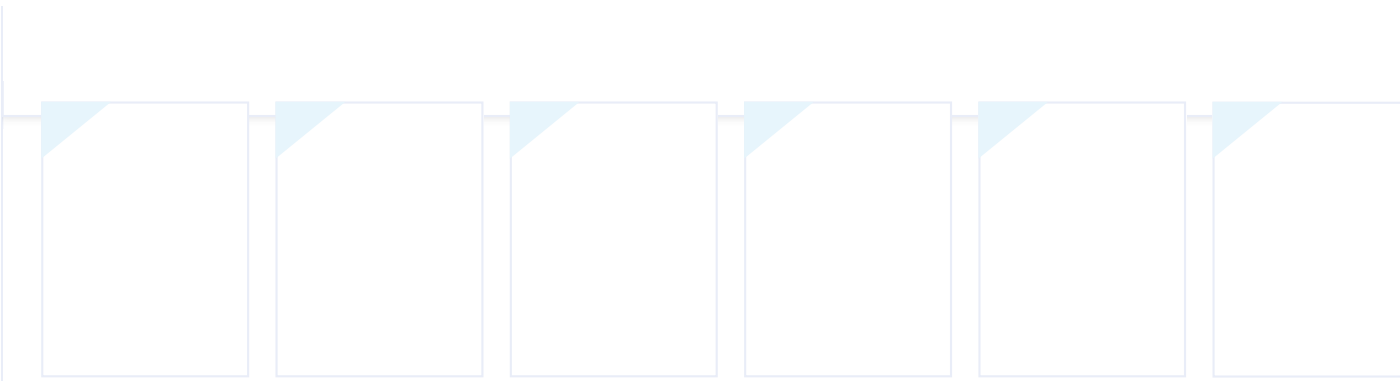
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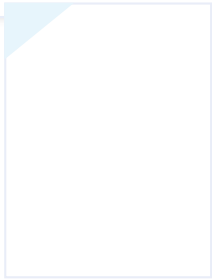
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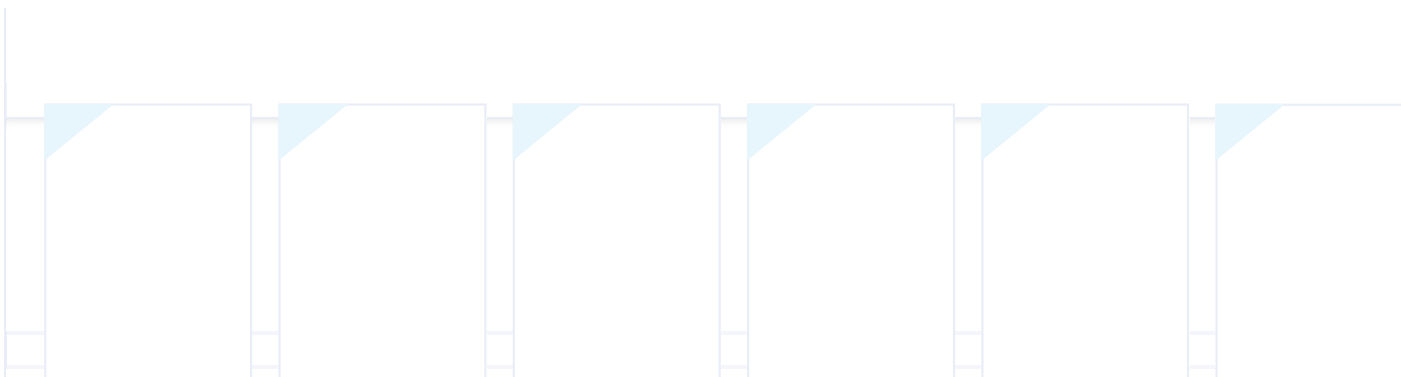
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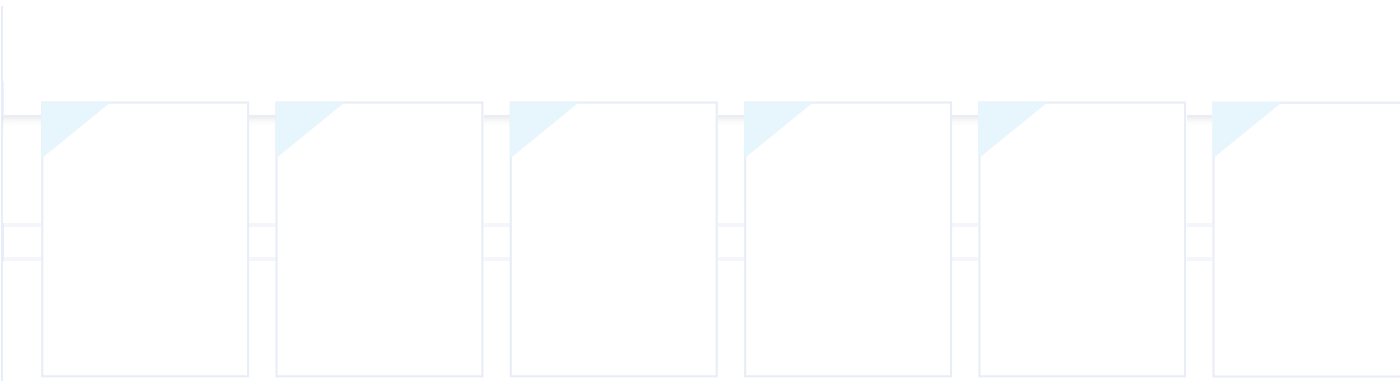
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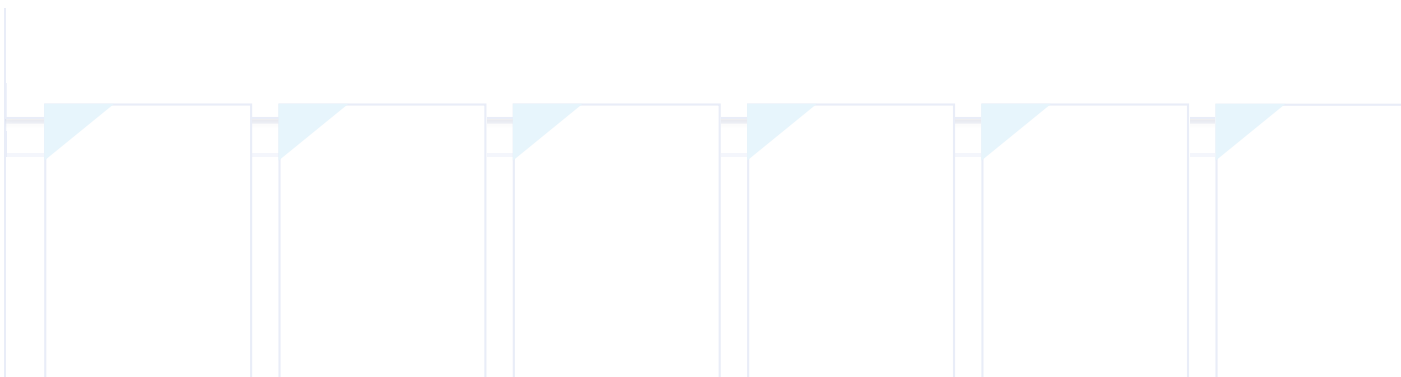
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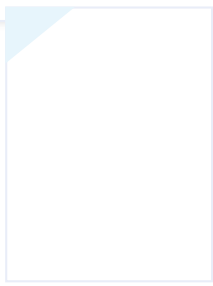
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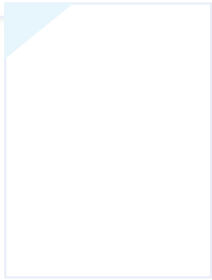
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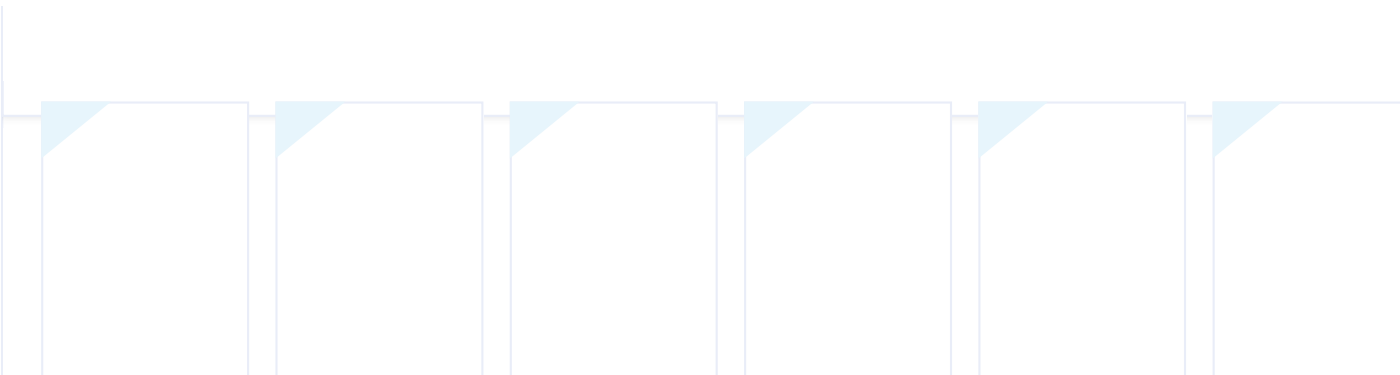
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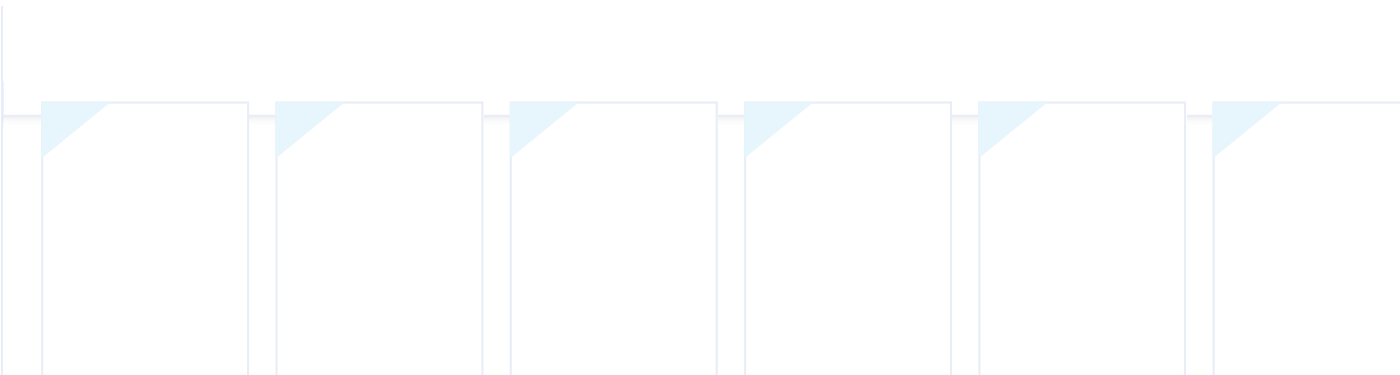
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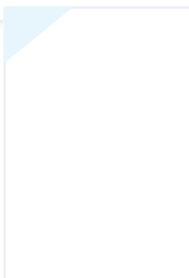
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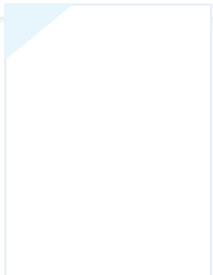

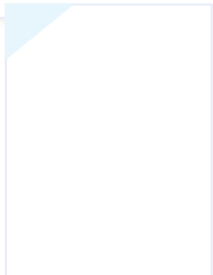



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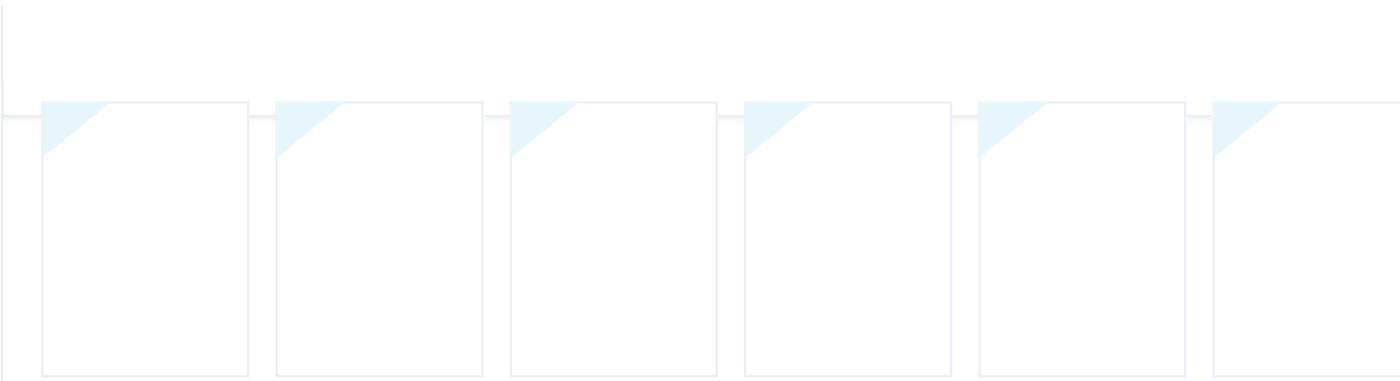
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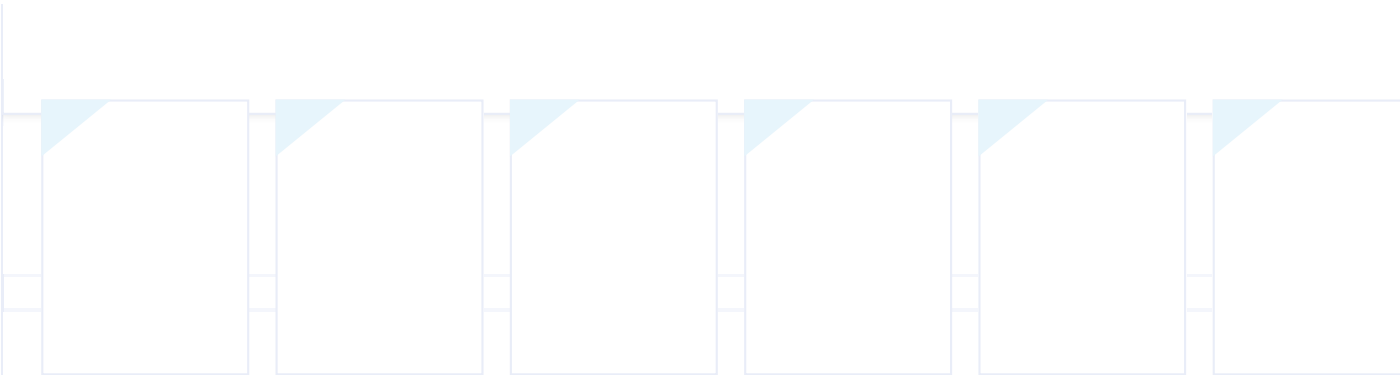
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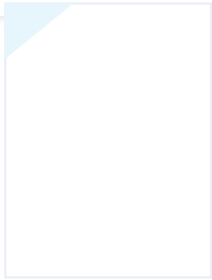
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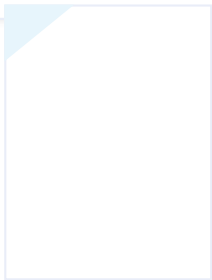


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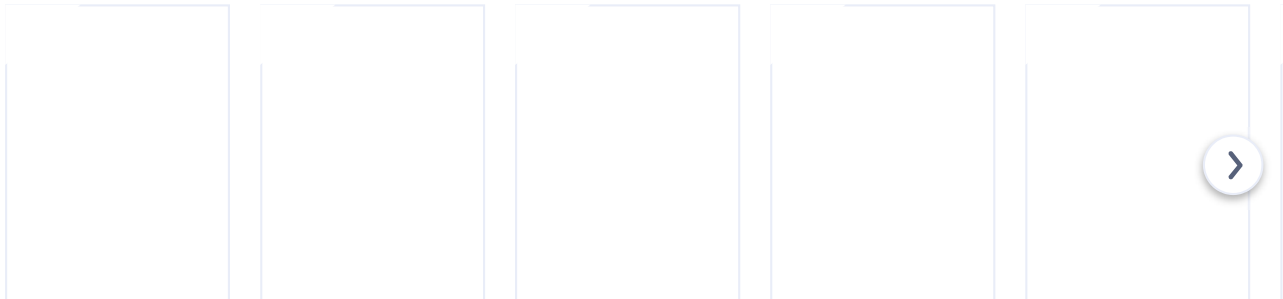
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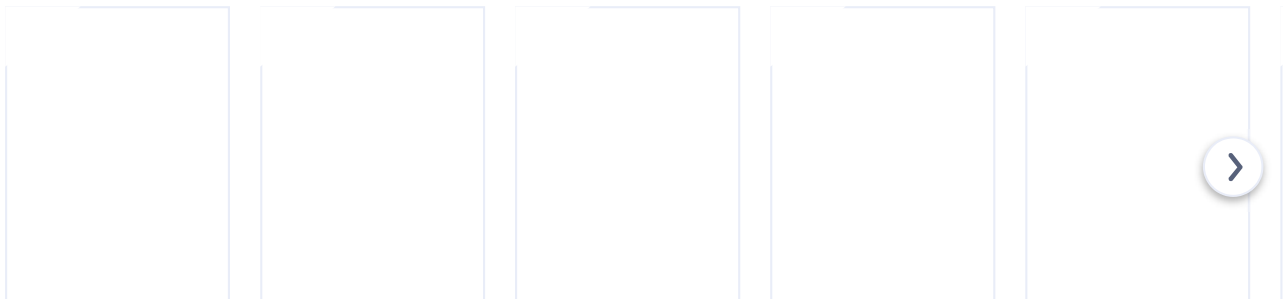
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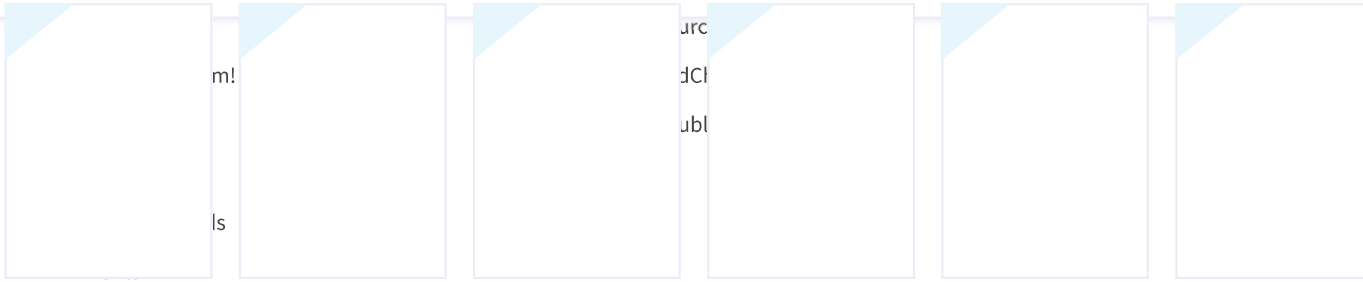


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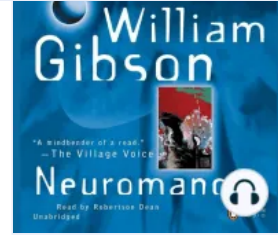
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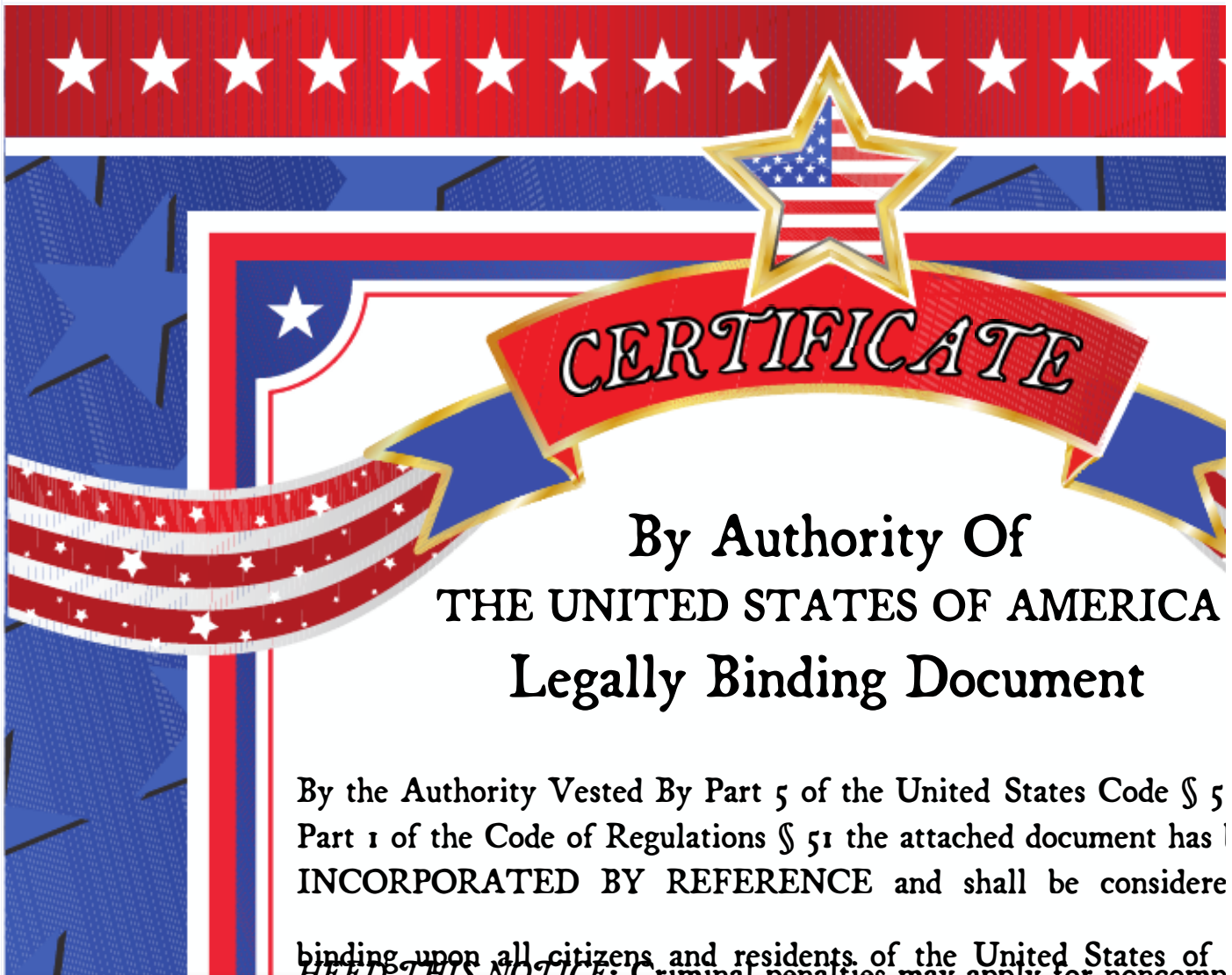


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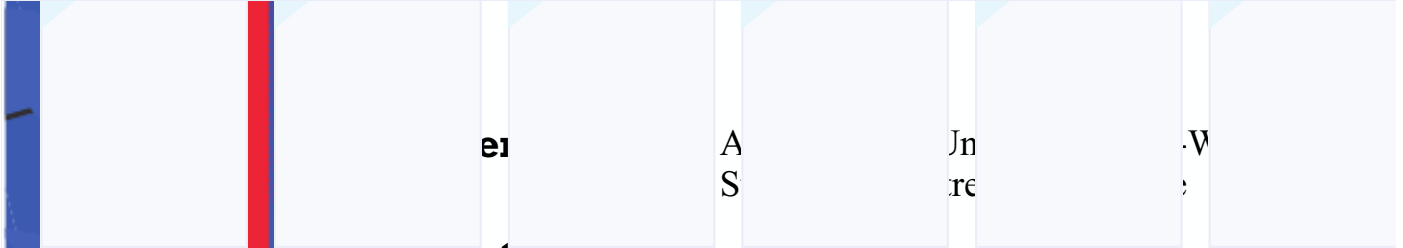
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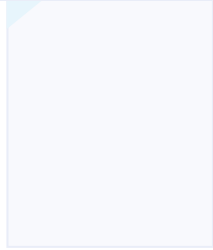
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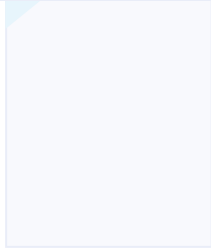
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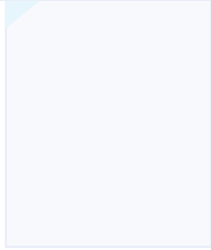
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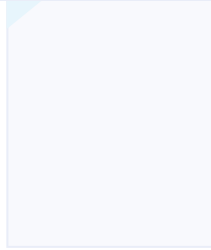
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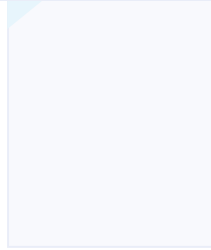
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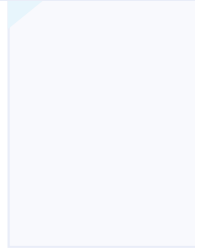
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# Standard Specification for UNCOATED SEVEN-WIRE STRESS-RELIEF STRAND FOR PRESTRESSED CONCRET

This Standard is issued under the fixed designation A 416; 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 reapproval.

*This specification has been approved for use by agencies of the Department of Defense for listing in their Specifications and Standards.*

## 1. Scope

1.1 This specification covers two grades of uncoated seven-wire, uncoated stress-relief strand for use in prestressed concrete. The ultimate strengths of the strand are Grade 250 and Grade 270.

4.1.1 Quantity (feet),

4.1.2 Diameter of strand



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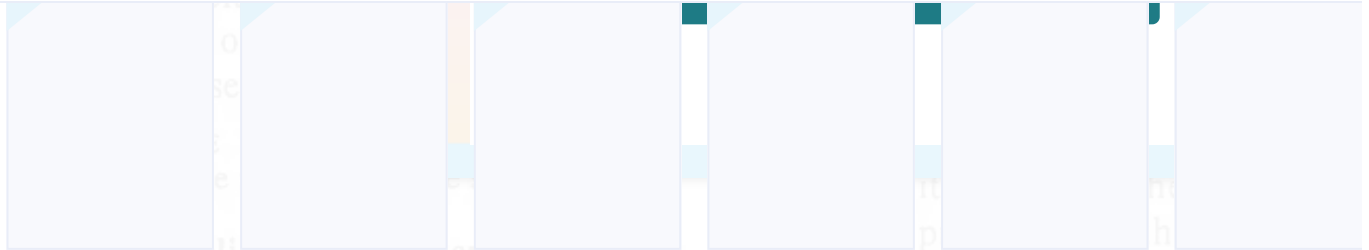
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### 3. Description of Terms

3.1 *Strand*—All strand shall be of the seven-wire type having a center wire enclosed tightly by six helically placed outer wires with a uniform pitch of not less than 12 and not more than 16 times the nominal diameter of the strand.

### 4. Ordering Information

4.1 Orders for seven-wire stress relieved strand under this specification shall include the following information:

<sup>1</sup> This specification is under the jurisdiction of Committee A-1 on Steel, Stainless and Related Alloys and is the direct responsibility of Subcommittee A-1.1 on Steel Reinforcement.

Current edition approved September 1, 1974. Originally published as A 416 - 68. Last previous edition A 416 - 68.

<sup>2</sup> *Annual Book of ASTM Standards*, Vol. 7.01, Steel Reinforcing Bars, and 10.

<sup>3</sup> *Annual Book of ASTM Standards*, Vol. 7.01, Steel Reinforcing Bars, and 10.



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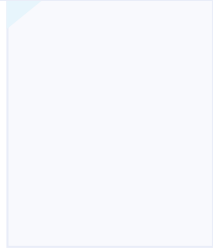
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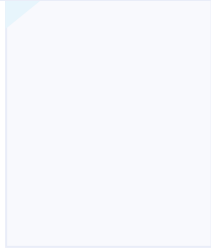
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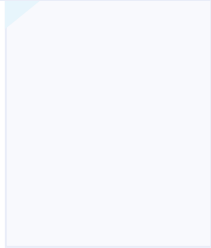
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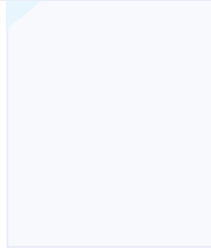
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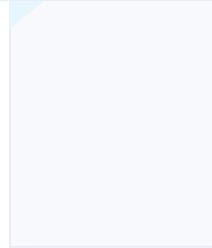
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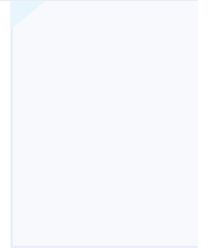
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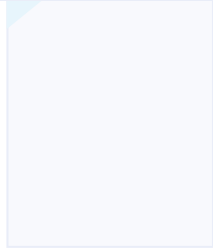
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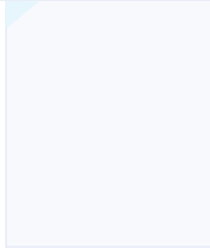
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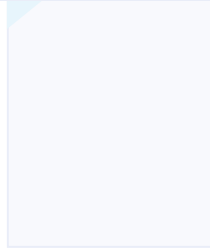
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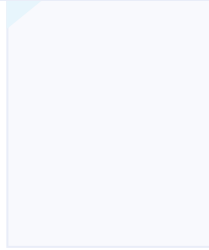
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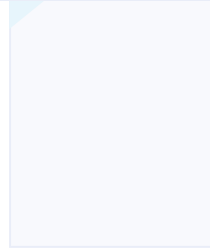
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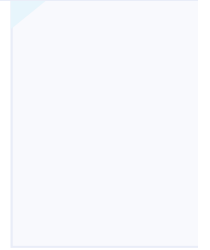
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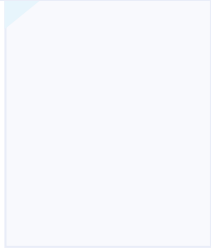
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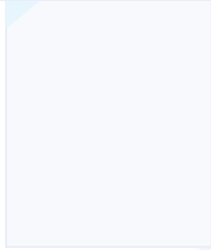
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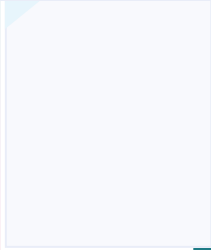
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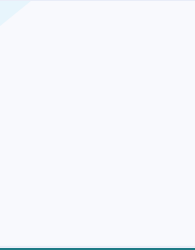
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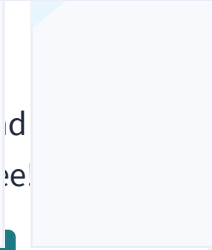
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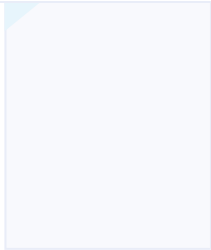
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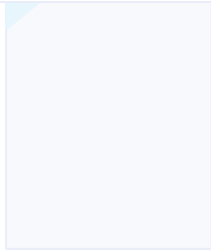
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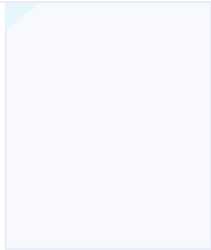
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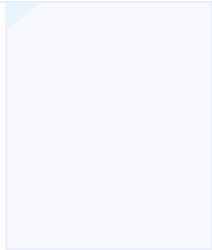
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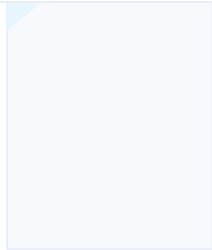
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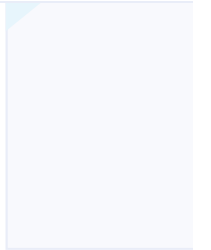
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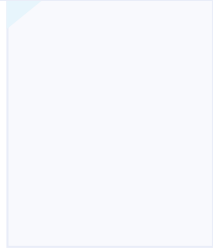
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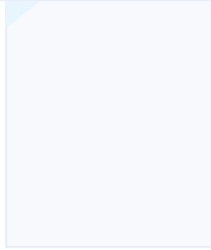
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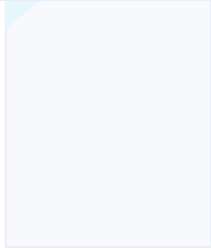
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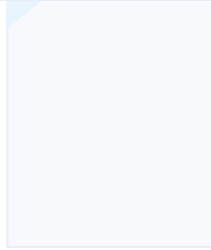
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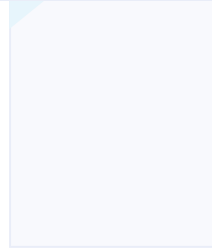
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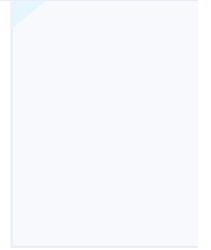
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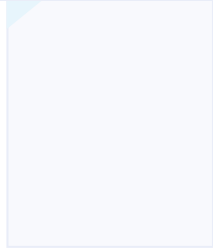
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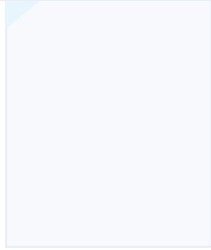
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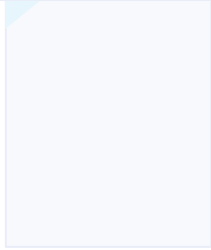
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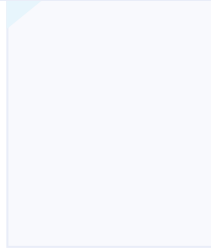
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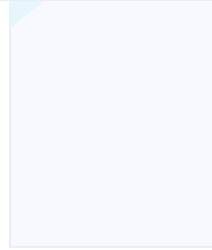
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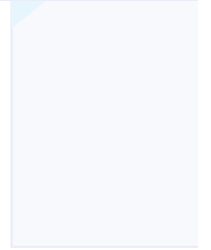
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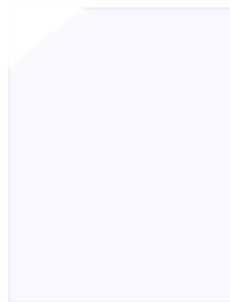
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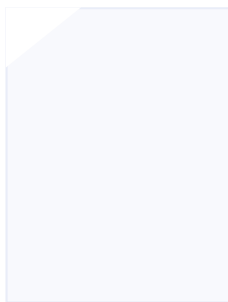
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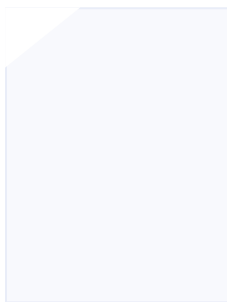
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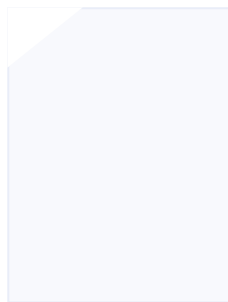
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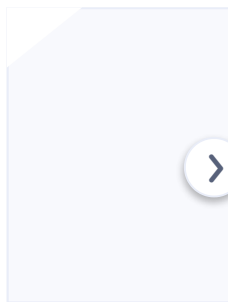
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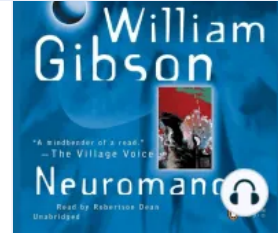
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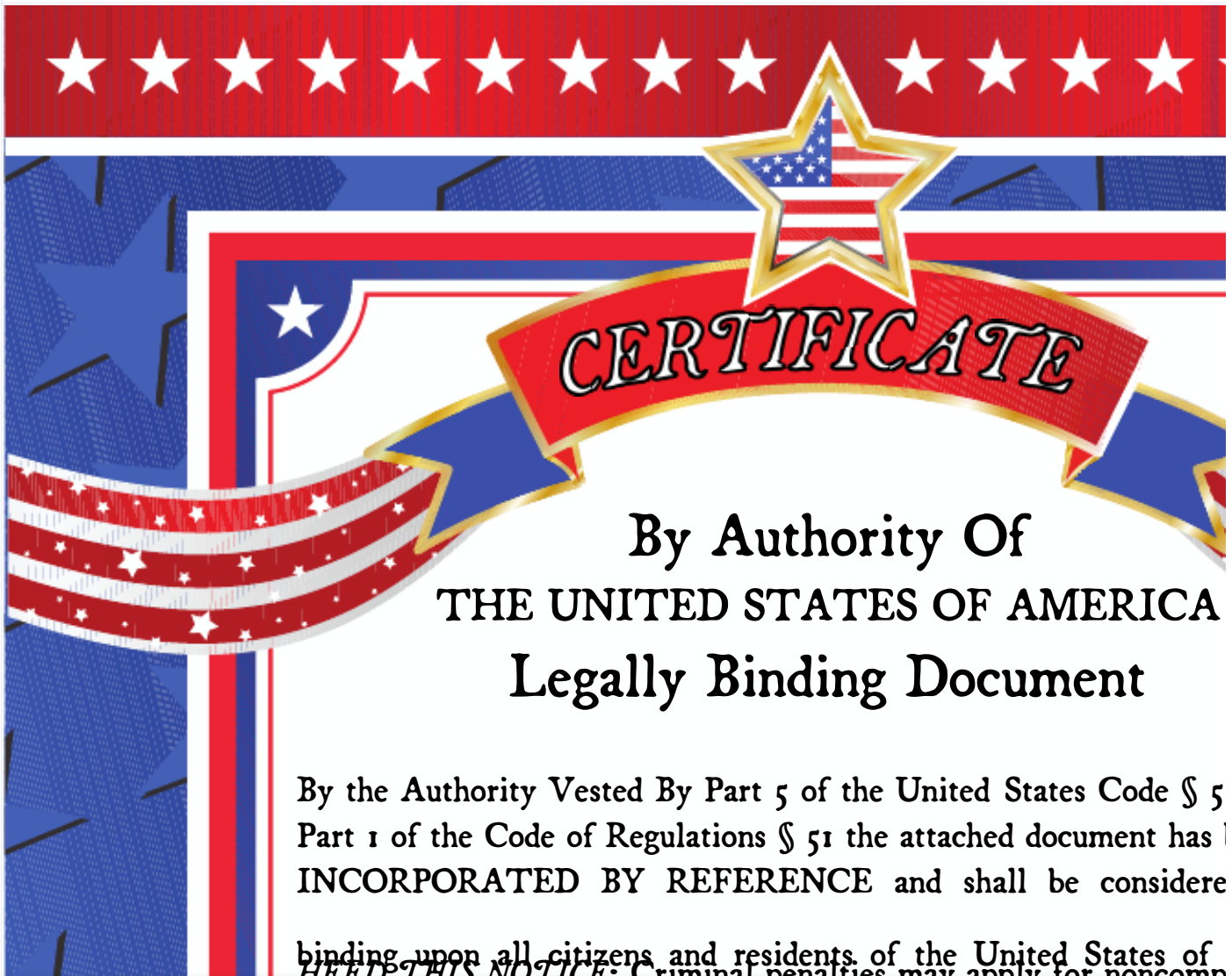


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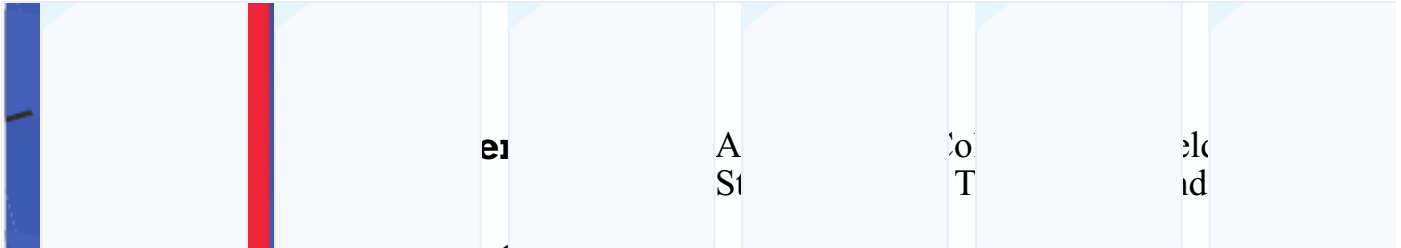
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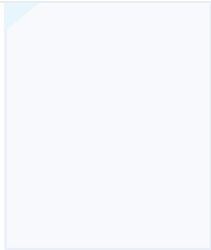
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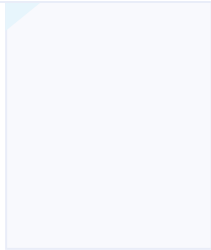
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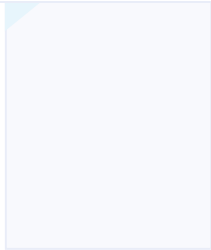
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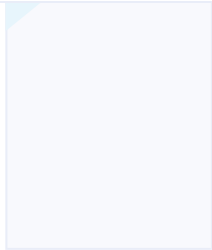
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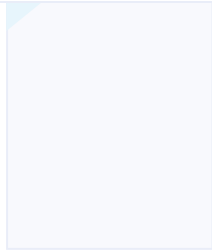
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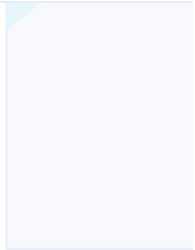
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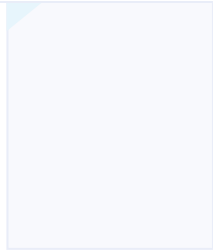
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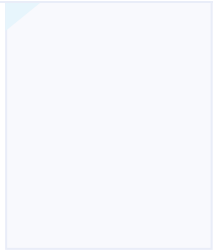
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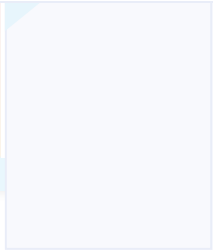
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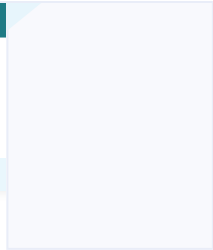
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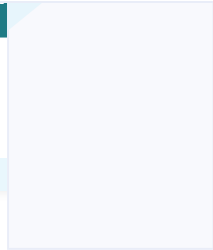
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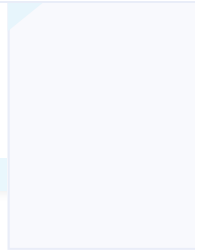
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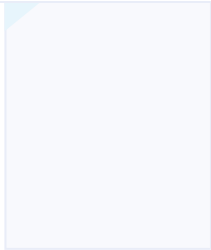
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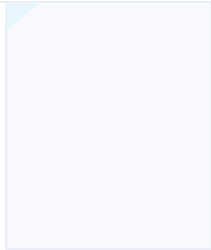
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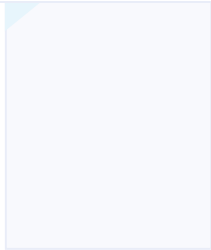
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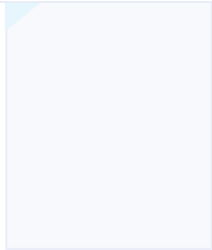
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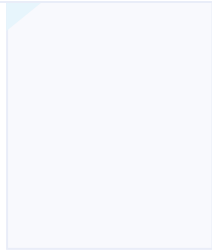
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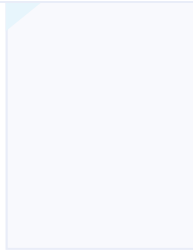
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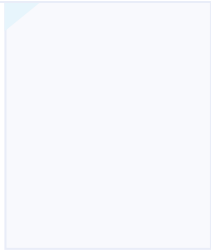


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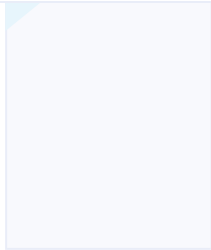
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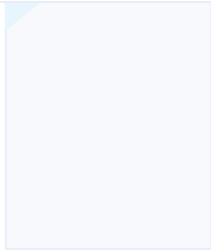
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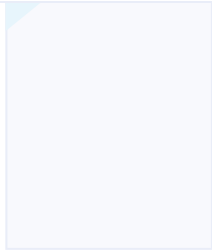
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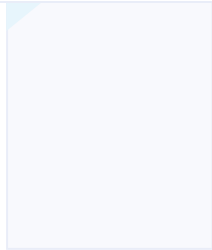
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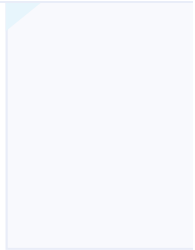
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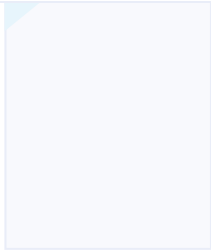
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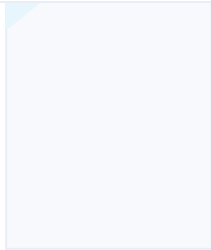
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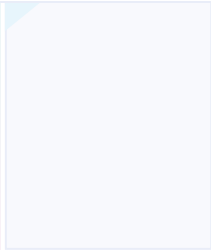
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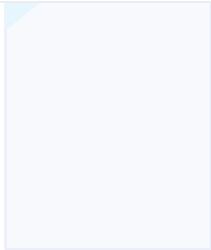


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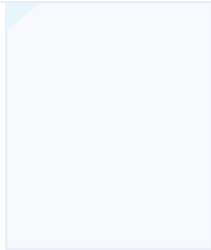
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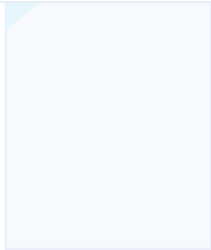
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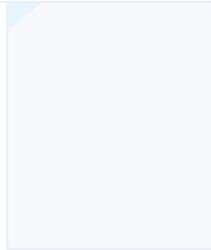
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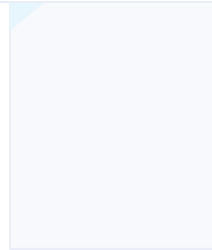
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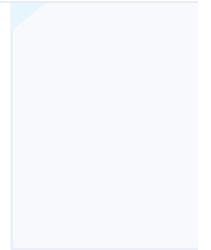
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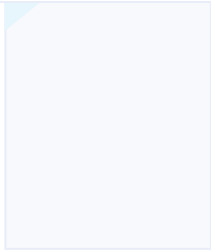


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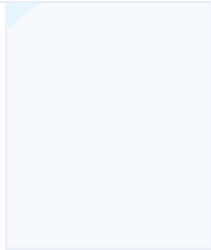
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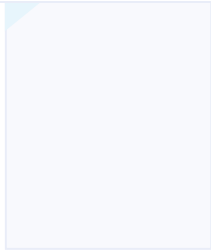
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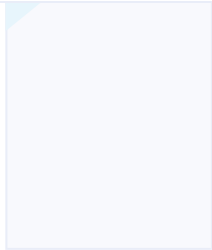
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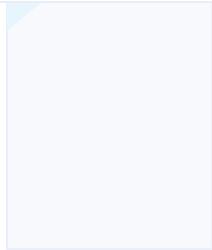
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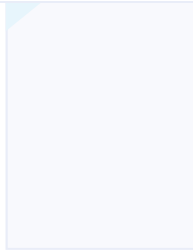
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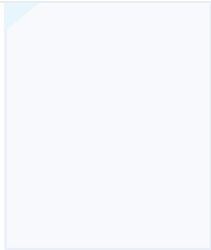


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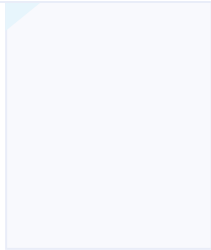
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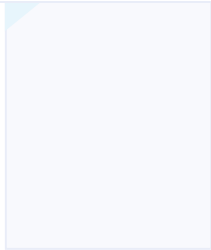
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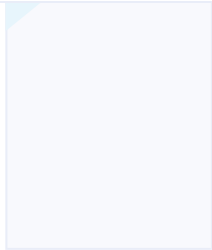
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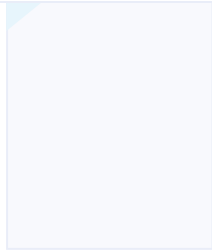
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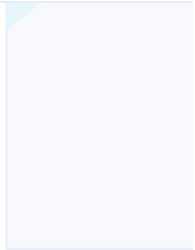
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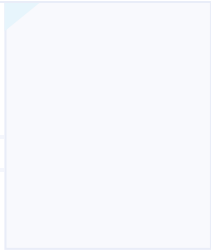


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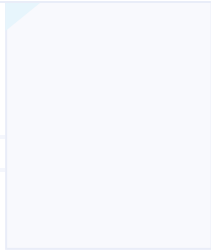
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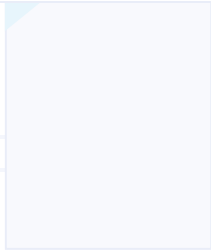
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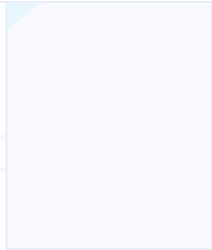
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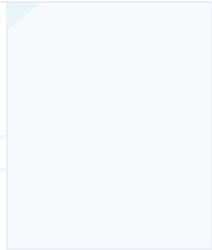
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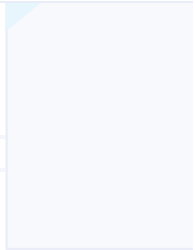
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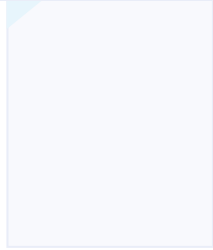
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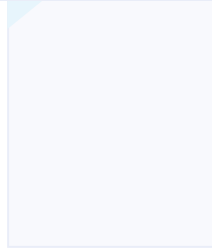
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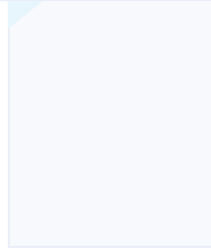
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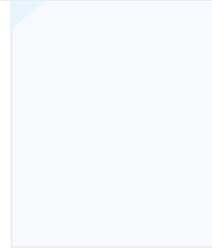
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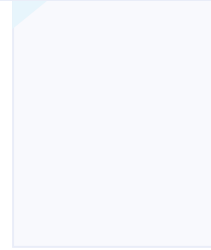
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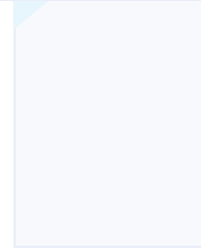
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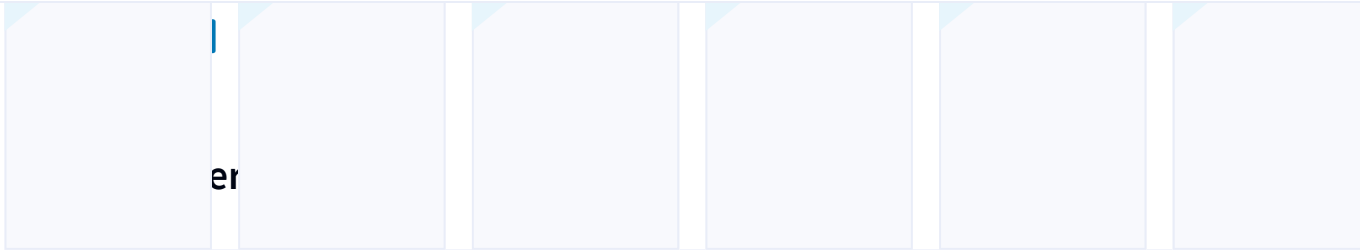
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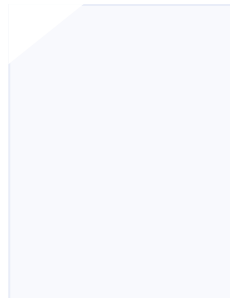
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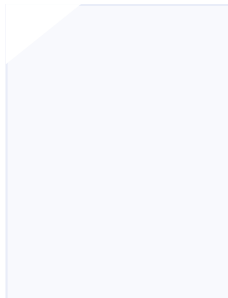
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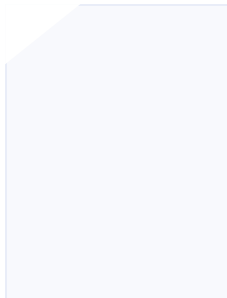
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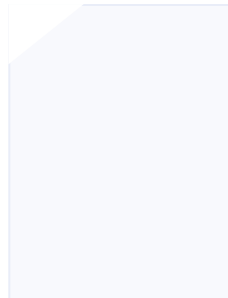
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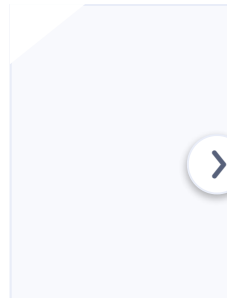
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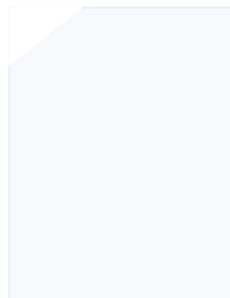
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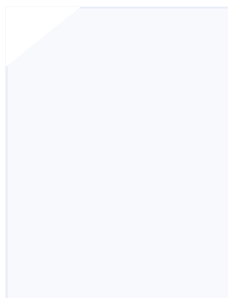
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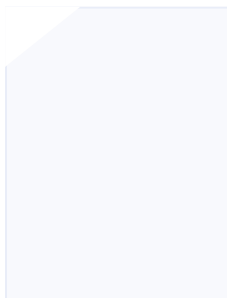
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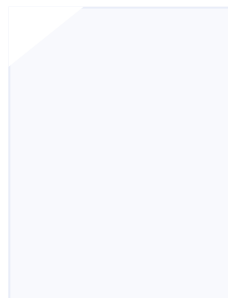
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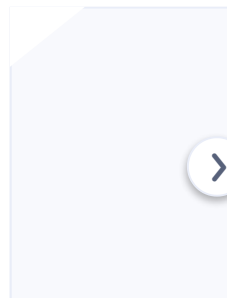
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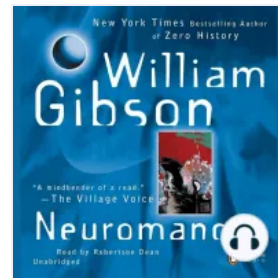
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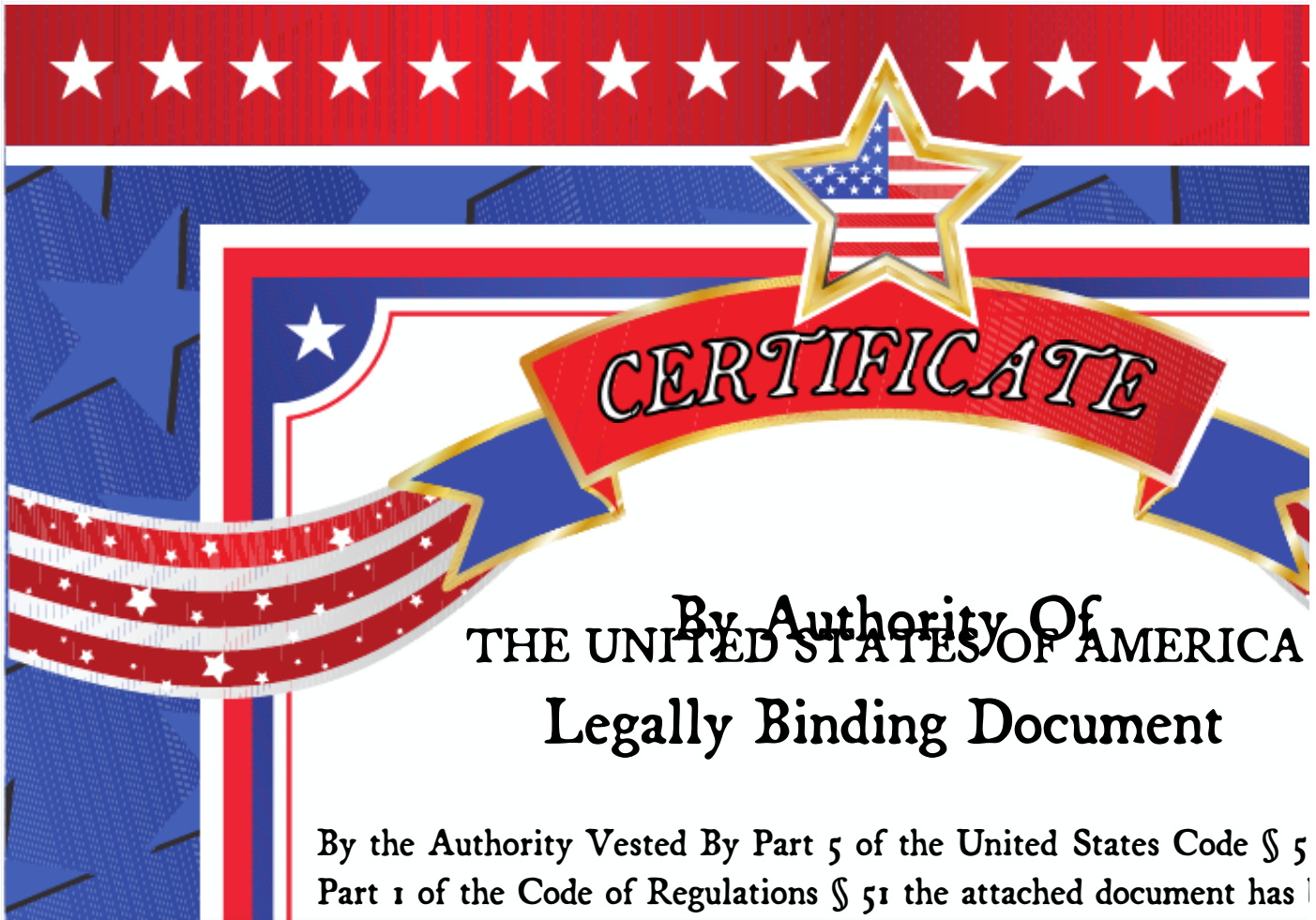
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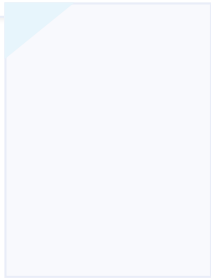


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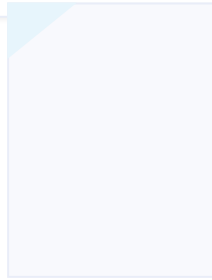


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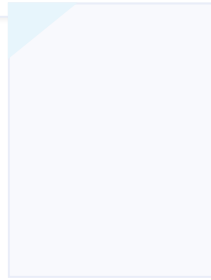
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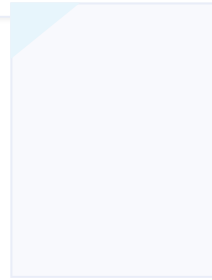
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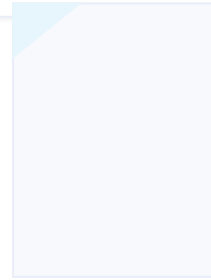
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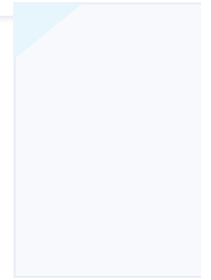
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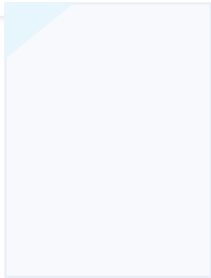


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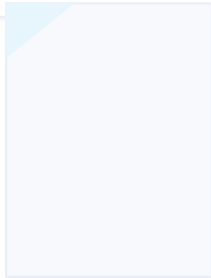


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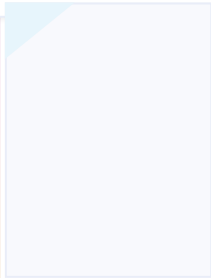
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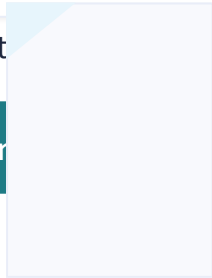
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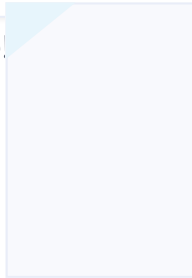
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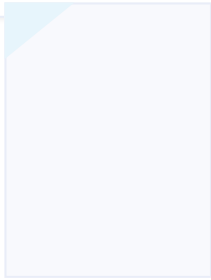


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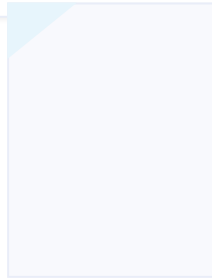


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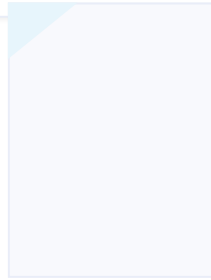
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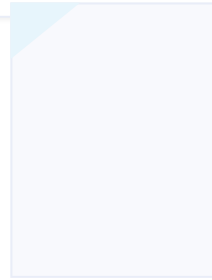
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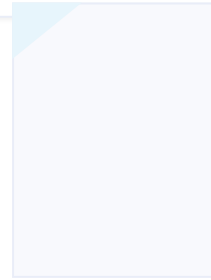
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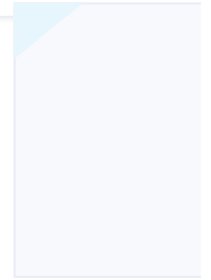
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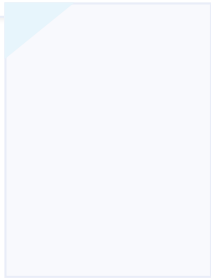
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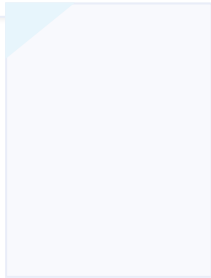


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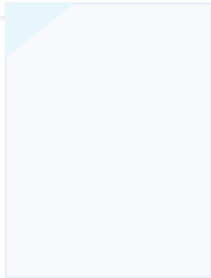
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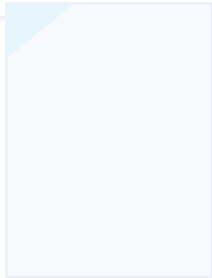
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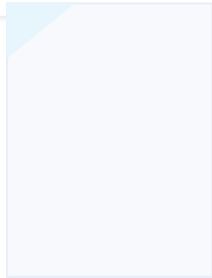
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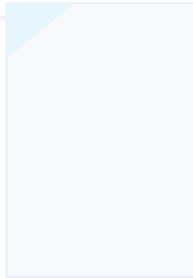
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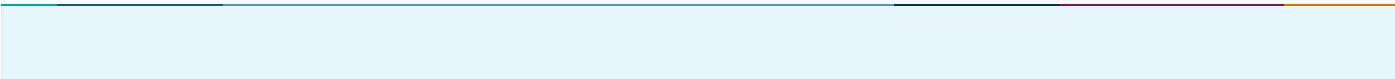
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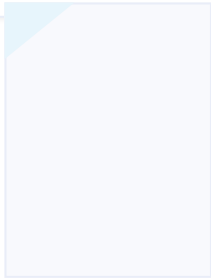


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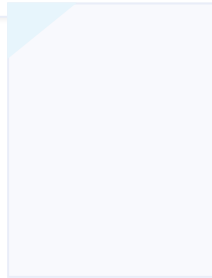


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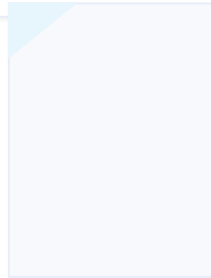
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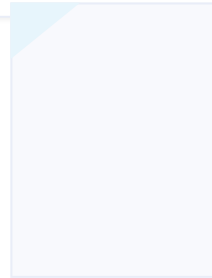
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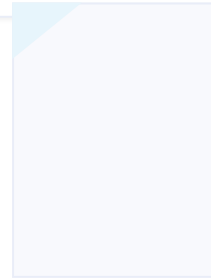
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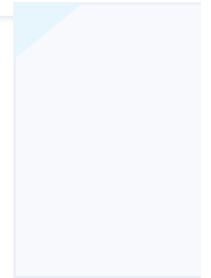
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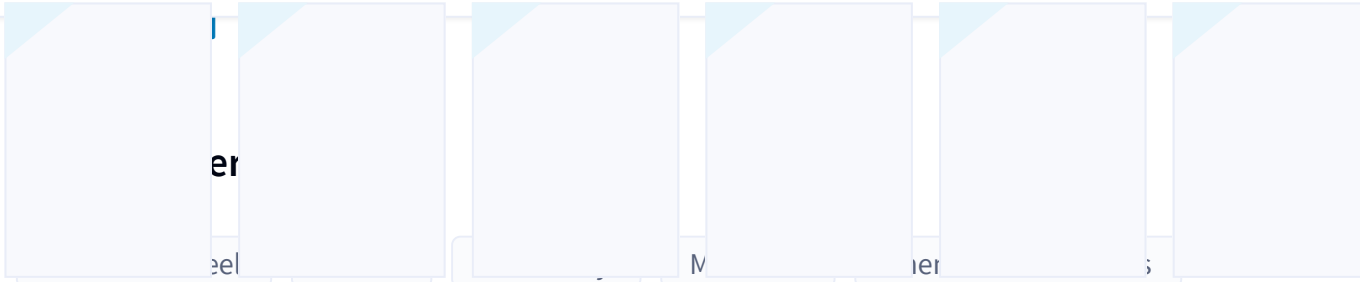


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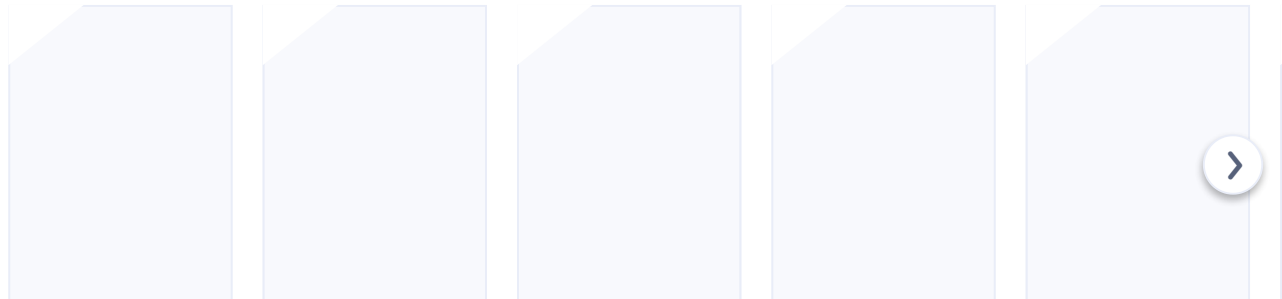
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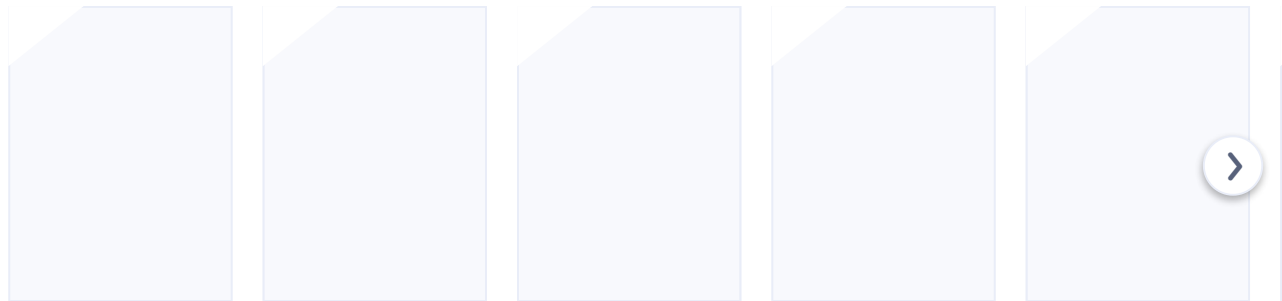
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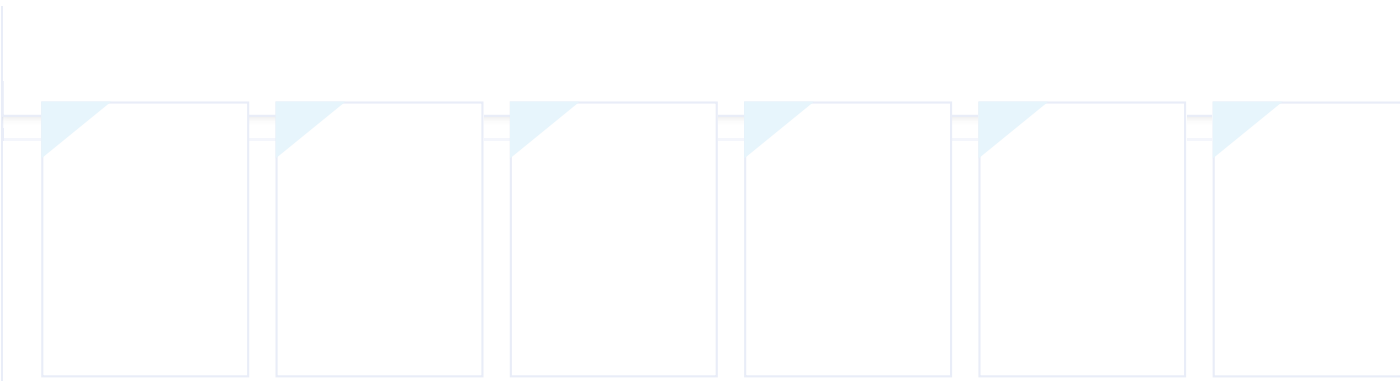
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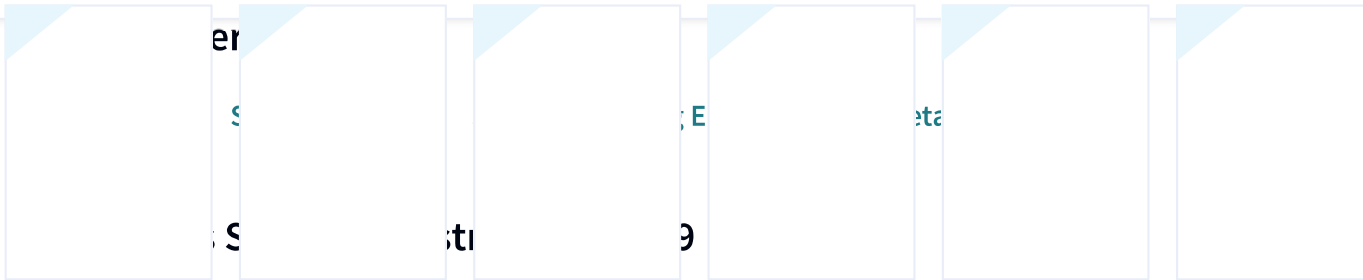


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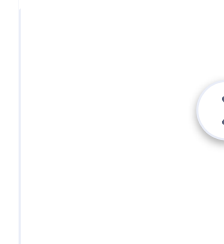
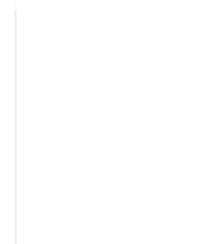
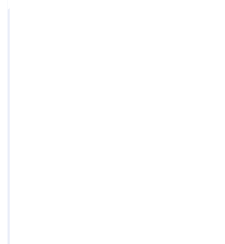
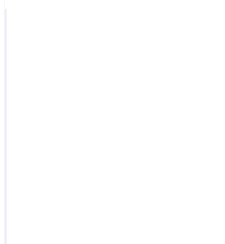
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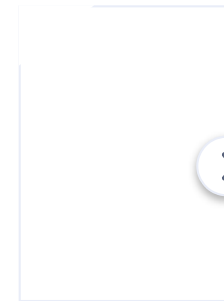
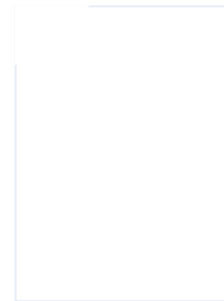
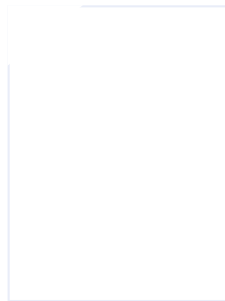
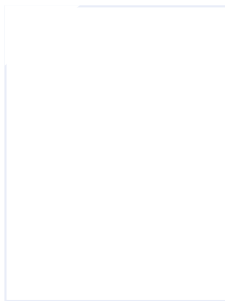
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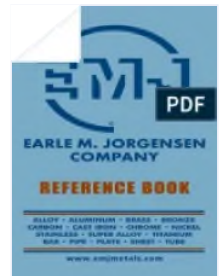
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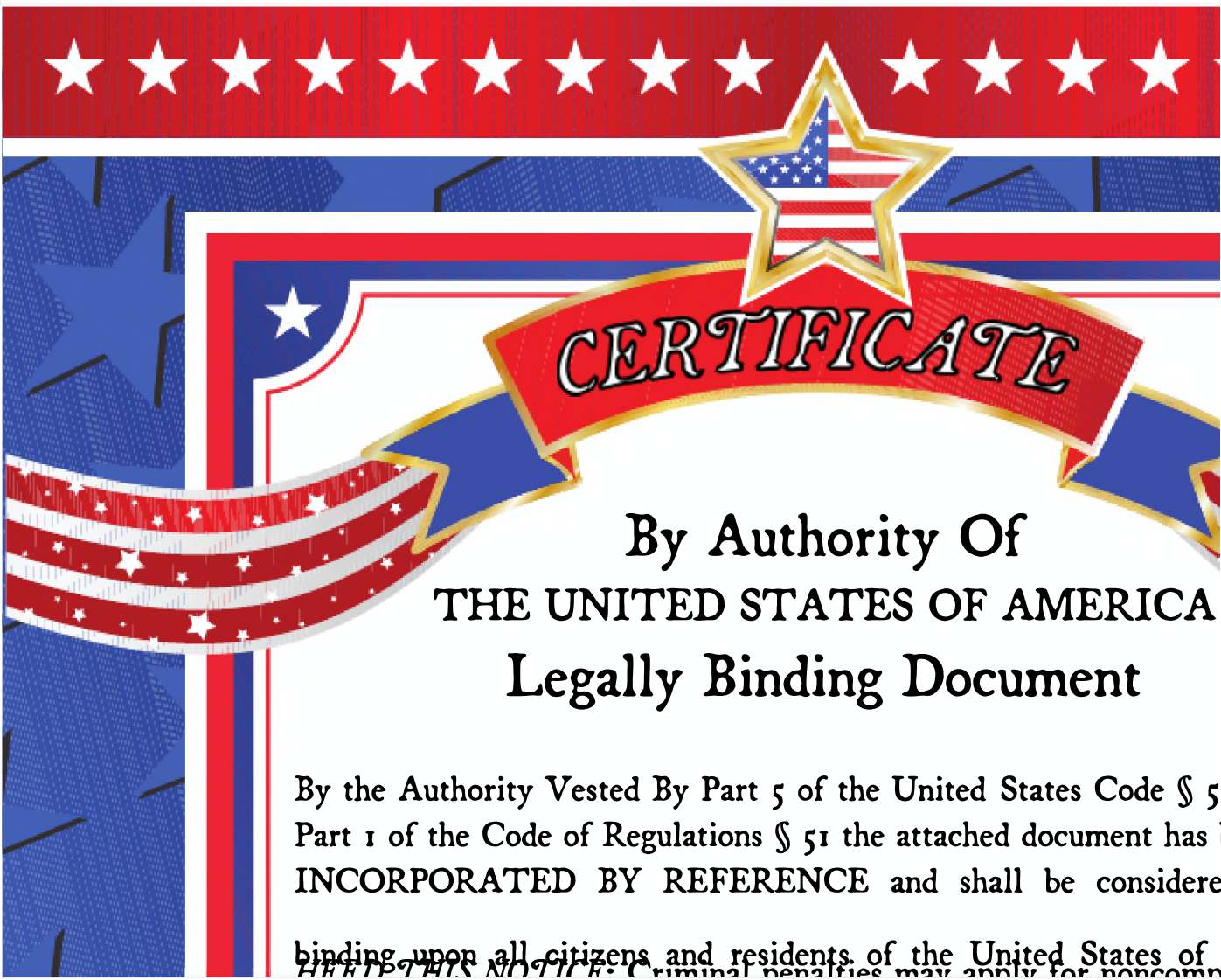
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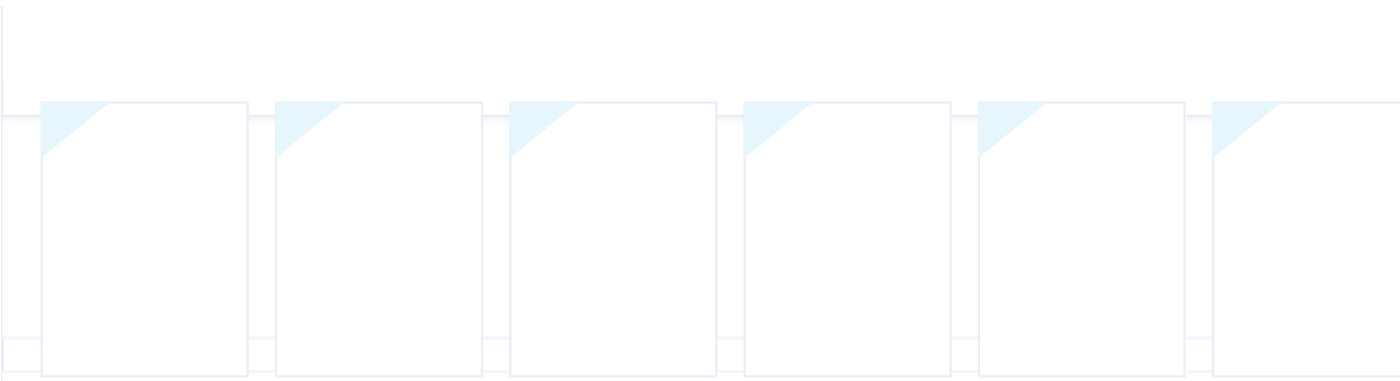


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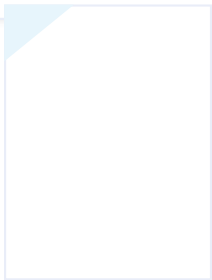
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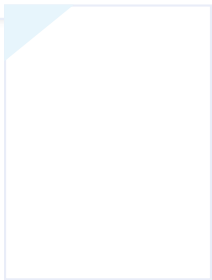
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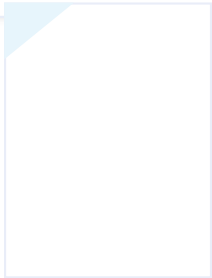


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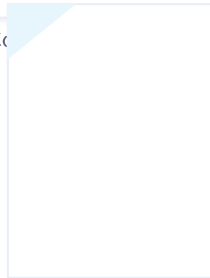


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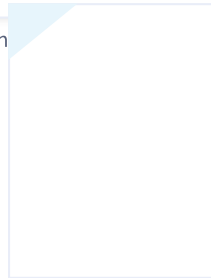
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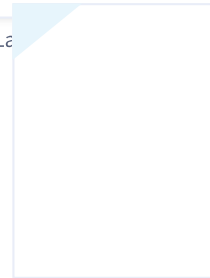
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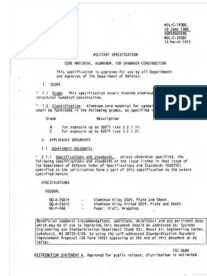
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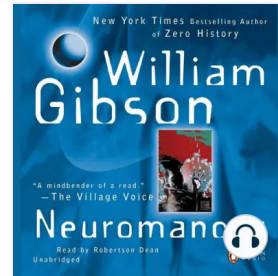
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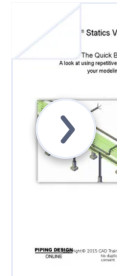
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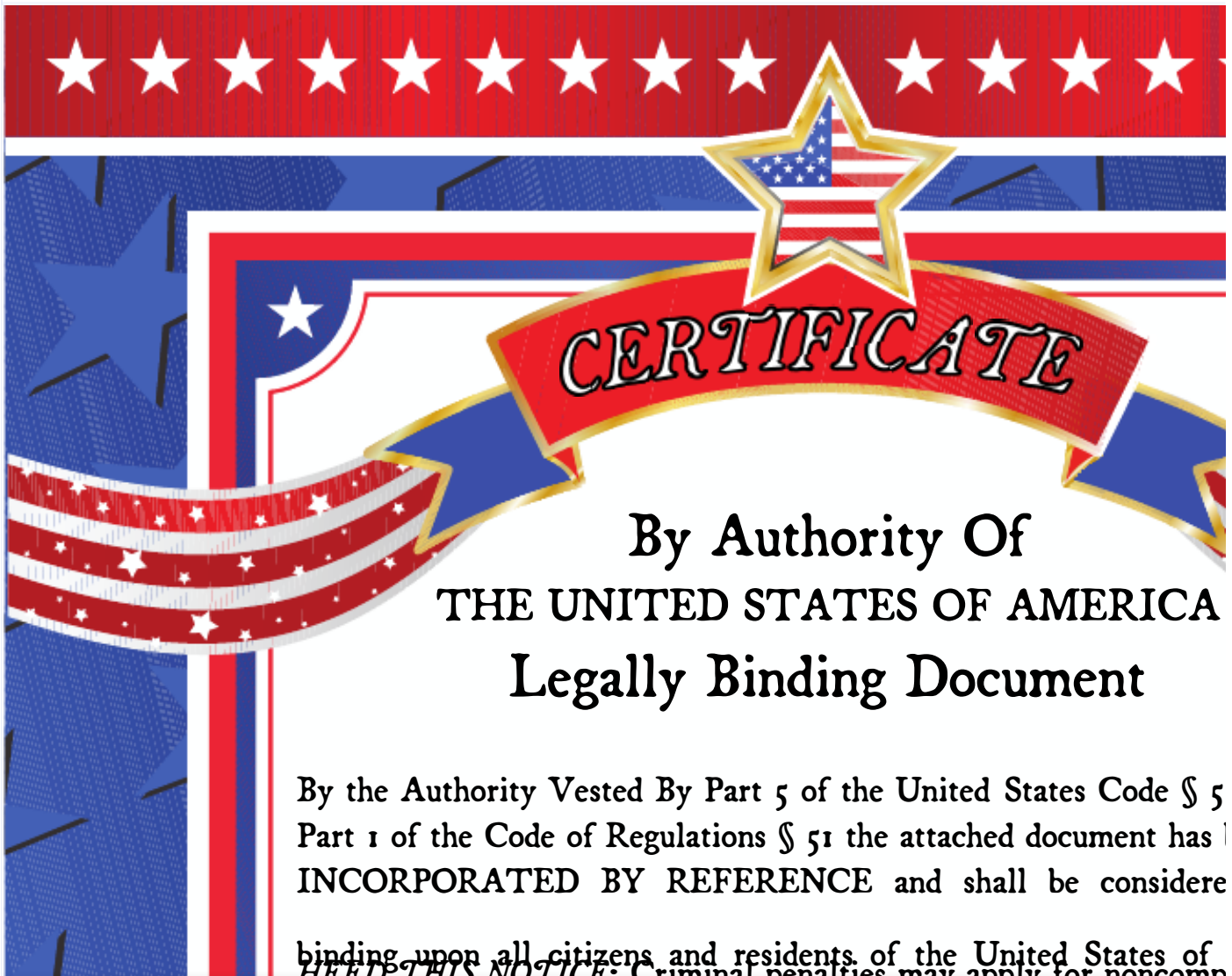


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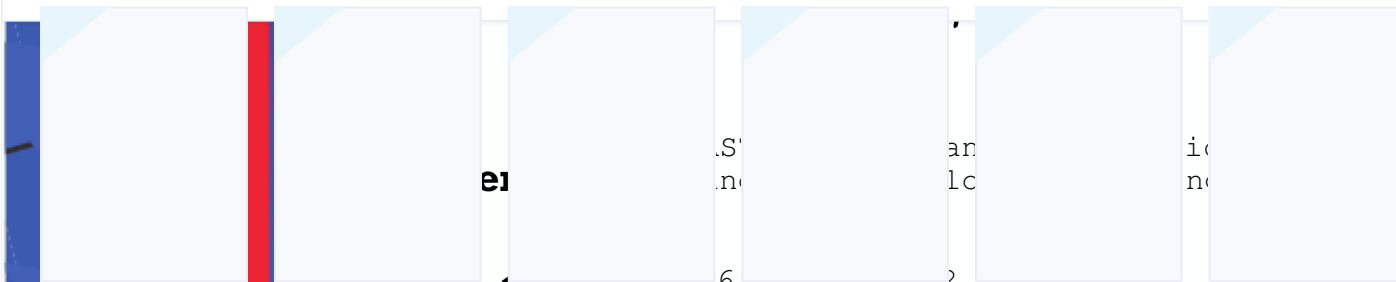


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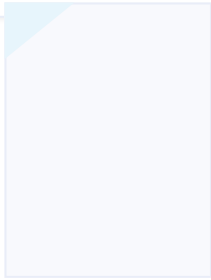


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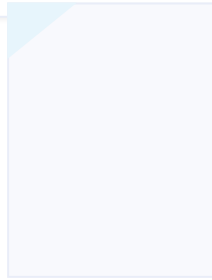


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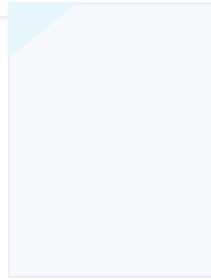
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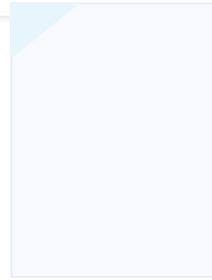
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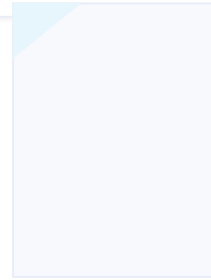
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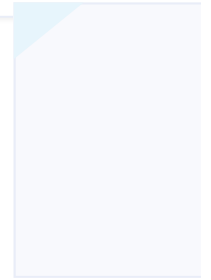
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Designation: B 283 – 96

# Standard Specification for Copper and Copper-Alloy Die Forgings (Hot-Pressed

This standard is issued under the fixed designation B 283; the number immediately following the designation original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

*This specification has been approved for use by agencies of the Department of Defense. Consult the DoD Index Standards for the specific year of issue which has been adopted by the Department of Defense.*

## 1. Scope\*

1.1 This specification covers the requirements for copper and copper alloy die forgings produced by the hot pressing method. The following copper and copper alloys are included:

Copper or Copper Alloy

UNS No.

Name

C11000

Copper

C14500

copper-tellurium

C14700

copper-sulfur

C36500

C37700

C46400

C48200

C48500

C61900

C62300

C63000

C63200

C64200

C64210

C65500

C67500

C67600

C77400

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<sup>1</sup>This specification is under the jurisdiction of ASTM Committee B-5 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.02 on Rod, Bar, Wire, Shapes, and Forgings.

Current edition approved Sept. 10, 1996. Published December 1996. Originally published as B 283 – 53 T. Last previous edition B 283 – 94.

<sup>2</sup> Annual Book of ASTM Standards, Vol 02.01.

\* A Summary of Changes section appears at the end of this specification.

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## B 283

4.1.1 For definition of terms related to copper and copper alloys refer to Terminology B 846.

4.2 Definition of Term Specific to This Standard:

4.2.1 hot pressed forging, *n*—a product made by pressing a heated blank or section of wrought copper or copper alloy in a closed impression die.

### 5. Ordering Information

5.1 Orders for product to this specification should include the following information:

5.1.1 ASTM designation and year of issue,

5.1.2 Copper or Copper Alloy UNS No. designation (Section 1),

5.1.3 Drawing showing the shape dimensions and tolerances (Section 11),

5.1.4 Temper (Section 8),

5.1.5 Quantity; total weight or number of pieces for each

C48500 and 99.5 % for all

### 8. Temper

8.1 Tempers, as defined in this specification are M10 (forged-quenched) and TQ5 (annealed).

### 9. Mechanical Property Requirements

9.1 Mechanical property agreement between the manufacturer and purchaser.

9.2 Product specified to ASME Boiler and Pressure Vessel Code shall have properties as prescribed in Table 1 with Test Methods E 8.

### 10. Heat Treatment

10.1 Product produced

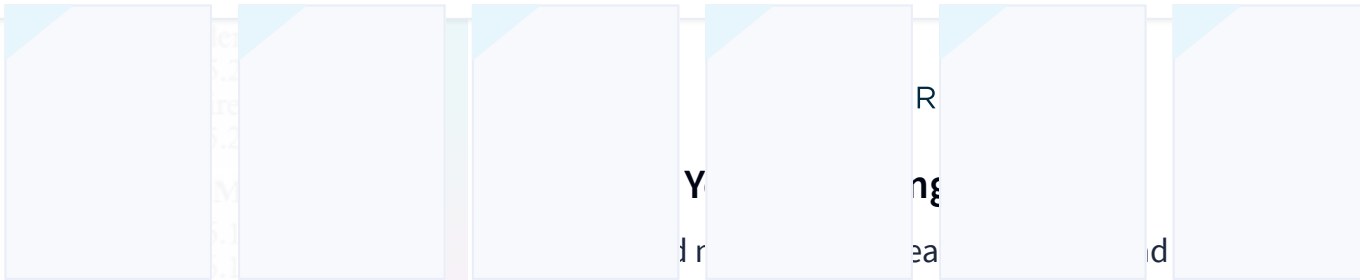


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### 7. Chemical Composition

7.1 The materials shall conform to the requirements specified in Table 1 for the Copper or Copper Alloy UNS No. designated in the ordering information.

7.2 These composition limits do not preclude the presence of other elements when limits for unnamed elements are required, they shall be established by agreement between manufacturer or supplier and the purchaser.

7.2.1 For copper alloys in which zinc is specified as a remainder, either copper or zinc is permitted to be taken as the difference between the sum of results for all the elements analyzed and 100 %. When copper is so determined, that difference value shall conform to the requirements given in Table 1.

7.2.2 For copper alloys for which copper is specified as the remainder, copper may be taken as the difference between the sum of all the elements analyzed and 100 %.

7.3 When all the elements in Table 1 are determined for the individual alloy, the sum of results shall be 99.6 % min for Copper Alloy UNS No. C36500, C46400, C48200,

ment, be determined as follows:

Element	
Aluminum	
Arsenic	
Copper	
Iron	<1.3 %
Lead	>1.3 %
Manganese	
Nickel	>0.5 %
Phosphorus	>0.05 %
Silicon	
Tin	<1.3 %
Zinc	>1.3 %
	>2 %

Tellurium

NOTE—< = less than; > = greater than

13.1.2 Test method(s) to determine the amount of element(s) required is

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ASTM B 283

TABLE 2 Tensile Requirements

Diameter or Section Thickness, in. (mm)	Tensile Strength, min		Yield Strength at 0.5% Extens Load, min	
	ksi	MPa <sup>a</sup>	ksi	M
Copper Alloy UNS No. C 37700				
Up to 1½ (38.1), incl	50	345	18	1
Over 1½ (38.1)	46	317	15	1
Copper Alloy UNS No. C 64200				
Up to 1½ (38.1), incl	70	482	25	1

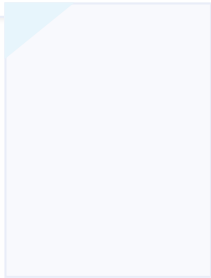


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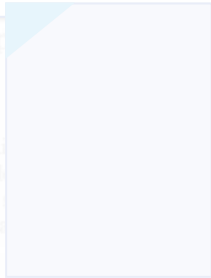


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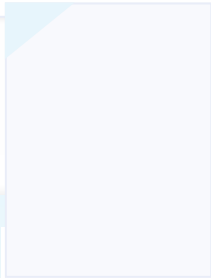
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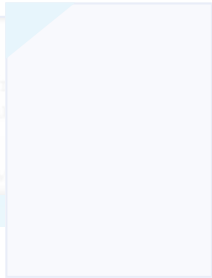
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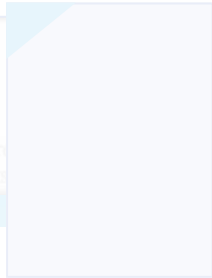
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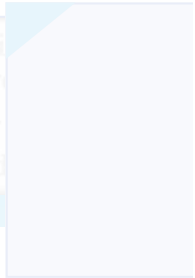
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#### S1. Referenced Documents

S1.1 The following date of material purchase and the extent referenced:

##### S1.1.1 Federal Standards

Fed. Std. No. 102 Levels

Fed. Std. No. 123

Fed. Std. No. 185

Copper-Base Alloys

##### S1.1.2 Military Specifications

MIL-STD-105 Sampling

specification by Attributes

MIL-STD-129 Marking for Shipment and Storage

##### S1.1.3 Military Specification:<sup>6</sup>

MIL-C-3993 Packaging of Copper and Copper-Base Alloy Mill Products

#### S2. Quality Assurance

##### S2.1 Responsibility for Inspection:

S2.1.1 Unless otherwise specified in the contract or purchase order, the manufacturer is responsible for the performance of all inspection and test requirements specified. Except as otherwise specified in the contract or purchase order, the manufacturer may use his own or any other

<sup>6</sup> Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, ATTN: NPODS.

#### S4. Preparation for Deliver

##### S4.1 Preservation, Packa

S4.1.1 Military Agencies—by size, composition, grade and packaged, Level A or specified in the contract or with the requirements of M

##### S4.1.2 Civil Agencies—T

102 shall be referenced for d packaging protection.

##### S4.2 Marking:

S4.2.1 Military Agencies marking required by the con for shipment shall be in acc

##### S4.2.2 Civil Agencies—In

required by the contract c shipment shall be in accord



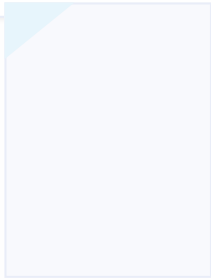


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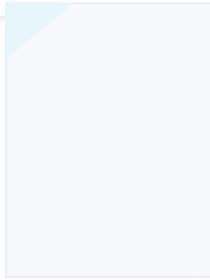


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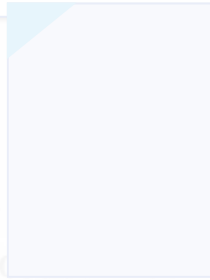
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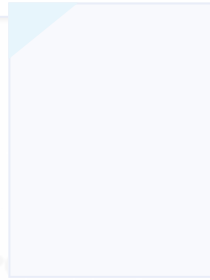
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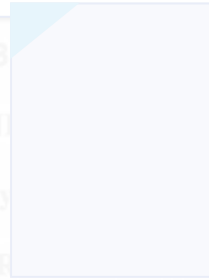
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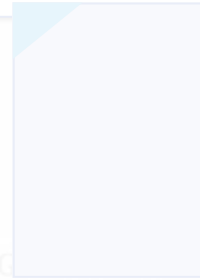
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TABLE X1.1 Nominal Compositions and Forgeability Ratings

Copper or Copper Alloy UNS No.	Nominal Composition, %									
	Copper	Lead	Tin	Iron	Nickel	Aluminum	Silicon	Manganese	Zinc	Sulfur
C 11000	100	...	...	...	...	...	...	...	...	...
C 14500	99.45	...	...	...	...	...	...	...	...	...
C 14700	99.5	...	...	...	...	...	...	...	...	0.01
C 36500	60	0.6	...	...	...	...	...	...	39.4	...
C 37700	60	2	...	...	...	...	...	...	38	...
C 46400	60	...	0.8	...	...	...	...	...	39.2	...
C 48200	60	0.7	0.8	...	...	...	...	...	38.5	...
C 48500	60	...	...	...	...	...	...	...	...	...
C 61900	87.5	...	...	...	...	...	...	...	...	...
C 62300	88	...	...	...	...	...	...	...	...	...
C 63000	81	...	...	...	...	...	...	...	...	...
C 63200	81	...	...	...	...	...	...	...	...	...
C 64200	91	...	...	...	...	...	...	...	...	...
C 64210	91.3	...	...	...	...	...	...	...	...	...
C 65500	96	...	...	...	...	...	...	...	...	...
C 67500	58.5	...	...	...	...	...	...	...	...	...
C 67800	58.5	...	...	...	...	...	...	...	...	...
C 77400	45	...	...	...	...	...	...	...	...	...

<sup>A</sup> Relative forgeability rating to common units, calibration in to values shown represent the general. Intricate parts are more likely to  
<sup>B</sup> One or more of these elements




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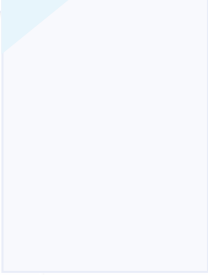
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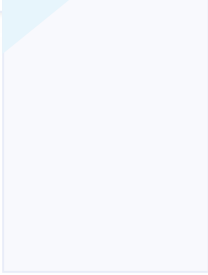




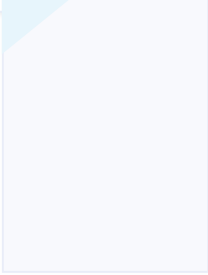




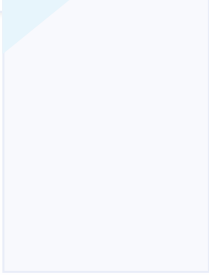
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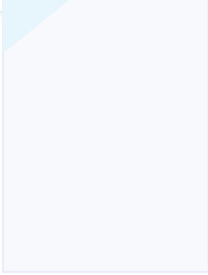
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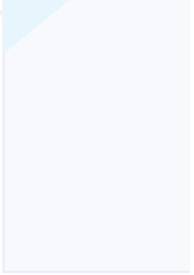
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### X2. DIMENSIONAL TOLERANCES

X2.1 The data in Table X2.1 do not constitute a part of this specification. They are given merely to indicate to the purchaser the various forging types and some dimensional tolerances used on commercially designed hot-pressed forgings up to 2 lb (0.91 kg). For heavier forgings, consult the purchaser's specification or the manufacturer's data.

**TABLE X2.1 Dimensional Tolerances**

Forging types:	Tolerances, plus and minus Except as indicated	
	Steel	Copper or Copper Alloy
Solid	0.010 (0.25)	0.008 (0.20)
Solid, with symmetrical cavity	0.010 (0.25)	0.008 (0.20)
Solid, with eccentric cavity	0.012 (0.30)	0.008 (0.20)
Solid, deep extrusion		
Hollow, deep extrusion		
Thin section, short (up to 6 in. (152 mm))		
Thin section, long (over 6 in. (152 mm))		
Thin section, round		
Draft angles, outside and inside		
Machining allowance (on one side)		
Flatness (maximum deviation)		

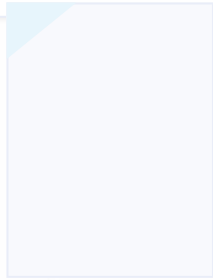


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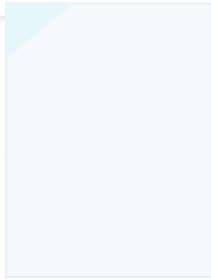


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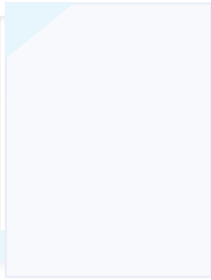
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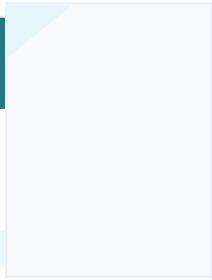
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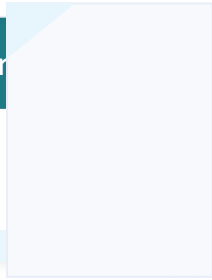
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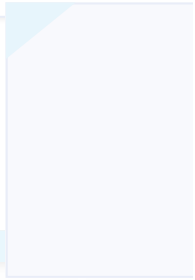
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### X3. TYPICAL MECHANICAL PROPERTIES

X3.1 Mechanical properties of any forging are influenced by shape and size. Unless otherwise specified in the purchase order or specifically guaranteed by the manufacturer, acceptance of forgings under this specification shall not depend on

tests. (Frequently, the design adequate test sections.) Therefore not constitute a part of this specification. They are for general information only. They

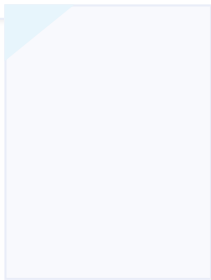


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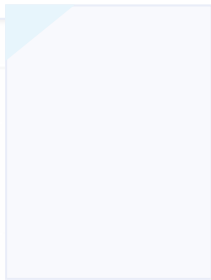


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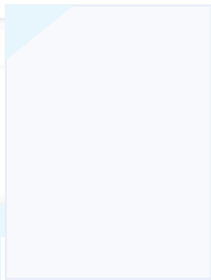
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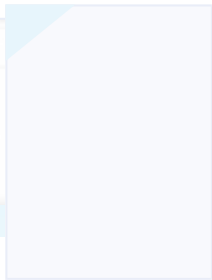
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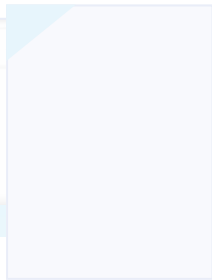
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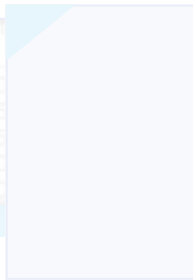
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X4.1 The SI unit for force is the newton (N) in accordance with the International System of Units. The derived SI unit for force is the newton (N) as that force which when applied to a body having a mass of one kilogram gives it an acceleration of one metre per second squared ( $N = kg \cdot m/s^2$ ). The derived SI unit for pressure or

equivalents are expressed as the same as  $MN/m^2$  and  $N/mm^2$ .

#### SUMMARY OF CHANGES

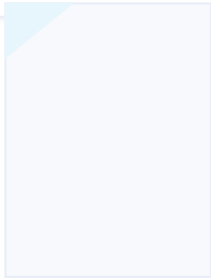
This section identifies the location of selected changes to this specification that have since the 1994 issue as follows:

- (1) Scope: Revised and safety caveat added as required.
- (2) General Requirements: A new section which enables the specification to utilize Specification B 249. This is a new section.
- (3) Terminology: Revised to reference Terminology B 846.
- (4) Ordering Information: Reorganized and expanded for greater clarity.
- (5) Material and Manufacture: Material and Manufacture material.
- (6) Chemical composition: Revised for greater clarity.
- (7) Mechanical Properties: Revised for greater clarity.
- (8) Heat Treatment: A new section added to the Materials and Manufacture section.
- (9) Test Methods: Individual test methods revised for greater clarity.

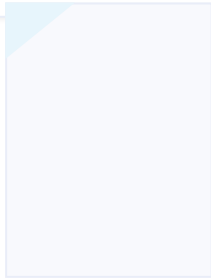


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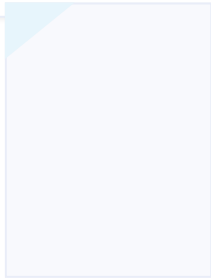
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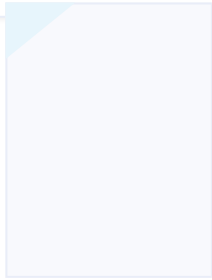
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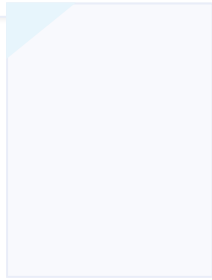
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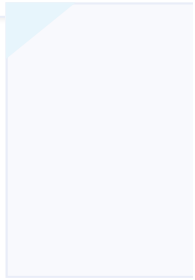
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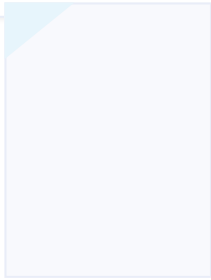


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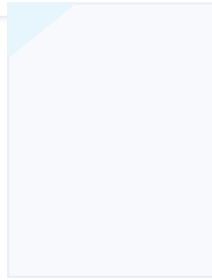


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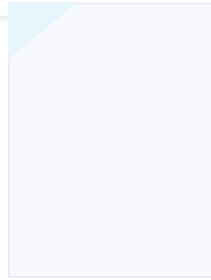
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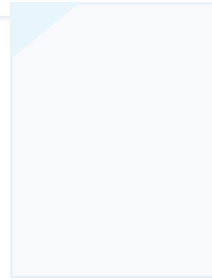
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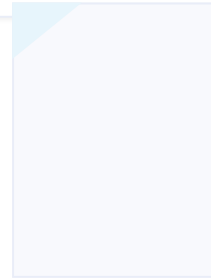
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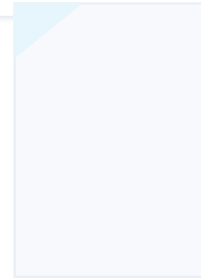
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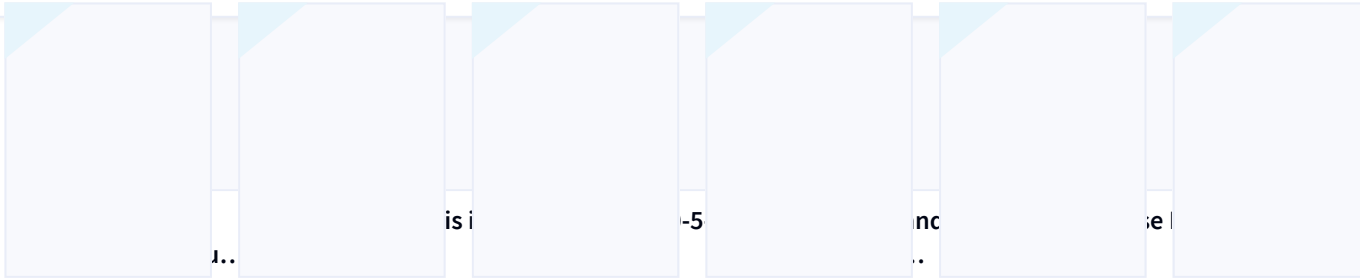


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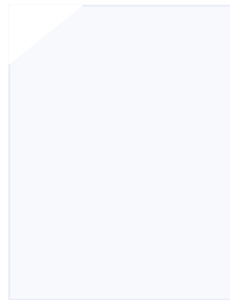
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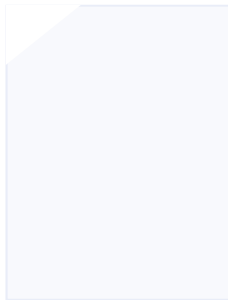
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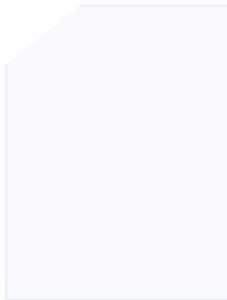
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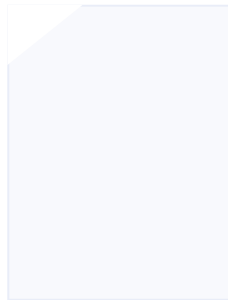
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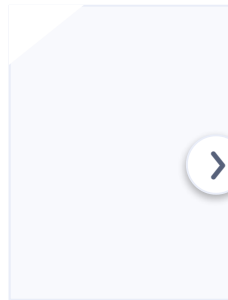
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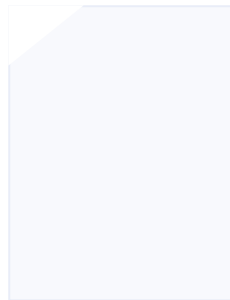
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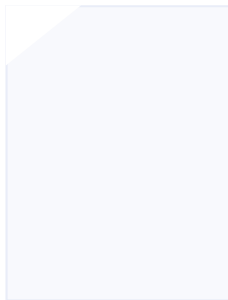
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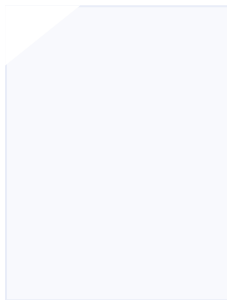
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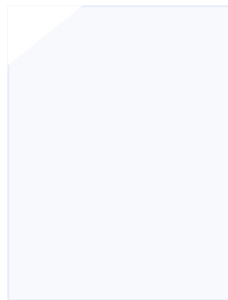
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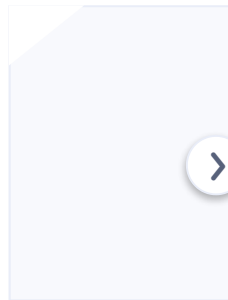
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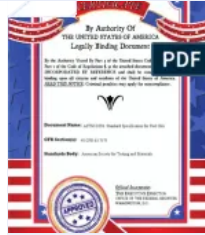


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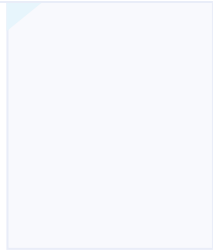
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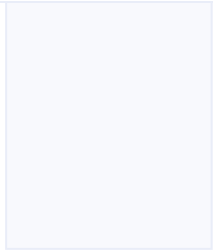
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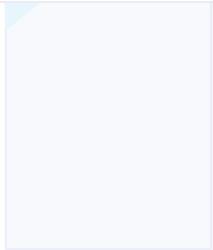
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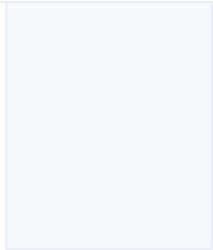
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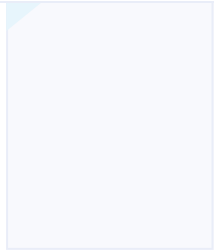
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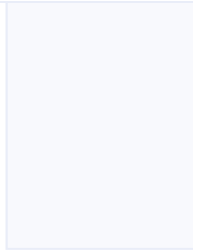
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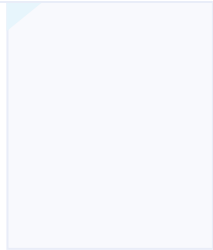
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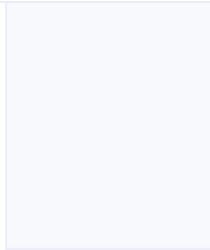
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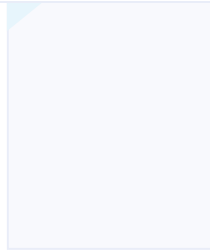
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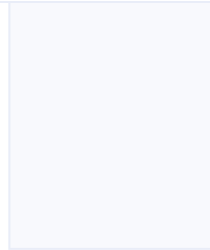
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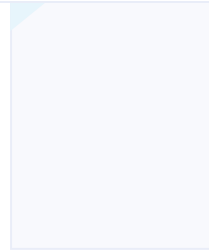
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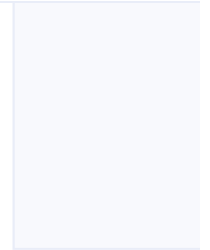
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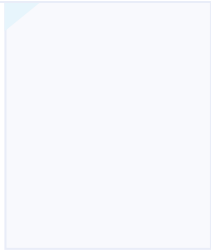


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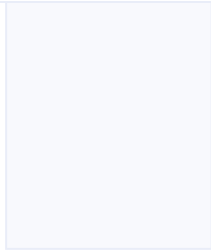
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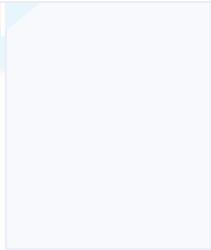
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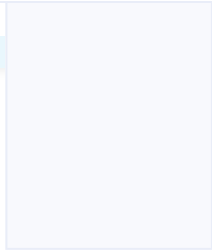
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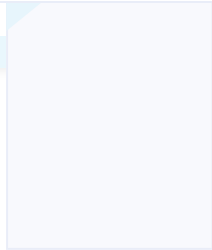
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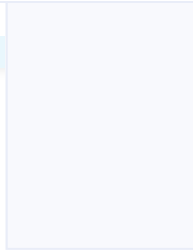
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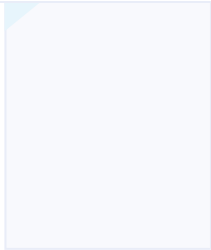
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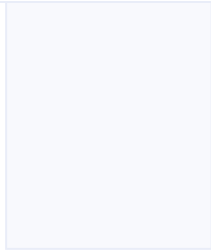
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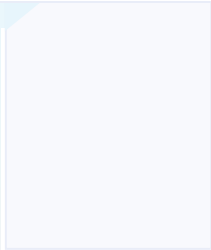
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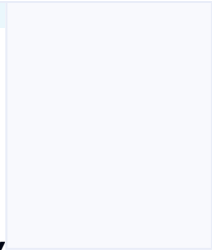
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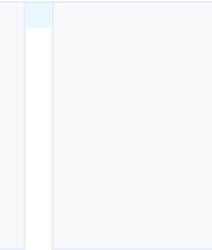
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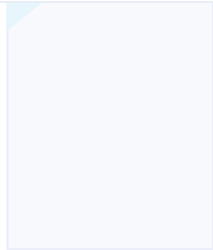


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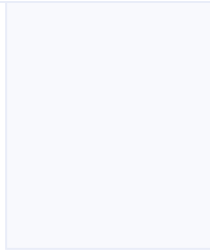
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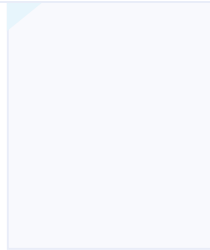
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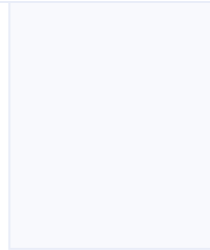
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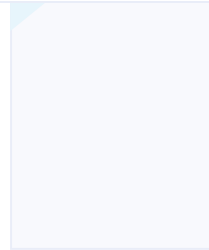
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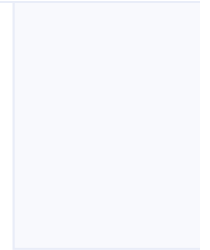
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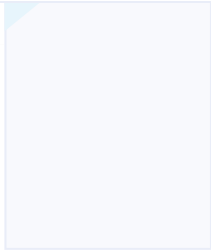
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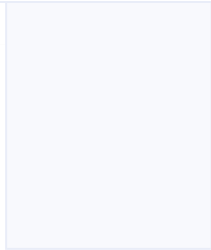
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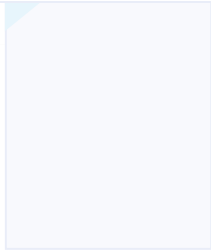
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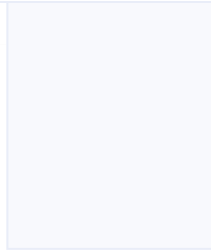
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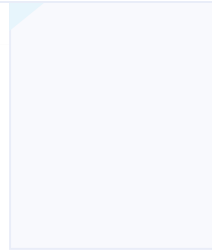
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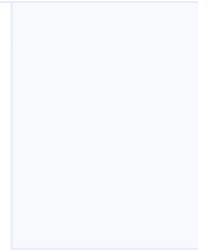
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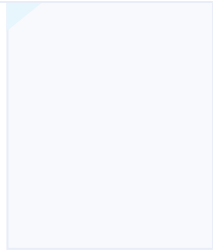
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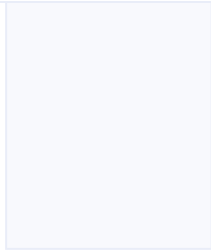
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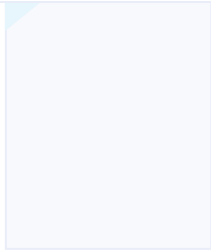
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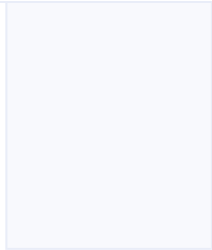
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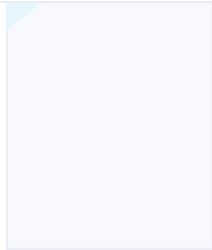
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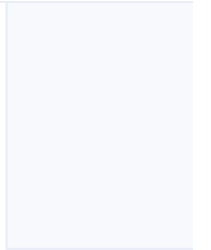
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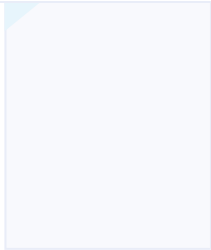
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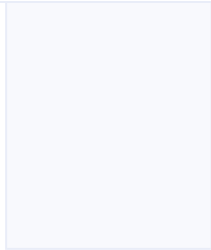
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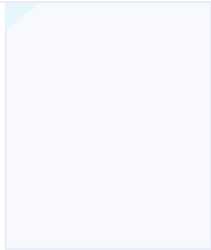
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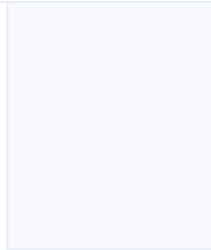
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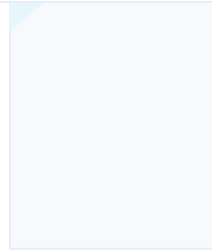
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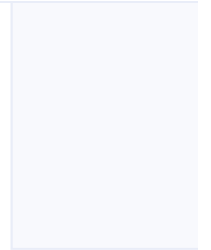
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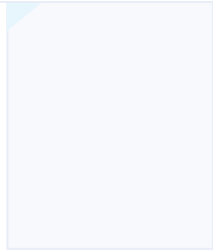
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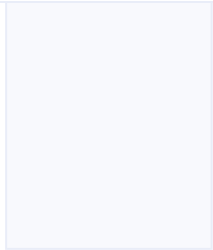
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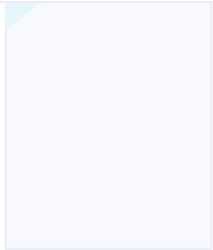
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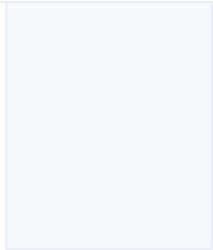
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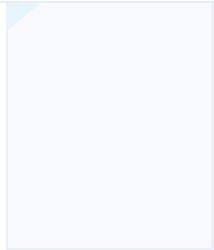
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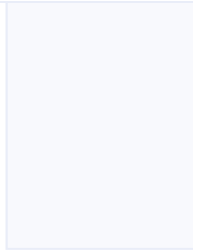
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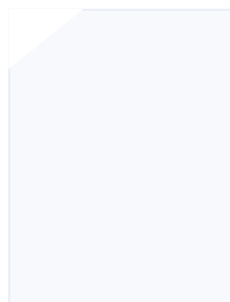
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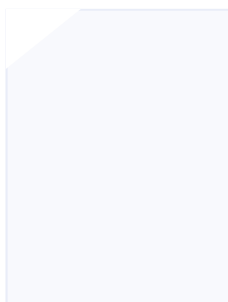
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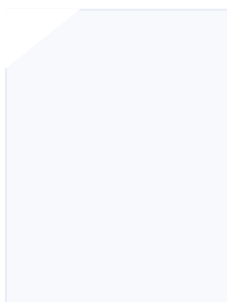
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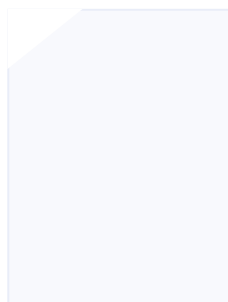
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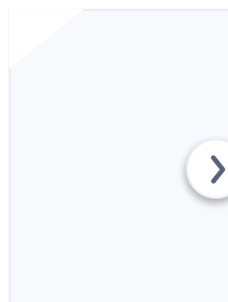
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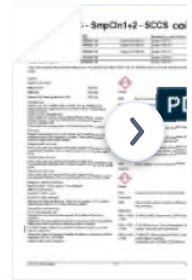
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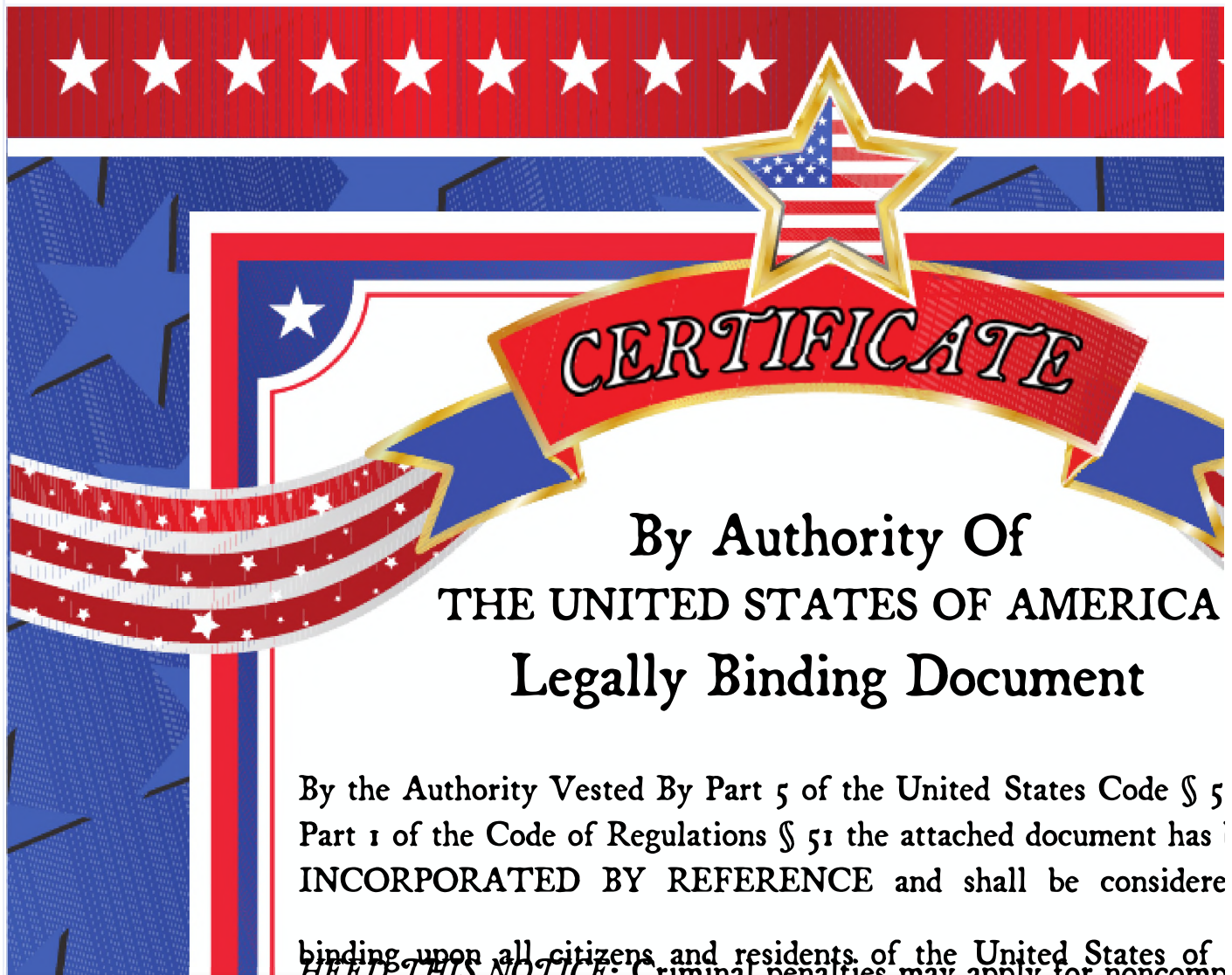


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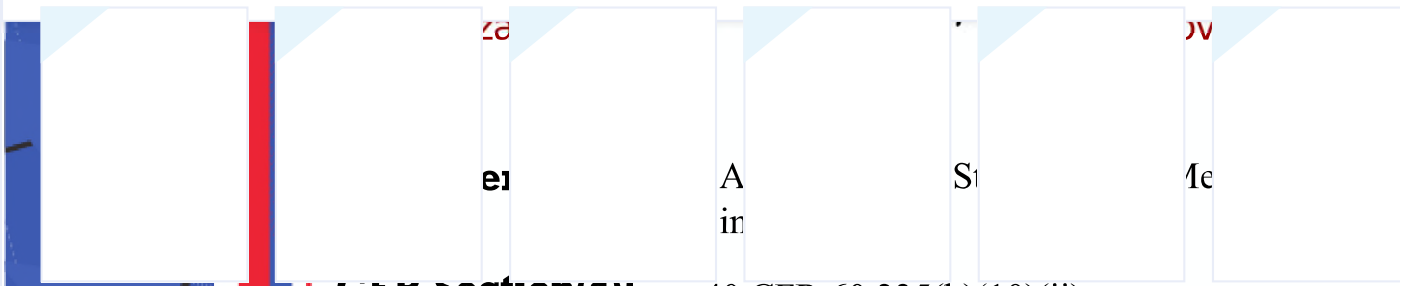


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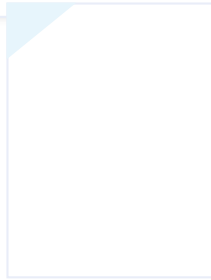


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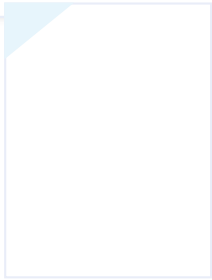
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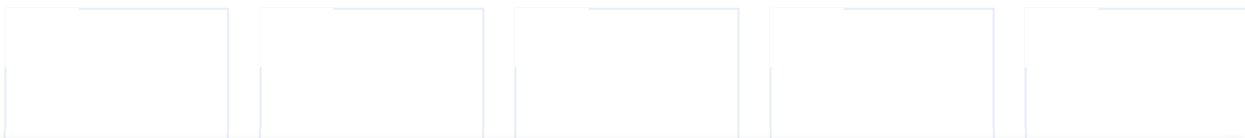
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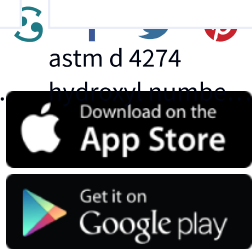
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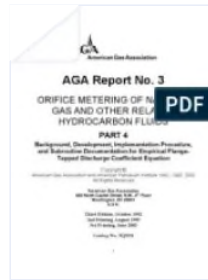
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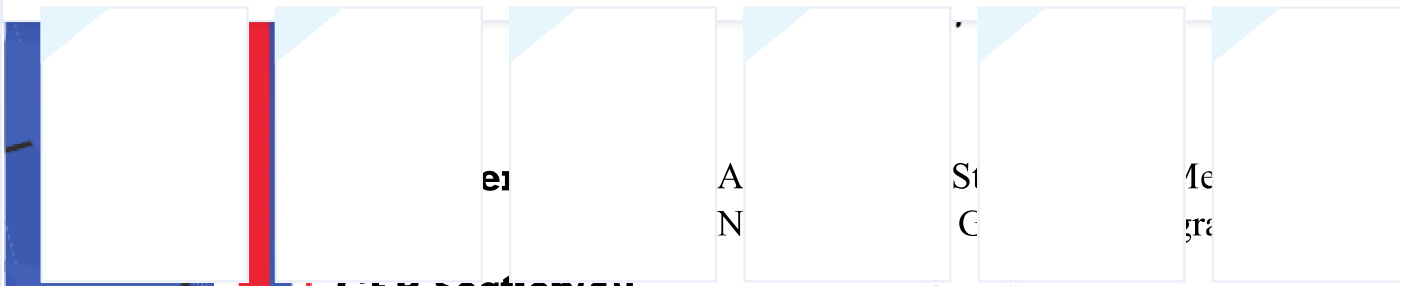


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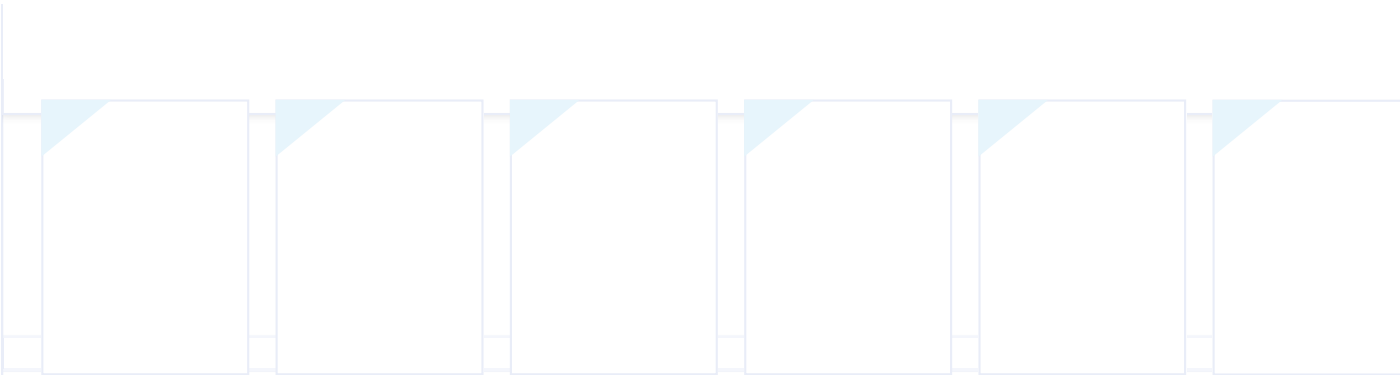


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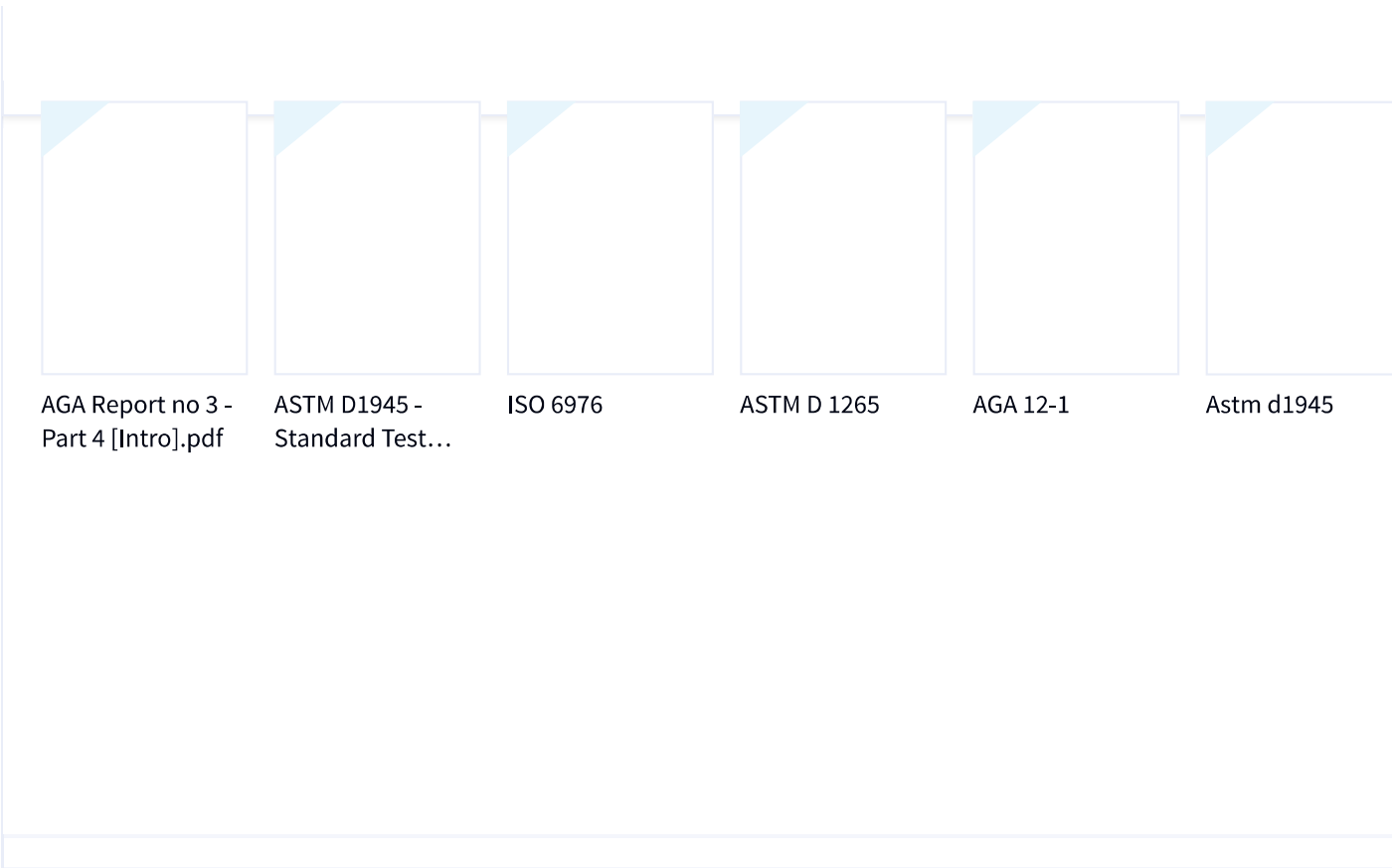
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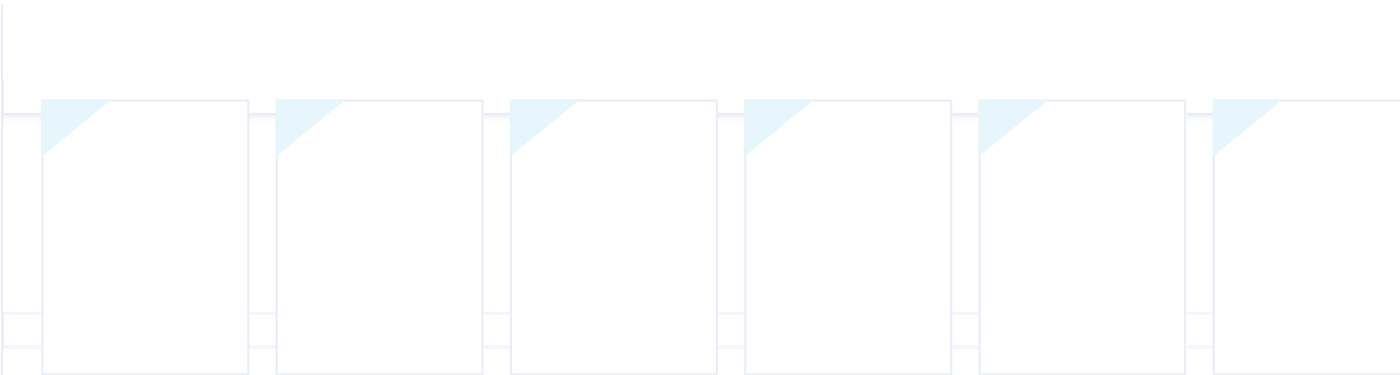
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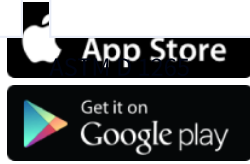
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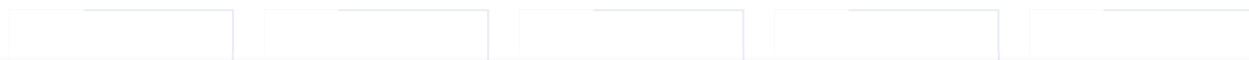
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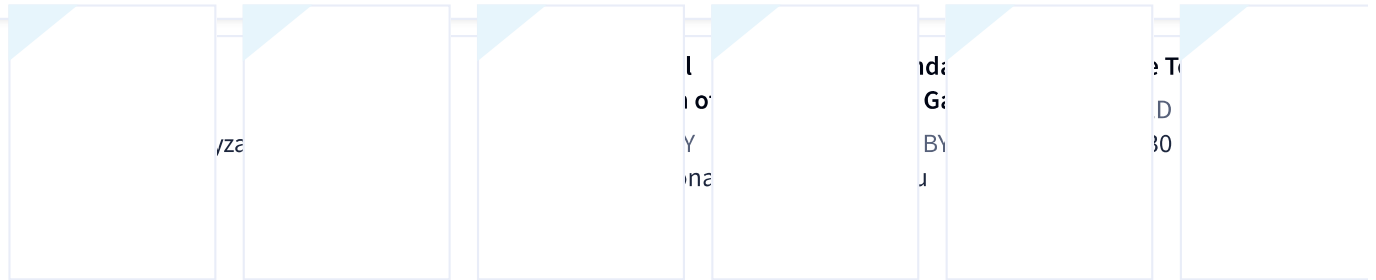


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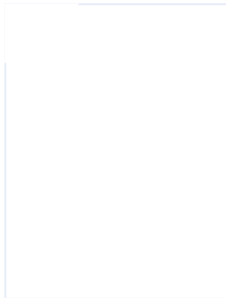
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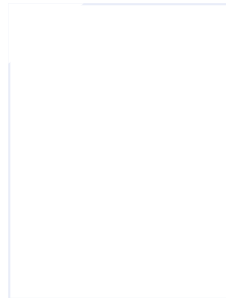
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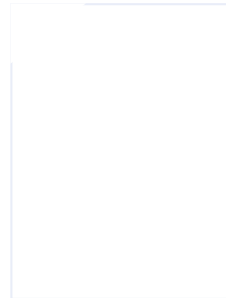
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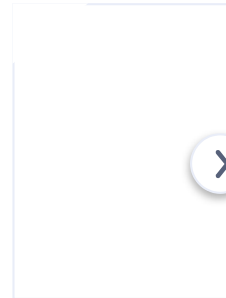
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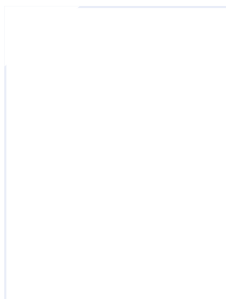
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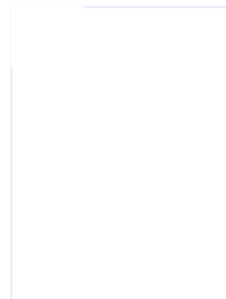
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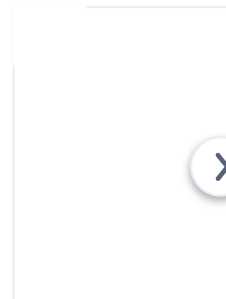
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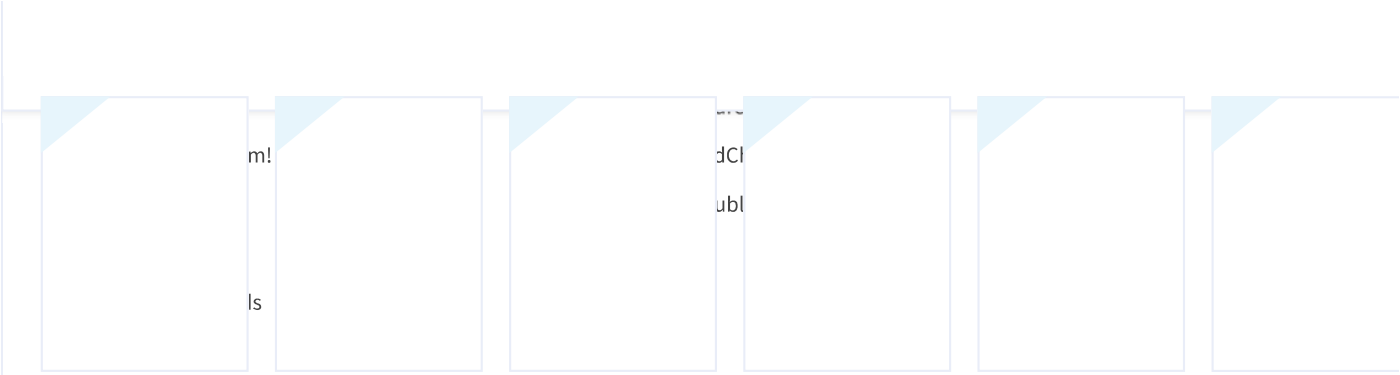


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