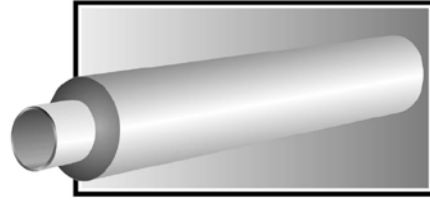


Submittal Data

Copper Pipe



Short Form Pipe Specifications

Copper tube (Type K, L, and M) shall be manufactured to ASTM B88. Copper tube shall be supplied in 3.66 m (12 ft), 6.1 m (20 ft) or 10.06 m (33 ft) lengths. *

Product

Copper tube shall be produced from copper alloy UNS C12200. Straight lengths shall be supplied in hard or annealed tempers. All copper coils shall be supplied in annealed temper.

Joining

Soldering and brazing with capillary solder joint fittings is the most common way to join copper tube. Most soldering is done at temperatures of 177^o to 288^oC (350 to 550^oF), while brazing is done at temperatures of 593 to 843C (1100 to 1550^oF). Other methods of joining are compression coupled, flared and victaulic joint (please call your Urecon representative for more details).

*Highlighted area indicates product proposed for this project

Temperature Ranges

The choice for soldering or brazing usually depends on the copper tube operating conditions. Solder joints are generally used on system temperatures that do not exceed 121C (250^oF) while brazed joints are generally used on systems with high internal pressures or operating temperatures between 121 and 177C (250 and 350^oF).

Silver soldering is generally used for below grade applications.

Fittings

Wrought copper and copper alloy solder joint pressure fittings conform to ASME/ANSI standard B16.22 – 1995.

Cast copper alloy solder joint pressure fittings conform to ASME/ANSI standard B16.18 – 1995. All wrought copper fittings are NSF61 registered.

Copper tube sizes

Nominal O.D.		Actual O.D.		Nominal Wall Thickness: Type:					
				K		L		M	
mm	inches	mm	inches	(mm)	(inches)	(mm)	(inches)	(mm)	(inches)
6	¼	9.53	.375	.89	.035	.76	.030		
10	3/8	12.7	.500	1.24	.049	.89	.035	.64	.025
13	½	15.88	.625	1.24	.049	1.02	.040	.71	.028
16	5/8	19.05	.750	1.24	.049	1.07	.042		
20	¾	22.22	.875	1.65	.065	1.14	.045	.81	.032
25	1	28.58	1.125	1.65	.065	1.27	.050	.89	.035
32	1 ¼	34.93	1.375	1.65	.065	1.40	.055	1.07	.042
38	1 ½	41.28	1.625	1.83	.072	1.52	.060	1.24	.049
50	2	53.98	2.125	2.11	.083	1.78	.070	1.47	.058
60	2 ½	66.68	2.625	2.41	.095	2.03	.080	1.65	.065
75	3	79.38	3.125	2.77	.109	2.29	.090	1.83	.072
89	3 ½	92.08	3.625	3.05	.120	2.54	.100	2.11	.083
100	4	104.78	4.125	3.40	.134	2.79	.110	2.41	.095
125	5	130.18	5.125	4.06	.160	3.18	.125	2.77	.109
150	6	155.58	6.125	4.88	.192	3.56	.140	3.10	.122
200	8	206.38	8.125	6.88	.271	5.08	.200	4.32	.170

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