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BSI Standards Publication

## Copper and copper alloys — Seamless, round tubes for general purposes

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## National foreword

This British Standard is the UK implementation of EN 12449:2016+A1:2019. It supersedes BS EN 12449:2016, which is withdrawn.

The start and finish of text introduced or altered by amendment is indicated in the text by tags. Tags indicating changes to CEN text carry the number of the CEN amendment. For example, text altered by CEN amendment A1 is indicated by A1 A1.

The UK participation in its preparation was entrusted to Technical Committee NFE/34, Copper and copper alloys.

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

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**EUROPÄISCHE NORM**

October 2019

ICS 23.040.15; 77.120.30

Supersedes EN 12449:2016

English Version

## Copper and copper alloys - Seamless, round tubes for general purposes

Cuivre et alliages de cuivre - Tubes ronds sans soudure pour usages généraux

Kupfer und Kupferlegierungen - Nahtlose Rundrohre zur allgemeinen Verwendung

This European Standard was approved by CEN on 28 February 2016 and includes Amendment 1 approved by CEN on 7 August 2019.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

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## European foreword

This document (EN 12449:2016+A1:2019) has been prepared by Technical Committee CEN/TC 133 "Copper and copper alloys", the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by April 2020 and conflicting national standards shall be withdrawn at the latest by April 2020.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document includes Amendment 1 approved by CEN on 7 August 2019.

This document supersedes A1 EN 12449:2016 A1.

The start and finish of text introduced or altered by amendment is indicated in the text by tags A1 A1.

In comparison with EN 12449:2012, the following significant technical changes were made:

- a) Addition of the new material CuFe0,1Sn0,1P (CW125C);
- b) Modification of the elongation values for Cu-DHP (CW024A) in material condition R250 including new Table 16;
- c) Modification of iron and tin content for CuZn37Pb1 (CW605N) from 0,2 % to 0,3 % in Table 7;
- d) Replacement of the material number CW121C by CW124C for CuSi3Zn2P.

Within its programme of work, Technical Committee CEN/TC 133 requested CEN/TC 133/WG 3 "Copper tubes (installation and industrial)" to revise the following standard:

— EN 12449:2012, *Copper and copper alloys — Seamless, round copper tubes for general purposes.*

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

- EN 1057, *Copper and copper alloys — Seamless, round copper tubes for water and gas in sanitary and heating applications;*
- EN 12450, *Copper and copper alloys — Seamless, round copper capillary tubes;*
- EN 12451, *Copper and copper alloys — Seamless, round tubes for heat exchangers;*
- EN 12452, *Copper and copper alloys — Rolled, finned, seamless tubes for heat exchangers;*
- EN 12735-1, *Copper and copper alloys — Seamless, round tubes for air conditioning and refrigeration — Part 1: Tubes for piping systems;*
- EN 12735-2, *Copper and copper alloys — Seamless, round tubes for air conditioning and refrigeration — Part 2: Tubes for equipment;*
- EN 13348, *Copper and copper alloys — Seamless, round copper tubes for medical gases or vacuum;*
- EN 13349, *Copper and copper alloys — Pre-insulated copper tubes with solid covering;*
- EN 13600, *Copper and copper alloys — Seamless copper tubes for electrical purposes.*

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According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

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## Introduction

The European Committee for Standardization (CEN) draws attention to the fact that it is claimed that compliance with this document may involve the use of a patent concerning the alloy CuSi3Zn2P (CW124C) and CuZn21Si3P (CW724R) given in 6.1.

CEN takes no position concerning the evidence, validity and scope of this patent right.

The holder of this patent right has assured the CEN that he is willing to negotiate licenses under reasonable and not-discriminatory terms and conditions with applicants throughout the world. In this respect, the statement of the holder of this patent right is registered with CEN.

— For CuSi3Zn2P (CW124C) information may be obtained from:

VIEGA GmbH & Co. KG  
Ennester Weg 9  
57439 Attendorn  
GERMANY

— For CuZn21Si3P (CW724R) information may be obtained from:

Wieland-Werke AG  
Graf-Arco-Straße 36  
89079 Ulm  
GERMANY

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights other than those identified above. CEN shall not be held responsible for identifying any or all such patent rights.

CEN and CENELEC (<http://www.cencenelec.eu/ipr/Patents/PatentDeclaration/Pages/default.aspx>) maintain on-line lists of patents relevant to their standards. Users are encouraged to consult the lists for the most up to date information concerning patents.



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## 1 Scope

This European Standard specifies the composition, property requirements and tolerances on dimensions and form for seamless round drawn copper and copper alloy tubes for general purposes supplied in the size range from 3 mm up to and including 450 mm outside diameter and from 0,3 mm up to and including 20 mm wall thickness.

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

NOTE Tubes having an outside diameter less than 80 mm and/or a wall thickness greater than 2 mm in certain alloys are most frequently used for free machining purposes which are specified in EN 12168.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 1655, *Copper and copper alloys - Declarations of conformity*

EN 1971-1, *Copper and copper alloys - Eddy current test for measuring defects on seamless round copper and copper alloy tubes - Part 1: Test with an encircling test coil on the outer surface*

EN 1971-2, *Copper and copper alloys - Eddy current test for measuring defects on seamless round copper and copper alloy tubes - Part 2: Test with an internal probe on the inner surface*

EN 1976, *Copper and copper alloys - Cast unwrought copper products*

EN 10204, *Metallic products - Types of inspection documents*

EN 16090, *Copper and copper alloys - Estimation of average grain size by ultrasound*

EN ISO 196, *Wrought copper and copper alloys - Detection of residual stress - Mercury(I) nitrate test (ISO 196)*

EN ISO 2624, *Copper and copper alloys - Estimation of average grain size (ISO 2624)*

EN ISO 6506-1, *Metallic materials - Brinell hardness test - Part 1: Test method (ISO 6506-1)*

EN ISO 6507-1, *Metallic materials - Vickers hardness test - Part 1: Test method (ISO 6507-1)*

EN ISO 6892-1, *Metallic materials - Tensile testing - Part 1: Method of test at room temperature (ISO 6892-1)*

EN ISO 8493, *Metallic materials - Tube - Drift-expanding test (ISO 8493)*

ISO 6957, *Copper alloys - Ammonia test for stress corrosion resistance*