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Superseding AMS4535B	

Copper-Beryllium Alloy, Mechanical Tubing  
98Cu - 1.9Be  
Solution and Precipitation Heat Treated  
(TF00, formerly AT)

(Composition similar to UNS C17200)

RATIONALE

AMS4535C has been reaffirmed to comply with the SAE five-year review policy.

1. SCOPE:

1.1 Form:

This specification covers a copper-beryllium alloy in the form of mechanical tubing.

1.2 Application:

This tubing has been used typically for parts requiring a combination of high strength, wear resistance, and corrosion resistance and where thermal conductivity, electrical conductivity, and low magnetic susceptibility may be important, but usage is not limited to such applications.

1.3 Safety - Hazardous Materials:

While the materials, methods, applications, and processes described or referenced in this specification may involve the use of hazardous materials, this specification does not address the hazards which may be involved in such use. It is the sole responsibility of the user to ensure familiarity with the safe and proper use of any hazardous materials and to take necessary precautionary measures to ensure the health and safety of all personnel involved.

2. APPLICABLE DOCUMENTS:

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been cancelled and no superseding document has been specified, the last published issue of that document shall apply.

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<http://www.sae.org/technical/standards/AMS4535C>**

## 2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001 or [www.sae.org](http://www.sae.org).

AMS 2223      Tolerances, Copper and Copper Alloy Seamless Tubing  
AMS 2750      Pyrometry

## 2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959 or [www.astm.org](http://www.astm.org).

ASTM B 251      General Requirements for Wrought Seamless Copper and Copper-Alloy Tube  
ASTM B 251M    General Requirements for Wrought Seamless Copper and Copper-Alloy Tube (Metric)  
ASTM B 643      Copper-Beryllium Alloy Seamless Tube  
ASTM E 3        Preparation of Metallographic Specimens  
ASTM E 8        Tension Testing of Metallic Materials  
ASTM E 8M      Tension Testing of Metallic Materials (Metric)  
ASTM E 18      Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials  
ASTM E 112     Determining Average Grain Size  
ASTM E 478     Chemical Analysis of Copper Alloys

## 3. TECHNICAL REQUIREMENTS:

### 3.1 Composition:

Shall conform to the percentages by weight shown in Table 1, determined by wet chemical methods in accordance with ASTM E 478, by spectrochemical methods, or by other analytical methods acceptable to purchaser.

TABLE 1 - Composition

Element (3.1.1)	min	max
Beryllium	1.80	2.00
Nickel + Cobalt	0.20	--
Nickel + Cobalt + Iron	--	0.6
Aluminum	--	0.20
Silicon	--	0.20
Copper (3.1.2)	remainder	
Sum of Named Elements (3.1.3)	99.5	--

- 3.1.1 These composition limits do not preclude the presence of other elements. Limits may be established and analysis required for unnamed elements by agreement between the manufacturer or supplier and purchaser.

3.1.2 Copper may be reported as “remainder”, or as the difference between the sum of results for all elements and 100%, or as the result of direct analysis.

3.1.3 When all the elements in the table are analyzed, the sum shall be 99.5% minimum, but such determination is not required for routine acceptance of each lot.3.2

3.2 Condition:

Hot reduced or hot and cold reduced, solution and precipitation heat treated; TF00 Temper (See 8.2).

3.3 Heat Treatment:

Tubing shall be heat treated as follows; pyrometry shall be in accordance with AMS 2750.

3.3.1 Solution: Heat within the range 1400 to 1475 °F (760 to 802 °C), hold at heat for 30 to 60 minutes, and cool as required.

3.3.2 Precipitation: Heat to 600 to 675 °F (316 to 357 °C), hold at heat for not less than 3 hours, and cool as required.

3.4 Properties:

Tubing shall conform to the following requirements (See 8.3):

3.4.1 Tensile Properties: Shall be as specified in Table 2 for tubing 2.00 inches (50.8 mm) and under in nominal wall thickness, determined in accordance with ASTM E 8 or ASTM E 8M.

TABLE 2 - Minimum Tensile Properties

Property	Value
Tensile Strength	161 ksi (1110 MPa)
Yield Strength at 0.2% Offset	130 ksi ( 896 MPa)
Elongation in 4D	3%

3.4.2 Hardness: Tubing 0.188 inch (4.78 mm) and over in nominal wall thickness shall have hardness of 36 to 45 HRC, or equivalent (See 8.4), determined in accordance with ASTM E 18.

3.4.3 Average Grain Size: Tubing with an outside diameter to wall thickness ratio greater than 3.0 shall have average grain size not larger than specified in Table 3, determined in accordance with ASTM E 112.

TABLE 3 - Maximum Average Grain Size

Nominal Wall Thickness Inches	Nominal Wall Thickness Millimeters	Grain Size Millimeter
Up to 1.00, excl	Up to 25.4, excl	0.050
1.00 to 1.50, excl	25.4 to 38.1, excl	0.075
1.50 to 2.00, excl	38.1 to 50.8, excl	0.100

3.4.4 Microstructure: Tubing shall contain not more than 6% beta phase constituent, determined at 100X magnification on specimens prepared in accordance with ASTM E 3.

3.5 Quality:

Tubing, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from imperfections detrimental to usage of the tubing.

3.6 Tolerances:

Shall conform to AMS 2223 as applicable to refractory alloys unless ASTM B 643 or other applicable tolerance specification is specified by purchaser.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The vendor of tubing shall supply all samples for vendor's tests and shall be responsible for the performance of all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the tubing conforms to specified requirements.

4.2 Classification of Tests:

All technical requirements are acceptance tests and shall be performed on each heat or lot as applicable.

4.3 Sampling and Testing:

Shall be in accordance with ASTM B 251 or ASTM B 251M and the following; a lot shall be all tubing of the same size, from the same heat, processed at one time through all steps of manufacture.

4.3.1 One or more chemical analysis samples from each heat shall be analyzed in accordance with 3.1.

4.3.2 One or more tensile specimens from each lot shall be tested in accordance with 3.4.1.

4.3.3 One or more hardness specimens from each lot shall be tested in accordance with 3.4.2.