



Standard Specification for Aluminum and Aluminum-Alloy Extruded Round Tubes for General-Purpose Applications¹

This standard is issued under the fixed designation B 491/B 491M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

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

1. Scope

1.1 This specification covers aluminum and aluminum-alloy extruded round tubes either in coils or straight lengths, for general purpose applications such as refrigeration service, gas lines, oil lines, and instrument lines, in the alloys (Note 2) and tempers shown in Table 2 [Table 3], in outside diameters of 0.250 through 0.750 in. [6.00 through 20.00 mm]. For diameters over 0.500 through 0.750 in. [over 12.50 through 20.00 mm], the diameter and wall-thickness tolerances and eddy-current test parameters, if required, shall be agreed upon by the producer and the purchaser. Only tubes in aluminum 1200-H111 and 1235-H111 are sized after extrusion to minimize ovalness.

1.2 Alloy and temper designations are in accordance with ANSI H35.1[H35.1M]. The equivalent Unified Numbering System alloy designations are those of Table 1 preceded by A9 (for example, A91050 for aluminum 1050) in accordance with Practice E 527.

NOTE 1—For extruded tubes see Specification B 221, and for drawn tubes for general-purpose applications see Specification B 483.

NOTE 2—Throughout this specification the term *alloy* in the general sense includes aluminum as well as aluminum alloy.

NOTE 3—For inch-pound orders specify B 491; for metric orders specify B 491M. Do not mix units.

1.3 For acceptance criteria for inclusion of new aluminum and aluminum alloys in this specification, see Annex A2.

1.4 The values stated in either inch-pound or SI units are to be regarded separately as standards. The SI units are shown either in brackets or in separate tables. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from two systems will result in nonconformance with the specification.

2. Referenced Documents

2.1 The following documents of the issue in effect on the date of material purchase form a part of this specification to the

extent referenced herein:

2.2 ASTM Standards:

B 557 Test Methods of Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products²

B 557M Test Methods of Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products (Metric)²

B 660 Practices for Packaging/Packing of Aluminum and Magnesium Products²

B 666/B 666M Practice for Identification Marking of Aluminum Products²

B 807 Practice for Extrusion Press Solution Heat Treatment for Aluminum Alloys²

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications³

E 34 Test Methods for Chemical Analysis of Aluminum and Aluminum Base Alloys⁴

E 55 Practice for Sampling Wrought Nonferrous Metals and Alloys for Determination of Chemical Composition⁴

E 215 Practice for Standardizing Equipment for Electromagnetic Testing of Seamless Aluminum-Alloy Tube⁵

E 227 Test Method for Optical Emission Spectrometric Analysis of Aluminum and Aluminum Alloys by the Point-to-Plane Technique⁴

E 527 Practice for Numbering Metals and Alloys (UNS)⁶

E 607 Test Method for Optical Emission Spectrometric Analysis of Aluminum and Aluminum Alloys by the Point-to-Plane Technique, Nitrogen Atmosphere⁷

E 716 Practices for Sampling Aluminum and Aluminum Alloys for Spectrochemical Analysis⁷

E 1251 Test Method for Optical Emission Spectrometric Analysis of Aluminum and Aluminum Alloys by the Argon Atmosphere, Point-to-Plane, Unipolar Self-Initiating Capacitor Discharge⁷

2.3 ANSI Standards:

H35.1 Alloy and Temper Designation Systems for Aluminum²

¹ This specification is under the jurisdiction of ASTM Committee B07 on Light Metals and Alloys and is the direct responsibility of Subcommittee B07.03 on Aluminum Alloy Wrought Products.

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² *Annual Book of ASTM Standards*, Vol 02.02.

³ *Annual Book of ASTM Standards*, Vol 14.02.

⁴ *Annual Book of ASTM Standards*, Vol 03.05.

⁵ *Annual Book of ASTM Standards*, Vol 03.03.

⁶ *Annual Book of ASTM Standards*, Vol 01.01.

⁷ *Annual Book of ASTM Standards*, Vol 03.06.