

ASME B16.22-2018
(Revision of ASME B16.22-2013)

Wrought Copper and Copper Alloy Solder-Joint Pressure Fittings

AN AMERICAN NATIONAL STANDARD



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Mechanical Engineers**

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Two Park Avenue • New York, NY • 10016 USA

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FOREWORD

Standardization of cast and wrought solder-joint fittings was initiated in Subcommittee 11 of American Standards Association (ASA) Sectional Committee A40 on Plumbing Requirements and Equipment. Development work culminated in the publication of ASA A40.3-1941. The standard benefited from work done by A. R. Maupin of the National Bureau of Standards, both before and during its development, on the strength of solder joints.

In 1949, work on these fittings was transferred to Sectional Committee B16, which established Subcommittee 9 (now Subcommittee J) with a scope broader than plumbing applications. The first standard developed was approved as ASA B16.18-1950, Cast-Brass Solder Joint Fittings. It was then decided to revise ASA A40.3 as a B16 standard covering only wrought solder-joint fittings. This effort was facilitated by a 1950 draft prepared by joint effort of the Copper and Brass Research Association and the Manufacturers Standardization Society of the Valve and Fittings Industry (MSS). The draft, after review and approval by Subcommittee 9 and the Sectional Committee, was approved as ASA B16.22-1951.

Revisions were published as ASA B16.22-1963 and, after reorganization of ASA as the American National Standards Institute (ANSI), as ANSI B16.22-1973. In these editions, updated practices, new materials, and new types of fittings were incorporated into the standard, as well as editorial improvements and updating of referenced specifications and standards.

In 1979, Subcommittee I (formerly 9, now J) added metric dimensional equivalents and made other minor improvements. This revision was approved by ANSI, after approval by the Committee and secretariat organizations, as ANSI B16.22-1980.

In 1982, American National Standards Committee B16 was reorganized as an ASME Committee operating under procedures accredited by ANSI.

In 1989, Subcommittee J removed metric equivalents and updated referenced standards.

In 1995, Subcommittee J defined bursting strength, defined standard gaging method for threaded ends, revised solder-joint lengths for $\frac{1}{8}$ -in. size external and internal ends, and revised minimum wall-thickness values based on a comprehensive bursting-test study. Following approval by the Standards Committee and ASME, approval as an American National Standard was given by ANSI on July 24, 1995, with the designation ASME B16.22-1995.

In 1998, editorial revisions, which included the addition of a new section on quality systems and a change in the designation of ASTM B32 alloys, were issued as an addendum. This addendum to the 1995 edition of ASME B16.22, after approval by the ASME B16 Committee and ASME, was approved as ASME B16.22a-1998.

In the 2001 edition, Subcommittee J converted the physical requirements to SI (metric) units of measure, added requirements for tube stops, clarified ovalate and alignment requirements, and made numerous editorial revisions. Alloy E and Alloy HB were incorporated into the table listing pressure-temperature ratings for the soldering and brazing materials, plus values for the 95-5 tin-antimony solder were revised. These revisions to pressure-temperature ratings reflected the data from a National Institute of Standards and Technology (NIST) solder-joint testing study, initiated in 1993 to develop stress rupture and strength data on copper tube sleeve joints using various solders. Following approval by the ASME B16 Standards Committee, approval as an American National Standard was given by ANSI on October 11, 2001, with the designation ASME B16.22-2001.

In the 2012 edition, the phrase "pressure-temperature ratings" replaced "working pressure" throughout the text. Following approval by the ASME B16 Standards Committee, approval as an American National Standard was given by ANSI on October 22, 2012, with the designation ASME B16.22-2012.

In the 2013 edition, provisions were included to recognize low lead alloys to comply with the U.S. Safe Drinking Water Act, which took effect in January 2014. Following approval by the ASME B16 Standards Committee, approval as an American National Standard was given by ANSI on July 29, 2013, with the designation ASME B16.22-2013.

In this 2018 edition, the U.S. Customary tables formerly in Mandatory Appendix II have been merged with the SI tables in the main text; the tables and figures have been redesignated, Mandatory Appendix II has been deleted, and the cross-references have been updated accordingly. In addition, para. 10.3 has been revised to change the requirements for threaded ends to allow a bead with or without ribs to retain consistency with the requirements of ASME B16.18, and all reference standards in what was formerly Mandatory Appendix III have been updated. Following approval by the ASME B16 Standards Committee, approval as an American National Standard was given by ANSI on August 3, 2018, with the new designation ASME B16.22-2018.

ASME B16 COMMITTEE

Standardization of Valves, Flanges, Fittings, and Gaskets

(The following is the roster of the Committee at the time of approval of this Standard.)

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T. A. McMahon , Emerson Process Management	

SUBCOMMITTEE J — COPPER AND COPPER ALLOY FLANGES, FLANGED FITTINGS, AND SOLDER JOINT FITTINGS

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CORRESPONDENCE WITH THE B16 COMMITTEE

General. ASME Standards are developed and maintained with the intent to represent the consensus of concerned interests. As such, users of this Standard may interact with the Committee by requesting interpretations, proposing revisions or a case, and attending Committee meetings. Correspondence should be addressed to:

Secretary, B16 Standards Committee
The American Society of Mechanical Engineers
Two Park Avenue
New York, NY 10016-5990
<http://go.asme.org/Inquiry>

Proposing Revisions. Revisions are made periodically to the Standard to incorporate changes that appear necessary or desirable, as demonstrated by the experience gained from the application of the Standard. Approved revisions will be published periodically.

The Committee welcomes proposals for revisions to this Standard. Such proposals should be as specific as possible, citing the paragraph number(s), the proposed wording, and a detailed description of the reasons for the proposal, including any pertinent documentation.

Proposing a Case. Cases may be issued to provide alternative rules when justified, to permit early implementation of an approved revision when the need is urgent, or to provide rules not covered by existing provisions. Cases are effective immediately upon ASME approval and shall be posted on the ASME Committee web page.

Requests for Cases shall provide a Statement of Need and Background Information. The request should identify the Standard and the paragraph, figure, or table number(s), and be written as a Question and Reply in the same format as existing Cases. Requests for Cases should also indicate the applicable edition(s) of the Standard to which the proposed Case applies.

Interpretations. Upon request, the B16 Standards Committee will render an interpretation of any requirement of the Standard. Interpretations can only be rendered in response to a written request sent to the Secretary of the B16 Standards Committee.

Requests for interpretation should preferably be submitted through the online Interpretation Submittal Form. The form is accessible at <http://go.asme.org/InterpretationRequest>. Upon submittal of the form, the Inquirer will receive an automatic e-mail confirming receipt.

If the Inquirer is unable to use the online form, he/she may e-mail the request to the Secretary of the B16 Standards Committee at SecretaryB16@asme.org, or mail it to the above address. The request for an interpretation should be clear and unambiguous. It is further recommended that the Inquirer submit his/her request in the following format:

Subject:	Cite the applicable paragraph number(s) and the topic of the inquiry in one or two words.
Edition:	Cite the applicable edition of the Standard for which the interpretation is being requested.
Question:	Phrase the question as a request for an interpretation of a specific requirement suitable for general understanding and use, not as a request for an approval of a proprietary design or situation. Please provide a condensed and precise question, composed in such a way that a "yes" or "no" reply is acceptable.
Proposed Reply(ies):	Provide a proposed reply(ies) in the form of "Yes" or "No," with explanation as needed. If entering replies to more than one question, please number the questions and replies.
Background Information:	Provide the Committee with any background information that will assist the Committee in understanding the inquiry. The Inquirer may also include any plans or drawings that are necessary to explain the question; however, they should not contain proprietary names or information.

Requests that are not in the format described above may be rewritten in the appropriate format by the Committee prior to being answered, which may inadvertently change the intent of the original request.

Moreover, ASME does not act as a consultant for specific engineering problems or for the general application or understanding of the Standard requirements. If, based on the inquiry information submitted, it is the opinion of the Committee that the Inquirer should seek assistance, the inquiry will be returned with the recommendation that such assistance be obtained.

ASME procedures provide for reconsideration of any interpretation when or if additional information that might affect an interpretation is available. Further, persons aggrieved by an interpretation may appeal to the cognizant ASME Committee or Subcommittee. ASME does not “approve,” “certify,” “rate,” or “endorse” any item, construction, proprietary device, or activity.

Attending Committee Meetings. The B16 Standards Committee regularly holds meetings and/or telephone conferences that are open to the public. Persons wishing to attend any meeting and/or telephone conference should contact the Secretary of the B16 Standards Committee.

ASME B16.22-2018

SUMMARY OF CHANGES

Following approval by the ASME B16 Standards Committee and ASME, and after public review, ASME B16.22-2018 was approved by the American National Standards Institute on August 3, 2018.

In ASME B16.22-2018, the U.S. Customary tables formerly in Mandatory Appendix II have been merged with the SI tables in the main text; the tables and figures have been redesignated, Mandatory Appendix II has been deleted, and the cross-references have been updated accordingly. In addition, this edition includes the following changes identified by a margin note, **(18)**. The Record Numbers listed below are explained in more detail in the “List of Changes in Record Number Order” following this Summary of Changes.

<i>Page</i>	<i>Location</i>	<i>Change (Record Number)</i>
1	1	First paragraph editorially revised
1	3.1	Editorially revised
1	3.1.2	Second paragraph editorially revised
2	5	Editorially revised
2	9.2	In the second paragraph, last line editorially revised
3	10.3	Revised (15-2330)
3	12.3	In Note, last sentence editorially revised
12	Mandatory Appendix II	Updated (18-799)

LIST OF CHANGES IN RECORD NUMBER ORDER

Record Number	Change
15-2330	Revised para. 10.3 to change the requirements for threaded ends to allow a bead with or without ribs to retain consistency with the requirements of the ASME B16.18 standard.
18-799	Updated references in Mandatory Appendix II, formerly Mandatory Appendix III.

WROUGHT COPPER AND COPPER ALLOY SOLDER-JOINT PRESSURE FITTINGS

(18) 1 SCOPE

This Standard establishes specifications for wrought copper and wrought copper alloy, solder-joint, seamless fittings designed for use with seamless copper tube conforming to ASTM B88 (water and general plumbing systems), ASTM B280 (air conditioning and refrigeration service), and ASTM B819 (medical gas systems), as well as fittings intended to be assembled with soldering materials conforming to ASTM B32, brazing materials conforming to AWS A5.8, or tapered pipe thread conforming to ASME B1.20.1.

This Standard is allied with ASME B16.18, which covers cast copper alloy pressure fittings. It provides requirements for fitting ends suitable for soldering. This Standard covers the following:

- (a) pressure-temperature ratings
- (b) abbreviations for end connections
- (c) size and method of designating openings of fittings
- (d) marking
- (e) material
- (f) dimensions and tolerances
- (g) tests

2 GENERAL

2.1 Relevant Units

This Standard states values in both SI (metric) and U.S. Customary units. These systems of units are to be regarded separately as standard. Within the text, the U.S. Customary units are shown in parentheses. The values stated in each system are not exact equivalents; therefore, it is required that each system of units be used independently of the other. Combining values from the two systems constitutes nonconformance with the Standard.

2.2 References

Standards and specifications adopted by reference in this Standard are shown in [Mandatory Appendix II](#). It is not considered practical to identify the specific edition of each standard and specification in the individual references. Instead, the specific edition reference is identified in [Mandatory Appendix II](#).

2.3 Quality Systems

Requirements relating to the product manufacturer's quality system program are described in [Nonmandatory Appendix B](#).

3 PRESSURE-TEMPERATURE RATINGS

3.1 Rating of Fittings and Joints

(18)

The internal pressure-temperature rating for a solder-joint system is dependent on not only fitting and tube strength, but also composition of the solder used for the joint and selection of valves and appurtenances.

3.1.1 Solder Joints. Pressure-temperature ratings for solder joints to the dimensions of [Table 3.1.1-1](#), made with typical commercial solders, are given in [Table I-1](#).

The internal pressure-temperature rating of the system with solder joints shall be the lowest of the values shown in [Table 3.1.1-2](#) and [Table I-1](#) and those of the tube, valves, and appurtenances.

3.1.2 Braze Joints. Pressure-temperature ratings for braze joints to the dimensions of [Table 3.1.1-1](#), made with typical commercial brazing materials, shall be considered equal to the values given in [Table 3.1.1-2](#). (18)

The internal pressure-temperature rating of the system with braze joints shall be the lowest of the values shown in [Table 3.1.1-2](#) and those of the tube, valves, and appurtenances.

3.2 Bursting Strength

Fittings manufactured to the Standard shall have an ambient-temperature bursting strength of at least 4 times the 38°C (100°F) internal pressure rating as shown in [Table 3.1.1-2](#).

4 TERMINOLOGY

4.1 Size

The size of the fittings shown in [Table 3.1.1-1](#) corresponds to standard water tube size as shown in ASTM B88. The size of the threaded ends corresponds to nominal pipe size as shown in ASME B1.20.1.

Fittings are designated by the size of the openings in the sequence illustrated in [Figure 4.1-1](#).

4.2 Abbreviations

The following symbols are used to designate the type of fitting end:

- C = solder-joint fitting end made to receive copper tube diameter (female)
- F = internal ANSI standard taper pipe-thread end (female) NPTI