

Recommended Practices for the Brazing of Copper Tubing and Fittings for Medical Gas Systems



American Welding Society



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Key Words—Copper, torch brazing, tubing, joint specifications, inspection, medical gas distribution systems

**AWS D10.13/D10.13M: 2001
An American National Standard**

**Approved by
American National Standards Institute
May 11, 2001**

Recommended Practices for the Brazing of Copper Tubing and Fittings for Medical Gas Systems

Supersedes ANSI/AWS D10.13-95

Prepared by
AWS D10 Committee on Piping and Tubing

Under the Direction of
AWS Technical Activities Committee

Approved by
AWS Board of Directors

Abstract

This document provides the minimum requirements for brazing of copper tubing for use in medical gas distribution systems and also contains criteria for cleanliness, fabrication, and installation and various inspection and testing options.



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International Standard Book Number: 0-87171-571-6

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Foreword

(This Foreword is not a part of AWS D10.13/D10.13M:2001, *Recommended Practices for the Brazing of Copper Tubing and Fittings for Medical Gas Systems*, but is included for information purposes only.)

These recommended practices have been developed to address the fabrication of gas and vacuum distribution systems in health care facilities. Included in this document are standards for the preparation and cleanliness of materials and equipment, joint heating and filler metal application techniques, and testing and inspection options.

This document provides guidance for implementation of the requirements of NFPA 99C, *Gas and Vacuum Systems*. NFPA 99C specifies the materials used in these systems and requires that brazing procedures and brazers be qualified in accordance with either AWS B2.2-91, *Standard for Brazing Procedure and Performance Qualification*, or the ASME *Boiler and Pressure Vessel Code*, Section IX, *Welding and Brazing Qualifications*, as modified by NFPA 99C. Requirements of NFPA 99C are stated using mandatory language (i.e., “shall”). The recommendations of the D10A Subcommittee on Brazing of Piping and Tubing are stated using non-mandatory language (i.e., “should”).

Comments and suggestions for the improvement of this standard are welcome. They should be sent to the Secretary, AWS D10 Committee on Piping and Tubing, American Welding Society, 550 N.W. LeJeune Road, Miami, FL 33126.

