



Designation: B 501 – 99

Standard Specification for Silver-Coated, Copper-Clad Steel Wire for Electronic Application¹

This standard is issued under the fixed designation B 501; 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 silver-coated, round, copper-clad steel wire for electronic application.

1.2 Silver coatings in mass percentages of the total mass of the coated wire are as follows: 1.25, 2.5, 4.0, 6.1, and 8.0.

1.2.1 Silver-coated wire having different minimum percentage of silver by mass may be obtained by mutual agreement between the manufacturer and the purchaser. For information purposes, the thickness of coating in microinches provided by the mass percentages listed in 1.2 is shown in Table 1.

1.3 Four classes of copper-clad steel wire are covered as follows: Class 30HS nominal 30 % conductivity hard-drawn, Class 30A nominal 30 % conductivity annealed, Class 40HS nominal 40 % conductivity hard-drawn, and Class 40A nominal 40 % conductivity annealed.

1.4 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only except for resistivity, where the SI units are to be regarded as the standard.

1.5 The following safety hazards caveat pertains to the test method described in this specification. *This standard does not purport to address all of the safety problems, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.* (See Note 1).

NOTE 1—**Caution:** Consideration should be given to toxicity and flammability when selecting solvent cleaners.

2. Referenced Documents

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

2.2 *ASTM Standards:*

¹ This specification is under the jurisdiction of ASTM Committee B-1 on Electrical Conductors and is the direct responsibility of Subcommittee B01.06 on Composite Conductors.

Current edition approved April 10, 1999. Published June 1999. Originally published as B 509 – 69. Last previous edition B 509 – 93.

B 193 Test Method for Resistivity of Electrical Conductor Materials²

B 258 Specification for Standard Nominal Diameters and Cross-Sectional Areas of AWG Sizes of Solid Round Wires Used as Electrical Conductors²

B 452 Specification for Copper-Clad Steel Wire for Electronic Application²

E 50 Practices for Apparatus, Reagents, and Safety Precautions for Chemical Analysis of Metals³

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *lot*—any amount of wire of one class and size presented for acceptance at one time, such amount, however, not to exceed 10 000 lb (4500 kg) (Note 2).

3.1.2 *sample*—a quantity of production units (coils, reels, etc.) selected at random from the lot for the purpose of determining conformance of the lot to the requirements of this specification.

3.1.3 *specimen*—a length of wire removed for test purposes from any individual production unit of the sample.

NOTE 2—A lot should comprise material taken from a product regularly meeting the requirements of this specification. Inspection of individual lots of less than 500 lb (250 kg) of wire cannot be justified economically. For small lots of 500 lb (250 kg) or less, the purchaser may agree to the manufacturer's regular inspection of the product as a whole as evidence of acceptability of such small lots.

4. Ordering Information

4.1 Orders for material under this specification shall include the following information:

4.1.1 Quantity of each size,

4.1.2 Wire size (see 7.1 and Table 1),

4.1.3 Class of basis wire (see 1.3),

4.1.4 Mass percentage of coating (see 1.2 and Table 1),

4.1.5 Package size (see Section 12),

4.1.6 Special packaging marking, if required, and

² *Annual Book of ASTM Standards*, Vol 02.03.

³ *Annual Book of ASTM Standards*, Vol 03.05.

TABLE 1 Silver Mass Percent and Thickness of Coating

Diameter		Cross-Sectional Area at 20°C			Thickness of Silver, $\mu\text{in.}$ (for information only)				
in.	mm	cmil	in.^2	mm^2	1.25 %	2.5 %	4.0 %	6.1 %	8.0 %
0.0720	1.829	5 180	0.00407	2.63	176	352	569	876	1 158
0.0641	1.628	4 110	0.00323	2.08	156	313	507	779	1 031
0.0571	1.450	3 260	0.00256	1.65	139	279	451	694	918
0.0508	1.290	2 580	0.00203	1.31	124	248	401	618	817
0.0453	1.151	2 050	0.00161	1.04	111	222	358	551	728
0.0403	1.024	1 620	0.00128	0.823	98	197	318	490	648
0.0359	0.912	1 290	0.00101	0.653	88	176	284	437	577
0.0320	0.813	1 020	0.000804	0.519	78	156	253	389	515
0.0285	0.724	812	0.000638	0.412	70	139	225	347	458
0.0253	0.643	640	0.000503	0.324	62	124	200	308	407
0.0226	0.574	511	0.000401	0.259	55	111	179	275	363
0.0201	0.511	404	0.000317	0.205	49	98	159	244	323
0.0179	0.455	320	0.000252	0.162	44	88	141	218	288
0.0159	0.404	253	0.000199	0.128	39	78	126	193	256
0.0142	0.361	202	0.000158	0.102	35	69	112	173	228
0.0126	0.320	159	0.000125	0.0804	31	62	100	153	203
0.0113	0.287	128	0.000100	0.0647	28	55	89	137	182
0.0100	0.254	100	0.0000785	0.0507	24	49	79	122	161
0.0089	0.226	79.2	0.0000622	0.0401	22	44	70	108	143
0.0080	0.203	64.0	0.0000503	0.0324	39	39	63	97	129
0.0071	0.180	50.4	0.0000396	0.0255	35	35	56	86	114
0.0063	0.160	39.7	0.0000312	0.0201	31	31	50	77	101
0.0056	0.142	31.4	0.0000246	0.0159	26	26	44	68	90
0.0050	0.127	25.0	0.0000196	0.0127	24	24	40	61	80
0.0045	0.114	20.2	0.0000159	0.0103	22	22	36	55	72
0.0040	0.102	16.0	0.0000126	0.00811	20	20	32	49	64
0.0035	0.089	12.2	0.00000962	0.00621	18	18	28	43	56
0.0031	0.079	9.61	0.00000755	0.00487	16	16	24	38	50

4.1.7 Place of inspection (see 9.1).

5. Materials and Manufacture

5.1 The basis material shall consist of copper-clad steel wire conforming to the product description, quality and specification requirements of Specification B 452.

5.2 The silver-coated wire shall consist of the basis wire coated with silver. The quality of the silver-coated wire shall be such that the finished product meets the properties and requirements in this specification (Note 3).

NOTE 3—Silver coatings on copper-clad steel provide for:

- (a) A barrier between the copper and insulation whose curing temperature in the process of fabricating is too high for the use of tin-coated wires.
- (b) A low contact resistance between the strands of outer conductors of coaxial conductors used in high-frequency circuits.
- (c) A low radio-frequency resistance of conductors used in high-frequency circuits (skin effect).
- (d) Good solderability for high-temperature hook-up wires which prohibit the use of tin-coated wires due to high curing temperatures used in fabricating the finished wire.

6. General Requirements

6.1 Tensile strength and elongation of the silver-coated wire shall conform to the requirements of Specification B 452 for the applicable size and class of copper-clad steel wire.

6.2 *Resistivity*— The electrical resistivity at a temperature of 20°C shall not exceed the values prescribed in Table 2. See Note 4 for calculating electrical resistance.

TABLE 2 Resistivity

Class of Wire	Resistivity, max at 20°C	
	$\Omega\text{-mm}^2/\text{m}$	$\Omega\text{-mm}^2/\text{m}$
30HS and 30A	0.05862 (0.0586160)	
40HS and 40A	0.04397 (0.043970)	

6.3 *Continuity of Coating*—The coating shall be continuous. The continuity of the coating shall be determined on representative samples taken before stranding or insulating and shall be determined by the sodium polysulfide test, in accordance with 10.2.3.1. Wire whose coating mass corresponds to a thickness less than 0.00005 in. (50 $\mu\text{in.}$) shall not be subject to this test.

6.4 *Mass of Coating*— The mass of coating expressed in percent of the total mass of the wire shall be not less than the percentage specified and referred to in this specification or the percentage as agreed on between the manufacturer and purchaser at the time of the placing of the order. For ease of comparison, the thickness of coating for various percentages has been included in Table 1.

6.5 *Joints*—Necessary joints in the wire and rods prior to final coating and drawing shall be made in accordance with good commercial practice. Joints made after coating shall not be allowed to remain in the final product.

NOTE 4—Relationships which may be useful in connection with the values of electrical resistivity prescribed in this specification are shown in Table 2. Resistivity units are based on the International Annealed Copper