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Standard Specification for Compact Round Concentric-Lay-Stranded Aluminum Conductors, Steel-Reinforced (ACSR/COMP)¹

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1. Scope

1.1 This specification covers compact round concentric-lay-stranded conductors made from aluminum 1350-H19 (extra hard) wires and round zinc-coated, aluminum-coated, or aluminum-clad steel core wires usually used in overhead lines. These conductors shall be constructed with one steel core wire surrounded by one or more layers of helically-laid compacted or otherwise shaped aluminum wires (Explanatory [Note 1](#) and [Note 2](#)).

1.2 Compact ACSR covered by this specification has five types of steel core wire which are designated by abbreviations as follows (Explanatory [Note 2](#) and [Note 7](#)).

1.2.1 *ACSR/GA2/COMP*—Compact ACSR using Class A zinc-coated steel wire,

1.2.2 *ACSR/GC2/COMP*—Compact ACSR using Class C zinc-coated steel wire,

1.2.3 *ACSR/AW2/COMP*—Compact ACSR using aluminum-clad steel wire, AW2 (Normal Strength),

1.2.4 *ACSR/AW3/COMP*—Compact ACSR using aluminum-clad steel wire, AW3 (High Strength).

1.3 The SI values of density and resistivity are to be regarded as standard. For all other properties the inch-pound values are to be regarded as standard and the SI units may be approximate.

NOTE 1—Prior to 1975, aluminum 1350 was designated as EC aluminum.

NOTE 2—The aluminum and temper designations conform to ANSI H35.1. Aluminum 1350 corresponds to Unified Numbering System A91350 in accordance with Practice [E527](#).

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

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.

¹ This specification is under the jurisdiction of ASTM Committee [B01](#) on Electrical Conductors and is the direct responsibility of Subcommittee [B01.07](#) on Conductors of Light Metals.

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2.2 ASTM Standards:²

- [B193 Test Method for Resistivity of Electrical Conductor Materials](#)
- [B230/B230M Specification for Aluminum 1350–H19 Wire for Electrical Purposes](#)
- [B232/B232M Specification for Concentric-Lay-Stranded Aluminum Conductors, Coated-Steel Reinforced \(ACSR\)](#)
- [B263B263/B263M Test Method for Determination of Cross-Sectional Area of Stranded Conductors](#)
- [B341/B341M Specification for Aluminum-Coated \(Aluminized\) Steel Core Wire for Aluminum Conductors, Steel Reinforced \(ACSR/AZ\) \(Withdrawn 2007\)³](#)
- [B354 Terminology Relating to Uninsulated Metallic Electrical Conductors](#)
- [B498/B498M Specification for Zinc-Coated \(Galvanized\) Steel Core Wire for Use in Overhead Electrical Conductors](#)
- [B500/B500M Specification for Metallic Coated or Aluminum Clad Stranded Steel Core for Use in Overhead Electrical Conductors](#)
- [B502B502/B502M Specification for Aluminum-Clad Steel Core Wire for Use in Overhead Electrical Aluminum Conductors](#)
- [B802MB802/B802M Specification for ~~Zinc-5%~~Zinc-5 % Aluminum-Mischmetal Alloy-Coated Steel Core Wire for Aluminum Conductors, Steel Reinforced \(ACSR\)~~\[Metric\]\(Discontinued 1998-Replaced by B 802/B802M\)\(ACSR\) \(Withdrawn 1998\)~~](#)
- [E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)
- [E527 Practice for Numbering Metals and Alloys in the Unified Numbering System \(UNS\)](#)

2.3 Other Documents:

- [ANSI H35.1 American National Standard Alloy and Temper Designation Systems For Aluminum⁴](#)
- [NBS Handbook 100—Copper Wire Tables of the National Bureau of Standards⁵](#)

3. Ordering Information

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

- 3.1.1 Quantity of each size and stranding (Table 1),
- 3.1.2 Conductor size: circular-mil area or AWG (Section 6, and Table 1),
- 3.1.3 Steel wire coating or aluminum-clad (see 11.3),
- 3.1.4 Special tension test, if required (see 15.3),
- 3.1.5 Place of inspection (Section 16), and

TABLE 1 Construction Requirements for Compact Round Concentric-Lay-Stranded Aluminum Conductors, Steel Reinforced

Required Construction						Nominal Mass for Conductors With:					
Conductor Size (Aluminum Wires)		AWG	Number of Aluminum Wires	Steel Wire Diameter		Compact Conductor Diameter		Coated Steel Core Wire		Aluminum-Clad Steel Core Wire	
cmil	mm ²			in.	mm	in.	mm	lb/1000 ft	kg/km	lb/1000 ft	kg/km
336 400	170.2	...	18	0.1367	3.47	0.628	15.95	364.8	543.3	357.2	531.1
266 800	135.0	...	18	0.1217	3.09	0.559	14.20	289.1	430.8	283.1	421.1
211 600	107.2	0000	6	0.1878	4.77	0.517	13.13	290.8	433.4	276.5	412.1
167 800	85.1	000	6	0.1672	4.25	0.461	11.71	230.5	343.9.0	219.2	327.1
133 100	67.3	00	6	0.1489	3.78	0.410	10.41	182.8	272.3	173.8	258.9
105 600	53.5	0	6	0.1327	3.37	0.365	9.27	145.2	216.4	138.1	205.8
83 690	42.4	1	6	0.1181	3.00	0.326	8.28	115.0	171.4	109.4	163.0
66 360	33.6	2	7	0.1299	3.30	0.298	7.57	106.6	158.6	99.8	148.4
66 360	33.6	2	6	0.1052	2.67	0.290	7.37	91.2	135.9	86.8	129.2
52 620	26.7	3	6	0.0937	2.38	0.258	6.55	72.4	107.9	68.8	102.6
41 740	21.1	4	7	0.1029	2.61	0.236	5.99	67.0	99.7	62.7	93.4
41 740	21.2	4	6	0.0834	2.12	0.229	5.82	57.3	85.6	54.5	81.4
26 240	13.3	6	6	0.0661	1.68	0.182	4.62	36.0	53.7

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁵ Available from National Technical Information Service (NTIS), 5301 Shawnee Rd., Alexandria, VA 22312, <http://www.ntis.gov>.

3.1.6 Packaging and Package Marking (Section 17).

4. Joints

4.1 Electric-butt welds, electric-butt, cold-upset welds, or cold-pressure welds in the individual round-drawn or shaped aluminum wires may be made during the stranding process. No weld shall occur within 50 ft (15 m) of a weld in the same wire or in any other wire of the completed conductor.

4.2 There shall be no joints of any kind made in the finished coated, or aluminum-clad steel wires.

5. Lay

5.1 The ~~preferred length of lay of the aluminum wires of aluminum conductors, steel-reinforced, having a single wire steel core and one layer of aluminum wires is 14 times the outside diameter of the conductor but the lay shall be not wires, shall not be less than 13 nor more than 16 times that diameter.~~ the outside diameter of that layer.

5.2 The ~~preferred length of lay of the outside layer of aluminum wires of aluminum conductors, steel-reinforced, having multiple layers of aluminum wires is 12 times the outside diameter of the conductor but the lay shall be not wires, shall not be less than 11 nor more than 14 times that diameter.~~ the outside diameter of that layer.

5.3 The ~~preferred length of lay of the layer immediately beneath the outside layer of aluminum wires of aluminum conductors, steel-reinforced, having multiple layers of aluminum wires is 14 times the outside diameter of such layer but the lay shall be not wires, shall not be less than 11 nor more than 17.5 times that diameter.~~ the outside diameter of that layer.

5.4 The length of lay of the various layers of steel wire shall conform to the requirements of Specification **B500/B500M**.

5.5 In a conductor having multiple layers of aluminum wires, the length of lay of any aluminum layer shall not be less than the length of lay of the aluminum layer immediately beneath it.

5.6 The direction of lay of the outside layer of aluminum wires shall be right hand.

5.7 The direction of lay shall be reversed in successive layers.

6. Construction

6.1 The diameter of the steel core wire, the number of aluminum wires, the aluminum cross-sectional area, the diameter and weight of the compact round concentric-lay-stranded aluminum conductors, steel-reinforced, shall be as shown in **Table 1**.

7. Rated Strength of Conductor

7.1 The rated strength of a completed conductor shall be taken as the aggregate strength of the aluminum and steel components, calculated as follows: The strength contribution of the aluminum wires shall be taken as the percentage, according to the number of layers of aluminum wires, indicated in **Table 2**, of the sum of the strengths of the 1350-H19 wires, calculated on the basis of the nominal wire diameter for the corresponding noncompacted construction given in Specification **B232/B232M** and the appropriate specified minimum average tensile strength given in Specification **B230/B230M**. The strength contribution of the steel

TABLE 2 Strength Rating Factors

Stranding				Rating Factor, %	
Number of Wires		Number of Layers		Aluminum	Steel
Aluminum	Steel	Aluminum	Steel		
6	1	1	^A	96	96
7	1	1	^A	96	96
18	1	2	^A	93	96

^A Central steel wire only: the 96 % Rating Factor is applied to the single steel wire core in the event it contains a weld (made prior to drawing).

core shall be taken as 96 % of the strength of the steel wire calculated from its specified nominal diameter and the appropriate specified minimum stress at 1 % extension given in Specification [B341/B341M](#), [B498/B498M](#), [B502/B502M](#), or [B802/B802M](#), whichever is applicable.

7.2 Rated strength and breaking strength values shall be rounded to three significant figures, in the final value only, in accordance with Practice [E29](#).

7.3 Rated strength of conductors are given in [Table 3](#).

8. Density

8.1 For the purpose of calculating mass, mass per unit length, cross sections, and so forth, the density of aluminum 1350 shall be taken as ~~2705 kg/m~~ from the applicable³ (0.0975 lb/in.³ ASTM³) at 20 °C; wire specification, [B230/B230M](#).

8.2 For the purpose of calculating mass, mass per unit length, cross sections, and so forth, the density of coated steel wire shall be taken as ~~7780 kg/m~~ from the applicable³ (0.281 lb ASTM/in.³) at 20 °C; wire specification, [B498/B498M](#) or [B802/B802M](#).

8.3 For the purpose of calculating mass, mass per unit length, cross sections, and so forth, the density of aluminum-clad steel wire shall be taken as ~~6590 kg/m~~ from the applicable³ (0.2381 lb ASTM/in.³) at 20 °C; wire specification, [B502/B502M](#).

9. Mass and Electrical Resistance

9.1 The mass and electrical resistance of a unit length of stranded conductor are a function of the length of lay. The approximate mass and electrical resistance may be determined using an increment of 1.5 % for conductors composed of 1 steel and 6 or 7 aluminum wires and an increment of 2 % for conductors composed of 1 steel and 18 aluminum wires. When greater accuracy is desired, the increment based on the specific lay of the conductor may be calculated (Explanatory [Note 4](#)).

9.2 In the calculation of the electrical resistance of a completed conductor, coated steel wires may be included.

9.3 The maximum electrical resistance of a unit length of stranded conductor shall not exceed 102 % of the nominal dc resistance shown in [Table 4](#) (Explanatory [Note 6](#)). When the dc resistance is measured at other than 20 °C, it is to be corrected by using the multiplying factor given in [Table 5](#).

9.4 For conductors to be used in covered or insulated wires or cables dc resistance measurements may be used in lieu of the method outlined in Section [12](#).

TABLE 3 Rated Strengths for Compact Round Concentric-Lay-Stranded Aluminum Conductors, Steel-Reinforced

Conductor Size			Rated Strength For Conductors With:										
			Aluminum-Coated Steel Core Wire		Aluminum-Clad Steel Core Wire		Coated Steel Core Wire:						
cmil	mm ²	AWG	Number of Aluminum Wires					Class A		Class B		Class C	
				kips	kN	kips	kN	kips	kN	kips	kN	kips	kN
336 400	170.2	...	18	8.26	36.3	8.54	37.6	8.68	38.2	8.54	37.5	8.40	36.9
266 800	135.0	...	18	6.54	28.81	6.82	30.0	6.88	30.3	6.77	29.8	6.66	29.3
211 600	107.2	0000	6	7.42	32.9	7.69	34.1	8.35	37.1	8.08	35.9	7.95	35.3
167 800	85.1	000	6	5.88	26.1	6.30	28.0	6.62	29.4	6.41	28.5	6.30	28.1
133 100	67.3	00	6	4.88	21.4	5.13	22.5	5.30	23.3	5.13	22.5	5.05	22.2
105 600	53.5	0	6	3.98	17.6	4.25	18.8	4.38	19.4	4.25	18.8	4.12	18.2
83 690	42.4	1	6	3.29	14.4	3.45	15.1	3.55	15.6	3.45	15.1	3.34	14.7
66 360	33.6	2	7	3.26	14.4	3.51	15.6	3.64	16.1	3.51	15.6	3.39	15.0
66 360	33.7	2	6	2.64	11.7	2.76	12.3	2.85	12.7	2.76	12.3	2.68	11.9
52 620	26.7	3	6	2.13	9.44	2.23	9.89	2.29	10.2	2.23	9.91	2.17	9.61
41 740	21.1	4	7	2.16	9.60	2.28	10.1	2.36	10.5	2.28	10.2	2.20	9.81
41 740	21.2	4	6	1.76	7.83	1.78	7.95	1.86	8.30	1.81	8.07	1.76	7.83
26 240	13.3	6	6	1.12	4.98	Not	Not	1.19	5.28	1.16	5.13	1.12	4.98
						Standard	Standard						

TABLE 4 Nominal dc Resistance Values

Required Construction				Nominal dc Resistance at 20 °C for Conductors With:					
Conductor Size (Aluminum Wires)		Number of Aluminum Wires	Steel Wire Diameter		Coated Steel Core Wire		Aluminum-Clad Steel Core Wire		
cmil	mm ²		in.	mm	ohm/1000 ft	ohm/km	ohm/1000 ft	ohm/km	
336 400	170.2	...	18	0.1367	3.472	0.05113	0.1680	0.05060	0.1662
266 800	135.0	...	18	0.1217	3.091	0.06451	0.2118	0.06384	0.2096
211 600	107.2	0000	6	0.1878	4.770	0.07956	0.2611	0.07720	0.2533
167 800	85.1	000	6	0.1672	4.247	0.1004	0.3288	0.09739	0.3191
133 100	67.3	00	6	0.1489	3.782	0.1266	0.4157	0.1228	0.4033
105 600	53.5	0	6	0.1327	3.371	0.1594	0.5230	0.1546	0.5074
83 690	42.4	1	6	0.1181	3.000	0.2012	0.6600	0.1952	0.6403
66 360	33.6	2	7	0.1299	3.299	0.2503	0.8239	0.2393	0.7874
66 360	33.6	2	6	0.1052	2.672	0.2536	0.8332	0.2460	0.8084
52 620	26.7	3	6	0.0937	2.380	0.3203	1.049	0.3107	1.017
41 740	21.1	4	7	0.1029	2.614	0.3985	1.309	0.3809	1.251
41 740	21.2	4	6	0.0834	2.118	0.4034	1.322	0.3914	1.282
26 240	13.3	6	6	0.0661	1.679	0.6423	2.104

TABLE 5 Temperature Correction Factors for Conductor Resistance

NOTE 1—Although the temperature coefficient of aluminum is different from steel, the approximate temperature correction factor is given in the above chart. For a more accurate conductor resistance calculation the individual resistance temperature coefficient for the aluminum and for the steel must be included in the dc resistance equations shown in Explanatory Note 6. As per Test Method B193, the 20 °C temperature coefficient of resistance for 1350 aluminium at 61.0 % IACS is 0.00403. The 20 °C temperature coefficient of resistance for aluminum clad steel at 20.3 % IACS is 0.00306. The 20 °C temperature coefficient of resistance for zinc or aluminum coated steel is not defined in Test Method B193, however a approximated value of 0.005 has been used.

Temperature, °C	Multiplying Factor for Conversion to 20 °C
0	1.088
5	1.064
10	1.042
15	1.02
20	1.00
25	0.98
30	0.961
35	0.943
40	0.925

10. Workmanship, Finish, and Appearance

10.1 The conductor shall be clean and free of imperfections not consistent with good commercial practice.

11. Requirements for Wires

11.1 Before stranding and compacting, the round aluminum wire used shall conform to the requirements of Specification B230/B230M.

11.2 Aluminum wires shaped before stranding shall meet the requirements of Specification B230/B230M, except for shape, tensile and elongation requirements, and diameter tolerances. The minimum tensile and elongation requirements shall be 96 % of those for round wires of the same nominal area, provided the completed conductor is capable of meeting the requirements of Section 7. The area tolerances for the shaped wires shall be such that the finished conductor conforms to Section 12.

11.3 Before stranding, the steel core wire used shall conform to the requirements of Specification B341/B341M, B498/B498M, B502/B502M, or B802M/B802M, whichever is applicable.