



Designation: ~~B317/B317M-07 (Reapproved 2015)^{ε1}~~ B317/B317M-23

Standard Specification for Aluminum-Alloy Extruded Bar, Rod, Tube, Pipe, Structural Profiles, and Profiles for Electrical Purposes (Bus Conductor)¹

This standard is issued under the fixed designation B317/B317M; 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 U.S. Department of Defense.

^{ε1} NOTE—Table 2 was reformatted editorially in November 2016.

1. Scope*

1.1 This specification covers 6101 aluminum-alloy extruded bar, rod, tube, pipe, (Schedules 40 and 80), structural profiles, and profiles in selected tempers for use as electric conductors as follows:

1.1.1 *Type B*—Hot-finished bar, rod, tube, pipe, structural profiles and profiles in T6, T61, T63, T64, T65, and H111 tempers with Type B tolerances, as shown in the “List of ANSI Tables of Dimensional Tolerances.”

1.1.2 *Type C*—Hot-finished rectangular bar in T6, T61, T63, T64, T65, and H111 tempers with Type C tolerances as listed in the tolerances and permissible variations tables.

1.2 Alloy and temper designations are in accordance with ANSI H35.1. The equivalent Unified Numbering System alloy designation in accordance with Practice E527 is A96101 for Alloy 6101.

NOTE 1—Type A material, last covered in the 1966 issue of this specification, is no longer available; therefore, requirements for cold-finished rectangular bar have been deleted.

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

1.3 The values stated in either SI or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

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.

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.

Current edition approved Oct. 1, 2015Nov. 1, 2023. Published October 2015December 2023. Originally approved in 1957. Last previous edition approved in 20072015 as B317/B317M-07-B317/B317M-07 (2015)^{ε1}. DOI: 10.1520/B0317-B0317M-07R15E01-10.1520/B0317_B0317M-23.

*A Summary of Changes section appears at the end of this standard

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:*²

- [B193 Test Method for Resistivity of Electrical Conductor Materials](#)
- [B253 Guide for Preparation of Aluminum Alloys for Electroplating](#)
- [B557 Test Methods for Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products](#)
- [B557M Test Methods for Tension Testing Wrought and Cast Aluminum- and Magnesium-Alloy Products \(Metric\)](#)
- [B660 Practices for Packaging/Packing of Aluminum and Magnesium Products](#)
- [B666/B666M Practice for Identification Marking of Aluminum and Magnesium Products](#)
- [B807/B807M Practice for Extrusion Press Solution Heat Treatment for Aluminum Alloys](#)
- [B881 Terminology Relating to Aluminum- and Magnesium-Alloy Products](#)
- [B918B918/B918M Practice for Heat Treatment of Wrought Aluminum Alloys](#)
- [B985 Practice for Sampling Aluminum Ingots, Billets, Castings and Finished or Semi-Finished Wrought Aluminum Products for Compositional Analysis](#)
- [E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)
- ~~[E34 Test Methods for Chemical Analysis of Aluminum and Aluminum-Base Alloys \(Withdrawn 2017\)](#)~~³
- [E55 Practice for Sampling Wrought Nonferrous Metals and Alloys for Determination of Chemical Composition](#)
- [E290 Test Methods for Bend Testing of Material for Ductility](#)
- [E527 Practice for Numbering Metals and Alloys in the Unified Numbering System \(UNS\)](#)
- ~~[E607 Test Method for Atomic Emission Spectrometric Analysis Aluminum Alloys by the Point to Plane Technique Nitrogen Atmosphere \(Withdrawn 2011\)](#)~~³
- [E716 Practices for Sampling and Sample Preparation of Aluminum and Aluminum Alloys for Determination of Chemical Composition by Spark Atomic Emission Spectrometry](#)
- [E1004 Test Method for Determining Electrical Conductivity Using the Electromagnetic \(Eddy Current\) Method](#)
- [E1251 Test Method for Analysis of Aluminum and Aluminum Alloys by Spark Atomic Emission Spectrometry](#)
- [E3061 Test Method for Analysis of Aluminum and Aluminum Alloys by Inductively Coupled Plasma Atomic Emission Spectrometry \(Performance Based Method\)](#)

2.3 *ANSI Standards:*³

- [H35.1/H35.1 \(M\) Alloy and Temper Designation Systems for Aluminum](#)
- [H35.2 Dimensional Tolerances for Aluminum Mill Products](#)
- ~~[H35.2 \(M\)](#)~~[H35.2 \(M\) Dimensional Tolerances for Aluminum Mill Products \(Metric\)](#)

2.4 *Military/CEN Standard:*⁴

- ~~[MIL-STD-129](#)~~[CEN EN 14242 Marking for Shipment and Storage Aluminium and aluminium alloys – Chemical analysis – Inductively coupled plasma optical emission spectrometric analysis](#)

2.5 *Federal Standard:*⁵

- [Fed. Std. No. 123 Marking for Shipment \(Civil Agencies\)](#)

2.6 *Military Standard:*⁵

- [MIL-STD-129 Marking for Shipment and Storage](#)

3. Terminology

3.1 *Definitions:*

3.1.1 Refer to Terminology **B881** for definition of product terms used in this specification.

3.1.1.1 Note: Tees, Zees, I-beams, and H-sections are rarely used as conductors.

3.1.1.1 *Discussion—*

Tees, Zees, I-beams, and H-sections are rarely used as conductors.

3.2 *Definitions of Terms Specific to This Standard:*

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

⁴ CEN Standards: Available from European Committee for Standardization (CEN), Rue de la Science 23, B-1000, Brussels, Belgium, <http://www.cen.eu>.

⁵ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>.



3.2.1 *capable of*—The term *capable of* as used in this specification means that the test need not be performed by the producer of the material. However, should subsequent testing by the purchaser establish that the material does not meet these requirements, the material shall be subject to rejection.

4. Ordering Information

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

4.1.1 This specification designation (which includes the number, the year, and the revision letter, if applicable),

4.1.2 Quantity in ~~pounds or pieces~~; pieces or pounds (kilograms),

4.1.3 Type (1.1.1 and 1.1.2),

4.1.4 Temper (Section 9, Table 2),

4.1.5 Type of section (Section 3),

4.1.6 ~~Cross-Sectional Dimensions: Bar—Thickness and width, or distance across flats, and edge contour (Section 13); Rod—Diameter; Pipe—Nominal pipe size and schedule number (40 or 80); Structural Profile—Nominal dimensions and type of section; Round Tube—Outside or inside diameter and wall thickness; Square or Sharp-Cornered Tube—Distance across flats and wall thickness; Round-Cornered Tube Other than Round—A drawing is required,~~

4.1.6.1 Bar—Thickness and width, or distance across flats, and edge contour (Section 13);

4.1.6.2 Rod—Diameter;

TABLE 1 Chemical Composition Limits^{A,B,C,F}

Element	Alloy Designation 6101 Composition, %
Silicon	0.30–0.7
Iron	0.50
Copper	0.10
Manganese	0.03
Magnesium	0.35–0.8
Chromium	0.03
Zinc	0.10
Boron	0.06
Other elements. ^D	
—Each	0.03
Each, max	0.03
Total ^E , max	0.10
Aluminum	remainder
Aluminum, min	Rem.

^A Limits are in weight percent maximum unless shown as a range.

^B Analysis shall be made for the elements for which limits are shown in this table.

^C To determine conformance to these limits, an observed value or a calculated value obtained from analysis shall be rounded off to the nearest unit in the last right-hand place of the figures used in expressing the specified limit, in accordance with the rounding-off method of Practice E29.

^D *Others* includes all unlisted metallic elements. The producer may analyze samples for trace elements not specified in the specification. However, such analysis is not required and may not cover all metallic *Others* elements. Should any analysis by the producer or the purchaser establish that an *Others* element exceeds the limit of *Each* or that the aggregate of several *Others* elements exceeds the limit of *Total*, the material shall be considered nonconforming.

^E *Other Elements*—Total shall be the sum of unspecified metallic elements 0.010 % or more, rounded to the second decimal before determining the sum.

^F In case of any discrepancy in the values listed in this table when compared to those listed in the "Teal Sheets" (International Alloy Designations and Chemical Composition Limits for Wrought Aluminum and Wrought Aluminum Alloys), the composition limits registered with The Aluminum Association and published in the "Teal Sheets" shall be considered the controlling composition. The "Teal Sheets" are available at <http://www.aluminum.org/tealsheets>.

TABLE 2 Tensile Property Limits^{A,B,C}

Temper	Specified Thickness, in. [mm]	Tensile Strength, ksi [MPa]		Yield Strength, (0.2 % offset), ksi [MPa]	
		min	max	min	max
T6	0.125–0.500 [3.20–12.50]	29.0 [200]	...	25.0 [170]	...
T61	0.125–0.749 [3.20–18.00]	20.0 [140]	...	15.0 [105]	...
	0.750–1.499 [18.01–35.00]	18.0 [125]	...	11.0 [75]	...
	1.500–2.000 [35.01–50.00]	15.0 [105]	...	8.0 [55]	...
T62^D	0.125–1.000 [3.20–25.00]	27.0 [185]	...	22.0 [150]	...
T63^C	0.125–1.000 [3.20–25.00]	27.0 [185]	...	22.0 [150]	...
T64	0.125–1.000 [3.20–25.00]	15.0 [105]	...	8.0 [55]	...
T65	0.125–0.749 [3.20–20.00]	25.0 [170]	32.0 [221]	20.0 [140]	27.0 [185]
H111	0.250–2.000 [6.30–50.00]	12.0 [85]	...	8.0 [55]	...

^A To determine conformance to this specification, each value shall be rounded off to the nearest 0.1 ksi (1 MPa) for strength in accordance with the rounding-off method of Practice E29.

^B For explanation of SI unit MPa, see Appendix X2.

^C See Annex A1.

^D Formerly designated T62 temper.

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4.1.6.3 *Pipe*—Nominal pipe size and schedule number (40 or 80);

4.1.6.4 *Structural Profile*—Nominal dimensions and type of section;

4.1.6.5 *Round Tube*—Outside or inside diameter and wall thickness;

4.1.6.6 *Square or Sharp-Cornered Tube*—Distance across flats and wall thickness;

4.1.6.7 *Round-Cornered Tube Other than Round*—A drawing is required.

4.1.7 ~~Length~~, Length.

4.2 Additionally, orders for material to this specification shall include the following information when required by the purchaser:

4.2.1 Whether solution heat treatment at the extrusion press is unacceptable (8.2),

4.2.2 Whether witness of inspection by the purchaser's representative is required prior to material shipment (Section 16),

4.2.3 Whether marking for identification is required (Section 18),

4.2.4 Whether certification is required (Section 20), and

4.2.5 Whether Practices B660 ~~applies~~ apply and, if so, the levels of preservation, packaging, packing, and marking required (Section 19).

4.2.6 Whether pipe or tube produced through porthole or bridge dies is acceptable (Section 5), and

4.2.7 Whether an alternative tensile sampling selection procedure is acceptable (Section 9).



5. Manufacture

5.1 The bars, rods, tubes, pipes, structural profiles, and profiles shall be produced by hot extrusion or by similar methods at the option of the producer, provided that the production method results in material that meets all requirements of this specification. Pipe or tube may be produced through porthole or bridge type dies when specified by the purchaser.

6. Quality Assurance

6.1 *Responsibility for Inspection and Tests*—Unless otherwise specified in the contract or purchase order, the producer is responsible for the performance of all inspection and test requirements specified herein. The producer may use his own or any other suitable facilities for the performance of the inspection and test requirements specified herein, unless disapproved by the purchaser in the order or at the time of contract signing. The purchaser shall have the right to perform any of the inspections and tests set forth in this specification where such inspections are deemed necessary to assure that material conforms to prescribed requirements.

6.2 *Lot Definition*—An inspection lot shall be defined as follows:

6.2.1 For heat-treated tempers, an inspection lot shall consist of an identifiable quantity of material of the same mill form, alloy, temper, and nominal dimensions traceable to a heat-treat lot or lots, and subjected to inspection at one time.

6.2.2 For nonheat-treated tempers, an inspection lot shall consist of an identifiable quantity of material of the same mill form, alloy, temper, and nominal dimensions subjected to inspection at one time.

7. Chemical Composition

7.1 *Limits*—The material shall conform to the chemical composition limits in Table 1. Conformance shall be determined by the producer by analyzing samples taken at the time ingots are poured, or samples taken from the finished or semifinished product. If chemical composition has been determined during the course of manufacture, analysis of the finished product shall not be required.

NOTE 2—It is standard practice in the United States aluminum industry to determine conformance to the chemical composition limits prior to further processing of ingots into wrought products. Due to the continuous nature of the process, it is not practical to keep a specific ingot analysis identified with a specific quantity of finished material.

7.2 *Number of Samples*—If it becomes necessary to analyze bar, rod, tube, pipe, (Schedules 40 and 80), structural profiles, or profiles for conformance to chemical composition limits, the method used for determination of chemicals composition shall be by agreement between the producer and purchaser. Analysis shall be performed in accordance with Practices E716, Test Methods E1251 or E3061, or ECN EN 14242 (ICP Method). The number of samples taken for determination of chemical composition shall be as follows:

7.2.1 *Methods of Sampling*—When samples are taken at the time the ingots are poured, at least one sample. Samples for chemical analysis shall be taken for each group of in accordance with Practice B985 ingots poured simultaneously from the same source of molten metal.

7.2.2 *Methods of Analysis*—When samples are taken from the finished or semifinished product, a sample shall be taken to represent each 4000 lb (1800 kg), or fraction thereof, in the lot, except that Analysis shall be performed in accordance with Test Method E1251 not more than, Test Method E3061 one sample shall be required per piece., or CEN EN 14242 (ICP Method).

7.3 *Methods of Sampling*—Samples for determination of chemical composition shall be taken in accordance with one of the following methods:

7.3.1 Samples for chemical analysis shall be taken from the material by sawing, milling, turning, or clipping a representative piece or pieces to obtain a prepared sample of not less than 75 g. Sampling shall be in accordance with Practice E55.

7.3.2 Sampling for spectrochemical analysis shall be in accordance with Practices E716. Samples for other methods of analysis shall be taken by methods suitable for the form of material being analyzed and the type of analytical method used.

7.3 *Methods of Analysis*—The determination of chemical composition shall be made in accordance with suitable chemical (Test



Methods ~~E34~~) or spectrochemical (Test Methods ~~E607~~ and ~~E1251~~), methods. Other methods may be used only when no published ASTM method is available. In case of dispute, the methods of analysis shall be agreed upon. Other methods of analysis or in the case of dispute may be by agreement between the producer and purchaser.

8. Heat Treatment

8.1 Except as noted in 8.2, heat treatment shall be in accordance with Practice ~~B918~~B918/B918M.

8.2 Unless otherwise specified, Alloy 6101 may be solution heat-treated and quenched at the extrusion press in accordance with Practice ~~B807~~B807M in the production of T6-type tempers.

9. Tensile Properties of Material as Supplied

9.1 *Limits*—The material shall conform to the tensile properties in Table 2.

9.2 *Number of Specimens*:

9.2.1 For material having a nominal weight of less than ~~1 lb~~ 1 lb/linear/linear ft [up through ~~1.71.7 kg~~ 1.71.7 kg/linear/linear m], one tension test specimen shall be taken for each ~~1000 lb~~ 500 kg, 1000 lb [500 kg], or fraction thereof, in the lot.

9.2.2 For material having a nominal weight of greater than 1 lb/linear ft [over 1.7 kg/linear m], one tension test specimen shall be taken for each ~~1000 ft~~ 1000 ft [300 m], or fraction thereof, in the lot.

9.2.3 Other procedures for selecting samples may be employed if agreed upon between the producer and the supplier or purchaser.

9.3 The geometry of test specimens and the location in the product from which they are taken shall conform to Test Methods ~~B557~~: [B557M].

9.4 *Test Methods*—The tensile testing shall be in accordance with Test Method ~~Methods~~ B557: [B557M].

9.5 *Retests*—When there is evidence that the test specimen is defective or is not representative of the lot of material, retesting shall be performed in accordance with Sections 8 and 9 of Test Method ~~Methods~~ B557: [B557M].

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10. Bend Properties

10.1 *Limits*:

10.1.1 *Flatwise Bends*—*Bend*—Bars shall be capable of being bent at room temperature through an angle of 90° around a pin or mandrel having a radius equal to *N* times its thickness without developing cracks or ruptures visible to the unaided eye corrected for normal vision. For a flatwise bend, the pin or mandrel shall be 90° from the working (extrusion) direction, and across the greater (width) dimension of the bar. The required 90° bend shall be in the working (extrusion) direction. This is a longitudinal bend as defined and shown in Test Methods E290, Fig. 1. Surface roughening (“orange peel” appearance) is not considered to be an injurious defect. The value of *N* is specified in Table 3 for specific tempers and thicknesses.

10.1.2 *Edgewise Bends*—*Bend*—Bars in the T64 and H111 tempers having a maximum thickness of ¼ in. (6.4 mm) and a maximum width of 2 in. (50.8 mm) shall be capable of being bent edgewise at room temperature through an angle of 90° to an inside bend radius equal to one half the bar width without developing cracks or ruptures visible to the unaided eye corrected for normal vision. For an edgewise bend, the pin or mandrel shall be 90° from the working (extrusion) direction, and across the lesser (thickness) dimension of the bar. This is also a longitudinal bend as defined and shown in Test Methods E290, Fig. 1. An edgewise bend shall be considered satisfactory if the thickness within the vicinity of any localized thinning is not less than 90 % of the maximum thickness within the center 60° of the bend when measured only along the outer edge of the bend.

10.2 *Number of Specimens*—The number of specimens (test frequency) shall be the same as for tension tests as required in 9.2.

10.3 *Test Specimens*—Bend test specimens (bar only) shall be a full section of the material with a minimum length of ~~12 in.~~ 12 in. (305 mm).