



Designation: A 227/A 227M – 99

Standard Specification for Steel Wire, Cold-Drawn for Mechanical Springs¹

This standard is issued under the fixed designation A 227/A 227M; 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 two classes of round cold-drawn steel spring wire having properties and quality for the manufacture of mechanical springs that are not subject to high stress or requiring high fatigue properties and wire forms.

1.2 The values stated in either SI (metric) units or inch-pound units are to be regarded separately as standard. The values stated in each system are not exact equivalents; therefore, each system must be used independent of the other.

2. Referenced Documents

2.1 ASTM Standards:

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products²

A 510 Specification for General Requirements for Wire Rods and Coarse Round Wire, Carbon Steel²

A 510M Specification for General Requirements for Wire Rods and Coarse Round Wire, Carbon Steel [Metric]²

A 700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Domestic Shipment³

A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products²

A 941 Terminology Relating to Steel, Stainless Steel, Related Alloys and Ferroalloys²

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications⁴

2.2 American National Standard:

B 32.4M Preferred Metric Sizes for Round, Square, Rectangle, and Hexagon Metal Products⁵

2.3 Military Standard:

MIL-STD-163 Steel Mill Products, Preparation for Shipment and Storage⁶

2.4 Federal Standard:

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)⁶

2.5 AIAG Standard:

AIAG B-5 02.00 Primary Metals Identification Tag Application Standard⁷

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 For definition of terms used in this specification, refer to Terminology A 941.

4. Ordering Information

4.1 It shall be the responsibility of the purchaser to specify all requirements that are necessary for material under this specification. Such requirement may include, but are not limited to, the following:

4.1.1 Quantity (mass),

4.1.2 Name of material (cold-drawn steel mechanical spring wire) and class (Table 1 or Table 2),

4.1.3 Wire diameter (Table 1 or Table 2),

4.1.4 Packaging (Section 15),

4.1.5 Cast or heat analysis report, if requested (Section 6),

4.1.6 Certification or test report, or both, if specified (Section 14), and

4.1.7 ASTM designation and date of issue.

NOTE 1—A typical ordering description is as follows: 15 000 kg Cold-Drawn Mechanical Spring Wire, Class I, Size 5.00 mm in 700-kg coils to ASTM A 227M dated _____, or for non-SI units, 30 000 lb Cold-Drawn Mechanical Spring Wire, Class I, Size 0.207 in. diameter in 500-lb coils to ASTM A 227 dated _____.

5. Manufacture

5.1 The steel may be made by any commercially accepted steel-making process. The steel may be either ingot cast or strand cast.

¹ This specification is under the jurisdiction of ASTM committee A-1 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.03 on Steel Rod and Wire.

Current edition approved March 10, 1999. Published May 1999. Originally published as A 227 – 39 T and A 227M – 80. Last previous edition A 227/A 227M – 93.

² Annual Book of ASTM Standards, Vol 01.03.

³ Annual Book of ASTM Standards, Vol 01.05.

⁴ Annual Book of ASTM Standards, Vol 14.02.

⁵ Available from American National Standards Institute, 11 West 42nd Street, 13th Floor, New York, NY 10036.

⁶ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

⁷ Available from the Automotive Industry Action Group, 26200 Lahser, Suite 200, Southfield, MI 48034.

TABLE 1 Tensile Requirements, SI Units^A

Diameter, ^B mm	Class I		Class II	
	Tensile Strength, MPa		Tensile Strength MPa	
	min	max	min	max
0.50	1960	2240	2240	2520
0.55	1940	2220	2220	2500
0.60	1920	2200	2200	2480
0.65	1900	2180	2180	2460
0.70	1870	2140	2140	2410
0.80	1830	2100	2100	2370
0.90	1800	2070	2070	2340
1.00	1770	2040	2040	2310
1.10	1740	2000	2000	2260
1.20	1720	1980	1980	2240
1.40	1670	1930	1930	2180
1.60	1640	1880	1880	2120
1.80	1600	1840	1840	2080
2.00	1580	1810	1810	2040
2.20	1550	1780	1780	2010
2.50	1510	1730	1730	1960
2.80	1480	1700	1700	1920
3.00	1460	1680	1680	1900
3.50	1420	1630	1630	1840
4.00	1380	1590	1600	1700
4.50	1350	1550	1550	1750
5.00	1320	1510	1510	1700
5.50	1300	1490	1490	1670
6.00	1280	1470	1470	1650
6.50	1250	1440	1440	1630
7.00	1220	1410	1410	1600
7.50	1200	1390	1390	1580
8.00	1190	1370	1370	1550
9.00	1160	1340
10.00	1130	1310
11.00	1110	1280
12.00	1090	1260
14.00	1050	1210
16.00	1010	1170

^A Tensile strength values for intermediate diameters may be interpolated.

^B Preferred sizes. For a complete list, refer to ANSI B32.4M, Preferred Metric Sizes for Round, Square, Rectangle, and Hexagon Metal Products.

5.2 The finished wire shall be free of detrimental pipe and undue segregation.

5.3 The wire shall be cold drawn to produce the desired mechanical properties.

6. Chemical Composition

6.1 The steel shall conform to the requirements for chemical composition prescribed in Table 3.

6.2 *Cast or Heat Analysis*—Each cast or heat of steel shall be analyzed by the manufacturer to determine the percentage of elements prescribed in Table 3. This analysis shall be made from a test specimen preferably taken during the pouring of the cast or heat. When requested, this shall be reported to the purchaser and shall conform to the requirements of Table 3.

6.3 *Product Analysis*—An analysis may be made by the purchaser from finished wire representing each cast or heat of steel. The chemical composition thus determined, as to elements required or restricted, shall conform to the product analysis requirements specified in Table 10 of Specification A 510 or A 510M.

6.4 For referee purposes, Test Methods, Practices and Terminology, A 751 shall be used.

7. Mechanical Properties

7.1 Tension Test:

TABLE 2 Tensile Requirements, Inch-Pound Units^A

Diameter, in.	Class I		Class II	
	Tensile Strength, ksi		Tensile Strength, ksi	
	min	max	min	max
0.020	283	323	324	364
0.023	279	319	320	360
0.026	275	315	316	356
0.029	271	311	312	352
0.032	266	306	307	347
0.035	261	301	302	342
0.041	255	293	294	332
0.048	248	286	287	325
0.054	243	279	280	316
0.062	237	272	273	308
0.072	232	266	267	301
0.080	227	261	262	296
0.092	220	253	254	287
0.106	216	248	249	281
0.120	210	241	242	273
0.135	206	237	238	269
0.148	203	234	235	266
0.162	200	230	231	261
0.177	195	225	226	256
0.192	192	221	222	251
0.207	190	218	219	247
0.225	186	214	215	243
0.250	182	210	211	239
0.312	174	200	201	227
0.375	167	193	194	220
0.438	165	190	191	216
0.500	156	180	181	205
0.562	152	176	177	201
0.625	147	170	171	194

^A Tensile strength values for intermediate diameters shall be interpolated.

TABLE 3 Chemical Requirements

Element	Composition, %
Carbon	0.45–0.85 ^A
Manganese	0.30–1.30 ^B
Phosphorus, max	0.040
Sulfur, max	0.050
Silicon	0.15–0.35

^A Carbon in any one lot shall not vary more than 0.13 %.

^B Manganese in any one lot shall not vary more than 0.30 %.

7.1.1 *Requirements*—The material as represented by tension test specimens shall conform to the requirements prescribed in Table 1 or Table 2.

7.1.2 *Number of Tests*—One test specimen shall be taken for each ten coils or fraction thereof, in a lot. Each cast or heat in a given lot shall be tested.

7.1.3 *Location of Tests*—Test specimens shall be taken from either end of the coil.

7.1.4 *Test Method*—The tension test shall be made in accordance with Test Methods and Definitions A 370.

7.2 Wrap Test:

7.2.1 *Requirements*—The material as represented by the wrap test specimens shall conform to the requirements specified in Table 4 or Table 5. Wrap test on wires over 8.5 mm or

TABLE 4 Wrap Test Requirements, SI Units

Diameter, mm	Mandrel Size	
	Class I	Class II
0.50 to 4.0, incl	1X ^A	2X
Over 4.0 to 8.0, incl	2X	4X

^A For 1X mandrel, wire shall be wrapped on itself.