



Designation: A 231/A231M – 96 (Reapproved 2002)

Standard Specification for Chromium-Vanadium Alloy Steel Spring Wire¹

This standard is issued under the fixed designation A 231/A231M; 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 round chromium-vanadium alloy steel spring wire having properties and quality intended for the manufacture of springs used at moderately elevated temperatures. This wire shall be either in the annealed and cold-drawn or oil-tempered condition as specified by the purchaser.

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 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 752 Specification for General Requirements for Wire Rods and Coarse Round Wire, Alloy Steel²

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

2.2 ANSI 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:

AIAGB-5 02.00 Primary Metals Identification Tag Application Standard⁷

3. Ordering Information

3.1 Orders for material under this specification should include the following information for each ordered item:

3.1.1 Quantity (mass),

3.1.2 Name of material (chromium-vanadium alloy steel wire),

3.1.3 Wire diameter (Table 1 and Table 2),

3.1.4 Packaging (Section 14),

3.1.5 Cast or heat analysis report (if requested) (5.2),

3.1.6 Certification or test report, or both, if specified (Section 13), and

3.1.7 ASTM designation and date of issue.

NOTE 1—A typical ordering description is as follows: 20 000 kg oil-tempered chromium-vanadium alloy steel wire, size 6.00 mm in 150-kg coils to ASTM A 231M dated _____, or for inch-pound units, 40 000 lb oil-tempered chromium-vanadium alloy steel spring wire, size 0.250 in. in 350-lb coils to ASTM A 231 dated _____.

4. Materials and Manufacture

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

4.2 The finished wire shall be free from detrimental pipe and undue segregation.

5. Chemical Composition

5.1 The steel shall conform to the requirements as to chemical composition specified in Table 3.

5.2 *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.

5.3 *Product Analysis (formerly Check Analysis)*—An analysis may be made by the purchaser from finished wire

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

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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.


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TABLE 1 Tensile Requirements, SI Units^A

Diameter, ^B mm	Tensile Strength, MPa		Reduction of Areas, min, %
	min	max	
0.50	2060	2260	C
0.55	2050	2240	C
0.60	2030	2220	C
0.65	2010	2200	C
0.70	2000	2160	C
0.80	1980	2140	C
0.90	1960	2120	C
1.00	1940	2100	C
1.10	1920	2080	C
1.20	1900	2060	C
1.40	1860	2020	C
1.60	1820	1980	C
1.80	1800	1960	C
2.00	1780	1930	C
2.20	1750	1900	C
2.50	1720	1860	45
2.80	1680	1830	45
3.00	1660	1800	45
3.50	1620	1760	45
4.00	1580	1720	40
4.50	1560	1680	40
5.00	1520	1640	40
5.50	1480	1620	40
6.00	1460	1600	40
6.50	1440	1580	40
7.00	1420	1560	40
8.00	1400	1540	40
9.00	1380	1520	40
10.00	1360	1500	40
11.00	1340	1480	40
12.00	1320	1460	40

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

^B Preferred sizes. For a complete list, refer to ANSI B 32.4M, Preferred Metric Sizes for Round, Square, Rectangle, and Hexagon Metal Products.

^C The reduction of area test is not applicable to wire diameters under 2.34 mm.

TABLE 2 Tensile Requirements, Inch-Pound Units^A

Diameter, ^B in.	Tensile Strength, ksi		Reduction of Area, min, %
	min	max	
0.020	300	325	C
0.032	290	315	C
0.041	280	305	C
0.054	270	295	C
0.062	265	290	C
0.080	255	275	C
0.105	245	265	45
0.135	235	255	45
0.162	225	245	40
0.192	220	240	40
0.244	210	230	40
0.283	205	225	40
0.312	203	223	40
0.375	200	220	40
0.438	195	215	40
0.500	190	210	40

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

^B Preferred sizes. For a complete list, refer to ANSI B 32.4M, Preferred Metric Sizes for Round, Square, Rectangle, and Hexagon Metal Products.

^C The reduction of area test is not applicable to wire diameters under 0.092 in.

representing each cast or heat of steel. The chemical composition thus determined, as to elements required or restricted, shall conform to the product (check) analysis requirements specified in Table 5 of Specification A 752.

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

TABLE 3 Chemical Requirements

Element	Analysis, %
Carbon	0.48–0.53
Manganese	0.70–0.90
Phosphorus	0.040 max
Sulfur	0.040 max
Silicon	0.15–0.35
Chromium	0.80–1.10
Vanadium	0.15 min

6. Mechanical Properties

6.1 *Annealed and Cold Drawn*—When purchased in the annealed and cold-drawn condition, the wire shall have been given a sufficient amount of cold working to meet the purchaser’s coiling requirements and shall be in a suitable condition to respond properly to heat treatment. In special cases the hardness, if desired, shall be stated in the purchase order.

6.2 *Oil Tempered*—When purchased in the oil-tempered condition, the tensile strength and minimum percent reduction of area, sizes 2.50 mm or 0.105 in. and coarser, of the wire shall conform to the requirements as shown in Table 1 or Table 2.

6.2.1 *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.

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

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

6.3 *Wrap Test:*

6.3.1 Oil tempered or cold drawn wire 4.00 mm or 0.162 in. and smaller in diameter shall wind on itself as an arbor without breakage. Larger diameter wire up to and including 8.00 mm or 0.312 in. in diameter shall wrap without breakage on a mandrel twice the wire diameter. The wrap test is not applicable to wire over 8.00 mm or 0.312 in. in diameter.

6.3.2 *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.

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

6.3.4 *Test Method*—The wrap test shall be made in accordance with Supplement IV of Test Methods and Definitions A 370.

7. Metallurgical Properties

7.1 *Surface Condition:*

7.1.1 The surface of the wire as received shall be free of rust and excessive scale. No serious die marks, scratches, or seams may be present. Based upon examination of etched end specimen, seams shall not exceed 3.5 % of the wire diameter, or 0.25 mm or 0.010 in., whichever is the smaller as measured on a transverse section.

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 Test*—Test specimens shall be taken from either or both ends of the coil.