



Designation: B8 – 04

# Standard Specification for Concentric-Lay-Stranded Copper Conductors, Hard, Medium-Hard, or Soft<sup>1</sup>

This standard is issued under the fixed designation B8; 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 ( $\epsilon$ ) 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 bare concentric-lay-stranded conductors made from round copper wires, either uncoated or coated with tin, lead, or lead alloy for general use for electrical purposes. These conductors shall be constructed with a central core surrounded by one or more layers of helically laid wires.

NOTE 1—This specification also permits conductors for use as covered or insulated electrical conductors.

NOTE 2—Sealed conductors, that are intended to prevent longitudinal water propagation and are further covered/insulated, are also permitted within the guidelines of this specification.

1.2 For the purposes of this specification, conductors are classified as follows (Explanatory Note 1 and Note 2):

1.2.1 *Class AA*—For bare conductors usually used in overhead lines.

1.2.2 *Class A*—For conductors to be covered with weather-resistant (weather-proof), slow-burning materials, and for bare conductors where greater flexibility than is afforded by Class AA is required.

1.2.3 *Class B*—For conductors to be insulated with various materials such as rubber, paper, varnished cloth, and so forth, and for the conductors indicated under Class A where greater flexibility is required.

1.2.4 *Class C and Class D*—For conductors where greater flexibility is required than is provided by Class B conductors.

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

## 2. Referenced Documents

2.1 *ASTM Standards*:<sup>2</sup>

**B1 Specification for Hard-Drawn Copper Wire**

**B2 Specification for Medium-Hard-Drawn Copper Wire**

**B3 Specification for Soft or Annealed Copper Wire**

**B33 Specification for Tinned Soft or Annealed Copper Wire for Electrical Purposes**

**B172 Specification for Rope-Lay-Stranded Copper Conductors Having Bunch-Stranded Members, for Electrical Conductors**

**B173 Specification for Rope-Lay-Stranded Copper Conductors Having Concentric-Stranded Members, for Electrical Conductors**

**B174 Specification for Bunch-Stranded Copper Conductors for Electrical Conductors**<sup>3</sup>

**B189 Specification for Lead-Coated and Lead-Alloy-Coated Soft Copper Wire for Electrical Purposes**

**B193 Test Method for Resistivity of Electrical Conductor Materials**

**B246 Specification for Tinned Hard-Drawn and Medium-Hard-Drawn Copper Wire for Electrical Purposes**

**B263 Test Method for Determination of Cross-Sectional Area of Stranded Conductors**

**B354 Terminology Relating to Uninsulated Metallic Electrical Conductors**

**B787/B787M Specification for 19 Wire Combination Unilay-Stranded Copper Conductors for Subsequent Insulation**

## 3. Ordering Information

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

3.1.1 Quantity of each size and class,

3.1.2 Conductor size: circular-mil area or AWG (Section 6),

3.1.3 Class (see 1.2 and Table 1),

3.1.4 Temper (see 13.2),

3.1.5 Whether coated or uncoated; if coated, designate type of coating (see 13.1 and 13.2),

3.1.6 Details of special-purpose lays, if required (see 5.4),

3.1.7 When physical tests shall be made (see 8.2 and 8.3),

3.1.8 Package size (see 8.1),

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee B01 on Electrical Conductors and is the direct responsibility of Subcommittee B01.04 on Conductors of Copper and Copper Alloys.

Current edition approved April 1, 2004. Published April 2004. Originally approved in 1915. Last previous edition approved in 1999 as B8 – 99. DOI: 10.1520/B0008-04.

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

Available from American Association of State Highway and Transportation Officials (AASHTO), 444 N. Capitol St., NW, Suite 249, Washington, DC 20001.

<sup>3</sup> Withdrawn.

**TABLE 1 Construction Requirements of Concentric-Lay-Stranded Copper Conductors**

Area of Cross-Section, cmil	Size, American Wire Gage	Class AA		Class A		Class B <sup>A</sup>		Class C		Class D	
		Number of Wires	Diameter of Wires, mils	Number of Wires	Diameter of Wires, mils	Number of Wires	Diameter of Wires, mils	Number of Wires	Diameter of Wires, mils	Number of Wires	Diameter of Wires, mils
*5 000 000	...	...	...	169	172.0	217	151.8	271	135.8	271	135.8
4 500 000	...	...	...	169	163.2	217	144.0	271	128.9	271	128.9
4 000 000	...	...	...	169	153.8	217	135.8	271	121.5	271	121.5
3 500 000	...	...	...	127	166.0	169	143.9	217	127.0	271	113.6
*3 000 000	...	...	...	127	153.7	169	133.2	217	117.6	271	105.2
*2 500 000	...	...	...	91	165.7	127	140.3	169	121.6	217	107.3
*2 000 000	...	...	...	91	148.2	127	125.5	169	108.8	217	96.0
1 900 000	...	...	...	91	144.5	127	122.3	169	106.0	217	93.6
1 800 000	...	...	...	91	140.6	127	119.1	169	103.2	217	91.1
*1 750 000	...	...	...	91	138.7	127	117.4	169	101.8	217	89.8
1 700 000	...	...	...	91	136.7	127	115.7	169	100.3	217	88.5
1 600 000	...	...	...	91	132.6	127	112.2	169	97.3	217	85.9
*1 500 000	...	...	...	61	156.8	91	128.4	127	108.7	169	94.2
1 400 000	...	...	...	61	151.5	91	124.0	127	105.0	169	91.0
1 300 000	...	...	...	61	146.0	91	119.5	127	101.2	169	87.7
*1 250 000	...	...	...	61	143.1	91	117.2	127	99.2	169	86.0
1 200 000	...	...	...	61	140.3	91	114.8	127	97.2	169	84.3
1 100 000	...	...	...	61	134.3	91	109.9	127	93.1	169	80.7
*1 000 000	...	37	164.4	61	128.0	61	128.0	91	104.8	127	88.7
900 000	...	37	156.0	61	121.5	61	121.5	91	99.4	127	84.2
*800 000	...	37	147.0	61	114.5	61	114.5	91	93.8	127	79.4
*750 000	...	37	142.4	61	110.9	61	110.9	91	90.8	127	76.8
*700 000	...	37	137.5	61	107.1	61	107.1	91	87.7	127	74.2
650 000	...	37	132.5	61	103.2	61	103.2	91	84.5	127	71.5
*600 000	...	37	127.3	37	127.3	61	99.2	91	81.2	127	68.7
550 000	...	37	121.9	37	121.9	61	95.0	91	77.7	127	65.8
*500 000	...	19	162.2	37	116.2	37	116.2	61	90.5	91	74.1
450 000	...	19	153.9	37	110.3	37	110.3	61	85.9	91	70.3
*400 000	...	19	145.1	19	145.1	37	104.0	61	81.0	91	66.3
*350 000	...	12	170.8	19	135.7	37	97.3	61	75.7	91	62.0
*300 000	...	12	158.1	19	125.7	37	90.0	61	70.1	91	57.4
*250 000	...	12	144.3	19	114.7	37	82.2	61	64.0	91	52.4
*211 600	0000	7	173.9	7	173.9	19	105.5	37	75.6	61	58.9
*167 800	000	7	154.8	7	154.8	19	94.0	37	67.3	61	52.4
*133 100	00	7	137.9	7	137.9	19	83.7	37	60.0	61	46.7
*105 600	0	7	122.8	7	122.8	19	74.5	37	53.4	61	41.6
*83 690	1	3 <sup>B</sup>	167.0	7	109.3	19	66.4	37	47.6	61	37.0
*66 360	2	3 <sup>B</sup>	148.7	7	97.4	7	97.4	19	59.1	37	42.4
*52 620	3	3 <sup>B</sup>	132.5	7	86.7	7	86.7	19	52.6	37	37.7
*41 740	4	3 <sup>B</sup>	118.0	7	77.2	7	77.2	19	46.9	37	33.6
*33 090	5	...	...	...	...	7	68.8	19	41.7	37	29.9
*26 240	6	...	...	...	...	7	61.2	19	37.2	37	26.6
*20 820	7	...	...	...	...	7	54.5	19	33.1	37	23.7
*16 510	8	...	...	...	...	7	48.6	19	29.5	37	21.1
*13 090	9	...	...	...	...	7	43.2	19	26.2	37	18.8
*10 380	10	...	...	...	...	7	38.5	19	23.4	37	16.7
*6 530	12	...	...	...	...	7	30.5	19	18.5	37	13.3
*4 110	14	...	...	...	...	7	24.2	19	14.7	37	10.5
*2 580	16	...	...	...	...	7	19.2	19	11.7	...	...
*1 620	18	...	...	...	...	7	15.2	19	9.2	...	...
*1 020	20	...	...	...	...	7	12.1	19	7.3	...	...
*640	22	...	...	...	...	7	9.6	19	5.8	...	...
*404	24	...	...	...	...	7	7.6	19	4.6	...	...

\* The sizes of conductors that have been marked with an asterisk provide for one or more schedules of preferred series, and are commonly used in the industry. The sizes not marked are given simply as a matter of reference and it is suggested that their use be discouraged.

<sup>A</sup> For unidirectional/unilay constructions the number of wires shown are minimum requirements.

<sup>B</sup> Although Class AA conductors having three strands do not conform to the construction requirements of 1.1, they are listed in this table for convenience.

3.1.9 Lagging, if required (see section 15.2),

3.1.10 Special package marking, if required (Section 14), and

3.1.11 Place of inspection (Section 15).

#### 4. Joints

4.1 Welds and brazes may be made in rods or in wires prior to final drawing. Joints may not be made in the finished wires

composing hard-drawn or medium-hard-drawn Class AA conductors of seven wires or less. In other conductors, welds and brazes may be made in the finished individual wires composing the conductor, but shall not be closer together than prescribed in Table 2.

**TABLE 2 Minimum Distance Between Joints in the Completed Conductor**

Number of Wires in Conductor	Hard or Medium-Hard					Soft
	Class AA	Class A	Class B	Class C	Class D	All Classes
3	none permitted	...	...	...	...	1 ft
7	none permitted	50 ft	50 ft	...	...	1 ft
12	50 ft	50 ft	...	...	...	1 ft
19	50 ft	50 ft	50 ft	50 ft	...	1 ft
20 to 36	50 ft	50 ft	50 ft	50 ft	...	1 ft in a layer <sup>A</sup>
37 to 60	...	25 ft	25 ft	25 ft	25 ft	1 ft in a layer <sup>A</sup>
61 and over	...	5 ft	5 ft	5 ft	5 ft	1 ft in a layer <sup>A</sup>

<sup>A</sup> Except as indicated, the limitations apply to closeness of joints throughout the completed conductor.

## 5. Lay

5.1 For Class AA conductors composed of less than seven wires, the preferred lay is 11 times the outside diameter of the completed conductor, but shall be not less than 8 nor more than 14 times this diameter.

5.2 For Class AA conductors composed of seven wires or more, the preferred lay of a layer of wires is 13.5 times the outside diameter of that layer, but shall be not less than 10 nor more than 16 times this diameter.

5.3 For all other classes the lay of a layer of wires shall be not less than 8 nor more than 16 times the outside diameter of that layer, except that for conductors composed of 37 wires or more, this requirement shall apply only to the two outer layers. The lay of the layers other than the two outer layers shall be at the option of the manufacturer, unless otherwise agreed upon.

5.3.1 For conductors to be used in covered or insulated wires or cables, the lay length shall be not less than 8 nor more than 16 times the outer diameter of the finished conductor. For conductors of 37 wires or more, this requirement shall apply to the wires in the outer two layers. The lay of the layers other than the two outer layers shall be at the option of the manufacturer, unless otherwise agreed upon.

5.4 Other lays for special purposes shall be furnished by special agreement between the manufacturer and the purchaser (Explanatory Note 3).

5.5 The direction of lay of the outer layer shall be left-hand, and for conductors having a nominal cross-sectional area larger than No. 8 AWG, shall be reversed in successive layers, unless otherwise specified by the purchaser.

5.5.1 For conductors to be used in covered or insulated wires or cables, the direction of lay of the outer layer shall be left hand and shall be reversed in successive layers, unidirectional, or unilay, unless otherwise agreed upon.

## 6. Construction

6.1 The areas of cross section, numbers, and diameters of wires in the various classes of concentric-lay-stranded conductors shall conform to the requirements prescribed in Table 1 (Explanatory Notes 3 and 10).

6.2 The diameters of the wires listed in Table 1 are nominal. Where “combination strand” is required in order to insulate the conductor properly (strands in the outer layer having a larger diameter than those in the inner layers) the diameters shall be subject to a tolerance of  $\pm 5\%$ , provided that the area of cross section after stranding is in accordance with Section 11.

6.3 Where compressed stranding is required in order to insulate the conductor properly, one or more layers of any

stranded conductor consisting of 7 wires or more may be slightly compressed, thereby reducing the outside diameter of the conductor to the nominal values shown in Table 3, provided that the area of cross section after stranding is in accordance with Section 11.

## 7. Physical and Electrical Tests of Conductors Stranded of Soft Wires

7.1 Tests for the electrical properties of wires composing conductors made from soft or annealed copper wire, bare or coated, shall be made before stranding.

7.2 Tests for the physical properties of soft or annealed copper wire, bare or coated, may be made upon the wires before stranding or upon wires removed from the complete stranded conductor, but need not be made upon both. Care shall be taken to avoid mechanical injury to wire removed from the conductor for the purpose of testing.

7.3 The physical properties of wire when tested before stranding shall conform to the applicable requirements of 13.2.

7.4 The physical properties of wires removed from the completed stranded conductor shall be permitted to vary from the applicable requirements of 13.2 by the following amounts (Explanatory Note 4):

7.4.1 *Average of Results Obtained on All Wires Tested*—The minimum elongation required shall be reduced in numerical value 5 (for example, from 30 to 25 %) from the numerical requirements for the wire before stranding.

7.4.2 *Results Obtained on Individual Wires*—The elongation of individual wires shall be reduced in numerical value 15 from the minimum requirements before stranding (that is, 10 in addition to the 5 allowed in 7.4.1), but in no case shall the elongation of any individual wire be less than 5 %.

7.5 In the event that the requirements prescribed in 7.4.2 are met but those prescribed in 7.4.1 are not met, a retest shall be permitted wherein all wires of the conductor shall be tested for the purpose of final determination of conformance to 7.4.

7.6 Elongation tests to determine compliance shall not be made on the conductor as a unit.

7.7 If a tinning, lead-coating, or lead-alloy-coating test is required, it shall be made on the wires prior to stranding.

## 8. Physical and Electrical Tests of Conductors Stranded of Hard-Drawn or Medium-Hard-Drawn Wires

8.1 Tests for the physical and electrical properties of wires composing conductors made from hard-drawn or medium-hard-drawn wires, uncoated or coated, shall be made before but not after stranding.