



Designation: A 884/A 884M – 04

Standard Specification for Epoxy-Coated Steel Wire and Welded Wire Reinforcement¹

This standard is issued under the fixed designation A 884/A 884M; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This specification covers plain and deformed steel wire and plain and deformed steel welded wire reinforcement with protective epoxy coating. A Class A minimum coating thickness is required for wire and welded wire reinforcement intended for use in concrete and masonry. A Class B minimum coating thickness is required for wire and welded wire reinforcement intended for use in mechanically stabilized earth applications. A Type 1 coating is a fusion-bonded epoxy coating that has been designed to be sufficiently flexible to allow fabrication of the coated wire or welded wire reinforcement. A Type 2 coating is a fusion-bonded epoxy coating that has not been designed to be sufficiently flexible to allow fabrication of the coated wire or welded wire reinforcement.

NOTE 1—The coating applicator is identified throughout this specification as the manufacturer.

1.2 Other organic coatings may be used provided they meet the requirements of this specification.

1.3 This specification is applicable for orders in either SI units (Specification A 884M) or in inch-pound units [Specification A 884].

1.4 The values stated in either SI or inch-pound units are to be regarded as standard. Within the text, the inch-pound units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other except as specifically noted in Table 1. Combining values from the two systems may result in nonconformance with this specification.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

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 A01.05 on Steel Reinforcement.

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2. Referenced Documents

2.1 *ASTM Standards:*²

A 82 Specification for Steel Wire, Plain, for Concrete Reinforcement

A 185 Specification for Steel Welded Wire Reinforcement, Plain, for Concrete

A 496 Specification for Steel Wire, Deformed, for Concrete Reinforcement

A 497/A 497M Specification for Steel Welded Wire Reinforcement, Deformed, for Concrete

A 775/A 775M Specification for Epoxy-Coated Reinforcing Steel Bars

A 934/A 934M Specification for Epoxy-Coated Prefabricated Steel Reinforcing Bars

G 12 Test Method for Nondestructive Measurement of Film Thickness of Pipeline Coatings on Steel

2.2 *NACE International Standard:*

RP-287-87 Field Measurement of Surface Profile of Abrasive Blast-Cleaned Steel Surface Using a Replica Tape³

2.3 *Society for Protective Coatings Specifications:*

SSPC-SP 10 Near-White Blast Cleaning⁴

SSPC-VIS 1 Pictorial Surface Preparation Standards for Painting Steel Surfaces⁴

2.4 *Unified Facilities Guide Specification:*

NFGS 03200A Concrete Reinforcement⁵

2.5 *American Concrete Institute Specification:*

ACI 301 Specifications for Structural Concrete⁶

3. Terminology

3.1 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 NACE International, 1440 South Creek, Houston, TX 77084.

⁴ Available from Society for Protective Coatings, 40 24th Street, Pittsburgh, PA 15222.

⁵ Available from NFESC, 560 Center Drive, Port Hueneme, CA 93043.

⁶ Available from the American Concrete Institute, 38800 Country Club Drive, P.O. Box 9094, Farmington Hills, MI 48333-9094.

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

TABLE 1 Test Requirements

Wire Size No. MW or MD, mm	Wire Size No. W or D, in.	Mandrel Diameter, mm [in.]	Time to Complete, s (maximum)
6.5 to 39	1 to 6	twice the diameter of the wire being tested	15
>39	>6	four times the diameter of the wire being tested	45

3.1.1 *conversion coating, n*—a preparation of the blast-cleaned steel surface prior to coating application that is designed to pretreat the metal to promote coating adhesion, reduce metal/coating reactions, improve corrosion resistance, and increase blister resistance.

3.1.2 *disbonding, n*—loss of adhesion between the fusion-bonded epoxy coating and the steel reinforcement.

3.1.3 *fusion-bonded epoxy coating, n*—a product containing pigments, thermosetting epoxy resins, crosslinking agents, and other additives. It is applied in the form of a powder on a clean, heated, metallic substrate and fuses to form a continuous barrier coating.

3.1.4 *holiday, n*—a discontinuity in a coating that is not discernible to a person with normal or corrected vision.

3.1.5 *patching material, n*—a liquid, two-part epoxy coating used to repair damaged or uncoated areas.

3.1.6 *wetting agent, n*—a material that lowers the surface tension of water, allowing it to penetrate more effectively into small discontinuities in the coating, giving a more accurate indication of the holiday count.

4. Ordering Information

4.1 It shall be the responsibility of the purchaser to specify all requirements that are necessary for the coated wire and welded wire reinforcement under this specification. Such requirements to be considered include, but are not limited to, the following:

- 4.1.1 Wire or welded wire reinforcement specification and year of issue,
- 4.1.2 Wire size,
- 4.1.3 Wire spacing and sizes, if welded wire reinforcement,
- 4.1.4 Length and width of sheets or rolls,
- 4.1.5 Quantity,
- 4.1.6 Class and type of coating,
- 4.1.7 Requirements for the epoxy powder coating and provision of test data (5.2 and 5.3),
- 4.1.8 Requirements for patching material (5.4),
- 4.1.9 Quantity of patching material,
- 4.1.10 Specific requirements for test frequency (9.1),
- 4.1.11 Additional specimens to be provided to the purchaser for testing from the coated wire or welded wire reinforcement being furnished (12.1),
- 4.1.12 Whether a report on tests performed on the coated wire or welded wire reinforcement being furnished is required (15.2), and
- 4.1.13 Manufacturer qualification and certification requirements (if any).

NOTE 2—It is recommended that the manufacturing procedures and

processes be audited by an independent certification program for epoxy coating applicators plants, such as that provided by the Navy Facility Guide Specification or equivalent.

NOTE 3—A typical ordering description is as follows: 150 sheets 150 × 300 – MD 45 × MD 26 2440 mm (+0, +0) × 6.1 m [6 × 12 – W7.0 × W4.0 96 in. (+0, +0) × 20 ft] epoxy coated to Specification A 884/A 884M _____ Class A Type 2. Include written certifications for powder coating and coated WWR, and one patch kit.

5. Materials

5.1 Plain or deformed steel wire or welded wire reinforcement to be coated shall meet the requirements the applicable Specification, A 82, A 185, A 496, or A 497 as specified by the purchaser and shall be free of surface contaminants such as oil, grease, or paint when received at the manufacturer's plant and prior to cleaning and coating.

5.2 Type 1 coatings shall meet the requirements of and shall be qualified in accordance with Annex A1 of Specification A 775/A 775M. Type 2 coatings shall meet the requirements of and shall be qualified in accordance with Annex A1 of Specification A 934/A 934M. Upon request, the purchaser shall be provided with the test report for review.

5.2.1 A written certification shall be furnished to the purchaser that properly identifies the designation of each lot of powder coating used in the order, material quantity represented, date of manufacture, name and address of the powder coating manufacturer, and a statement that the supplied powder coating is the same composition as that qualified in accordance with 5.2.

5.2.2 The powder coating shall be stored in a temperature-controlled environment following the written recommendations of the powder coating manufacturer until ready for use. At this point, if the storage temperature is below the plant ambient temperature, the powder coating shall be given sufficient time to reach approximate plant ambient temperature. The powder coating shall be used within the powder coating manufacturer's written recommended shelf life.

5.3 If specified in the order, a representative 0.2 kg [8 oz] sample of the powder coating shall be supplied to the purchaser from each batch. The sample shall be packaged in an airtight container and identified by batch number.

5.4 If specified in the order, patching material, compatible with the coating and inert in concrete, and recommended by the coating manufacturer shall be supplied to the purchaser.

6. Surface Preparation

6.1 The surface of the steel wire or welded wire reinforcement to be coated shall be cleaned by abrasive blast cleaning to near-white metal in accordance with SSPC-SP10. The final surface condition shall be defined according to SSPC-VIS 1. Average blast profile maximum roughness depth readings of 40 to 100 μm [1.5 to 4.0 mils] as determined by replica tape measurements using NACE RP-287-87 shall be considered suitable as an anchor pattern.

NOTE 4—Abrasive blast cleaning of wire and welded wire reinforcement with a high degree (> 90 %) of grit in the cleaning media provides the most suitable anchor profile for coating adhesion. After grit has been recycled, a small portion will take on the appearance of shot.

NOTE 5—The use of a profilometer type surface measurement instrument which measures the peak count as well as the maximum profile depth is recommended.

6.2 Multidirectional, high-pressure, dry air knives shall be used after blasting to remove dust, grit, and other foreign matter from the steel surface. The air knives shall not deposit oil on the steel reinforcement.

NOTE 6—It is recommended that incoming wire and welded wire reinforcement and blast media should be checked for salt contamination prior to use. Blast media found to be salt contaminated should be rejected. Wire and welded wire reinforcement found to be salt contaminated from exposure to deicing salts or salt spray should be cleaned by acid washing or other suitable methods to remove salt contaminants from the surface prior to blast cleaning.

6.3 It shall be permissible for the manufacturer to use a chemical wash or conversion of the blast-cleaned steel reinforcement surface, or both, to enhance coating adhesion. This pretreatment shall be applied after abrasive cleaning and before coating, in accordance with the written application instructions specified by the pretreatment manufacturer.

7. Coating Application

7.1 The powder coating shall be applied to the cleaned and pretreated (if used) surface as soon as possible after surface treatments have been completed, and before visible oxidation of the surface occurs discernible to a person with normal or corrected vision. In no case shall application of the coating be delayed more than 3 h after cleaning.

7.2 The fusion-bonded epoxy powder coating shall be applied in accordance with the written recommendations of the manufacturer of the powder coating for initial steel surface temperature range and post-application cure requirements. During continuous operations, the temperature of the surface immediately prior to coating shall be measured using infrared guns or temperature-indicating crayons, or both, at least once every 30 min.

NOTE 7—The use of infrared and temperature-indicating crayon measurement of the reinforcement is recommended.

7.3 The coating shall be applied by electrostatic spray or other suitable method.

8. Requirements for Coated Wire or Welded Wire Reinforcement

8.1 Coating Thickness:

8.1.1 *Class A*—For acceptance purposes, at least 90 % of all coating thickness measurements after curing shall be $\geq 175 \mu\text{m}$ [7 mils]. A finding that more than 5 % of the coating thickness measurements are below $125 \mu\text{m}$ [5 mils] shall be considered cause for rejection.

8.1.2 *Class B*—For acceptance purposes, at least 90% of all coating thickness measurements after curing shall be $\geq 450 \mu\text{m}$ [18 mils], for both plain and deformed welded wire reinforcement for use in mechanically stabilized earth applications. A finding that more than 5 % of the coating thickness measurements are below $400 \mu\text{m}$ [16 mils] shall be considered cause for rejection.

8.1.3 A minimum of fifteen coating thickness measurements shall be taken approximately evenly spaced along each side of the coated wire or welded wire reinforcement test specimen.

8.1.4 Measurements shall be made in accordance with Test Method G 12 following the instructions for calibration and use recommended by the thickness gage manufacturer. Pull-off or fixed-probe gages shall be used. Pencil-type pull-off gages that require the operator to observe the reading at the instant the magnet is pulled from the surface shall not be used.

8.2 Coating Continuity:

8.2.1 There shall not be more than an average of three holidays per metre [one holiday per foot] on the coated wire (spool and individual lengths).

8.2.2 In welded wire reinforcement, there shall not be more than an average of 9 holidays per metre [3 holidays per foot] when the wire spacing is 100 mm [4 in.] or less, and there shall not be more than an average of 6 holidays per metre [2 holidays per foot] when the wire spacing is greater than 100 mm [4 in.]. When measuring the number of holidays, at least 13 mm [0.5 in.] of wire shall be included on each side of the intersection being checked. Damage at cut ends shall not be counted. Voids (uncoated areas) at welded intersections shall be counted. If more than one void is present within 13 mm [0.5 in.] of the intersection area, it shall be counted as one void.

8.2.3 Holiday checks to determine acceptability of the wire or welded wire reinforcement shall be made at the manufacturer's plant with a 67½-V, 80 000-Ω, wet-sponge-type dc holiday detector.

NOTE 8—Holiday detection is not intended for use at the job site.

8.3 Bend Test—Type 1 Coating Requirement Only:

8.3.1 The flexibility of the coating shall be evaluated by bending production coated steel wire and welded wire reinforcement at a uniform rate 180° (after rebound) around a mandrel of specified size as prescribed in Table 1. The test specimens shall be between 20 and 30°C [68 and 86°F].

8.3.2 Cracking or disbonding of the coating on the outside radius or wrinkling of the coating on the inside radius of the bent wire or welded wire reinforcement visible to a person with normal or corrected vision shall be considered cause for rejection of the coated wire or reinforcement represented by the bend test sample.

8.4 *Place of Testing*—Testing of coated steel wire or welded wire reinforcement shall be done at the manufacturer's plant prior to shipment.

8.5 *Time of Testing*—The requirements for coated wire or welded wire reinforcement shall be met at the manufacturer's plant prior to shipment.

9. Number of Tests

9.1 The purchaser shall have the option to specify the sampling and test schedule for the number and frequency of tests for coating thickness, flexibility, and continuity.

9.2 If the number and frequency of tests are not specified by the purchaser:

9.2.1 Tests for coating thickness and continuity shall be made on a minimum of 0.3 m [1 ft] of each size of wire or style of welded wire reinforcement coated during each production hour.

9.2.2 Bend tests for Type 1 coating flexibility shall be conducted on at least one wire of each size or style of welded wire reinforcement from each 2 h of production.