



Designation: A 497/A 497M – 05a

Standard Specification for Steel Welded Wire Reinforcement, Deformed, for Concrete¹

This standard is issued under the fixed designation A 497/A 497M; 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 welded wire reinforcement made from cold-worked drawn or rolled deformed wire, or a combination of deformed and non-deformed wires, to be used for the reinforcement of concrete.

NOTE 1—Welded wire for concrete reinforcement has been described by various terms: welded wire fabric, WWF, fabric, and mesh. The wire reinforcement industry prefers the term “welded wire reinforcement” (WWF) as being more representative of the range of products being manufactured. Therefore, the term “welded wire fabric” has been replaced with the term “welded wire reinforcement” in this specification and in other related specifications.

1.2 The values stated in either inch-pound or SI units are to be regarded as the 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. Combining values may result in nonconformance with the specification.

2. Referenced Documents

2.1 ASTM Standards:²

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

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

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

2.2 Military Standards:

MIL-STD-129 Marking for Shipment and Storage³

MIL-STD-163 Steel Mill Products Preparation for Shipment and Storage³

2.3 Federal Standard:

Fed. Std. No. 123 Marking for Shipments (Civil Agencies)³

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 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 Standardization Documents Order Desk, Building 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094.

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *convoluted wire, n*—when wire for welded wire reinforcement is shaped into a sinusoidal wave shape, it is commonly referred to as convoluted wire. The wire is used in the manufacture of cages for certain applications of concrete pipe reinforcing. Only non-deformed wire is normally subject to convolution.

3.1.2 *welded wire reinforcement, n*—as used within the scope and intent of this specification, welded wire reinforcement designates a material composed of cold-worked steel wire, fabricated into sheets or rolls by the process of electric resistance welding. The finished material shall consist essentially of a series of longitudinal and transverse wires arranged substantially at right angles to each other, and welded together at points of intersection.

4. Ordering Information

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

4.1.1 Quantity (weight or square area),

4.1.2 Name of material (deformed welded wire reinforcement for concrete),

4.1.3 Wire spacings and sizes,

4.1.4 Minimum yield strength if Supplement S1 of Specification A 496/A 496M A 496/A 496M applies; and minimum yield strength if wire conforming to Specification A 82/A 82M A 82/A 82M is to be used and Supplement S1 of Specification A 82/A 82M A 82/A 82M applies.

4.1.5 Yield strength measurement. The purchaser shall have the options described in Specification A 496/A 496M, section 13.3,

4.1.6 Request for outside inspection (if not requested, section 15.1 applies),

4.1.7 Exclusion of over-steeling, if required (see 9.4.1),

4.1.8 Length and width of sheets or rolls,

4.1.9 Packaging (see Section 15), and

4.1.10 ASTM designation and year of issue.

NOTE 2—A typical ordering description is as follows: 10 000 ft² welded deformed wire reinforcement for concrete, 100 × 300 – MD100 × MD40

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

2450 mm × 6 m [4 × 12 – D15 × D6 96 in. × 20 ft.] in secured bundles of flat sheets, to ASTM A 497 – ____.

5. Materials

5.1 The wire used in the manufacture of welded wire reinforcement shall conform to Specification A 496/A 496M A 496/A 496M and its Supplement S1 if so ordered, either solely or in combination with wire conforming to Specification A 82/A 82M A 82/A 82M and its Supplement S1 if so ordered.

5.2 Welded wire reinforcement shall be furnished either in flat sheets, or in rolls, as specified by the purchaser.

6. Manufacture

6.1 The wires shall be assembled by automatic machines or by other suitable mechanical means that will assure accurate spacing and alignment of all wires of the finished welded wire reinforcement.

6.2 Longitudinal and transverse wires shall be securely connected at every intersection by a process of electrical-resistance welding which employs the principle of fusion combined with pressure.

6.3 Wire of proper yield strength and quality when fabricated in the manner herein required shall result in a strong, serviceable mat-type product having substantially square or rectangular openings. It shall be fabricated and finished in a workmanlike manner, and shall conform to this specification.

NOTE 3—A variation of manufacturing includes the application of one or more longitudinal convoluted wires at one edge of welded wire reinforcement for concrete pipe reinforcing cages. This shape allows the cage ends to be expanded to a larger diameter to accommodate the bell-shaped ends of concrete pipe.

7. Mechanical Property Requirements

7.1 *Tensile*—Wire for the production of welded wire reinforcement, deformed, is described in Specification A 496/A 496M A 496/A 496M. Tensile tests shall be made on wire cut from the welded wire reinforcement and tested either across or between the welds; no less than 50 % shall be across welds. Tensile tests across a weld shall have the welded intersection located approximately at the center of the wire being tested and the cross wire forming the welded intersection shall extend approximately 25 mm [1 in.] beyond each side of the welded intersection.

NOTE 4—Tensile and bend testing are normally done at the time wire is drawn. The manufacturer's finished product shall meet the requirements of this specification and Specifications A 496/A 496M and A 82/A 82M if applicable.

7.2 *Bend Test*—The wire shall withstand the bend test as described in Specification A 496/A 496M A 496/A 496M and shall be performed on a specimen taken from between the welds.

7.3 *Weld Shear Strength*—The weld shear strength between longitudinal and transverse wires shall be tested as described in Section 8. The minimum average shear value in Newtons shall not be less than 241 multiplied by the nominal area of the larger wire in square millimeters [in pounds-force shall not be less than 35 000 multiplied by the nominal area of the larger

wire in square inches], where the smaller wire is not less than MD25 [D4] and has an area of 40 % or more of the area of the larger wire.

7.3.1 Welded wire reinforcement having a relationship of larger and smaller wires other than that covered in 7.3 shall meet an average weld shear strength requirement of not less than 3.6 kN [800 lbf] provided that the smaller wire is not smaller than MD26 [D4].

7.3.2 Weld-shear tests for determination of conformance to the requirements of 7.3 shall be conducted using a weld tester as described in Section 8.

7.3.3 Four welds selected at random from the specimen described in 10.2 shall be tested for weld shear strength. The transverse wire of each test specimen shall extend approximately 25 mm [1 in.] on each side of the longitudinal wire. The longitudinal wire of each test specimen shall be of such length below the transverse wire so as to be adequately engaged by the grips of the testing machine. It shall be of such length above the transverse wire that its end shall be above the center line of the upper bearing of the weld tester.

7.3.4 The material shall be deemed to conform to the requirements for weld shear strength if the average of the four samples complies with the value stipulated in 7.3. If the average fails to meet the prescribed value, all the welds across the specimen shall then be tested. The welded wire reinforcement shall be deemed acceptable if the average of all weld shear test values across the specimen meets the prescribed minimum value.

8. Weld Shear Test Apparatus and Methods

8.1 As the welds in welded wire reinforcement contribute to the bond and anchorage value of the wires in concrete, the weld acceptance tests shall be made in a weld tester that stresses the weld in a manner similar to which it is stressed in concrete. In order to accomplish this, the vertical wire in the weld tester shall be stressed in an axis close to its center line. Also the horizontal wire shall be held closely to the vertical wire, and in the same relative position, so as to prevent rotation of the horizontal wire. When the welded wire reinforcement is manufactured with different wire sizes, the larger diameter wire shall be the “vertical wire” when tested (see Fig. 1⁴).

8.2 The weld tester shown in Fig. 1 shall be hung in a ball and socket, or similar self aligning arrangement, at the center of the machine and used with an anvil sized such that it fully supports the horizontal wire and allows the vertical wire of the test specimen to move freely in the vertical direction. This, or a similarly effective fixture designed on the same principle, shall be acceptable.

8.3 Test specimens shall be inserted through the notch in the anvil using the smallest notch available in which the vertical wire fits loosely. The vertical wire shall be in contact with the surface of the free rotating rollers while the horizontal wire shall be supported by the anvil on each side of the slot. The bottom jaws of the testing machine shall grip the lower end of the vertical wire and the load shall be applied at a rate of stressing not to exceed 689 MPa/min [100 ksi/min].

⁴ A detailed drawing showing complete dimensions of the testing jig may be obtained from ASTM International Headquarters. Request ADJA0185.

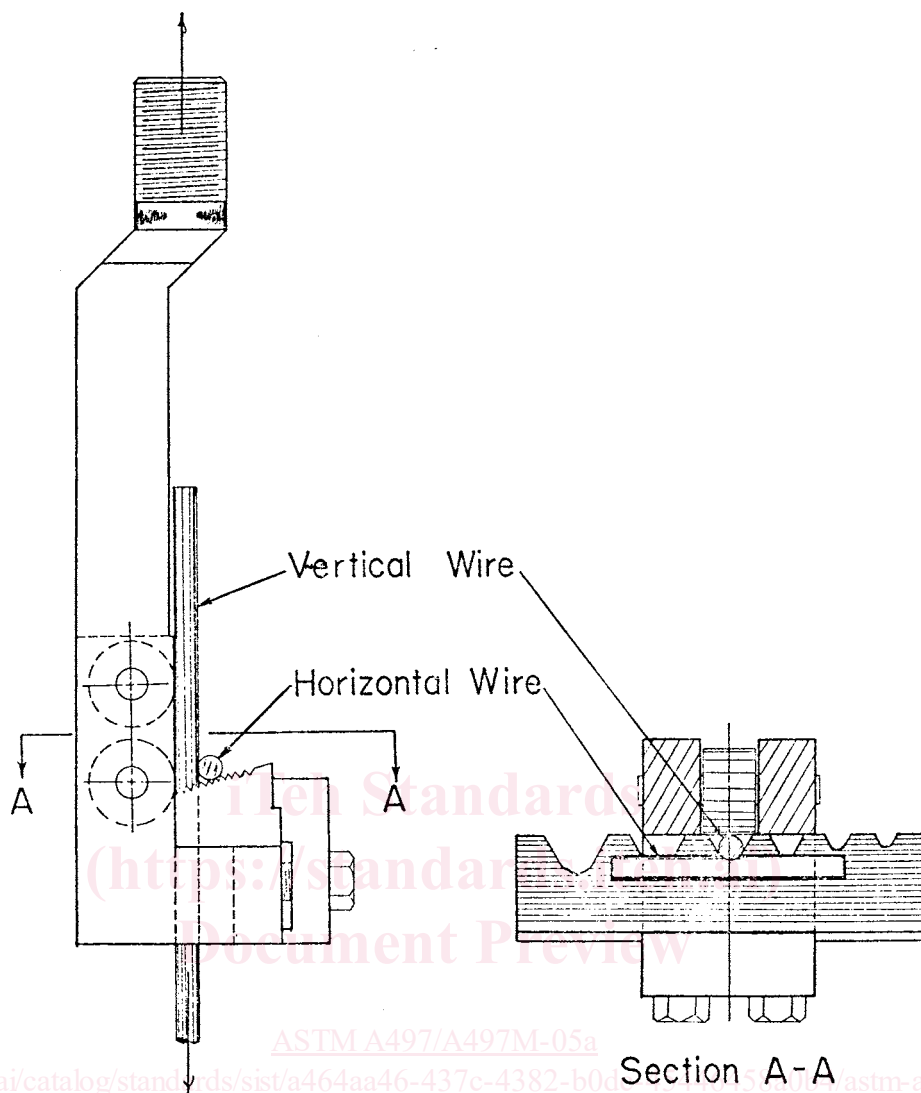


FIG. 1 Welded Wire Reinforcement Weld Tester

9. Dimensions

9.1 *Width*—The width of welded wire reinforcement shall be considered to be the center-to-center distance between outside longitudinal wires. The permissible variation shall not exceed 13 mm [0.5 in.] greater or less than the specified width. In case the width of flat sheets or rolls is specified as the overall width (tip-to-tip length of cross wires), the width shall not vary more than ± 25 mm [± 1 in.] from the specified width. When measurements involve a convoluted wire, the measurement shall be made to the approximate center of the sinusoidal wave shape.

9.2 *Length*—The overall length of flat sheets, measured on any wire, shall not vary more than ± 25 mm [± 1 in.], or 1 %, whichever is greater.

9.3 Overhang of the transverse wires shall not project beyond the centerline of each longitudinal edge wire more than a distance of 25 mm [1 in.], unless otherwise specified. When transverse wires are specified to project a specific length beyond the center line of a longitudinal edge wire, the permissible variation shall not exceed 13 mm [0.5 in.] greater or less than the specified length.

9.4 The permissible variation in weight of any wire in the finished welded wire reinforcement shall conform to the tolerances prescribed for the wire before fabrication, in Specification A 496/A 496M A 496/A 496M, with the following exceptions:

9.4.1 Unless otherwise precluded by the purchaser in 4.1, the manufacturer shall be permitted to apply over-sized wire. The size differential shall not exceed two “D” size increments on sizes MD52 [D8] and smaller, and four “D” size increments on sizes larger than MD52 [D8]. A “D” size increment is a whole number increment, for example, D5 to D6, or D5.4 to D6.4, and so forth. In all cases where such over-steeling is practiced, the manufacturer shall identify the welded wire reinforcement with the style originally ordered. With the permission of the purchaser, the manufacturer shall be permitted to exceed the limits of this section.

9.5 The average spacing of wires shall be such that the total number of wires contained in a sheet or roll is equal to or greater than that determined by the specific spacing, but the center-to-center distance between individual members shall not vary more than 6.35 mm [0.25 in.] from the specified spacing.