



Designation: A65 – 07

Standard Specification for Steel Track Spikes¹

This standard is issued under the fixed designation A65; 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.

1. Scope*

1.1 This specification covers steel track spikes used as fastenings between railroad rails, tie plates, and ties.

1.2 Three grades of spikes are described, Grades 1, a lower carbon steel; Grade 2, a higher carbon steel; and Grade 3, a carbon structural steel, conforming to Specification [A36/A36M](#).

1.3 Supplementary Requirement (S1) are provided for use and shall only apply when specified in the purchase order.

1.4 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

2. Referenced Documents

2.1 *ASTM Standards*:²

[A6/A6M Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling](#)
[A29/A29M Specification for Steel Bars, Carbon and Alloy, Hot-Wrought, General Requirements for](#)
[A36/A36M Specification for Carbon Structural Steel](#)
[A370 Test Methods and Definitions for Mechanical Testing of Steel Products](#)
[A700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Shipment](#)

2.2 *American Railway Engineering and Maintenance of Way Association Manual for Railway Engineering*:³
[Design of Cut Track Spike \(1963\), Chapter 5, Part 2](#)

3. Ordering Information

3.1 Orders for spikes under this specification shall include the following information as appropriate:

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 A01.01 on Steel Rails and Accessories.

Current edition approved May 1, 2007. Published May 2007. Original approved in 1916. Last previous edition approved in 2001 as A65 – 01. DOI: 10.1520/A0065-07.

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 American Railway Engineering and Maintenance of Way Assn (AREM), 8201 Corporate Drive, Suite 1125, Landover, MD 20785.

- 3.1.1 *Quantity* (weight),
- 3.1.2 *Grade* in accordance with 1.2 and [Table 1](#), [Table 2](#), [Table 3](#), [Table 4](#), [Table 5](#), and [Table 6](#),
- 3.1.3 *Design*—AREMA design (see [2.2](#)), or other, including drawings if required,
- 3.1.4 *Dimensions*—cross section and length,
- 3.1.5 *Supplementary Requirement* if to apply (see S 1) and [Table 1](#), and
- 3.1.6 *Certification and Test Report Requirements* (see [12.1](#)).

4. Manufacture

- 4.1 The steel shall be made by any of the following processes: electric-furnace or basic-oxygen.
- 4.2 The steel may be cast by a continuous process, or in ingots.

5. Chemical or Alternative Tension Test Requirements

5.1 The manufacturer has the option to furnish spikes from steel conforming to the heat or cast analysis described in [5.2](#), the alternative analysis described in [5.3](#), or the alternative tension test described in [5.4](#).

5.2 *Heat or Cast Analysis*—An analysis of each heat or cast shall be made by the manufacturer of the steel to determine the percentage of the elements specified in [Table 1](#). The analysis shall be made from a test sample taken preferably during the pouring of the heat or cast. The chemical composition thus determined shall conform to the requirements of [Table 1](#). All elements listed in [Table 1](#) shall be reported in the test analysis to the purchaser when requested.

5.3 *Alternative Analysis*—When the heat or cast analysis of the steel cannot be furnished and the spike manufacturer elects to offer the material on the basis of chemical composition, an analysis of three finished spikes selected at random from each 10-ton (9-Mg) lot shall be made by the manufacturer and the separate chemical compositions shall conform to the requirements of [Table 1](#). The product analysis for specified elements shall conform to the permitted variations in Table B of Specification [A6/A6M](#).

5.4 *Alternative Tension Test*—The manufacturer of the spikes may, at his option, elect to substitute a tension test for the chemical analysis specified in [5.2](#) or [5.3](#). The tension test results determined on one full size spike selected at random from each 10-ton (9-tonne) lot of finished spikes or fraction

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

TABLE 1 Chemical Requirements

Element	Grade 1	Grade 2	Grade 3
Carbon	0.12 min	0.30 min	0.26 max
Manganese	... ^A090 max
Phosphorous	0.04 max	0.04 max	0.04 max
Sulfur	0.05 max	0.05 max	0.05 max
Silicon	0.40 max
Copper	^B	^B	^B
Chromium
Nickel
Molybdenum
Vanadium

^AWhere an ellipses is shown, there is no requirement, but the element shall be reported in the test analysis.

^BThe purchaser can specify a minimum copper content of 0.20 %.

TABLE 2 Product Analysis

Element ^A	Allowance Beyond Limits of Specified Chemical Analysis	
	% under min limit	% over max limit
Carbon	0.03	0.04
Managanese	0.06	0.08
Phosphorous	...	0.010
Sulfur	...	0.010
Silicon	...	0.05

^AFor other elements not listed in this table, the permitted variations of Table B in Specification A6/A6M shall apply.

TABLE 3 Tension Test Requirements

Property	Grade 1	Grade 2	Grade 3
Yield point , min, psi MPa	27 500 (190)	35 000 (240)	36 000 (240)
Tensile strength, min, psi MPa	55 000 (380)	70 000 (485)	58 000 (400)
Elongation in 2 in. or 50 mm, min %	25	25	23

TABLE 4 Bend Test Requirements

	Grade 1	Grades 2 and 3
Body bend, cold	180°—flat on itself	120°—around pin of diameter not greater than spike thickness
Head bend, cold	backward to the line of the face	backward to an angle of 55° with face

thereof, and tested in accordance with Test Methods A370, shall conform to the properties listed in Table 3.

5.5 *Product Analysis*—An analysis may be made by the purchaser from a sample taken from a finished spike representing each heat or cast, or 10-ton (9-tonne) lot if spikes are furnished in accordance with 5.3. The chemical composition thus determined shall conform to the requirements in Table 1 and Table 2.

6. Bend Requirements

6.1 *Body Bend*—The body of a full-size finished spike shall withstand the bend test described in Table 4 without cracking on the outside of the bent portion.

6.2 *Head Bend*—The head of a full-size finished spike shall withstand the bend test described in Table 4 without showing evidence of forging laps.

6.3 *Number of Tests*—One bend test of each type specified in 6.1 and 6.2 shall be made from each 5-ton (4.5-tonne) lot of finished spikes or fraction thereof.

7. Dimensions and Permissible Variations

7.1 The finished spikes shall conform to the dimensions specified by the purchaser, subject to the permissible variations prescribed in Table 5.

8. Workmanship, Finish, and Appearance

8.1 The finished spikes shall be straight, with well-formed heads and sharp points and shall be free of injurious and other imperfections not consistent with good commercial practice.

9. Retests

9.1 If, during the tension or bend tests, a previously undiscovered material or manufacturing flaw should be disclosed that interferes with the test or the interpretation of results, the substitution of another sample spike shall be permitted after it is demonstrated to the satisfaction of the purchaser or his representative, that the condition is not typical of the remainder of the lot.

9.2 Spikes represented by tests that fail to meet the requirements prescribed in 5.4, 6.1, and 6.2 may be treated and resubmitted for test.