



Designation: A 911/A 911M – 99

Standard Specification for Uncoated, Stress-Relieved Steel Bars for Prestressed Concrete Railroad Ties¹

This standard is issued under the fixed designation A 911/A 911M; 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 uncoated stress-relieved steel bars for use in prestressed concrete railroad ties.

1.2 Supplement I describes low-relaxation bars and relaxation testing for that product. Low-relaxation bars shall be furnished when specifically ordered, and may be furnished in place of regular bars if mutually agreed to by the purchaser and manufacturer.

1.3 This specification is applicable for orders in either inch-pounds units (as Specification A 911) or in SI units (as Specification A 911M).

1.4 The values stated in either inch-pound units or SI units are to be regarded separately as standards. Within the text, the SI 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 from the two systems may result in nonconformance with the specification.

2. Referenced Documents

2.1 ASTM Standards:

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products²

E 328 Methods for Stress-Relaxation Tests for Materials and Structures³

2.2 Federal Standard:

Fed. Std. No. 123 Marking for Shipments (Civil Agencies)⁴

2.3 Military Standards:

MIL-STD-129 Marking for Shipment and Storage⁴

MIL-STD-163 Steel Mill Products Preparation for Shipment and Storage⁴

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *lot, n*—all the coils of bars of the same nominal bar size contained on an individual shipping release or shipping order, from the same cast or heat of steel.

4. Ordering Information

4.1 It shall be the responsibility of the purchaser to specify all requirements that are necessary for bars ordered to this specification. Such requirements shall include, but are not limited to, the following:

4.1.1 Quantity (weight) [mass],

4.1.2 Name of material (uncoated, stress-relieved bars for prestressed concrete railroad ties),

4.1.3 Diameter of bar (inches) [millimetres],

4.1.4 Packaging,

4.1.5 ASTM designation and year of issue, and

4.1.6 Special requirements, if any.

NOTE 1—A typical ordering description is as follows: 100 tons [90 t] uncoated, stress-relieved steel bars for prestressed concrete railroad ties, 0.394-in. [10-mm] diameter bars in 6.5-ft [2.0-m] diameter coils to ASTM A XXX – [A XXXM –].

5. Manufacture

5.1 The bars shall be made from properly identified heats of steel made by the electric-furnace, the open-hearth, or the basic oxygen process.

5.2 After hot-rolling, the bars shall be cold-drawn and finally stress-relieved by induction heat treatment to produce the desired mechanical properties and then coiled.

6. Chemical Requirements

6.1 An analysis of each heat of steel shall be made by the manufacturer from test samples taken during the pouring of each heat.

6.2 The analysis of the steel shall conform to the chemical requirements specified in Table 1.

¹ This specification is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.05 on Steel Reinforcement.

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² Annual Book of ASTM Standards, Vol 01.03.

³ Annual Book of ASTM Standards, Vol 03.01.

⁴ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.



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TABLE 1 Chemical Requirements

| Element | Composition, % |
|-----------------|------------------------|
| Carbon | 0.70–0.90 ^A |
| Silicon | 0.10–0.35 |
| Manganese | 0.50–0.90 ^B |
| Chromium, max | 0.15 |
| Phosphorus, max | 0.030 |
| Sulphur, max | 0.035 |
| Copper, max | 0.30 |

^ACarbon in any one lot shall not vary more than 0.13 %.

^BManganese in any one lot shall not vary more than 0.30 %.

7. Mechanical Requirements

7.1 Test Method—Tests shall be made in accordance with Test Methods and Definitions A 370, including Annex A4, using full-size bar specimens taken from either end of the coil of the finished product.

7.2 Tensile Strength—The minimum tensile strength of the finished bar, as represented by test specimens, shall conform to the requirements prescribed in Table 2.

7.3 Yield Strength—Yield strength shall be measured at 1 % extension under load. The load at this extension is recorded as yield strength and shall meet the requirements of Table 2.

7.4 Elongation—The total elongation after rupture shall not be less than 6.0 % and shall be measured in a gage length of 4 in. [100 mm].

7.5 Wrapping Test—Bars shall withstand being wound around a mandrel with a diameter of five times the bar diameter without cracking or other surface defects occurring on the outside of the bent portion. The bar shall be bent around the mandrel 1½ turns beginning with a 90° bend.

8. Dimensions and Permissible Variations

8.1 The size of the finished bar shall be expressed as the nominal diameter of the bar in decimals of an inch [millimeter]. The required initial diameters before cold-drawing, and the final diameters after cold-drawing shall be as follows:

| Initial Diameter | Final Diameter |
|---------------------|---------------------|
| 0.591 in. [15 mm] | 0.370 in. [9.4 mm] |
| 0.614 in. [15.6 mm] | 0.394 in. [10 mm] |
| 0.654 in. [16.6 mm] | 0.413 in. [10.5 mm] |

8.2 Permissible Variations in Diameter:

8.2.1 All bars shall conform to a size tolerance of ± 0.002 in. [± 0.05 mm] from the nominal diameter.

8.3 Out of Round—The difference between the largest and smallest diameter, measured at the same section, shall not be greater than 0.002 in. [0.04 mm].

9. Workmanship, Finish, and Appearance

9.1 Joints:

TABLE 3 Relaxation Requirements

| f_{pi}/f_{pu} ^A | Max Stress Losses after 1000 h, % |
|------------------------------|-----------------------------------|
| 0.50 | 1.0 |
| 0.60 | 1.0 |
| 0.70 | 2.5 |
| 0.80 | 5.0 |

^A f_{pi} = initial prestress load, and

f_{pu} = specified minimum tensile strength.

9.1.1 There shall be no welds or joints in the finished bar. Any welds or joints made during manufacture to promote continuity of operations shall be removed.

9.2 The finished bar shall be uniform in diameter in conformance with Section 8 and shall be free of imperfections not consistent with good commercial practice.

9.3 Straightness—After uncoiling, there shall be no residual out of line deformation greater than 0.4 in. [10 mm] in a length of 40 in. [1000 mm].

10. Sampling

10.1 Test specimens may be taken from either end of the coil. Any specimen found to contain a joint should be discarded and a new specimen obtained.

11. Number of Tests

11.1 One test specimen each for the tensile test and the wrapping test shall be taken for each 10 coils or fraction thereof in a lot.

12. Inspection

12.1 The purchaser shall be allowed to request that a representative inspect or witness the inspection and testing of the material prior to shipment. Such agreement shall be made by the purchaser and manufacturer as part of the purchase contract.

12.2 When such inspection or witness of inspection and testing is agreed upon, the purchaser's representative shall be afforded reasonable access to facilities to assure that the material meets the requirements of this specification. Inspection and tests shall be conducted so as to avoid unnecessary interference with the manufacturer's operations.

13. Rejection and Rehearing

13.1 Failure of any test specimen to comply with the requirements of this specification shall constitute grounds for rejection of the lot represented by the specimen.

13.2 The manufacturer shall be allowed to resubmit the lot for inspection by testing a sample from each reel and sorting out nonconforming material.

13.3 In the event that testing of any individual sample results in a reasonable doubt as to the ability of the bar to satisfy any requirement of this specification, two additional tests shall be made on samples of bar from the same reel, and if failure occurs in either of these tests, the represented coil shall be rejected.

14. Certification

14.1 In the event that outside inspection is waived, a manufacturer's certification that the material has been tested in

TABLE 2 Mechanical Requirements

| | |
|--|--------------------|
| Yield strength, min | 200 ksi [1375 MPa] |
| Tensile strength, min | 228 ksi [1570 MPa] |
| Ratio of yield strength to tensile strength, max | 0.95 |
| Elongation after rupture in a gage length of 4 in. [100 mm], min | 6.0 % |
| Reduction of area, min | 30.0 % |