



Designation: E 574 – 00

Standard Specification for Duplex, Base Metal Thermocouple Wire With Glass Fiber or Silica Fiber Insulation¹

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1. Scope

1.1 This specification sets forth the requirements for duplex, types E, J, K, N and T thermocouple wire, insulated with E-glass, S-glass, amorphous silica fiber or polycrystalline fiber.

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. They may not be exact equivalents, but either may be used as given.

1.3 *This standard does not purport to address all of the safety problems, 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.*

2. Referenced Documents

2.1 ASTM Standards:

D 1125 Test Methods for Electrical Conductivity and Resistivity of Water²

E 207 Test Method for Thermal EMF Test of Single-Thermoelement Materials by Comparison with a Reference Thermoelement of Similar Emf-Temperature Properties³

E 220 Test Method for Calibration of Thermocouples by Comparison Techniques³

E 230 Specification and Temperature-Electromotive Force (Emf) Tables for Standardized Thermocouples³

E 344 Terminology Relating to Thermometry and Hydrometry³

3. Terminology

3.1 *Definitions*—The definitions given in Terminology E 344 shall apply to this standard.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *amorphous silica fiber, n*—a continuous filament of heat insulating material whose principal constituent is amorphous silica.

3.2.2 *duplex wire, n*—a matched pair of parallel, solid thermoelements, individually insulated (double wrap or braid) with insulating fibers and a fiber braid of the same material overall.

3.2.3 *E-glass, n*—a family of calcia-alumina-silicate glasses that are used for general purposes and most electrical applications.

3.2.4 *impregnate, vt*—to saturate the fiber insulation of wires with a high-temperature electrical insulating compound to form a moisture barrier around the wires and to inhibit fraying of the fibers.

3.2.5 *polycrystalline fiber, n*—a continuous polycrystalline filament of heat insulating material whose composition is alumina, boria, and silica in an approximate ratio of 3:1:2, respectively.

3.2.6 *S-glass, n*—a family of magnesia-alumina-silicate glasses with a higher tensile strength and higher softening temperature than E-glass.

4. Significance and Use

4.1 This specification presents the requirements for impregnated and non-impregnated fiber insulated thermocouple wire for normally accepted industrial use, but does not attempt to define such usage.

4.2 A supplement contains the requirements for insulated thermocouple wire that will be exposed to high humidity. The purchase order or inquiry shall specify if this supplement is required.

5. Classification

5.1 *Class A—Duplex*—E-glass fiber insulated, impregnated with a high-temperature electrical insulating compound and color coded in accordance with ANSI/ASTM Specification E 230.

5.2 *Class B—Duplex*—E-glass fiber insulated (Note 1) not impregnated and not color coded.

¹ This specification is under the jurisdiction of ASTM Committee E20 on Temperature Measurement and is the direct responsibility of Subcommittee E20.04 on Thermocouples.

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² *Annual Book of ASTM Standards*, Vol 11.01.

³ *Annual Book of ASTM Standards*, Vol 14.03.

5.3 *Class C–Duplex*—Amorphous silica fiber insulated (Note 2) not impregnated and not color coded.

5.4 *Class D–Duplex*—Polycrystalline fiber insulated (Notes 2 and 3) not impregnated and not color coded.

5.5 *Class E–Duplex*—S-glass fiber insulated, impregnated with a high-temperature electrical insulating compound and color coded in accordance with ANSI/ASTM Specification E 230.

5.6 *Class F–Duplex*—S-glass fiber insulated (Note 1) not impregnated and not color coded.

NOTE 1—May be heat treated to retard fraying when specified in ordering information (6.1.8).

NOTE 2—Fibers may be pre-treated with an organic compound to facilitate braiding.

NOTE 3—May be heat cleaned after braiding to remove organic compound when specified in ordering information (6.1.8).

6. Ordering Information

6.1 The purchase order shall specify the following information:

- 6.1.1 Total insulated wire length,
- 6.1.2 Thermocouple type,
- 6.1.3 Tolerance on initial values of emf versus temperature (standard or special),
- 6.1.4 Class of insulation,
- 6.1.5 Thermoelement diameter,
- 6.1.6 Minimum acceptable continuous length per spool, if applicable,
- 6.1.7 Supplementary testing, if required (see Supplementary Requirements),
- 6.1.8 Special requirements (if any),
- 6.1.9 Deviations or special requirements not covered herein, and
- 6.1.10 Required documentation (see Section 9).

7. Technical Requirements

7.1 Insulated Thermocouple Wire:

7.1.1 *Materials*—Thermoelements shall be solid thermocouple grade materials with a smooth, bright finish (Note 4) and shall be fully annealed prior to insulating.

NOTE 4—An optional copper-flash coating on the iron thermoelement is permitted to prevent rusting. This coating must be applied uniformly so inhomogeneity is not introduced.

7.1.2 *Sizes*—Thermoelements shall be specified in American Wire Gage (AWG) nomenclature. Corresponding thermoelement diameters shall be as listed in Table 1.

7.1.3 Calibration:

7.1.3.1 *Standard Method*—When required by the purchase order, calibration of the insulated thermocouple wire shall be performed by one of the procedures described in Test Method E 207 or Test Method E 220.

7.1.3.2 *Thermoelement Initial Calibration Tolerances*—Standard and special tolerances on initial values of emf versus temperature are given in Table 1 of ANSI/ASTM Specification E 230. The purchase order shall specify whether standard or special tolerances are required.

7.2 Insulation Materials:

7.2.1 Individual thermoelements shall be covered with a braid, or double wrap (one wrap in each direction) of glass fibers (Classes A and E), a braid of glass fibers (Classes B and F), or braid of fibers (Classes C and D).

7.2.2 The outer covering shall consist of a braid of the same material applied over the bare thermoelements.

7.2.3 For Classes A and E duplex thermoelements, the insulation on the individual thermoelements and the outer braid shall be impregnated with a moisture and heat-resistant electrical insulating compound. The fibers shall be bonded sufficiently to each other to prevent fraying under normal conditions of installation and service.

7.2.4 Each individual Class A and E thermoelement wrap or braid and the outer braid shall be color coded in accordance with ANSI/ASTM Specification E 230.

7.2.5 The purchase order may specify that an enamel coating be applied to each bare thermoelement designated as Class A and Class E.

7.2.6 Classes B, C, D and F insulated thermoelements are supplied without impregnation, color coding, or enamel (Notes 1-4).

7.2.7 Insulating materials shall be suitable for continuous use to the temperatures listed in Table 2.

7.2.8 The amount of insulation coverage affects the durability and abrasion resistance of the insulating material. Application conditions should be discussed with the manufacturer to address these needs.

7.3 Dimensions and Finish:

7.3.1 The maximum outside transverse dimension, including outer covering, of insulated duplex thermocouple wire shall not exceed the dimensions given in Table 1.

7.3.2 The duplex insulated thermocouple wire shall be capable of being wound around a mandrel having a diameter of

TABLE 1 Maximum Outside Transverse Dimensions of Insulated Wire

Uninsulated Thermoelement Diameter		Maximum Outside Dimensions				
Gage (AWG)	Nominal Diameter		Classes A, B, E and F		Classes C and D	
	mm	(in.)	mm	(in.)	mm	(in.)
20	0.8	(0.032)	2.7	(0.105)	4.5	(0.180)
22	0.6	(0.025)	2.3	(0.090)	4.1	(0.160)
24	0.5	(0.020)	2.1	(0.080)	3.8	(0.150)
30	0.3	(0.010)	1.7	(0.065)	none	

TABLE 2 Maximum Recommended Continuous Use Temperatures for Insulating Materials

Materials	Temperature	Comment
Enamels and impregnants	200°C (400°F)	May be used to 500°C (930°F) with decomposition and color loss in hot zone
E-Glass fibers (not impregnated)	340°C (650°F)	Retains 75 % of tensile strength, softens at 730°C (1350°F)
S-Glass fibers (not impregnated)	395°C (750°F)	Retains 80 % of tensile strength, softens at 850°C (1560°F)
Amorphous silica fibers (not impregnated)	980°C (1800°F)	None
Polycrystalline fibers (not impregnated)	1250°C (2200°F)	None