
**Steel for the prestressing of
concrete —**

**Part 4:
Strand**

Acier pour armatures de précontrainte —

Partie 4: Torons

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ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Email: copyright@iso.org
Website: www.iso.org

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Contents

Page

Foreword	iv
1 Scope	1
2 Normative reference	1
3 Terms and definitions	1
4 Conditions of manufacture	1
4.1 Steel.....	1
4.2 Stress-relieving heat treatment.....	1
4.3 Compacted strand.....	2
4.4 Welds.....	2
4.4.1 2-wire and 3-wire strand.....	2
4.4.2 7-wire and 19-wire strand.....	2
4.5 Cracks.....	2
4.6 Finishing and appearance.....	2
5 Strand configuration	2
6 Properties	3
6.1 Dimensions, masses and strength of strand.....	3
6.2 Elongation and ductility.....	3
6.3 Relaxation.....	3
6.4 Fatigue.....	3
6.5 Stress corrosion.....	3
6.6 Deflected tensile test.....	3
7 Designation	5
8 Delivery conditions	5
8.1 General.....	5
8.2 Reel dimension.....	5
8.3 Curvature of strand.....	6
Annex A (informative) Considerations on stress corrosion	7
Annex B (informative) Deflected tensile strength	8
Bibliography	9

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 16, *Steels for the reinforcement and prestressing of concrete*.

This second edition cancels and replaces the first edition (ISO 6934-4:1991), which has been technically revised. It also incorporates the Technical Corrigenda ISO 6934-4:1991/Cor 1:1992 and ISO 6934-4:1991/Cor 1:2000.

The main changes compared to the previous edition are as follows:

- subclause [4.6](#) has been added to introduce finishing and appearance;
- [Figure 1](#) has been updated;
- subclause [6.5](#) and [Annex A](#) have been added to introduce and elaborate on stress corrosion;
- subclause [6.6](#) and [Annex B](#) have been added to introduce and elaborate on deflected tensile test;
- [Table 1](#) has been updated;
- in [Clause 7](#), the terminology "newtons per square millimetre" has been replaced with "MPa";
- in [Clause 8](#), packing and protection requirements has been added.

A list of all parts in the ISO 6934 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Steel for the prestressing of concrete —

Part 4: Strand

1 Scope

This document specifies requirements for steel strand which has been given a stress-relieving heat treatment according to the general requirements specified in ISO 6934-1. This document covers 10 grades of steel strand for use in prestressed concrete construction; each strand can contain either 2, 3, 7 or 19 individual wires. In case of any conflict between the requirements of this document and ISO 6934-1, the requirements of document prevail.

2 Normative reference

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 6934-1, *Steel for the prestressing of concrete — Part 1: General requirements*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 6934-1 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at <https://www.iso.org/obp>

— IEC Electropedia: available at <http://www.electropedia.org/>

3.1

compacted strand

strand which has been compressed (e.g. by cold working after stranding) and given a stress-relieving heat treatment before winding into reel form

4 Conditions of manufacture

4.1 Steel

The strand shall be manufactured from steel wire in accordance with ISO 6934-1.

4.2 Stress-relieving heat treatment

The strand shall be subjected to a low-temperature heat treatment as a continuous linear process by unreeling and running the strand through a suitable form of heating (see ISO 6934-1).

The strand shall be rewound into reels or onto reels having a core diameter which is sufficiently large to ensure that the strand shall be reasonably straight when unreeled (see 8.3).

4.3 Compacted strand

The 7-wire strand shall conform with [4.2](#) before drawing.

After drawing and stress-relieving heat treatment, the strand shall have a pitch of 14 to 18 times the nominal strand diameter.

4.4 Welds

4.4.1 2-wire and 3-wire strand

The wire from which the strand is manufactured shall not contain welds.

4.4.2 7-wire and 19-wire strand

There shall be no strand joints, or strand splices in any length of the finished strand, unless specifically agreed by the purchaser.

During the process of manufacture of individual wires for stranding, welding is permitted only prior to or at the diameter used during the last thermal treatment. There shall be no welds in the wire after it has been drawn through the first die in the wire drawing. If agreed upon by the purchaser, butt-welded joints may be made in the individual wires during manufacture of the strand, provided there is not more than one such joint in any 45 m section of the finished strand.

4.5 Cracks

Longitudinal cracks with a depth less than 4 % of the diameter of the component wires shall not be considered as defects.

4.6 Finishing and appearance

The finished strand shall be uniform in diameter and shall be free of imperfections not consistent with good commercial strand practices.

The strand shall not be oiled or greased. Slight rusting, provided it is not sufficient to cause pits visible to the unaided eye, shall not be cause for rejection.

When the strand is cut without seizings, the wire shall not fly out of position. If any wire flies out of position and can be replaced by hand, the strand shall be considered satisfactory.

5 Strand configuration

The following requirements apply in addition to those of ISO 6934-1.

In 2-wire and 3-wire strand, the individual wires shall be of the same nominal diameter and the pitch shall be 12 to 22 times the nominal strand diameter.

In 7-wire strand, the diameter of the straight centre-wire shall be at least 2 % greater than the diameter of the outer helical wires. The latter shall be tightly spun around the centre wire, with a pitch between 12 and 18 times the nominal strand diameter.

The direction of lay shall be subject to agreement between the manufacturer and purchaser.

In 19-wire strand, the configuration shall be 9 + 9 + 1 Seale strands or 12(6 + 6) + 6 + 1 Warrington strands, and the pitch shall be 12 to 22 times the nominal strand diameter as shown in [Figure 1](#).