



~~Designation: A933/A933M-07~~ Designation: A933/A933M – 10

# ~~Standard Specification for Vinyl (PVC) Coated Steel Wire and Welded Wire Fabric for Reinforcement~~ Standard Specification for Vinyl-Coated Steel Wire and Welded Wire Reinforcement<sup>1</sup>

This standard is issued under the fixed designation A933/A933M; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## 1. Scope\*

~~1.1 This specification covers plain and deformed steel wire and plain and deformed steel welded wire fabric reinforcement with protective vinyl (PVC, polyvinyl (polyvinyl chloride, or polyvinyl chloride powder compound) coating. Class A is intended for use as reinforcement in concrete and Class B as reinforcement in earth. A Class A minimum coating thickness is required for wire and welded wire reinforcement intended for use in concrete and masonry. A Class B minimum coating thickness is required for wire and welded wire reinforcement intended for use in mechanically stabilized earth applications.~~

1.2 Other thermoplastic organic coatings may be used provided they meet the requirements of this specification.

NOTE 1—The coating applicator is identified throughout this specification as the manufacturer.

1.3 Requirements for coatings are contained in Annex A1.

~~1.4 This specification is applicable for orders in either inch-pound units (as Specification A933) or in SI units [as Specification A933M].~~

~~1.5 The values stated in either inch-pound or SI units are to be regarded as standard. 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 this specification.~~

1.4 Requirements for patching materials are contained in Annex A2.

1.5 The text of this specification contains notes or footnotes, or both, that provide explanatory material. Such notes and footnotes, excluding those in tables or figures, do not contain any mandatory requirements.

1.6 This specification is applicable for orders in either inch-pound units (as Specification A933) or in SI units [as Specification A933M].

1.7 The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

## 2. Referenced Documents

2.1 *ASTM Standards:*<sup>2</sup>

A82/A82M [Specification for Steel Wire, Plain, for Concrete Reinforcement](#)

A185/A185M [Specification for Steel Welded Wire Reinforcement, Plain, for Concrete](#)

A496/A496M [Specification for Steel Wire, Deformed, for Concrete Reinforcement](#)

A497/A497M [Specification for Steel Welded Wire Reinforcement, Deformed, for Concrete](#)

~~A775/A775M~~

~~A775/A775M~~ [Specification for Epoxy-Coated Steel Reinforcing Bars](#)

A884/A884M [Specification for Epoxy-Coated Steel Wire and Welded Wire Reinforcement](#)

A1064/A1064M [Specification for Steel Wire and Welded Wire Reinforcement, Plain and Deformed, for Concrete](#)

B117 [Practice for Operating Salt Spray \(Fog\) Apparatus](#)

D374 [Test Methods for Thickness of Solid Electrical Insulation](#)

D2240 [Test Method for Rubber Property Durometer Hardness](#)

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

Current edition approved March 1, 2007-2010. Published March 2007-November 2010. Originally approved in 1995. Last previous edition approved in 2001-2007 as ~~A993/A993M-95(2001)-A993/A993M-07~~. DOI: 10.1520/A0933\_A0933M-107.

<sup>2</sup> 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.

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

D2967 [Test Method for Corner Coverage of Powder Coatings](#)

D4060 [Test Method for Abrasion Resistance of Organic Coatings by the Taber Abraser](#)

G8 [Test Methods for Cathodic Disbonding of Pipeline Coatings](#)

G12 [Test Method for Nondestructive Measurement of Film Thickness of Pipeline Coatings on Steel](#)

G14 [Test Method for Impact Resistance of Pipeline Coatings \(Falling Weight Test\)](#)

G20 [Test Method for Chemical Resistance of Pipeline Coatings](#)

2.2 *National Association of Corrosion Engineers Standards:*<sup>3</sup>

RP-287-87 [Field Measurement of Surface Profile of Abrasive Blast Cleaned Steel Surface Using a Replica Tape](#)

TM-01-70 [Visual Standard for Surfaces of New Steel Air Blast Cleaned with Sand Abrasive \(NACE No. 2\)](#)

TM-01-75 [Visual Standard for Surfaces of New Steel Centrifugally Blast Cleaned with Steel Shot or Steel Grit \(NACE No. 2\)](#)

2.3 *Steel Structures Painting Council Specifications:*<sup>4</sup>

SSPC-PA2 [Measurement of Dry Coating Thickness with Magnetic Gages](#)

SSPC-SP10-85SSPC-SP 10 [Near-White Blast Cleaning](#)

SSPC-Vis1-67SSPC-Vis 1 [Pictorial Surface Preparation Standards for Painting Steel Surfaces](#)

SSPC-Vis2-82TStandard Methods of Evaluating Degree of Rusting on Painted Steel Surfaces

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<sup>3</sup> Available from National Association of Corrosion Engineers (NACE), 1440 South Creek Dr., Houston, TX 77084-4906, <http://www.nace.org>.

<sup>4</sup> Available from Society for Protective Coatings (SSPC), 40 24th St., 6th Floor, Pittsburgh, PA 15222-4656, <http://www.sspc.org>.

~~2.4 American Concrete Institute Standards:~~

~~ACI301 Specifications for Structural Concrete (American Concrete Institute) SSPC-Vis 2 Standard Methods of Evaluating Degree of Rusting on Painted Steel Surfaces~~

### 3. Terminology

#### 3.1 Definitions of Terms Specific to This Standard:

3.1.1 *conversion coating, n*—a preparation of the blast-cleaned steel surface prior to coating application that is designed to pretreat the metal to promote coating adhesion, reduce metal/coating reactions, improve corrosion resistance, and increase blister resistance.

3.1.2 *disbonding, n*—loss of adhesion between the fusion-bonded ~~V~~ vinyl coating and the steel reinforcement.

3.1.3 ~~fusion-bonded vinyl coating~~ *fusion-bonded vinyl coating, n*—a product containing pigments, thermoplastic ~~Vinyl~~ vinyl resin, and other additives. It is applied in the form of a powder on a clean, heated, metallic substrate and fuses to form a continuous barrier coating.

3.1.4 *holiday, n*—a discontinuity in a coating that is not discernible to a person with normal or corrected vision.

3.1.5 *patching material, n*—a liquid ~~Vinyl~~ vinyl coating used to repair damaged or uncoated areas.

### 4. Ordering Information

#### 4.1 The purchaser shall specify:

4.1.1 Wire or welded wire fabric specification;

4.1.2 Wire size;

4.1.3 Wire spacing and sizes, if welded wire fabric;

4.1.4 Length and width of sheets or rolls;

4.1.5 Quantity; and

4.1.6 Class of coating.

#### 4.2 The purchaser will specify:

4.2.1 Requirements for material samples (

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

4.1.1 Name of material (vinyl-coated steel wire or welded wire reinforcement),

4.1.2 Wire or welded wire reinforcement specification (5.1),

4.1.3 Wire size, if wire reinforcement,

4.1.4 Wire spacing and sizes, if welded wire reinforcement,

4.1.5 Length and width of sheets or rolls,

4.1.6 Quantity,

4.1.7 Class of coating,

4.1.8 Requirements for material samples (5.3),

4.2.2 Requirements 4.1.9 Requirements for patching material (5.4),

4.2.3 Requirements 4.1.10 Requirements for visual standards for surface cleaning comparison (6.1),

4.2.4 Specific 4.1.11 Specific requirements for test frequency (9.1), and

4.2.5 Requirements 4.1.12 Requirements for inspection of manufacturing plant (12.1)-), and

4.1.13 ASTM designation and year of issue.

### 5. Materials

5.1 Plain or deformed steel wire or welded wire ~~fabrie~~ reinforcement to be coated shall meet the requirements of one of the applicable specifications: A82/A82M, A185/A185M, A496/A496M, ~~or~~ A497/A497M, as specified by the purchaser, and shall be free of surface contaminants such as oil, grease, or paint when received at the manufacturer's plant and prior to cleaning and coating, or A1064/A1064M as specified by the purchaser, and shall be free of surface contaminants such as oil, grease, or paint when received at the manufacturer's plant and prior to cleaning and coating.

NOTE 2—Specifications A82/A82M, A185/A185M, A496/A496M, A497/A497M have been replaced by Specification A1064/A1064M.

5.2 The coating material shall meet the requirements listed in Annex A1. In addition to the requirements of Annex A1, the coating material shall have demonstrated long-term stability when embedded in concrete.

5.2.1 A written certification shall be furnished to the purchaser that properly identifies the number of each batch of coating material used in the order, material quantity represented, date of manufacture, name and address of manufacturer, and a statement that the supplied coating material meets the requirements of Annex A1.

5.3 If specified in the order, a representative 8-oz [0.20-kg] sample of the coating material shall be supplied to the purchaser from each batch. The sample shall be packaged in an airtight container and identified by batch number.

5.4 If specified in the order, patching material, compatible with the coating and inert in concrete, and recommended by the coating manufacturer, shall be supplied to the purchaser. Patching material for repairing damaged coating shall be compatible with

the coating, inert in concrete, and feasible for repairs at the applicator plant or the fabricating shop. Patching material shall be approved in accordance with Annex A2 prior to use.

5.4.1 The patching material manufacturer shall specify the metals surface preparation and the procedures for application of the patching material.

5.4.2 If specified in the order, patching material conforming to Annex A2 and recommended by the powder coating manufacturer shall be supplied to the purchaser.

~~NOTE2—When 3—When~~ subjected to temperatures above ~~392°F~~390°F [200°C] for a prolonged period of time, ~~PVC—a vinyl coating~~ is subject to decomposition. One of the products of decomposition is hydrochloric acid, HCl, which can damage concrete and reinforcing steel. Even in small amounts, HCl will accelerate corrosion of steel.

~~NOTE3—PVC-coated-~~ 4—Vinyl-coated wire has very low bond strength to concrete, and the use of deformed wire provides no advantage over smoothplain wire. The bond strength of ~~PVC-coated-vinyl-coated~~ welded wire ~~fabriereinforcement~~ is similar to that of uncoated plain welded wire ~~fabriereinforcement~~ since the cross wires provide the primary bond.

## 6. Surface Preparation

6.1 The surface of the steel wire or welded wire ~~fabriereinforcement~~ to be coated ~~will~~shall be cleaned by abrasive blast cleaning to near-white metal in accordance with SSPC-SP 10. Additional surface ~~treatment will be used~~ treatment, as indicated in ~~A1.3.3-46.3, is permitted.~~ Any of the following visual standards of comparison ~~will~~shall be used to define the final surface condition: ~~SSPC-Vis1-67T~~SSPC-Vis 1, ~~SSPC-Vis2-82T~~SSPC-Vis 2, NACE TM-01-70, and NACE TM-01-75. Average blast profile maximum roughness depth readings of 1.5 to 4.0 mils [0.04 to 0.10 mm] as determined by replica tape measurements using NACE RP-287-87, shall be considered suitable as an anchor pattern.

~~NOTE 45—Abrasive blast cleaning of wire and welded wire reinforcement with a high degree (>90 %) of grit in the cleaning media provides the most suitable anchor profile for coating adhesion. After grit has been recycled, a small portion will take on the appearance of shot.~~

~~NOTE5—The 6—The~~ use of a profilometer type surface measurement instrument which measures the peak count as well as the maximum profile depth is recommended.

6.2 Multidirectional, high-pressure, dry air knives shall be used after blasting to remove dust, grit, and other foreign matter from the steel surface. The air knives shall not deposit oil on the steel reinforcement.

~~NOTE6—It 7—It~~ is recommended that incoming wire and welded wire reinforcement and blast media should be checked for salt contamination prior to use. Blast media found to be salt contaminated should be rejected. Wire and welded wire reinforcement found to be salt contaminated from exposure to deicing salts or salt spray should be cleaned by acid washing or other suitable methods to remove salt contaminants from the surface prior to blast cleaning.

6.3 It shall be permissible for the manufacturer to use a chemical wash or conversion of the blast-cleaned steel reinforcement surface, or both, to enhance coating adhesion. This pretreatment shall be applied after abrasive cleaning and before coating, in accordance with the written application instructions specified by the pretreatment manufacturer.

## 7. Application of Coating

7.1 The coating shall be applied to the cleaned surface as soon as possible after cleaning, and before oxidation of the surface ~~occurs discernible to the unaided eye occurs.~~ a person with normal or corrected vision. However, in no case shall application of the coating be delayed more than 4 h after cleaning.

7.2 To achieve a chemical bond of the vinyl coating to metal, the steel wire or welded wire reinforcement ~~will~~shall be primed with appropriate primer as recommended by the manufacturer of the primer and vinyl powder compound.

7.3 The coating shall be applied and fully fused in accordance with the written recommendations of the manufacturer of the coating material.

## 8. Requirements for Coated Wire or Welded Wire ~~Fabric~~Reinforcement

### 8.1 Thickness of Coating:

8.1.1 *Class A*—The film thickness of the coating after fusing shall be 7 to 17 mils [175 to 425 μm] for both plain and deformed steel wire and welded wire ~~fabriereinforcement~~ used for concrete reinforcement. Thickness measurements below ~~57 mils~~ [125[175 μm] shall be considered cause for rejection. The upper film thickness limits do not apply to repaired areas of damaged coating.

8.1.2 *Class B*—The film thickness of the coating after fusing shall be a minimum of 18 mils [450 μm], for both plain and deformed steel wire and welded wire ~~fabriereinforcement~~ used for earth reinforcement, such as mechanically stabilized embankments. Thickness measurements below ~~16~~18 mils [400[450 μm] shall be considered cause for rejection or reclassification as Class A if the thickness meets the Class A requirements.

8.1.3 A single recorded coating thickness measurement is the average of three individual gauge readings obtained approximately evenly spaced along each side of the coated wire or welded wire reinforcement test specimen. A minimum of five recorded measurements shall be taken approximately evenly spaced along each side of the test specimen (a minimum of 10 recorded measurements per test specimen). No individual gauge reading shall be taken closer than 0.5 in. [13mm] from an intersection.

8.1.4 For acceptance purposes, the average of all coating thickness measurements shall not be less than the specified minimum thickness or more than the specified maximum thickness. No single recorded coating thickness measurement shall be less than 80 % of the specified minimum thickness or more than 120 % of the specified maximum thickness.

8.1.5 Measurements shall be made in accordance with SSPC-PA2 following the instructions for calibration and use recommended by the thickness gauge manufacturer. Pull-off or fixed-probe gauges shall be used. Pencil-type pull-off gauges that require the operator to observe the reading at the instant the magnet is pulled from the surface shall not be used.

#### 8.2 Continuity of Coating:

8.2.1 There shall not be more than an average of one holiday per foot [three holidays per metre] on the coated wire (spool and individual lengths).

~~8.2.1 If any of these deficiencies occur during the coating application process, they shall be patched in accordance with the patching material manufacturer's written recommendations.~~

8.2.2 In welded wire reinforcement, there shall not be more than an average of one holiday per foot [three holidays per metre] in each wire direction. Voids (uncoated areas due to the faraday cage effect and weld spurs) at welded intersections shall not be counted. Damage at cut ends shall not be counted.

8.2.3 Holiday checks to determine acceptability of the wire or welded wire fabriereinforcement shall be made at the manufacturer's plant with a 67½-V, 80 000 Ω, wet-sponge-type d-c holiday detector.

NOTE 78—Holiday detection is not intended for use at the job-site.

#### 8.3 Bend Test—Coating Requirement:

8.3.1 The adhesion of the coating shall be evaluated by bending production coated steel wire and welded wire reinforcement at a uniform rate 180° around a mandrel of specified size as prescribed in Table 1. The test specimens shall be at thermal equilibrium between 68° and 86°F [20 and 30°C].

8.3.2 Cracking or disbonding of the coating on the outside radius or wrinkling of the coating on the inside radius of the bent wire or welded wire reinforcement visible to a person with normal or corrected vision shall be considered cause for rejection of the coated wire or welded wire reinforcement represented by the bend test ~~sample specimen~~.

8.4 *Place of Testing*—Testing of coated steel wire or welded wire reinforcement shall be done at the manufacturer's plant prior to shipment.

8.5 *Time of Testing*—The requirements for coated wire or welded wire reinforcement shall be met at the manufacturer's plant prior to shipment.

### 9. Number of Tests

9.1 The purchaser may specify the sampling and test schedule for the number and frequency of tests for coating thickness, adhesion, and continuity.

9.2 If the number and frequency of tests are not specified by the purchaser:

9.2.1 Tests for coating thickness and continuity shall be made at the manufacturer's plant on a minimum of 1 linear ft [0.3 m] of each size wire or welded wire fabriereinforcement coated from each 2 h of production.

9.2.2 Bend tests for coating adhesion shall be conducted at the manufacturer's plant on at least one wire of each size or one style of fabriereinforcement from each 2 h of production.

### 10. Retests

10.1 If the specimen for coating thickness, continuity, or adhesion fails to meet the specified requirements, two retests on random ~~sample specimens~~ shall be conducted for each failed test. If the results of both retests meet the specified requirements, the coated material represented by the ~~sample specimens~~ shall be accepted.

### 11. Handling and Identification

11.1 All systems for handling coated reinforcement shall have padded contact areas. Bundling bands shall be padded, or suitable banding shall be used to prevent damage to the coating. Bundles of coated reinforcement shall be lifted with a strong back, spreader bar, multiple supports, or a platform bridge. The bundled reinforcement shall be transported with care and stored off the ground on protective cribbing. The coated reinforcement shall not be dropped or dragged.

11.2 If circumstances require storing coated wire or welded wire reinforcement outdoors for more than two months, protective storage measures shall be implemented to protect the coated reinforcement from sunlight, salt spray, and weather exposure. If the

**TABLE 1 Bend Test Requirements**

Wire Size No. <del>M</del> W or <del>M</del> D, <del>mm</del> in.	Wire Size No. <u>M</u> W or <u>MD</u> , <del>in.</del> mm	Mandrel Diameter	Time to Completion, s (maximum)
— 9 to 39	1.4 to 6	Two times the diameter of the tested wire	15
— 1.4 to 6	9 to 39	Two times the diameter of the tested wire	15
— >39	>6	Four times the diameter of the tested wire	45
— >6	>39	Four times the diameter of the tested wire	45



manufacturer stores coated wire or welded wire reinforcement outdoors without protective covering, the date on which the coated reinforcement is placed outdoors shall be recorded on its identification tag. Coated wire or welded wire reinforcement, whether individual pieces or bundles of pieces, or both, shall be covered with opaque polyethylene sheeting or other suitable opaque protective material. For stacked bundles, the protective covering shall be draped around the perimeter of the stack. The covering shall be secured adequately, and allow for air circulation around the coated reinforcement to minimize condensation under the covering.

## 12. Inspection

12.1 The inspector representing the purchaser shall have free entry at all times to the parts of the manufacturer's works that concern the manufacture of the material ordered. The manufacturer shall afford the inspector all reasonable facilities to satisfy him that the material is furnished in accordance with this specification. All tests and inspection shall be made at the place of manufacture prior to shipment, unless otherwise specified, and shall be so conducted as not to interfere unnecessarily with the operation of the works. On a random basis, coated specimens may be taken by the purchaser's representative from the production run for testing. All tests and inspection shall be made at the place of manufacture prior to shipment, unless otherwise specified, and shall be so conducted as not to interfere unnecessarily with the operation of the coating line. At a mutually agreed upon frequency, the purchaser or the purchaser's representative shall be permitted to take coated specimens from the production run for testing.

**13. The inspector representing the purchaser shall have free entry, at all times, to the parts of the manufacturer's coating line that concern the manufacture of the coated wire or welded wire reinforcement ordered. The manufacturer shall afford the inspector all reasonable facilities to satisfy the inspector that the coated wire or welded wire reinforcement is being furnished in accordance with this specification. All tests and inspection shall be made at the place of manufacture prior to shipment, unless otherwise specified, and shall be so conducted as not to interfere unnecessarily with the operation of the coating line. At a mutually agreed upon frequency, the purchaser or the purchaser's representative shall be permitted to take coated specimens from the production run for testing.**

## 13. Permissible Coating Damage Due to Handling and Processing

13.1 Prior to shipment, all visible damaged coating on each wire and welded wire reinforcement shall be repaired with patching material.

13.2 All uncoated areas that result from hanging or supporting coated wire or welded wire reinforcement shall be patched.

13.3 The maximum amount of repaired damaged coating shall not exceed 1 % of the total surface area in each 1-foot [0.3 m] 1-ft [0.3 m] of the wire. This limit shall not include sheared or cut ends that are coated with patching material (13.4).

13.4 When coated wire or welded wire reinforcement is sheared, saw-cut, or cut by other means, the cut ends shall be coated with patching material. Coated wire or welded wire reinforcement shall not be flame cut.

13.5 Patching shall be done in accordance with the patching material manufacturer's written recommendations. ~~Note 8—All visible damage incurred to the coating during shipping, handling, and installation of the wire and welded wire reinforcement shall be repaired with patching material.~~

## 14. Rejection

14.1 Coated steel wire and welded wire reinforcement represented by test specimens that do not meet the requirements of this specification shall be rejected and marked with contrasting color paint or other suitable identification. At the manufacturer's option, the affected lot shall be replaced or, alternatively, ~~will~~ shall be stripped of coating, recleaned, recoated, and resubmitted for acceptance testing in accordance with the requirements of this specification.

## 15. Certification

15.1 At the time of shipment the purchaser shall be furnished written certification that ~~samples~~ specimens representing each lot of coated steel reinforcement have been either tested or inspected as required by this specification and the requirements have been met. When specified in the purchase order or contract, a report of the test results shall be furnished.

15.2 A material test report, certificate of inspection, or similar document printed from or used in electronic form from an electronic data interchange (EDI) transmission shall be regarded as having the same validity as a counterpart printed in the certifier's facility. The content of the EDI transmitted document must meet the requirements of the invoked ASTM standard(s) and conform to any existing EDI agreement between the purchaser and the supplier. Notwithstanding the absence of a signature, the organization submitting the EDI transmission is responsible for the content of the report.

NOTE 9—The industry definition as invoked here is: EDI is the computer-to-computer exchange of business information in a standard format such as ANSI ASC X12.

## 16. Keywords

16.1 coating requirements; concrete reinforcement; corrosion resistance; steel wire; vinyl coating; welded wire ~~fabric~~ reinforcement