



Designation: A911/A911M – 11

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

This standard is issued under the fixed designation A911/A911M; 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 A supplementary requirement (S1) is provided for use where low-relaxation bars and relaxation testing for that product is required by the purchaser. The supplementary requirement applies only when specified in the purchase order or contract.

1.3 This specification is applicable for orders in either inch-pounds units (as Specification A911) or in SI units (as Specification A911M).

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*:²
A370 Test Methods and Definitions for Mechanical Testing of Steel Products
E328 Test Methods for Stress Relaxation for Materials and Structures
- 2.2 *Federal Standard*:³
Fed. Std. No. 123 Marking for Shipments (Civil Agencies)
- 2.3 *Military Standards*:³
MIL-STD-129 Marking for Shipment and Storage

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 A01.05 on Steel Reinforcement.

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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 Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, http://dodssp.daps.dla.mil.

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 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 Nominal diameter of bar (inches) [millimetres],
- 4.1.4 Inspection (Section 12),
- 4.1.5 Load-elongation curve (14.2),
- 4.1.6 Core diameter and length of coils (15.1),
- 4.1.7 Packaging,
- 4.1.8 Supplementary Requirement S1 (if desired), and
- 4.1.9 ASTM designation and year of issue.

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.

7. Mechanical Property Requirements

7.1 *Test Method*—Tests shall be made in accordance with Test Methods and Definitions A370, including Annex A4, using full-size bar specimens taken from either end of the coil of the finished product.

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



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

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

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

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 %

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 1-1/2 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 [millimetre]. 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. [0.05 mm].

9. Workmanship, Finish, and Appearance

9.1 Joints:

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 taken from either end of the coil are permitted.

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 order or 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 Reheating

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 specimen from each coil and sorting out nonconforming material.

13.3 In the event that testing of any individual specimen 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 specimens of bar from the same coil, 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 accordance with and meets the requirements of this specification shall be the basis of acceptance of the material.

14.2 The manufacturer shall, when requested in the order, furnish a representative load-elongation curve for each size shipped.

14.3 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