



Designation: A679/A679M – 06 (Reapproved 2012)

Standard Specification for Steel Wire, High Tensile Strength, Cold Drawn¹

This standard is issued under the fixed designation A679/A679M; 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 round, uncoated, high tensile strength, cold-drawn steel spring wire, having properties and quality suitable for the manufacture of mechanical springs and wire forms subject to high static stresses or infrequent dynamic load, or both.

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other.

2. Referenced Documents

2.1 ASTM Standards:²

[A370 Test Methods and Definitions for Mechanical Testing of Steel Products](#)

[A510 Specification for General Requirements for Wire Rods and Coarse Round Wire, Carbon Steel](#)

[A510M Specification for General Requirements for Wire Rods and Coarse Round Wire, Carbon Steel \(Metric\) \(Withdrawn 2011\)³](#)

[A700 Guide for Packaging, Marking, and Loading Methods for Steel Products for Shipment](#)

[A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products](#)

[A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys](#)

[E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)

2.2 ANSI Standard:⁴

[B32.4 Preferred Metric Sizes for Round, Square, Rectangle, and Hexagon Metal Products](#)

2.3 Federal Standard:⁵

[Fed. Std. No. 123 Marking for Shipment \(Civil Agencies\)](#)

2.4 AIAG Standard:⁶

[AIAGB-5 02.00 Primary Metals Identification Tag Application Standard](#)

3. Terminology

3.1 *Definitions*—For definitions of terms used in this specification, refer to Terminology [A941](#).

4. Ordering Information

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

4.1.1 Quantity (mass),

4.1.2 Name of material (steel wire, high tensile strength, hard drawn),

4.1.3 Dimensions ([Table 1](#) and [Section 9](#)),

4.1.4 Packaging ([Section 15](#)),

4.1.5 Heat analysis report, if requested ([6.2](#)),

4.1.6 Certification or test report, or both, if specified ([Section 14](#)), and

4.1.7 ASTM designation and year of issue.

NOTE 1—A typical ordering description is as follows: 20 Mg high tensile strength, hard-drawn steel mechanical spring wire, 5.00-mm diameter, 500-kg coils to ASTM A679/A679M dated _____, or for inch-pound units, 40 000-lb high tensile strength, hard-drawn steel mechanical spring wire, 0.192-in. diameter, in 1000-lb coils to ASTM A679/A679M dated _____.

5. Materials and Manufacture

5.1 The steel may be made by any commercially accepted steel making process. The steel may be either ingot cast or continuous strand cast. The rod to be used in the manufacture of wire furnished to this specification shall be in accordance with Specifications [A510](#) or [A510M](#).

5.2 The finished wire shall be free from detrimental pipe and undue segregation.

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 A01.03 on Steel Rod and Wire.

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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 The last approved version of this historical standard is referenced on www.astm.org.

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

⁵ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098.

⁶ Available from Automotive Industry Action Group (AIAG), 26200 Lahser Rd., Suite 200, Southfield, MI 48034.

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

TABLE 1 Tensile Requirements

Diameter, mm ^{A,B}	SI Units		Diameter, in.	Inch-Pound Units	
	Tensile Strength, MPa			Tensile Strength, ksi	
	min	max		min	max
0.50	2400	2650	0.020	350	387
0.55	2380	2620	0.023	343	380
0.60	2350	2600	0.026	337	373
0.65	2320	2580	0.029	331	366
0.70	2300	2550	0.032	327	361
0.80	2250	2500	0.035	322	356
0.90	2200	2450	0.041	314	347
1.00	2150	2400	0.048	306	339
1.10	2120	2380	0.054	300	331
1.20	2100	2350	0.062	293	324
1.40	2050	2300	0.072	287	317
1.60	2000	2250	0.080	282	312
1.80	1980	2220	0.092	275	304
2.00	1950	2200	0.106	268	296
2.20	1900	2150	0.120	263	290
2.50	1850	2100	0.135	258	285
2.80	1820	2050	0.148	253	279
3.00	1800	2000	0.162	249	275
3.50	1750	1950	0.177	245	270
4.00	1700	1900	0.1927	241	267
4.50	1680	1880	0.207	238	264
5.00	1650	1850			

^A Tensile strength values for intermediate diameters shall be interpolated.

^B Preferred sizes. For a complete list, refer to ANSI B32.4

5.3 The wire shall be cold drawn to produce the desired mechanical properties.

5.4 The wire finish shall be suitable for forming or coiling. It is not intended that this material be furnished with a metallic coating.

6. Chemical Composition

6.1 The steel shall conform to the requirements for chemical composition prescribed in Table 2.

6.2 Heat Analysis—Each heat of steel shall be analyzed by the manufacturer to determine the percentage of elements prescribed in Table 2. This analysis shall be made from a test specimen preferably taken during the pouring of the heat. When requested, in the purchase order, the heat analysis shall be reported to the purchaser.

6.3 Product Analysis—An analysis may be made by the purchaser from finished wire representing each heat of steel. The chemical composition thus determined, as to elements required or restricted, shall conform to the product analysis requirements specified in Table 7 of Specifications A510 or A510M.

TABLE 2 Chemical Requirements

Element	Composition, %
Carbon	0.65–1.00 ^A
Manganese	0.20–1.30 ^B
Phosphorus, max	0.040
Sulfur, max	0.050
Silicon	0.15–0.35

^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 %.

6.4 For referee purposes, Test Methods, Practices, and Terminology A751 shall be used.

7. Mechanical Properties

7.1 Tension Test:

7.1.1 Requirements—The material as represented by tension test specimens shall conform to the requirements prescribed in Table 1.

7.1.2 Number of Tests—One test specimen shall be taken for each 10 coils or fraction thereof, in a lot. Each heat in a given lot shall be tested.

7.1.3 Test Method—The tension test shall be made in accordance with Test Methods and Definitions A370.

7.2 Wrap Test:

7.2.1 Requirements—The material as represented by the wrap test specimens shall conform to the requirements specified in Table 3.

7.2.2 Number of Tests—One test specimen shall be taken for each 10 coils, or fraction thereof, in a lot. Each heat in a given lot shall be tested.

7.2.3 Location of Test—Test specimens shall be taken from either end of the coil.

7.2.4 Test Method—The wrap test shall be made in accordance with Test Methods and Definitions A370.

8. Metallurgical Requirements

8.1 Microstructure—The wire shall be cold drawn with a fine pearlite structure.

8.2 Surface Conditions—The wire surface shall not exhibit imperfections that exceed 3.5 % of the wire diameter or 0.25 mm (0.010 in.) in depth, whichever is smaller.

9. Dimensions and Permissible Variations

9.1 The permissible variations in the diameter of the wire shall be as specified in Table 4.

10. Workmanship, Finish, and Appearance

10.1 Workmanship—The wire shall not be kinked or improperly cast. To test for cast, one convolution of wire shall be cut from the coil and placed on a flat surface. The wire shall not spring up excessively nor show a wavy condition.

10.1.1 Each coil shall be one continuous length of wire, properly coiled and firmly tied. Welds made prior to cold drawing are permitted.

TABLE 3 Wrap Test Requirements^A

SI Units	
Diameter, mm	Mandrel Size
Over 0.50 to 3.00, incl	2x
Over 3.00 to 5.00, incl	4x
Inch-Pound Units	
Diameter, in.	Mandrel Size
0.020 to 0.162, incl	2x
Over 0.162 to 0.207, incl	4x

^A The symbol "X" represents the diameter of the wire tested.