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Standard Specification for Steel Strand, Uncoated Seven-Wire for Prestressed Concrete¹

This standard is issued under the fixed designation A416/A416M; 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.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

~~1.1 This specification covers two types and two grades of seven-wire, uncoated steel strand for use in pretensioned and post-tensioned prestressed concrete construction. The two types of strand are low-relaxation and stress-relieved (normal-relaxation). Low-relaxation strand shall be regarded as the standard type. Stress-relieved (normal-relaxation) strand will not be furnished unless specifically ordered, or by arrangement between purchaser and supplier. Grade 1725 [250] and Grade 1860 [270] have minimum ultimate strengths of 1725 MPa [250 ksi] and 1860 MPa [270 ksi], respectively, based on the nominal area of the strand.~~

~~1.2 The values stated in either inch-pound units or SI units are to be regarded as standard. Within the text, the inch-pound 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.~~

~~1.3 The supplementary requirements in S1 shall be specified for 15.2-mm [0.600-in.] diameter uncoated seven-wire steel strand if needed for applications in prestressed ground anchors.~~

~~1.1 This specification covers two types and two grades of seven-wire, uncoated steel strand for use prestressed concrete construction. The two types of strand are low-relaxation and stress-relieved (normal-relaxation). Low-relaxation strand is to be regarded as the standard type. Stress-relieved (normal-relaxation) strand will not be furnished unless specifically ordered. Grade 250 [1725] and Grade 270 [1860] have minimum tensile strengths of 250 ksi [1725 MPa] and 270 ksi [1860 MPa], respectively, based on the nominal area of the strand.~~

~~1.2 A supplementary requirement (S1) is provided for use where bond strength testing of 0.600-in. [15.24-mm] diameter Grade 270 [1860] strand for applications in prestressed ground anchors is required by the purchaser. The supplementary requirement applies only when specified in the purchase order.~~

~~1.3 This specification is applicable for orders in either inch-pound units (as Specification A416) or in SI units (as specification A416M).~~

~~1.4 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 specification.~~

2. Referenced Documents

2.1 ASTM Standards:²

A981/A981M [Test Method for Evaluating Bond Strength for 15.2 mm \(0.6 in.\)-0.600-in. \[15.24-mm\] Diameter Prestressing Steel Prestressing Strand, Grade 270 \[1860\], Uncoated, Used in Prestressed Ground Anchors](#)

A1061/A1061M [Test Methods for Testing Multi-Wire Steel Strand](#)

2.2 U.S. Military Standards:³

MIL-STD-129 [Marking for Shipment and Storage](#)

MIL-STD-163 [Steel Mill Products Preparation for Shipment and Storage—Marking for Shipment and Storage](#)

2.3 U.S. Federal Standard:³

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

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 19111-50948, <http://dodssp.daps.dla.mil>.

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

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *strand, n*—a group of wires having a center wire enclosed tightly by six helically placed outer wires with uniform pitch of not less than 12 and not more than 16 times the nominal diameter of the strand.

3.1.1.1 *Discussion*—The direction of lay may be either right- or left-hand, however, strands of different lays should not be spliced together.

4. Ordering Information

~~4.1 Orders for seven-wire low-relaxation or stress-relieved (normal-relaxation) strand under this specification should include the following information:~~

~~4.1.1 Quantity (metres [feet]);~~

~~4.1.2 Diameter of strand;~~

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

4.1.1 Quantity (feet [metres]),

4.1.2 Nominal diameter of strand,

4.1.3 Grade of strand,

4.1.4 Type of strand,

4.1.5 Packaging,

4.1.6 ASTM designation and year of issue, and

4.1.7 Special requirements, if any.

~~NOTE 1—A typical ordering description is as follows: 25600 m [84000 ft], 13 mm [0.5 in.], Grade 1860 [270] low-relaxation strand, in 3600-m [12000-ft] reelless packs to ASTM A416/A416M _____.~~

4.1.5 Weldless, if desired (8.1)

4.1.6 Outside inspection, if required (11.1),

4.1.7 Load-elongation curve, if desired (13.2),

4.1.8 Packaging (14.1),

4.1.9 Supplementary Requirement S1, if desired, and

4.1.10 ASTM designation and year of issue.

5. Materials and Manufacture

5.1 *Base Metal*—The base metal shall be carbon steel of such quality that when drawn to wire, fabricated into strand, and then thermally treated, shall have the properties and characteristics prescribed in this specification.

5.2 *Wire*—The wire from which the strand is to be fabricated shall be round and have a dry-drawn finish.

~~NOTE 2—This 1—This product is a composite of seven wires and is produced only to mechanical properties only. meet the prescribed mechanical properties. The chemical composition of all wires or any individual wire is not pertinent to this application, and heat identity is not necessarily maintained. It is possible that wire from more than one heat may be used in the manufacture of a reel or reelless pack. Traceability is based on pack identity of reels or reelless packs as maintained and reported by the manufacturer.~~

5.3 *Treatment*—After stranding, low-relaxation strand shall be subjected to a continuous thermal-mechanical treatment to produce the prescribed mechanical properties. For stress-relieved (normal-relaxation) strand, only thermal treatment is necessary. Temper colors which result from the stress-relieving operation are considered normal for the finished appearance of this strand.

6. Mechanical Property Requirements

~~6.1 Tests~~6.1 Tests for mechanical properties shall be conducted in accordance with Test Methods A1061/A1061M. ~~Low-relaxation strand shall also be tested as prescribed in Test Methods A1061/A1061M.~~

6.2 *Breaking Strength*—The breaking strength of the finished strand shall conform to the requirements prescribed in Table 1.

6.3 *Yield Strength*—Yield strength in ~~kN [pounds]~~ kN shall be measured at 1 % extension under load. The minimum yield strength shall be 90 % for low-relaxation strand and 85 % for stress-relieved (normal-relaxation) strand of the breaking strength listed in Table 1. Initial loads for the test and minimum yield strengths are listed in Table 2.

6.3.1 The extension under load shall be measured by an extensometer calibrated with the smallest division not larger than ~~0.0001 mm/mm in./in.~~ 0.0001 in./in. [mm/mm] of gage length.

6.4 *Elongation*—The total elongation under load shall not be less than 3.5 % using a gage length of not less than ~~600 mm [24 in.]~~ 600 mm. It shall be permissible to determine the total elongation value by adding, to the 1.0 % yield extension, the percent extension or movement between the jaws gripping the strand after yield determination. The percent is calculated on the new base length of jaw-to-jaw distance.

~~6.5 Relaxation Properties—Low-relaxation strand shall have relaxation losses of not more than 2.5% when initially loaded to 70% of specified minimum breaking strength or not more than 3.5% when loaded to 80% of specified minimum breaking strength of the strand after 1000 h tested under the conditions listed in 6.5.1 through 6.5.7.~~



TABLE 1 Breaking Strength Requirements

Nominal Diameter of Strand-Designation No. [mm]	Minimum Breaking Strength of Strand, mm [in.-kN]	Minimum Breaking Strength of Strand, kN [lbf]	Steel Area of Strand, mm ² [in. ²]	Weight
Grade 17 25 [250]				
Grade 250 [1725]				
–6	6.4 [0.250]	40.0 [9 000]	23.2 [0.036]	
0.250 [6.4]	9 000 [40.0]	0.036 [23.2]	122 [0.036]	
–8	7.9 [0.313]	64.5 [14 500]	37.4 [0.058]	
0.313 [7.9]	14 500 [64.5]	0.058 [37.4]	197 [0.058]	
–9	9.5 [0.375]	89.0 [20 000]	51.6 [0.080]	
0.375 [9.5]	20 000 [89.0]	0.080 [51.6]	272 [0.080]	
11	11.1 [0.438]	120.1 [27 000]	69.7 [0.108]	
0.438 [11.1]	27 000 [120.1]	0.108 [69.7]	367 [0.108]	
13	12.7 [0.500]	160.1 [36 000]	92.9 [0.144]	
0.500 [12.7]	36 000 [160.1]	0.144 [92.9]	490 [0.144]	
15	15.2 [0.600]	240.2 [54 000]	139.4 [0.216]	
0.600 [15.2]	54 000 [240.2]	0.216 [139.4]	737 [1094]	
1094 [737]				
	Grade 1860 [270]			
	Grade 270 [1860]			
–9	9.53 [0.375]	102.3 [23 000]	54.8 [0.085]	
0.375 [9.53]	23 000 [102.3]	0.085 [54.8]	290 [0.085]	
11	11.11 [0.438]	137.9 [31 000]	74.2 [0.115]	
0.438 [11.11]	31 000 [137.9]	0.115 [74.2]	390 [5]	
13	12.70 [0.500]	183.7 [41 300]	98.7 [0.153]	
0.500 [12.70]	41 300 [183.7]	0.153 [98.7]	53	
13a	13.20 [0.520]	200.2 [45 000]	107.7 [0.167]	
0.520 [13.20]	45 000 [200.2]	0.167 [107.7]	567	
14	14.29 [0.563]	230.0 [51 700]	123.9 [0.192]	
0.563 [14.29]	51 700 [230.0]	0.192 [123.9]	651 [92]	
15	15.24 [0.600]	260.7 [58 600]	140.0 [0.217]	
0.600 [15.24]	58 600 [260.7]	0.217 [140.0]	740 [17]	
16	15.75 [0.620]	277.4 [62 370]	149.2 [0.231]	
0.620 [15.75]	62 370 [277.4]	0.231 [149.2]	778 [1]	
18	17.78 [0.700]	353.2 [79 400]	189.7 [0.294]	
0.700 [17.78]	79 400 [353.2]	0.294 [189.7]	10 294	

6.5.1 If required, relaxation evidence shall be provided from the manufacturer's records of tests on similarly dimensioned strand of the same grade.

6.5.2 The temperature of the test specimen shall be maintained at $20 \pm 2^\circ\text{C}$ [$68 \pm 3.5^\circ\text{F}$].

6.5.3 The test specimen shall not be subjected to loading prior to the relaxation test.

6.5.4 The initial load shall be applied uniformly over a period of not less than 3 min and not more than 5 min, and the gage length shall be maintained constant; load relaxation readings shall commence 1 min after application of the total load.

6.5.5 Over-stressing of the test specimen during the loading operation shall not be permitted.

6.5.6 The duration of the test shall be 1000 h or a shorter period of at least 200 h, provided it can be shown by records that an extrapolation of the shorter period test results to 1000 h will provide similar relaxation values as the full 1000 h test.

6.5.7 The test gage length shall be at least 60 times the nominal diameter. If this gage length exceeds the capacity of the extensometer or testing machine, then it shall be permitted to substitute a gage length of 40 times the nominal strand diameter. —Low-relaxation strand shall have relaxation losses of not more than 2.5 % when initially loaded to 70 % of specified minimum breaking strength or not more than 3.5 % when loaded to 80 % of specified minimum breaking strength of the strand after 1000 hours of testing.

6.5.1 If required, relaxation evidence shall be provided from the manufacturer's records of tests on similarly dimensioned strand of the same grade.

7. Dimensions and Permissible Variations

7.1 The size of the finished strand shall be expressed as the nominal diameter of the strand in millimetres [inches]—inches [millimetres].

7.2 The diameter of the center wire of any strand shall be larger than the diameter of any outer wire in accordance with Table 3.

7.3 Permissible Variations in Diameter:

7.3.1 All Grade 1725 [250] 250 [1725] strand shall conform to a size tolerance of ± 0.40 mm [± 0.016 in.] ± 0.016 in. [± 0.40 mm] from the nominal diameter measured across the crowns of the wires.

7.3.2 All Grade 1860 [270] 270 [1860] strand shall conform to a size tolerance of $+0.65$, -0.15 mm [$+0.026$, -0.006 in.] $+0.026$, -0.006 in. [$+0.65$, -0.15 mm] from the nominal diameter measured across the crowns of the wire.