



Designation: A416/A416M – 12a

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 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 0.600-in. \[15.24-mm\] Diameter Steel Prestressing Strand](#),

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.

Current edition approved Sept. 1, 2012. Published October 2012. Originally approved in 1957. Last previous edition approved in 2012 as A416/A416M – 12. DOI: 10.1520/A0416_A0416M-12A.

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.

[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](#)

2.3 *U.S. Federal Standard*:³

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

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 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 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,

³ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, http://dodssp.daps.dla.mil.

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

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 1—This product is a composite of seven wires and is produced only to 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 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 for mechanical properties shall be conducted in accordance with 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 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 in./in. [0.0001 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 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 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 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 250 [1725] strand shall conform to a size tolerance of ± 0.016 in. [± 0.40 mm] from the nominal diameter measured across the crowns of the wires.

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

7.3.3 Variation in cross-sectional area and in unit stress resulting therefrom shall not be cause for rejection provided that the diameter differences of the individual wires and the diameters of the strand are within the tolerances specified.

7.4 It shall be permitted to furnish, under this specification, specially dimensioned low-relaxation and stress-relieved (normal-relaxation) strands with nominal diameters up to 0.750 in. [19 mm]. The breaking strength shall be defined, and the yield strength, as defined in **6.3**, shall not be less than 90 % and 85 % of the specified minimum breaking strength for low-relaxation and stress-relieved (normal-relaxation) strands, respectively. All other requirements shall apply.

8. Workmanship, Finish, and Appearance

8.1 Joints:

TABLE 1 Breaking Strength Requirements

Nominal Diameter of Strand, in. [mm]	Minimum Breaking Strength of Strand, lbf [kN]	Steel Area of Strand, in. ² [mm ²]	Weight [Mass] of Strand lb/1000 ft [kg/1000 m]
Grade 250 [1725]			
0.250 [6.4]	9 000 [40.0]	0.036 [23]	122 [182]
0.313 [7.9]	14 500 [64.5]	0.058 [37]	197 [294]
0.375 [9.5]	20 000 [89.0]	0.080 [52]	272 [405]
0.438 [11.1]	27 000 [120]	0.108 [69.7]	367 [548]
0.500 [12.7]	36 000 [160]	0.144 [92.9]	490 [730]
0.600 [15.2]	54 000 [240]	0.216 [139]	737 [1090]
Grade 270 [1860]			
0.375 [9.53]	23 000 [102]	0.085 [55]	290 [430]
0.438 [11.1]	31 000 [138]	0.115 [74.2]	390 [580]
0.500 [12.7]	41 300 [184]	0.153 [98.7]	520 [780]
0.520 [13.2]	45 000 [200]	0.167 [108]	570 [840]
0.563 [14.3]	51 700 [230]	0.192 [124]	650 [970]
0.600 [15.2]	58 600 [261]	0.217 [140]	740 [1100]
0.620 [15.7]	62 800 [279]	0.231 [150]	780 [1200]
0.700 [17.8]	79 400 [353]	0.294 [190]	1000 [1500]