



Designation: ~~B1–01 (Reapproved 2007)~~ B1 – 12

Standard Specification for Hard-Drawn Copper Wire¹

This standard is issued under the fixed designation B1; 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 hard-drawn round copper wire for electrical purposes.

1.2 The values stated in inch-pound or SI units are to be regarded separately as standard. Each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the specification. For conductor sizes designated by AWG or kcmil sizes, the requirements in SI units are numerically converted from the corresponding requirements in inch-pound units. For conductor sizes designation by AWG or kcmil, the requirements in SI units have been numerically converted from corresponding values stated or derived in inch-pound units. For conductor sizes designated by SI units only, the requirements are stated or derived in SI units as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.2.1 *Exception*—For density, resistivity and temperature, the values stated in SI units are to be regarded as standard.

2. Referenced Documents

2.1 *ASTM Standards*:²

[B49 Specification for Copper Rod Drawing Stock for Electrical Purposes](#)

[B193 Test Method for Resistivity of Electrical Conductor Materials](#)

[B258 Specification for Nominal Diameters and Cross-Sectional Areas of AWG Sizes of Solid Round Wires Used as Electrical Conductors](#)

2.2 *National Institute of Standards and Technology*:

[NBS Handbook 100—Copper Wire Tables](#)³

3. Ordering Information

3.1 Orders for material under this specification shall include the following information:

3.1.1 Quantity of each size,

3.1.2 Wire size: diameter in inches (5.4 and Table 1),

3.1.3 Type of copper, if special (Section 4),

3.1.4 Whether certification of resistivity of rod stock is acceptable instead of resistivity tests on the finished wire (6.2),

3.1.5 Package size (8.1),

3.1.6 Special package marking, if required, and

3.1.7 Place of inspection (7.1).

4. Materials and Manufacture

4.1 The material shall be copper of such quality and purity that the finished product shall have the properties and characteristics prescribed in this specification.

NOTE 1—Specification [B49](#) defines the materials suitable for use.

¹ This specification is under the jurisdiction of ASTM Committee B01 on Electrical Conductors and is the direct responsibility of Subcommittee B01.04 on Conductors of Copper and Copper Alloys.

Current edition approved March 15, 2007; Nov. 15, 2012. Published April 2007; November 2012. Originally approved in 1909. Last previous edition approved in 2004; 2007 as ~~B1–01~~ B1–01 (2007). DOI: 10.1520/B0001-01R07-10.1520/B0001-12.

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 the National Technical Information Service, 5285 Port Royal Road, Springfield, VA 22161.

TABLE 1 Tensile Properties

Diameter ^A		Area at 20°C			Nominal Tensile Strength ^B (see Explanatory Note 2)		Nominal Elongation, % ^B
in.	mm	cmil	in. ²	mm ²	psi	MPa	in 10 in. (250 mm)
0.4600	11.684	211 600	0.1662	107.0	49 000	340	3.8
0.4096	10.464	167 800	0.1318	85.0	51 000	350	3.3
0.3648	9.266	133 100	0.1045	67.4	52 800	365	2.8
0.3249	8.252	105 600	0.08291	53.5	54 500	375	2.4
0.2893	7.348	83 690	0.06573	42.4	56 100	385	2.2
0.2576	6.543	66 360	0.05213	33.6	57 600	395	2.0
0.2294	5.827	52 620	0.04133	26.7	59 000	405	1.8
0.2043	5.189	41 740	0.03278	21.2	60 100	415	1.7
0.1819	4.620	33 090	0.02599	16.8	61 200	420	1.6
0.1650*	4.191	27 220	0.02138	13.8	62 000	425	1.5
0.1620	4.115	26 240	0.02061	13.3	62 100	430	1.4
0.1443	3.665	20 820	0.01635	10.5	63 000	435	1.3
0.1340*	3.404	17 960	0.01410	9.10	63 400	435	1.3
0.1285	3.264	16 510	0.01297	8.37	63 700	440	1.3
0.1144	2.906	13 090	0.01028	6.63	64 300	445	1.2
0.1040*	2.642	10 820	0.008495	5.48	64 800	445	1.2
0.1019	2.588	10 380	0.008155	5.26	64 900	445	1.2
0.0920*	2.387	8 460	0.00665	4.29	65 400	450	1.1
0.0907	2.304	8 230	0.00646	4.17	65 400	450	1.1
0.0808	2.052	6 530	0.00513	3.31	65 700	455	1.1
0.0800*	2.032	6 400	0.00503	3.24	65 700	455	1.1
0.0720	1.829	5 180	0.00407	2.63	65 900	455	1.1
0.0650*	1.651	4 220	0.00332	2.14	66 200	455	1.0
0.0641	1.628	4 110	0.00323	2.08	66 200	455	1.0
0.0571	1.450	3 260	0.00256	1.65	66 400	460	1.0
0.0508	1.290	2 580	0.00203	1.31	66 600	460	1.0
0.0453	1.151	2 050	0.00161	1.04	66 800	460	1.0
0.0403	1.024	1 620	0.00128	0.823	67 000	460	1.0

^A The diameters marked by asterisks (*) are often employed by purchasers for communication lines, but are not in the American Wire Gage (B & S Wire Gage) series, as are the other diameters listed (see Explanatory Note 4).

^B These values are subject to the requirements of conformance criteria in Section 8 in determining acceptability of wire under this specification. They are intended to be used as the "minimum values" in design and in all dependent specifications.

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5. General Requirements (see Section 8)

5.1 Tensile Strength and Elongation—The wire shall conform to the requirements as to tensile strength and elongation prescribed in Table 1 (see Explanatory Note 1 and Note 2). For wire whose nominal diameter is more than 0.001 in. (±mil) (0.025 mm) greater than a size listed in Table 1 and less than that of the next larger size, the requirements of the next larger size shall apply.

5.2 Joints—No joints shall be made in the completed wire (see Explanatory Note 3). Joints in the wire and rods made prior to final drawing shall be in accordance with the best commercial practice. Tests on a specimen containing a joint shall show at least 95% of the tensile strength given in Table 1. Elongation tests shall not be made on a specimen containing a joint.

5.3 Resistivity—The electrical resistivity at 20°C shall not exceed the following values:

Nominal Diameter, in.	Resistivity at 20°C, lb/mile ²
0.460 to 0.325, incl	900.77
Under 0.325 to 0.0403, incl	910.15
Nominal Diameter, in.	Resistivity at 20°C, g/m ²
11.68 to 8.25, incl	0.15775
Under 8.25 to 1.02, incl	0.15940

5.4 Dimensions and Permissible Variations—The wire sizes shall be expressed as the diameter of the wire in decimal fractions of an inch to the nearest 0.0001 in. (or 0.001 mm) (see Explanatory Note 4). Within the range of diameters given in Table 1, the wire shall not vary from the specified diameter by more than plus and minus 1 %, expressed to the nearest 0.0001 in. (or 0.001 mm).

5.5 Finish—The wire shall be free of all imperfections not consistent with the best commercial practice.

6. Test Methods

6.1 Tensile Strength and Elongation :

6.1.1 Obtain the tensile strength, expressed in pounds per square inch, by dividing the maximum load carried by the specimen during the tension test, by the original cross-sectional area of the specimen. Tensile strength and elongation may be determined simultaneously on the same specimen.

6.1.2 Determine the elongation of the wire as the permanent increase in length due to the breaking of the wire in tension, measured between gage marks placed originally 10 in. (250 mm) apart upon the test specimen (see Explanatory Note 5).

6.1.3 If any part of the fracture takes place outside the gage marks or in the jaws of the testing machine, or if an examination of the specimen indicates a flaw, the value obtained may not be representative of the material. In such cases the test may be discarded and a new test made.

6.2 *Resistivity*— Determine the electrical resistivity of the material in accordance with Test Method B193 (see Explanatory Note 6). The purchaser may accept certification that the wire was drawn from rod stock meeting the International Standard for Annealed Copper instead of resistivity tests on the finished wire.

6.3 *Dimensional Measurements*—Dimensional measurements shall be made with equipment capable of measuring to a graduation of 0.0001 in. (0.001 mm). Take measurements on at least three places on each unit selected for this test. If accessible, take one measurement on each end and one near the middle. The average of the three measurements shall determine compliance with the requirements.

6.4 *Surface Finish*— Make a surface-finish inspection with the unaided eye (normal spectacles accepted).

7. Inspection

7.1 *General* (see Explanatory Note 7)—Unless otherwise specified in the contract or purchaser order, the manufacturer shall be responsible for the performance of all inspection and test requirements specified.

7.1.1 All inspections and tests shall be made at the place of manufacture unless otherwise specifically agreed to between the manufacturer and the purchaser at the time of the purchase.

7.1.2 The manufacturer shall afford the inspector representing the purchaser all reasonable manufacturer’s facilities to satisfy him that the material is being furnished in accordance with this specification.

7.1.3 Unless otherwise agreed upon between the purchaser and the manufacturer, conformance of the wire to the various requirements listed in Section 5 shall be determined on samples taken from each lot of wire presented for acceptance.

7.1.4 The manufacturer shall, if requested prior to inspection, certify that all wire in the lot was made under such conditions that the product as a whole conforms to the requirements of this specification as determined by regularly made and recorded tests.

7.2 Inspection and Testing Terms:

7.2.1 *Lot*—A lot is any amount of wire of one type and size presented for acceptance at one time, such amount, however, not to exceed 100 000 lb (45 000 kg) (see Explanatory Note 8).

7.2.2 *Sample*—A sample is a quantity of production units (coils, reels, etc.) selected at random from the lot for the purpose of determining conformance of the lot to the requirements of this specification.

7.2.3 *Specimen*—A specimen is a length of wire removed for test purposes from any individual production unit of the sample.

7.3 *Sample Size*— The number of production units in a sample (see Explanatory Note 7) shall be as follows:

7.3.1 For tension, elongation, and resistivity determinations, the sample shall consist of four production units. From each unit, one test specimen of sufficient length shall be removed for the performance of the required tests.

7.3.2 For dimensional measurements, the sample shall consist of a quantity of production units shown in Table 2 under the heading “First Sample.”

7.3.3 For surface-finish inspection and for packaging inspection (when specified by the purchaser at the time of placing the order) the sample shall consist of a quantity of production units shown in Table 3.

TABLE 2 Sampling for Dimensional Measurements

Number of Units in Lot	First Sample		Second Sample		Allowable Number of Defects in Both Samples, c_2
	Number of Units in Sample, n_1	Allowable Number of Defects in First Sample, c_1	Number of Units in Sample, n_2	n_1 plus n_2	
1 to 14, incl	all	0
15 to 50, incl	14	0
51 to 100, incl	19	0	23	42	1
101 to 200, incl	24	0	46	70	2
210 to 400, incl	29	0	76	105	3
401 to 800, incl	33	0	112	145	4
Over 800	34	0	116	150	4