



Designation: **A951/A951M – 11** **A951/A951M – 14**

Standard Specification for Steel Wire for Masonry Joint Reinforcement¹

This standard is issued under the fixed designation A951/A951M; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope*

1.1 This specification covers masonry joint reinforcement fabricated from cold-drawn steel wire. Joint reinforcement consists of longitudinal wires welded to cross wires.

1.2 The values stated in either ~~inch-pound~~ units or ~~inch-pound~~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 standard.

2. Referenced Documents

2.1 *ASTM Standards:*²

~~A82/A82M Specification for Steel Wire, Plain, for Concrete Reinforcement (Withdrawn 2013)~~³

~~A152 Specification for Wrought Iron Rivets and Rivet Rounds (Withdrawn 1972)~~³

~~A185/A185M Specification for Steel Welded Wire Reinforcement, Plain, for Concrete (Withdrawn 2013)~~³

~~A496/A496M Specification for Steel Wire, Deformed, for Concrete Reinforcement (Withdrawn 2013)~~³

~~A580/A580M Specification for Stainless Steel Wire~~

~~A641/A641M Specification for Zinc-Coated (Galvanized) Carbon Steel Wire~~

~~A1064/A1064M Specification for Carbon-Steel Wire and Welded Wire Reinforcement, Plain and Deformed, for Concrete~~

3. Ordering Information

3.1 It shall be the responsibility of the purchaser to specify all requirements that are necessary for the manufacture and delivery of the wire under this specification. Such requirements to be considered include, but are not limited to, the following:

3.1.1 Quantity (~~metres [linear feet]~~);(linear feet [metres]),

3.1.2 Type (truss, ladder),

3.1.3 Width (nominal thickness of masonry wall),

3.1.4 Wire size and wire specification,

3.1.5 Finish (see Section 6),

3.1.6 Packaging (see Section 12), and

3.1.7 ASTM designation number and year of issue.

4. Materials and Manufacture

4.1 Wire used in the manufacture of masonry joint reinforcement shall be round and shaped and conform to the applicable provisions of Specifications ~~A82/A82M~~A580/A580M, A1064/A1064M, or Type 304, ~~A580/A580M~~, Type or A1064/A1064M ~~304~~, except as modified herein.

NOTE 1—Specifications ~~A82/A82M~~, ~~A185/A185M~~, and ~~A496/A496M~~ have been replaced by Specification A1064/A1064M.

4.2 Masonry joint reinforcement shall be assembled by automatic machines or by other suitable mechanical means that will assure accurate spacing and alignment of all members of the finished product.

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

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

4.3 Longitudinal and cross wires shall be securely connected at every intersection by an electric-resistance welding process that includes both fusion welding together with applied pressure to join the materials.

4.4 Longitudinal wires shall be deformed. One set of two deformations shall occur around the perimeter of the wire at a maximum spacing of 0.7 times the diameter or width of the wire, but not less than eight sets per ~~25 mm [1 in.]~~ 1 in. [25 mm] of length.

NOTE 1—Wire used for joint reinforcement is knurled to form deformations and as such it does not come under the deformation requirements in ~~Specification A496/A496M or A1064/A1064M.~~

5. Mechanical Requirements

5.1 *Tensile Properties*—Wire used in the fabrication of masonry joint reinforcement shall conform to the requirements of **Table 1** based on nominal area of the wire.

5.2 *Tension Tests:*

5.2.1 Tension tests shall be made on individual wires cut from the finished product and tested either across or between the welds. No less than 50 % shall be across welds.

5.2.2 Tension tests across a weld shall have the welded joint located approximately at the center of the wire being tested.

5.2.3 Tensile strength shall be the average of four test values determined by dividing the maximum test load by the specified nominal cross-sectional area of the wire.

5.3 *Reduction of Area*—The ruptured section of the tensile specimen is measured to determine this property. The measurement shall be made only when rupture has occurred at a sufficient distance from the center of the weld to permit an accurate measurement of the fractured section. Additional testing is permitted when a suitable ruptured section is not obtained from the initial test. The wire shall meet the minimum reduction of area requirements of **Table 1**.

5.4 *Weld Shear Strength*—The weld shear strength in ~~Newtonspounds-force~~ shall not be less than ~~172-25 000~~ multiplied by the ~~specified nominal area in square millimetres for in pounds-force of the larger wire in square inches [in Newtons shall not be less than 25 000-172 multiplied by the specified nominal area of the larger wire in square inches].~~ millimeters].

NOTE 2—Since industry practice is to use butt welds in the manufacture of joint reinforcement, the weld shear strength in pounds-force is prescribed as 25 000 times the area of the larger wire rather than 35 000 times the area of the larger wire.

5.5 *Weld Shear Strength Tests:*

5.5.1 Test specimens shall be obtained from the finished product by cutting a section of longitudinal wire that includes one weld.

5.5.2 Weld shear strength tests shall be conducted using a fixture of such design as to prevent rotation of the cross wire. The cross wire shall be placed in the anvil of the testing device which is secured in the tensile machine and the load then applied to the longitudinal wire.

5.5.3 Weld shear strength shall be the average test load in ~~Newtonspounds~~ pounds [Newtons] of four test specimens selected at random.

5.6 *Bend Tests:*

5.6.1 Test specimens shall be obtained from the fabricated product by cutting a section of longitudinal wire without welds.

5.6.2 The test specimens shall be bent at room temperature through 180° around a pin, the diameter of which is equal to the nominal diameter of the specified wire. Shaped wires shall be placed on the pin so that the minimum dimension is perpendicular to the axis of the pin.

5.6.3 The specimen shall not break nor shall there be visible cracks of the base metal on the outside diameter of the bend.

6. Other Requirements

6.1 When corrosion protection of joint reinforcement is provided, it shall be in accordance with one of the following:

6.1.1 *Mill Galvanized*—Zinc coated, in accordance with the hot-dip method of Specification **A641/A641M**, with a minimum of ~~30 g/m² [0.1 oz per ft²]~~ [30 g/m²] of surface area. It shall be permissible to apply the coating before fabrication.

6.1.2 *Hot-Dip Galvanized*—Zinc coated, by the hot-dip method, in accordance with Specification **A152**, Class B (average zinc coating of ~~458 g/m² [1.50 oz per ft²]~~ [458 g/m²]). The coating shall be applied after fabrication.

7. Dimensions and Tolerances

7.1 *Longitudinal Wires*—The minimum size of longitudinal wires shall be ~~MW7 [W1.1]~~ W1.1 [MW7].

TABLE 1 Tension Test Requirements

Tensile strength, min, MPa [ksi]	550 [80]
Tensile strength, min, psi [MPa]	80 000 [550]
Yield strength, min, MPa [ksi]	485 [70]
Yield strength, min, psi [MPa]	70 000 [485]
Reduction of area, min, %	30



7.2 *Cross Wires*—The minimum size of cross wires shall be ~~MW7~~ ~~[W1.1]~~ W1.1 [MW7]. Cross wires shall not project beyond the outside longitudinal wires by more than ~~3 mm~~ ~~[1/8 in.]~~ in. [3 mm].

7.3 *Width*—The width of joint reinforcement is defined as the out-to-out distance of outside longitudinal wires. Width shall not vary by more than ~~3 mm~~ ~~[1/8 in.]~~ in. [3 mm] from the manufacturer's specified standard dimension. Width shall be measured as follows:

7.3.1 *Ladder Type Joint Reinforcement*—At opposite weld points, and

7.3.2 *Truss Type Joint Reinforcement*—From a weld point on one longitudinal wire perpendicular to a point on the opposite wire between adjacent weld points.

7.4 *Length*—The length of pieces of joint reinforcement shall not vary by more than ~~13 mm~~ ~~[1/2 in.]~~ in. [3 mm] from the specified length.

7.5 *Dimensions:*

7.5.1 The required dimensions shall be measured on three samples of joint reinforcement prior to galvanizing or on three samples from which the galvanizing has been removed.

7.5.2 Measure the dimensions of both longitudinal and cross wires to the nearest ~~0.030 mm~~ ~~[0.001 in.]~~ 0.001 in. [0.030 mm].

7.5.3 Measure the gaps between the ends of deformations around the circumference of the wire to the nearest ~~0.030 mm~~ ~~[0.001 in.]~~ 0.001 in. [0.030 mm].

8. Number of Tests

8.1 *Number of Tests*—One set of each test described herein shall be performed for each ~~91 500 metres~~ ~~[300 000 linear feet]~~ 300 000 linear feet [91 500 metres] of joint reinforcement, but not less than one set each week.

9. Inspection

9.1 The inspector representing the purchaser shall have free entry at all times, while work on the contract of the purchaser is being performed, to all parts of the manufacturer's facilities that concern the manufacture of the material ordered. The manufacturer shall afford the inspector all reasonable facilities to assure that the material is being furnished in accordance with this specification.

9.2 Except for yield strength, all tests and inspections shall be made at the place of manufacture prior to shipment, unless otherwise specified. Such tests shall be conducted so as not to interfere unnecessarily with the operation of the facilities.

9.3 If the purchaser considers it desirable to determine compliance with the strength requirements of ~~Specifications~~ Specification A82/A82M or A1064/A1064M, tension tests shall be made by a recognized laboratory, or by the wire supplier, observed by the purchaser's representative if desired, provided such tests do not interfere unnecessarily with manufacturing operations.

10. Rejection and Rehearing

10.1 Material that does not meet the requirements of this specification, shall be subject to rejection. Unless otherwise specified, any rejection shall be reported to the manufacturer within five days from the time of selection of test specimens.

10.2 In case a specimen fails to meet the tension or bend test, the material shall not be rejected until two additional specimens taken from other wires in the same bundle have been tested. The material shall be considered as meeting the specification in respect to any prescribed tensile property, provided the tested average for the three specimens, including the specimen originally tested, is equal to or exceeds the required minimum for the particular property in question, and further provided that none of the three specimens develops less than 80 % of the required minimum for the tensile property in question. The material shall be considered as meeting this specification in respect to bend test requirements provided both additional specimens satisfactorily pass the prescribed bend test.

10.3 Any material that is found not to meet the requirements of this specification subsequent to its acceptance at the manufacturer's facilities shall be subject to rejection and the manufacturer shall be notified promptly.

10.4 Welded joints shall withstand normal shipping and handling without becoming broken, but the presence of broken welds, regardless of cause, shall not constitute cause for rejection unless the number of broken welds per bundle exceeds 1 % of the total number of joints in a bundle.

10.5 In the event of rejection because of failure to meet the weld shear requirements, four additional specimens shall be taken from four different bundles and tested in accordance with 5.5. If the average of all the weld shear tests performed does not meet the requirement, the material shall be rejected.

10.6 In the event of rejection because of failure to meet the requirements for dimensions, the amount of material rejected shall be limited to those bundles which fail to meet this specification.

10.7 Rust, surface seams, or surface irregularities will not be cause for rejection provided the minimum dimensions, cross-sectional area, and tensile properties of a hand wire brushed test specimen are not less than the requirements of this specification.