



Designation: **A722/A722M – 12 A722/A722M – 15**

Standard Specification for Uncoated High-Strength Steel Bars for Prestressing ~~Prestressed~~ Concrete¹

This standard is issued under the fixed designation A722/A722M; 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 ~~uncoated~~ Type I and Type II high-strength steel bars intended for use in ~~pretensioned and post-tensioned~~ prestressed concrete construction or in prestressed ground anchors. Type I bars have a plain surface. Type II bars have surface deformations. Bars are of a minimum ~~ultimate~~ tensile strength level of 1035 MPa (150 000 psi)–150 000 psi [1035 MPa].

1.2 ~~Two types of bars are provided: Type I bar has a plain surface and Type II bar has surface deformations.~~

1.2 ~~Supplementary requirements of an optional nature are provided. They shall apply. A supplementary requirement (S1) is provided for use where bend tests of bars are required by the purchaser. The supplementary requirement applies only when specified by in the purchaser–purchase order.~~

1.3 ~~The text of this specification references notes and footnotes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the specification.~~

1.4 ~~This specification is applicable for orders in either inch-pound units (as Specification A722) or in SI units (as Specification A722M).~~

1.5 ~~The values stated in either inch-pound or SI units or inch-pound 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

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

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

~~[E30A751 Test Methods—Methods, Practices, and Terminology for Chemical Analysis of Steel, Cast Iron, Open-Hearth Iron, and Wrought Iron Steel Products \(Withdrawn 1995\)](#)~~

2.2 *Government Standards:* ~~Military Standard:~~³

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

2.3 *U.S. Federal Standards:* ~~Standard:~~³

[Fed. Std. 123 Marking for Shipment \(Civil Agencies\)](#)

3. Ordering Information

3.1 Orders for high-strength steel bars under this specification shall contain the following information:

3.1.1 Quantity,

3.1.2 Size and length,

3.1.3 Type I or Type II, and

3.1.4 ASTM designation A722 [A722M] and year-date of issue.

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 19111-5098, <http://www.dodssp.daps.mil>.

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

3.2 Orders for material under this specification should include the following information: The purchaser shall have the option to specify additional requirements, including but not limited, to the following:

- 3.2.1 Quantity, Report on chemical composition (5.1),
- 3.1.2 Name of material (uncoated high-strength bars for prestressing concrete);
- 3.1.3 ASTM designation and year of issue;
- 3.1.4 Size and length;
- 3.1.5 Type;
- 3.2.2 Special inspection requirements, if desired (see Section requirements (12.1.2),
- 3.2.3 Load-elongation curve (16.2),
- 3.2.4 Special preparation for delivery, if desired (see Section 11.7), and
- 3.1.8 Load-elongation curve, if required (see Section 15), and
- 3.2.5 Supplementary requirements, if desired: requirement (S1).

NOTE 1—A typical ordering description is as follows: 50 uncoated high-strength steel bars for prestressing concrete to ASTM A722/A722M —; 26 mm diameter, 12.20 m long, Type II; packed in accordance with A700; meeting supplementary bending properties.

4. Materials and Manufacture

4.1 The bars shall be rolled from properly identified heats of ingot cast or strand cast mold-cast or strand-cast steel. The standard sizes and dimensions of Type I and II bars shall be those listed in **Table 1** and **Table 2**, respectively.

4.2 The bars shall be subjected to cold-stressing to not less than 80 % 80 % of the minimum ultimate tensile strength, and then shall be stress-relieved, to produce the prescribed mechanical tensile properties.

5. Chemical Composition

5.1 An A chemical analysis of each heat of steel shall be made by determined in accordance with Test Methods, Practices, and Terminology A751 the manufacturer from. The manufacturer shall make the analysis on test samples taken during the pouring of each heat—the heat. When requested in the purchase order or contract, the chemical composition determined shall be reported to the purchaser.

5.1.1 Choice and use of chemical composition and alloying elements, to produce the mechanical tensile properties of the finished bar bars prescribed in Section 6.2.6, shall be made by the manufacturer, subject to the limitations in 5.1.2.

5.1.2 On heat analysis, phosphorus and sulfur shall not exceed the following:

COLSPEC/column="H"	Phosphorus	0.040 %
	Sulfur	0.050 %

5.2 A product analysis may be made by the purchaser from the finished bar representing each east or heat of steel. The phosphorus and sulfur contents thus determined shall not exceed the limits specified in 5.1.2 by 0.008 %.

5.3 Test Methods E30 shall be used for referee purposes.

6. Mechanical Properties

6.1 All testing for mechanical properties shall be performed in accordance with the requirements of Test Methods and Definitions A370.

TABLE 1 Dimensions for Type I (Plain) Bar

Nominal Diameter	Nominal Mass (Weight)	Nominal Area ^A
in.	kg/ft	in. ²
10	2.23	0.44
22	3.04	0.60
25	3.97	0.78
29	5.03	0.99
32	6.21	1.23
35	7.52	1.48

TABLE 1 Nominal Dimensions for Type I (Plain) Bars

Nominal Diameter	Nominal Weight (Mass)	Nominal Area ^A
in.	mm	mm ²
3/4	19	284
7/8	22	387
1	25	503
1 1/8	29	639
1 1/4	32	794
1 3/8	35	955

^A The nominal area is determined from the nominal diameter in inches. Values have been converted from inch-pound units to metric units [inches (millimetres)].



TABLE 2 Dimensions for Type II (Deformed) Bar

Nominal Diameter ^A	Nominal Mass (Weight)		Nominal Area ^B		
	in.	kg/m	lb/ft	mm ²	in. ²
5/8	1.46	0.98	181	0.28	
3/4	2.22	1.49	271	0.42	
1	4.48	3.01	548	0.85	
3/2	6.54	4.39	806	1.25	
1 3/8	8.28	5.56	1019	1.58	
1 1/2	13.54	9.10	1664	2.58	
1 3/4	27.10	18.20	3331	5.16	
2	35.85	24.09	4419	6.85	

TABLE 2 Nominal Dimensions for Type II (Deformed) Bars

Nominal Diameter ^A		Nominal Weight (Mass)		Nominal Area ^B	
in.	mm	lb/ft	kg/m	in. ²	mm ²
5/8	15	0.98	1.46	0.28	181
3/4	20	1.49	2.22	0.42	271
1	26	3.01	4.48	0.85	548
1 1/4	32	4.39	6.54	1.25	806
1 3/8	36	5.56	8.28	1.58	1019
1 1/2	46	9.10	13.54	2.58	1664
1 3/4	65	18.20	27.10	5.16	3331
2	75	24.09	35.85	6.85	4419

^A Nominal diameters are for identification only. Values have been converted from metric to inch-pound units.

^B The nominal area is determined from the bar weight [mass] less 3.5% for the ineffective weight [mass] of the deformations.

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6.2 Tensile Properties:

6.2.1 Finished bars shall have a minimum ultimate tensile strength of 1035 MPa (150 000 psi).

6.2.2 The minimum yield strength of Type I and Type II bars shall be 85 % and 80 %, respectively, of the minimum ultimate tensile strength of the bars. The yield strength shall be determined by either of the methods described in Test Methods and Definitions A370; however, in the extension under load method, the total strain shall be 0.7 %, and in the offset method the offset shall be 0.2 %.

6.2.3 The minimum elongation after rupture shall be 4.0 % in a gage length equal to 20 bar diameters, or 7.0 % in a gage length equal to 10 bar diameters.

6.3 Test Specimens—Tension tests shall be made using full-size bar test specimens. Machined reduced section test specimens are not permitted. All unit stress determinations shall be based on the nominal area shown in Table 1 or the effective area shown in Table 2.

6.4 Number of Tests—The number of tensile specimens tested shall be one from each 36 Mg (39 tons) or fraction thereof, of each size of bar rolled from each heat but not less than two from each heat. The specimens shall be randomly selected following the final processing operation.

6.5 Retests:

6.5.1 If any tensile property of any tension test specimen is less than that specified, and any part of the fracture is outside the middle third of the gage length, as indicated by scribe scratches marked on the specimen before testing, a retest shall be allowed.

6.5.2 If the results of an original tension test fail to meet specified requirements, two additional tests shall be made on samples of bar from the same heat and bar size, and if failure occurs in either of these tests, the bar size from that heat shall be rejected.

6.5.3 If any test specimen fails because of mechanical reasons such as failure of testing equipment, it shall be discarded and another specimen taken.

6.5.4 If any test specimen develops flaws, it shall be discarded and another specimen of the same size bar from the same heat substituted.

6. Tensile Requirements

6.1 Tension tests shall be conducted in accordance with Test Methods and Definitions A370.

6.2 Bars shall have a minimum tensile strength of 150 000 psi [1035 MPa].

6.3 The minimum yield strength of Type I and Type II bars shall be 85 % and 80 %, respectively, of the minimum tensile strength of the bars. The yield strength shall be determined by either of the methods described in Test Methods and Definitions A370; however, in the extension under load method, the total strain shall be 0.7 %, and in the offset method the offset shall be 0.2 %.

6.4 The minimum elongation after rupture shall be 4.0 % in a gage length equal to 20 bar diameters, or 7.0 % in a gage length equal to 10 bar diameters.

6.5 The minimum reduction of area from the nominal area shall be 20 % for Type I plain bars.

7. Number of Tests

7.1 The number of tension test specimens shall be one from each 39 tons [36 tonnes] or fraction thereof, of each size of bar rolled from each heat but not less than two tension test specimens from each heat.

7.2 For Type II bars, one set of dimensional property tests including bar weight [mass], and spacing, height and projected area of deformations shall be made of each bar size rolled from each heat.

8. Retests

8.1 If any tensile property of any tension test specimen is less than that specified, and any part of the fracture is outside the middle third of the gage length, as indicated by scribe scratches marked on the test specimen before testing, a retest shall be permitted.

8.2 If the results of an original tension test specimen fail to meet specified requirements, two additional tests shall be made on specimens from the same heat and bar size, and if failure occurs in either of these tests, the bar size from that heat shall be rejected.

8.3 If any test specimen fails because of mechanical reasons such as failure of testing equipment, it shall be discarded and another specimen taken.

8.4 If any test specimen develops flaws, it shall be discarded and another specimen of the same size bar from the same heat substituted.

9. Test Specimens

9.1 Tension test specimens shall be the full section of the bar as rolled. Machined-reduced section test specimens are not permitted. All unit stress determinations shall be based on the nominal area shown in [Table 1](#) or [Table 2](#).

10. Requirements for Deformations

10.1 ~~Material furnished as Type II barbars~~ shall have deformations spaced uniformly along the length of the bar. The deformations on opposite sides of the bar shall be similar in size and shape. The average spacing or distance between deformations on both sides of the bar shall not exceed ~~seven-tenths~~ seven-tenths of the nominal diameter of the bar.

10.2 The minimum height and minimum projected area of the deformations shall conform to the requirements shown in [Table 3](#).

10.3 *Mechanical Coupling*—For those bars having deformations arranged in a manner to permit coupling of the bars with a screw-on type coupler, it shall be the responsibility of the finished-bar manufacturer to demonstrate that a bar cut at any point along its length may be coupled to any other length of bar and that a coupled joint ~~supports~~ is capable of developing the minimum specified ~~ultimate tensile strength~~ ultimate tensile strength of the coupled bars. ~~The coupler type shall be provided or designed by the finished-bar manufacturer.~~

11. Measurements of Deformations

11.1 The average spacing of deformations shall be determined by dividing a measured length of the bar specimen by the number of individual deformations and fractional parts of deformations on any one side of the bar specimen. A measured length of the bar specimen shall be considered the distance from a point on a deformation to a corresponding point on any other deformation on the same side of the bar.

11.2 The average height of deformations shall be determined from measurements made on not less than two typical deformations. Determinations shall be based on three measurements per deformation: one at the center of the overall length, and the other two at the quarter points of the overall length.

11.3 To indicate adequately the conformity to the dimensional requirements, measurements shall be taken at random from one bar from each ~~30 Mg (33 tons)~~ 39 tons [36 tonnes] of each lot or fraction thereof.

11.4 Insufficient height, insufficient projected area, or excessive spacing of deformations shall not constitute cause for rejection unless it has been clearly established by determinations on each lot that typical deformation height or spacing does not conform to the minimum requirements prescribed in [Section 7.10](#). No rejection shall be made on the basis of measurements if fewer than ten adjacent deformations on each side of the bar are measured.

NOTE 1—~~The AS used within the intent of 11.3, the term “lot” shall mean~~ means all bars of the same nominal mass (weight) per metre (linear foot) ~~weight [mass] per linear foot [metre]~~ contained in an individual shipping release or shipping order.