



Designation: A394 – 08 (Reapproved 2015)

Standard Specification for Steel Transmission Tower Bolts, Zinc-Coated and Bare¹

This standard is issued under the fixed designation A394; 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 U.S. Department of Defense.

1. Scope*

1.1 This specification covers the chemical and mechanical requirements of hexagon and square-head zinc-coated steel bolts and atmospheric corrosion-resistant bolts, in nominal thread diameters of $\frac{1}{2}$, $\frac{5}{8}$, $\frac{3}{4}$, $\frac{7}{8}$ and 1 in. for use in the construction of transmission towers, substations, and similar steel structures. The various types of bolts covered in this specification are:

1.1.1 *Type 0*—Hot-dip zinc-coated bolts made of low or medium carbon steel.

1.1.2 *Type 1*—Hot-dip zinc-coated bolts made of medium carbon steel, quenched and tempered.

1.1.3 *Type 2*—Withdrawn in 2005.

1.1.4 *Type 3*—Bare (uncoated), quenched and tempered bolts made of weathering steel.

1.2 **Annex A1** of this specification covers hot-dip zinc-coated steel ladder bolts, step bolts, and support-equipment bolts.

1.3 Nuts and washers that are supplied under this specification that are hot-dip zinc coated shall be in accordance with **4.4**.

1.4 Terms used in this specification are defined in Terminology **F1789**.

1.5 The values stated in inch-pound units are to be regarded as standard. No other units of measurement are included in this standard.

1.6 *The following safety hazards caveat pertains only to the test methods portion, Section 11, of this specification. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health and environmental practices and determine the applicability of regulatory limitations prior to use.*

¹ This specification is under the jurisdiction of ASTM Committee **F16** on Fasteners and is the direct responsibility of Subcommittee **F16.02** on Steel Bolts, Studs and Nuts.

Current edition approved June 15, 2015. Published June 2015. Originally approved in 1955. Last previous edition approved in 2008 as A394 – 08^{ε1}. DOI: 10.1520/A0394-08R15.

2. Referenced Documents

2.1 ASTM Standards:²

A563 Specification for Carbon and Alloy Steel Nuts (Metric)
A0563_A0563M

D3951 Practice for Commercial Packaging

F436 Specification for Hardened Steel Washers (Metric)
F0436_F0436M

F606/F606M Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, Direct Tension Indicators, and Rivets

F788/F788M Specification for Surface Discontinuities of Bolts, Screws, Studs, and Rivets, Inch and Metric Series

F1470 Practice for Fastener Sampling for Specified Mechanical Properties and Performance Inspection

F1789 Terminology for F16 Mechanical Fasteners

F2329 Specification for Zinc Coating, Hot-Dip, Requirements for Application to Carbon and Alloy Steel Bolts, Screws, Washers, Nuts, and Special Threaded Fasteners

G101 Guide for Estimating the Atmospheric Corrosion Resistance of Low-Alloy Steels

2.2 ASME Standards:³

B1.1 Unified Screw Threads

B18.2.1 Square and Hex Bolts and Screws

B18.24 Part Identifying Number (PIN) Code System Standard for B18 Fastener Products

3. Ordering Information

3.1 Orders for products under this specification shall include the following:

3.1.1 Quantity (number of bolts and accessories).

3.1.2 Name of products, including accessories such as **A563** nuts and **F436** washers when desired.

3.1.3 Dimensions, including nominal bolt diameter and length. For bolts other than transmission-tower bolts, complete dimensions are required (see **Annex A1**).

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 American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

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

3.1.4 Type of bolt (for example, Type 0, 1, or 3).

3.1.4.1 When non-zinc-coated atmospheric corrosion-resistant steel is required, Type 3 bolts shall be specified by the purchaser.

3.1.5 ASTM designation and year of issue. When year of issue is not specified, bolts shall be furnished to the latest issue.

3.1.6 Additional requirements, if any, are to be specified on the purchase order:

3.1.6.1 Shear-strength testing (see 6.2.1 and 6.2.2). Include type of test required.

3.1.6.2 Additional tests.

3.1.6.3 Inspection (see 12.1 and 12.2).

3.1.6.4 Certification (see 14.1).

3.1.6.5 Test reports (see 14.1).

3.1.6.6 Other finishes, specify other protective finish, if required.

NOTE 1—Examples of ordering description:

(1) 1000 square-head transmission-tower bolts, ½ by 2 in. Type 1, hot-dip zinc coated, shear testing required, ASTM A394 – XX, with hot-dip zinc-coated hex nuts, Grade DH, ASTM A563 – XX,

(2) 1000 transmission tower bolts, ½ by 2 in. Type 0, hot-dip zinc coated, ASTM A394 – XX, with hot-dip zinc-coated hex nuts, Grade A, ASTM A563 – XX.

(3) 1000 transmission tower bolts, ½ by 2 in. Type 3, ASTM A394 – XX, with hex nuts, Grade DH3 weathering steel, ASTM A563 – XX and with 2 circular washers, Type 3, ASTM F436 – XX.

3.1.7 For establishment of a part identifying system, see ASME B18.24.

3.2 Recommended Nuts:

3.2.1 Unless otherwise specified, all nuts on these bolts shall be hex style and conform to the requirements of Specification A563 as follows.

| Bolt Type | Nut Grade | Finish |
|-----------|-----------|---------------------|
| 0 | A | hot-dip zinc-coated |
| 1 | DH | hot-dip zinc-coated |
| 3 | DH3 | plain |

3.3 Recommended Washers:

3.3.1 Suitable washers for use with Type 0 are hot-dip zinc-coated carbon-steel washers with dimensions that are in accordance with Specification F436. Suitable washers for use with Type 1 bolts are hot-dip zinc-coated Type 1 hardened-steel washers that are in accordance with Specification F436. Suitable washers for use with Type 3 bolts are Type 3 hardened-steel washers that are in accordance with Specification F436.

4. Materials and Manufacture

4.1 Steel for the manufacture of bolts shall be made by any of the following processes: open-hearth, electric-furnace, or basic-oxygen.

4.2 Heat Treatment:

4.2.1 Type 1 bolts produced from medium carbon steel shall be quenched in a liquid medium from above the austenizing temperature. Type 1 bolts produced from medium carbon steel to which chromium, nickel, molybdenum, or boron were intentionally added shall be quenched only in oil from above the austenizing temperature.

4.2.2 Type 3 bolts shall be quenched only in oil from above the austenizing temperature.

4.2.3 Type 1 bolts, regardless of the steel used, and Type 3 bolts shall be tempered by reheating to not less than 800°F.

4.2.4 Cold-headed Type 0 bolts shall be stress relief annealed before zinc coating to remove cold work effects such that the hardness measured anywhere on the surface or through the cross-section shall meet the requirements in 6.1.

4.3 Threads may be rolled or cut.

4.4 Zinc Coatings, Hot Dip:

4.4.1 Type 0 and Type 1 bolts shall be hot-dip zinc-coated accordance with the requirements of Specification F2329, except that the minimum average weight (thickness) of zinc coating shall be 1.65 oz/ft² (0.0028 in.) and the minimum weight of zinc coating on any one item shall be 1.50 oz/ft² (0.0025 in.).

4.4.2 Bolt threads shall not be cut, rolled, or otherwise finished after zinc coating.

4.4.3 Hot-dip zinc-coated nuts furnished under Specification A563 shall be tapped after zinc coating.

4.4.4 Hot-dip zinc-coated nuts and washers supplied for use with bolts under this specification shall be zinc-coated in accordance with 4.4.1.

4.5 Protection of Uncoated Surfaces—When hot-dip zinc-coated nuts are ordered, the cutting oil or some other suitable substance shall be left on the uncoated surface to inhibit rusting during shipment and storage. It is recommended that the additional lubricant be clean and dry to the touch.

4.6 Secondary Processing:

4.6.1 If any processing which can affect the mechanical properties or performance of the bolts is performed after the initial testing, the bolts shall be retested for all specified mechanical properties and performance requirements affected by the reprocessing.

4.6.2 When the secondary processing is heat treatment, the bolts shall be tested for all specified mechanical properties. Hot-dip zinc-coated bolts shall be tested for all specified mechanical properties.

5. Chemical Composition

5.1 Type 0 and Type 1 bolts shall conform to the chemical composition requirements specified in Table 1.

5.2 Type 3 bolts shall conform to one of the chemical compositions specified in Table 2. The selection of the chemical composition A, B, C, D, E, or F shall be at the option of the bolt manufacturer. See Guide G101 for methods of estimating the atmospheric corrosion resistance of low alloy steels.

6. Mechanical Properties

6.1 Tension Test—Types 0, 1, and 3 bolts having a length equal to or more than 3 diameters shall be wedge tension tested as specified in 11.1 and shall conform to the tensile strength requirements in Table 3. Zinc-coated bolts shall be tested after coating. Bolts too short for full size testing or for other reasons not subject to tension tests, shall meet the following hardness requirements:

TABLE 1 Chemical Requirements and Head Markings

| Head Marking | Bolt Type | Element, % | | | | |
|--------------|-----------|------------|-----------|------------|-----------------------------|-------|
| | | Carbon | Manganese | Phosphorus | Sulfur | Boron |
| T-0 | 0 | 0.55 max | ... | 0.048 max | 0.058 max | ... |
| T-1 | 1 | 0.28/0.55 | 0.60 min | 0.048 max | 0.058 max | ... |
| T-3 | 3 | ... | ... | ... | See Table 2 | ... |

TABLE 2 Chemical Requirements for Type 3 Heavy Hex Structural Bolts^A

| Element | Composition, % | | | | | |
|------------------|---------------------------|------------|-----------|-----------|-----------|-----------|
| | Type 3 Bolts ^A | | | | | |
| | A | B | C | D | E | F |
| Carbon: | | | | | | |
| Heat Analysis | 0.33–0.40 | 0.38–0.48 | 0.15–0.25 | 0.15–0.25 | 0.20–0.25 | 0.20–0.25 |
| Product Analysis | 0.31–0.42 | 0.36–0.50 | 0.14–0.26 | 0.14–0.26 | 0.18–0.27 | 0.19–0.26 |
| Manganese: | | | | | | |
| Heat Analysis | 0.90–1.20 | 0.70–0.90 | 0.80–1.35 | 0.40–1.20 | 0.60–1.00 | 0.90–1.20 |
| Product Analysis | 0.86–1.24 | 0.67–0.93 | 0.76–1.39 | 0.36–1.24 | 0.56–1.04 | 0.86–1.24 |
| Phosphorus: | | | | | | |
| Heat Analysis | 0.035 max | 0.06–0.125 | 0.035 max | 0.035 max | 0.035 max | 0.035 max |
| Product Analysis | 0.040 max | 0.06–1.25 | 0.040 max | 0.040 max | 0.040 max | 0.040 max |
| Sulfur: | | | | | | |
| Heat Analysis | 0.040 max | 0.040 max | 0.040 max | 0.040 max | 0.040 max | 0.040 max |
| Product Analysis | 0.045 max | 0.045 max | 0.045 max | 0.045 max | 0.045 max | 0.045 max |
| Silicon: | | | | | | |
| Heat Analysis | 0.15–0.35 | 0.30–0.50 | 0.15–0.35 | 0.25–0.50 | 0.15–0.35 | 0.15–0.35 |
| Product Analysis | 0.13–0.37 | 0.25–0.55 | 0.13–0.37 | 0.20–0.55 | 0.13–0.37 | 0.13–0.37 |
| Copper: | | | | | | |
| Heat Analysis | 0.25–0.45 | 0.20–0.40 | 0.20–0.50 | 0.30–0.50 | 0.30–0.60 | 0.20–0.40 |
| Product Analysis | 0.22–0.48 | 0.17–0.43 | 0.17–0.53 | 0.27–0.53 | 0.27–0.63 | 0.17–0.43 |
| Nickel: | | | | | | |
| Heat Analysis | 0.25–0.45 | 0.50–0.80 | 0.25–0.50 | 0.50–0.80 | 0.30–0.60 | 0.20–0.40 |
| Product Analysis | 0.22–0.48 | 0.47–0.83 | 0.22–0.53 | 0.47–0.83 | 0.27–0.63 | 0.17–0.43 |
| Chromium: | | | | | | |
| Heat Analysis | 0.45–0.65 | 0.50–0.75 | 0.30–0.50 | 0.50–1.00 | 0.60–0.90 | 0.45–0.65 |
| Product Analysis | 0.42–0.68 | 0.47–0.83 | 0.27–0.53 | 0.45–1.05 | 0.55–0.95 | 0.42–0.68 |
| Vanadium: | | | | | | |
| Heat Analysis | <i>B</i> | <i>B</i> | 0.020 min | <i>B</i> | <i>B</i> | <i>B</i> |
| Product Analysis | <i>B</i> | <i>B</i> | 0.010 min | <i>B</i> | <i>B</i> | <i>B</i> |
| Molybdenum: | | | | | | |
| Heat Analysis | <i>B</i> | 0.06 max | <i>B</i> | 0.10 max | <i>B</i> | <i>B</i> |
| Product Analysis | <i>B</i> | 0.07 max | <i>B</i> | 0.11 max | <i>B</i> | <i>B</i> |
| Titanium: | | | | | | |
| Heat Analysis | ... | ... | ... | ... | ... | ... |
| Product Analysis | <i>B</i> | <i>B</i> | <i>B</i> | 0.05 max | <i>B</i> | <i>B</i> |
| Product Analysis | <i>B</i> | <i>B</i> | <i>B</i> | 0.06 max | <i>B</i> | <i>B</i> |

^A A, B, C, D, E, and F are classes of material used for Type 3 bolts. Selection of a class shall be at the option of the bolt manufacturer.

^B These elements are not specified or required.

TABLE 3 Tensile Strength^A

| Nominal Size, in. | Minimum Tensile Load, lbf | |
|-------------------|---------------------------|----------------------------|
| | Type 0 ^B | Types 1 and 3 ^C |
| 1/2 | 10 500 | 17 050 |
| 5/8 | 16 700 | 27 100 |
| 3/4 | 24 700 | 40 100 |
| 7/8 | 34 200 | 55 450 |
| 1 | 44 850 | 72 700 |

^A Tensile strength based on the thread stress area, A_s , is calculated as follows:
 $A_s = 0.7854 [D - (0.9743/N)]^2$

where:

D = nominal diameter, and

N = threads per inch.

^B Based on 74 000 psi unit tensile strength.

^C Based on 120 000 psi unit tensile strength.

Type 0—Rockwell B
 Types 1 and 3—Rockwell C

6.2 Shear Strength:

6.2.1 When specified in the original inquiry and order, bolts, except as excluded in 6.2.2, shall be shear strength tested in accordance with 11.2 and shall meet the requirements given in [Table 4](#).

6.2.2 Bolts with unthreaded body lengths shorter than two times the nominal bolt diameter, are subject to shear strength testing only upon agreement between the purchaser and supplier as to testing method and shear strength values.