



Designation: A1035/A1035M – 15

# Standard Specification for Deformed and Plain, Low-Carbon, Chromium, Steel Bars for Concrete Reinforcement<sup>1</sup>

This standard is issued under the fixed designation A1035/A1035M; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reappraisal.

## 1. Scope\*

1.1 This specification covers deformed and plain low-carbon, chromium, steel bars, in cut lengths and coils for concrete reinforcement. These bars are furnished in three alloy types depending on the chromium range content. The standard sizes and dimensions of deformed bars and their number designations are given in [Table 1](#).<sup>2</sup>

1.2 Bars are of two minimum yield strength levels as defined in [9.2](#): namely, 100 000 psi [690 MPa], and 120 000 psi [830 MPa] designated as Grade 100 [690] and Grade 120 [830], respectively.

1.3 Bars are furnished to three different chemical compositions, designated as Alloy Type CL, CM, and CS. Chemical compositions are shown in [Table 2](#).

1.4 Plain bars, in sizes up to and including 2.25 in. [57.2 mm] 2½ in. [63.5 mm] in diameter in coils and cut lengths, when ordered shall be furnished under this specification in Grade 100 [690] and Grade 120 [830]. For ductility properties (elongation and bending), test provisions of the nearest smaller nominal diameter deformed bar size shall apply. Requirements providing for deformations and marking shall not be applicable.

NOTE 1—Welding of the material in this specification should be approached with caution since no specific provisions have been included to enhance its weldability. When this steel is to be welded, a welding procedure suitable for the chemical composition and intended use or service should be used.

1.5 Requirements for alternate bar sizes are presented in [Annex A1](#). The requirements in [Annex A1](#) only apply when specified by the purchaser (see [4.2.3](#)).

1.6 A supplementary requirement (S1) is provided for use where bend testing of bar sizes Nos. 14 and 18 [43, 57], and bar sizes Nos. 40, 50, and 60 in [Annex A1](#), is required by the purchaser. The supplementary requirement applies only when specified in the purchase order.

1.7 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.

1.8 This specification is applicable for orders in either inch-pound units (as Specification A1035) or in SI units (as Specification A1035M).

1.9 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*.<sup>3</sup>
- [A6/A6M Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling](#)
  - [A370 Test Methods and Definitions for Mechanical Testing of Steel Products](#)
  - [A510/A510M Specification for General Requirements for Wire Rods and Coarse Round Wire, Carbon Steel, and Alloy Steel](#)
  - [A700 Guide for Packaging, Marking, and Loading Methods for Steel Products for Shipment](#)
  - [A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products](#)
  - [E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)
  - [E290 Test Methods for Bend Testing of Material for Ductility](#)

<sup>1</sup> 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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<sup>2</sup> MMFX Technologies Corporation has several patented materials (US Patents #6,273,968, #6,709,534, #7,118,637, #7,214,278) that meet this specification. Interested parties are invited to submit information regarding the identification of an alternative(s) to this patented item to the ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee,<sup>1</sup> which you may attend.

<sup>3</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

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

**TABLE 1 Deformed Bar Designation Numbers, Nominal Weights [Masses], Nominal Dimensions, and Deformation Requirements**

Bar Designation No.	Nominal Weight, lb/ft [Nominal Mass, kg/m]	Nominal Dimensions <sup>4</sup>			Deformation Requirements, in. [mm]		
		Diameter, in. [mm]	Cross-Sectional Area, in. <sup>2</sup> [mm <sup>2</sup> ]	Perimeter in. [mm]	Maximum Average Spacing	Minimum Average Height	Maximum Gap (Chord of 12.5 % of Nominal Perimeter)
3 [10]	0.376 [ 0.560]	0.375 [ 9.5]	0.11 [ 71]	1.178 [ 29.9]	0.262 [ 6.7]	0.015 [0.38]	0.143 [ 3.6]
4 [13]	0.668 [ 0.994]	0.500 [12.7]	0.20 [ 129]	1.571 [ 39.9]	0.350 [ 8.9]	0.020 [0.51]	0.191 [ 4.9]
5 [16]	1.043 [ 1.552]	0.625 [15.9]	0.31 [ 199]	1.963 [ 49.9]	0.437 [11.1]	0.028 [0.71]	0.239 [ 6.1]
6 [19]	1.502 [ 2.235]	0.750 [19.1]	0.44 [ 284]	2.356 [ 59.8]	0.525 [13.3]	0.038 [0.97]	0.286 [ 7.3]
7 [22]	2.044 [ 3.042]	0.875 [22.2]	0.60 [ 387]	2.749 [ 69.8]	0.612 [15.5]	0.044 [1.12]	0.334 [ 8.5]
8 [25]	2.670 [ 3.973]	1.000 [25.4]	0.79 [ 510]	3.142 [ 79.8]	0.700 [17.8]	0.050 [1.27]	0.383 [ 9.7]
9 [29]	3.400 [ 5.060]	1.128 [28.7]	1.00 [ 645]	3.544 [ 90.0]	0.790 [20.1]	0.056 [1.42]	0.431 [10.9]
10 [32]	4.303 [ 6.404]	1.270 [32.3]	1.27 [ 819]	3.990 [101.3]	0.889 [22.6]	0.064 [1.63]	0.487 [12.4]
11 [36]	5.313 [ 7.907]	1.410 [35.8]	1.56 [1006]	4.430 [112.5]	0.987 [25.1]	0.071 [1.80]	0.540 [13.7]
14 [43]	7.65 [11.38 ]	1.693 [43.0]	2.25 [1452]	5.32 [135.1]	1.185 [30.1]	0.085 [2.16]	0.648 [16.5]
18 [57]	13.60 [20.24 ]	2.257 [57.3]	4.00 [2581]	7.09 [180.1]	1.58 [40.1]	0.102 [2.59]	0.864 [21.9]

<sup>4</sup> The nominal dimensions of a deformed bar are equivalent to those of a plain round bar having the same weight [mass] per foot [metre] as the deformed bar.

**TABLE 2 Chemical Compositions of Alloy Type**

Alloy Type	Composition Max, % <sup>4</sup>						
	Carbon	Chromium	Manganese	Nitrogen	Phosphorus	Sulfur	Silicon
1035 CL	0.3	2.0–3.9	1.5	0.05	0.035	0.045	0.5
1035 CM	0.2	4.0–7.9	1.5	0.05	0.035	0.045	0.5
1035 CS	0.15	8.0–10.9	1.5	0.05	0.035	0.045	0.5

<sup>4</sup> Maximum unless range is indicated; percentages refer to weight [mass] percentages.

## 2.2 U.S. Military Standard:<sup>4</sup>

**MIL-STD-129 Marking for Shipment and Storage**

## 2.3 U.S. Federal Standard:<sup>4</sup>

**Fed. Std. No. 123 Marking for Shipment (Civil Agencies)**

## 3. Terminology

### 3.1 Definitions of Terms Specific to This Specification:

3.1.1 *deformations, n*—transverse protrusions on a deformed bar.

3.1.2 *deformed bar, n*—steel bar with protrusions; a bar that is intended for use as reinforcement in reinforced concrete construction.

3.1.2.1 *Discussion*—The surface of the bar is provided with protrusions that inhibit longitudinal movement of the bar relative to the concrete surrounding the bar in such construction. The protrusions conform to the provisions of this specification.

3.1.3 *lot, n*—all the bars of one bar size and pattern of deformations contained in an individual shipping release or shipping order.

3.1.4 *plain bar, n*—steel bar without protrusions.

3.1.5 *rib, n*—longitudinal protrusion on a deformed bar.

## 4. Ordering Information

4.1 Orders for low-carbon, chromium steel bars for concrete reinforcement under this specification shall contain the following information:

<sup>4</sup> Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS. Or visit: <http://assist.daps.dla.mil/online>.

4.1.1 Quantity (weight) [mass],

4.1.2 Deformed or plain,

4.1.3 Bar designation number (size) of deformed bars, or nominal diameter (size) of plain bars,

4.1.4 Cut lengths or coils,

4.1.5 Alloy Type (see **Table 2**),

4.1.6 Grade, and

4.1.7 ASTM designation A1035 [A1035M] and year of issue.

4.2 The purchaser shall have the option to specify additional requirements, including, but not limited to, the following:

4.2.1 Special package marking requirements (**20.2**);

4.2.2 Supplementary Requirement S1, bend tests for bar sizes Nos. 14 and 18 [43 and 57], or bar sizes Nos. 40, 50, and 60 in **Annex A1**;

4.2.3 Optional requirements of **Annex A1**; and

4.2.4 Other special requirements, if any.

## 5. Materials and Manufacture

5.1 The bars shall be rolled from properly identified heats of mold-cast or strand-cast steel. The steel shall be made by any commercially accepted process.

## 6. Chemical Composition

6.1 The chemical analysis of each heat shall be determined in accordance with Test Methods, Practice, and Terminology **A751**. The manufacturer shall make the analysis on test samples taken preferably during the pouring of the heat. The percentages of carbon, manganese, phosphorus, sulfur, silicon, chromium, and nitrogen, shall be determined and reported as required in **Section 16**.

6.2 The chemical composition for the different Alloy Types as shown by heat analysis shall be limited to **Table 2** of this specification.

## 7. Requirements for Deformations

7.1 Deformations shall be spaced along the bar at substantially uniform distances. The deformations on opposite sides of the bar shall be similar in size, shape, and pattern.

7.2 The deformations shall be placed with respect to the axis of the bar so that the included angle is not less than 45°. Where the line of deformations forms an included angle with the axis of the bar from 45 to 70° inclusive, the deformations shall alternately reverse in direction on each side, or those on one side shall be reversed in direction from those on the opposite side. Where the line of deformations is over 70°, a reversal in direction shall not be required.

7.3 The average spacing or distance between deformations on each side of the bar shall not exceed seven tenths of the nominal diameter of the bar.

7.4 The overall length of deformations shall be such that the gap (measured as a chord) between the ends of the deformations on opposite sides of the bar shall not exceed 12½ % of the nominal perimeter of the bar. Where the ends terminate in a longitudinal rib, the width of the longitudinal rib shall be considered the gap. Where more than two longitudinal ribs are involved, the total width of all longitudinal ribs shall not exceed 25 % of the nominal perimeter of the bar; furthermore, the summation of gaps shall not exceed 25 % of the nominal perimeter of the bar. The nominal perimeter of the bar shall be 3.1416 times the nominal diameter.

7.5 The spacing, height, and gap of deformations shall conform to the requirements prescribed in **Table 1**.

## 8. Measurements of Deformations

8.1 The average spacing of deformations shall be determined by measuring the length of a minimum of 10 spaces and dividing that length by the number of spaces included in the measurement. The measurement shall begin from a point on a deformation at the beginning of the first space to a corresponding point on a deformation after the last included space. Spacing measurements shall not be made over a bar area containing bar marking symbols involving letters or numbers.

8.2 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.

8.3 Insufficient height, insufficient circumferential coverage, or excessive spacing of deformations shall not constitute cause for rejection unless it has been clearly established by determinations on each lot tested that typical deformation height, gap, or spacing do not conform to the minimum requirements prescribed in Section 7. No rejection shall be made on the basis of measurements if fewer than ten adjacent deformations on each side of the bar are measured.

## 9. Tensile Requirements

9.1 The material, as represented by the test specimens, shall conform to the requirements for tensile properties prescribed in **Table 3**.

9.2 The yield strength shall be determined by the offset method (0.2 % offset), described in Test Methods and Definitions **A370**.

9.3 When material is furnished in coils, the test specimen shall be taken from the coil and straightened prior to placing it in the jaws of the tensile testing machine. (See **Note 2**.)

**NOTE 2**—Straighten the test specimen to avoid formation of local sharp bends and to minimize cold work. Insufficient straightening prior to attaching the extensometer can result in lower-than-actual yield strength readings.

9.3.1 Test specimens taken from post-fabricated material shall not be used to determine conformance to this specification. (See **Note 3**.)

**NOTE 3**—Multiple bending distortion from mechanical straightening and fabricating machines can lead to excessive cold work, resulting in higher yield strengths, lower elongation values, and a loss of deformation height.

9.4 The percentage of elongation shall be as prescribed in **Table 3**.

## 10. Bending Requirements

10.1 The bend test specimen shall withstand being bent around a pin without cracking on the outside radius of the bent portion. The requirements for degree of bending and sizes of pins are prescribed in **Table 4**. When material is furnished in coils, the test specimen shall be straightened prior to placement in the bend tester.

10.2 The bend test shall be made on specimens of sufficient length to ensure free bending and with apparatus that provides:

10.2.1 Continuous and uniform application of force throughout the duration of the bending operation.

10.2.2 Unrestricted movement of the specimen at points of contact with the apparatus and bending around a pin free to rotate.

**TABLE 3 Tensile Properties Requirements**

Type	A1035 CL		A1035 CM		A1035 CS	
	Grade 100 [690]	Grade 120 [830]	Grade 100 [690]	Grade 120 [830]	Grade 100 [690]	Grade 120 [830]
Tensile strength, min, psi [MPa]	130 000 [900]	150 000 [1030]	150 000 [1030]	150 000 [1030]	150 000 [1030]	150 000 [1030]
Yield strength (0.2 % offset), min, psi [MPa]	100 000 [690]	120 000 [830]	100 000 [690]	120 000 [830]	100 000 [690]	120 000 [830]
Elongation in 8 in. [200 mm], min, %:						
Bar Designation No.						
3 through 11 [10 through 36]	7	7	7	7	7	7
14, 18 [43, 57]	6	6	6	6	6	6