



Designation: B1001 – 17

Standard Specification for Copper Electrode Wire Used for Welding Seams of Steel Cans¹

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1. Scope

1.1 This specification establishes the requirements for drawn, soft annealed round copper electrode wire used in welding machines for the purpose of seam welding of cans.

1.2 *Units*—The values stated in SI units are to be regarded as standard. The values given in parentheses are mathematical conversions to inch-pound units that are provided for information only and are not considered standard.

1.3 *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards*:²

- [B49 Specification for Copper Rod for Electrical Purposes](#)
- [B193 Test Method for Resistivity of Electrical Conductor Materials](#)
- [B224 Classification of Coppers](#)
- [B250/B250M Specification for General Requirements for Wrought Copper Alloy Wire](#)
- [B258 Specification for Nominal Diameters and Cross-Sectional Areas of AWG Sizes of Solid Round Wires Used as Electrical Conductors](#)
- [E8/E8M Test Methods for Tension Testing of Metallic Materials](#)
- [E53 Test Method for Determination of Copper in Unalloyed Copper by Gravimetry](#)
- [E2575 Test Method for Determination of Oxygen in Copper and Copper Alloys \(Withdrawn 2017\)](#)³

¹ This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.02 on Rod, Bar, Wire, Shapes and Forgings.

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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.

[F16 Test Methods for Measuring Diameter or Thickness of Wire and Ribbon for Electronic Devices and Lamps](#)

[2.2 NIST Document](#):⁴

[NBS Handbook 100 Copper Wire Tables](#)

3. General Requirements

3.1 The following sections of Specification [B250/B250M](#), as applicable, constitute a part of this specification:

- 3.1.1 Terminology,
- 3.1.2 Materials and Manufacture,
- 3.1.3 Workmanship, Finish, and Appearance,
- 3.1.4 Sampling,
- 3.1.5 Number of Tests and Retests,
- 3.1.6 Test Methods,
- 3.1.7 Significance of Numerical Limits,
- 3.1.8 Inspection,
- 3.1.9 Rejection and Rehearing,
- 3.1.10 Certification,
- 3.1.11 Test Report, and
- 3.1.12 Packaging and Package Marking.

4. Ordering Information

4.1 Include the following specified choices when placing orders for product under this specification, as applicable:

- 4.1.1 ASTM designation and year of issue,
- 4.1.2 Copper [Alloy] UNS No. designation (see Classification [B224](#)),
- 4.1.3 Temper (Temper Section 7),
- 4.1.4 Form (wire) and size (diameter) (Dimensions and Permissible Variations Section 11),
- 4.1.5 How furnished: straight length or coils,
- 4.1.6 Quantity; weight for each size and form,
- 4.1.7 Intended application, and
- 4.1.8 Package type (stem, reel, bulk or drum).
- 4.1.9 The following options are available but may not be included unless specified at the time of placing the order, when required:
 - 4.1.9.1 Heat identification or traceability details,
 - 4.1.9.2 Electromagnetic (eddy current) examination,

⁴ Available from National Institute of Standards and Technology (NIST), 100 Bureau Dr., Stop 1070, Gaithersburg, MD 20899-1070, <http://www.nist.gov>.

- 4.1.9.3 Certification, and
- 4.1.9.4 Mill Test Report.

5. Materials and Manufacture

5.1 Materials:

5.1.1 The material of manufacture shall be drawn wire of the designated copper UNS number of such purity to be suitable for use prescribed herein.

5.2 Manufacture:

5.2.1 The product shall be manufactured by hot-working, cold-working, and annealing processes to produce a uniform structure in the finished product.

5.2.2 The product shall be hot- or cold-worked to the finished size and subsequently annealed to meet the temper properties specified.

6. Chemical Composition

6.1 The material shall conform to the chemical composition requirements in **Table 1** for the copper UNS number designation specified in ordering information.

6.2 These composition limits do not preclude the presence of other elements. By agreement between the manufacturer and purchaser, limits may be established and analysis required for specific elements.

7. Temper

7.1 The standard temper for the product described in this specification include:

- 7.1.1 O60 Soft Annealed or Hard Temper H04.

8. Physical Properties

8.1 Electrical resistivity in annealed condition at 20 °C: 0.15328 Ω·g/m² Maximum (100.00 % IACS Minimum). (See NBS Handbook 100.)

9. Mechanical Properties

9.1 Product furnished to this specification shall conform to the tensile requirements prescribed in **Table 2**.

9.1.1 Tensile requirements for product diameters not covered in **Table 2** shall be agreed upon by the manufacturer and the supplier.

9.2 Acceptance or rejection based upon mechanical properties shall depend upon tensile strength and elongation.

9.2.1 Tensile tests performed on samples containing a rod joint (weld) shall provide a tensile strength of at least 95 % of the minimum requirement provided in **9.2**.

10. Other Requirements

10.1 The surface of electrode wire shall be free of oxides visible to the eye.

10.2 The surface of electrode wire shall be free of flaws that may interfere with the welding or feeding process.

10.3 The surface of electrode wire shall be free of oils and other contaminants that may interfere with welding.

11. Dimensions, Mass, and Permissible Variations

11.1 Electrode wire diameter sizes shall be expressed as the nominal diameter of the wire in decimal fractions of a millimeter to the nearest 0.001 mm.

NOTE 1—This specification considers the normal range of nominal electrode wire diameters to range from 1.200 to 2.500 mm (0.047 to 0.098 in.). Dimensional requirements outside of this range shall be addressed in the purchase order or contract.

11.2 The diameter (individual measurements and the mean) of the wire shall not vary more than plus 1 % or minus 2 % from the stated nominal value of the electrode wire.

12. Workmanship, Finish, and Appearance

12.1 Electrode wire shall be free from defects that would render it unsuitable for its intended application.

13. Sampling

13.1 For routine sampling of electrode wire for conformance, the method of sampling shall be in accordance with **14.1** unless otherwise agreed upon by the purchaser and the supplier.

13.2 *Electrode Wire Lot*—A container, or group of containers, of electrode wire with homogenous test results in a quantity of 4536 kg (10 000 lb) or less.

13.3 In case of dispute concerning chemical composition, electrical resistivity, mechanical properties, or size, the method of sampling shall be in accordance with Section **15** with a sample from each container under dispute. If the test sample passes the appropriate test(s), the product in the specific container shall be considered to conform to the requirements of this specification. If the test piece sample fails the appropriate test(s) the product in the specific container shall be determined not to conform to the requirements of this standard specification.

13.4 In case of special requirements specified in the purchase order or contract, the method of sampling shall be as agreed between the supplier and the purchaser.

14. Number of Tests and Retests

14.1 Tests:

14.1.1 Chemical composition of electrode wire may be determined from the analysis of rod used as feedstock for the production of the wire.

14.1.1.1 If chemical composition cannot be determined from rod feedstock analysis, chemical composition shall be determined as the mean of at least two replicate analyses of each sample of wire.

14.1.2 Electrical resistivity shall be determined from the results of at least one sample per lot. Electrical resistivity may be determined from results of rod feedstock used to fabricate the electrode wire.

TABLE 1 Chemical Composition

UNS Number Copper Type	C11000 ^A ETP	C11020 ^A FRHC
Copper incl silver, min	99.90 %	99.90 %
Oxygen	<650 ppm	<650 ppm

^A See Specification **B49**.