



Designation: **B232/B232M—11 B232/B232M – 17**

Standard Specification for Concentric-Lay-Stranded Aluminum Conductors, Coated- Steel Reinforced (ACSR)¹

This standard is issued under the fixed designation B232/B232M; 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 concentric-lay-stranded conductors made from round aluminum 1350-H19 (extra hard) wires and round, coated steel core wire(s) for use as overhead electrical conductors (Explanatory [Note 1](#) and Explanatory [Note 2](#)).

1.2 ACSR covered by this specification has nine types of coated steel core wire which are designated by abbreviations as follows (Explanatory [Note 2](#)):

- 1.2.1 *ACSR/GA* or *ACSR/GA2*—ACSR using Class A zinc-coated steel wire,
- 1.2.2 *ACSR/GC* or *ACSR/GC2*—ACSR using Class C zinc-coated steel wire,
- 1.2.3 *ACSR/MA* or *ACSR/MA2*—ACSR using Class A Zn-5Al-MM coated steel wire,
- 1.2.4 *ACSR/HS* or *ACSR/GA3*—ACSR using Class A zinc-coated high-strength steel wires,
- 1.2.5 *ACSR/MS* or *ACSR/MA3*—ACSR using Class A Zn-5Al-MM coated high-strength steel wires,
- 1.2.6 *ACSR/GA4*—ACSR using Class A zinc-coated extra-high-strength steel wires,
- 1.2.7 *ACSR/MA4*—ACSR using Class A Zn-5Al-MM coated extra-high-strength steel wires,
- 1.2.8 *ACSR/GA5*—ACSR using Class A zinc-coated ultra-high-strength steel wires,
- 1.2.9 *ACSR/MA5*—ACSR using Class A Zn-5Al-MM coated ultra-high-strength steel wires.

1.3 The values stated in either SI units or inch-pound units are to be regarded separately as standard. 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.

1.4 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.

1.5 This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.

2. Referenced Documents

2.1 The following documents of the issue in effect on date of material purchase form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards*:²

[B230/B230M Specification for Aluminum 1350–H19 Wire for Electrical Purposes](#)

[B263 Test Method for Determination of Cross-Sectional Area of Stranded Conductors](#)

[B354 Terminology Relating to Uninsulated Metallic Electrical Conductors](#)

[B498/B498M Specification for Zinc-Coated \(Galvanized\) Steel Core Wire for Use in Overhead Electrical Conductors](#)

[B500/B500M Specification for Metallic Coated or Aluminum Clad Stranded Steel Core for Use in Overhead Electrical Conductors](#)

[B606 Specification for High-Strength Zinc-Coated \(Galvanized\) Steel Core Wire for Aluminum and Aluminum-Alloy Conductors, Steel Reinforced](#)

¹ This specification is under the jurisdiction of ASTM Committee B01 on Electrical Conductors and is the direct responsibility of Subcommittee B01.07 on Conductors of Light Metals.

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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.



- B802/B802M Specification for Zinc–5 % Aluminum-Mischmetal Alloy-Coated Steel Core Wire for Aluminum Conductors, Steel Reinforced (ACSR)
- B803 Specification for High-Strength Zinc–5 % Aluminum-Mischmetal Alloy-Coated Steel Core Wire for Use in Overhead Electrical Conductors
- B957 Specification for Extra-High-Strength and Ultra-High-Strength Zinc-Coated (Galvanized) Steel Core Wire for Overhead Electrical Conductors
- B958 Specification for Extra-High-Strength and Ultra-High-Strength Class A Zinc–5% Aluminum-Mischmetal Alloy-Coated Steel Core Wire for Use in Overhead Electrical Conductors
- E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- E527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)
- 2.3 *ANSI Documents:*
 - ANSI H35.1 American National Standard Alloy and Temper Designation Systems for Aluminum³
 - ANSI H35.1M American National Standard for Alloy and Temper Designations Systems for Aluminum [Metric]³
- 2.4 *NIST Document:*
 - NBS Handbook 100—Copper Wire Tables⁴
- 2.5 *Aluminum Association Document:*
 - Publication 50, Code Words for Overhead Aluminum Electrical Conductors⁵

3. Terminology

- 3.1 *Definitions:*
 - 3.1.1 *Galvanized*—zinc coated.
 - 3.1.2 *Aluminized*—aluminum coated.
- 3.2 *Abbreviations:*
 - 3.2.1 *Zn-5Al-MM*—zinc-5 % aluminum-mischmetal alloy.
 - 3.2.2 *ACSR*—aluminum conductor, steel reinforced.
 - 3.2.3 *ACSR/GA or ACSR/GA2*—reinforced with galvanized steel core wire, coating Class A in accordance with Specification B498/B498M.
 - 3.2.4 *ACSR/GC or ACSR/GC2*—reinforced with galvanized steel core wire, coating Class C in accordance with Specification B498/B498M.
 - 3.2.5 *ACSR/HS or ACSR/GA3*—reinforced with high-strength galvanized steel core wire in accordance with Specification B606.
 - 3.2.6 *ACSR/MA or ACSR/MA2*—reinforced with Zn-5Al-MM coated steel core wire, coating Class A in accordance with Specification B802/B802M.
 - 3.2.7 *ACSR/MS or ACSR/MA3*—reinforced with high-strength Zn-5Al-MM coated steel core wire in accordance with Specification B803.
 - 3.2.8 *ACSR/MA4*—reinforced with extra-high-strength Zn-5Al-MM coated steel core wire in accordance with Specification B958.
 - 3.2.9 *ACSR/GA4*—reinforced with extra-high-strength galvanized steel core wire in accordance with Specification B957.
 - 3.2.10 *ACSR/MA5*—reinforced with ultra-high-strength Zn-5Al-MM coated steel core wire in accordance with Specification B958.
 - 3.2.11 *ACSR/GA5*—reinforced with ultra-high-strength galvanized steel core wire in accordance with Specification B957.

4. Classification

- 4.1 For the purpose of this specification conductors are classified as follows (Explanatory Notes 1 and 2):
 - 4.1.1 *Class AA*—For bare conductors usually used in overhead lines. These conductors are divided into two types as follows:
 - 4.1.1.1 Conductors used for regular over-head line construction, and
 - 4.1.1.2 Conductors having a high ratio of mechanical strength to current-carrying capacity used for overhead ground wires and for extra-long span construction. These are denoted under the Class column in Table 1 and Table 2 as “(HS)” for High Strength.
 - 4.1.2 *Class A*—For conductors to be covered with weather-resistant materials.

5. Ordering Information

- 5.1 Orders for material under this specification shall include the following information:
 - 5.1.1 Quantity of each size, stranding, and class,

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

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

⁵ Available from Aluminum Association, Inc., 1525 Wilson Blvd., Suite 600, Arlington, VA 22209, <http://www.aluminum.org>.



TABLE 1 Construction Requirements of Aluminum Conductors, Steel Reinforced (ACSR)

Size		Code Words ^A	Class	Stranding Design Aluminum/ Steel	Stranding						Nominal O.D. of Conductors, in.	Mass, lb/1000 ft
cmil	AWG				Aluminum Wires			Steel Wires				
					Number	Diameter, in.	Layers	Number	Diameter, in.	Layers		
2 312 000	...	Thrasher	AA	76/19	76	0.1744	4	19	0.0814	2	1.802	2523
2 167 000	...	Kiwi	AA	72/7	72	0.1735	4	7	0.1157	1	1.735	2301
2 156 000	...	Bluebird	AA	84/19	84	0.1602	4	19	0.0961	2	1.762	2508
1 780 000	...	Chukar	AA	84/19	84	0.1456	4	19	0.0874	2	1.602	2072
1 590 000	...	Falcon	AA	54/19	54	0.1716	3	19	0.1030	2	1.545	2042
1 590 000	...	Lapwing	AA	45/7	45	0.1880	3	7	0.1253	1	1.504	1790
1 510 500	...	Parrot	AA	54/19	54	0.1672	3	19	0.1003	2	1.505	1938
1 510 500	...	Nuthatch	AA	45/7	45	0.1832	3	7	0.1221	1	1.466	1700
1 431 000	...	Plover	AA	54/19	54	0.1628	3	19	0.0977	2	1.465	1838
1 431 000	...	Bobolink	AA	45/7	45	0.1783	3	7	0.1189	1	1.427	1611
1 351 500	...	Martin	AA	54/19	54	0.1582	3	19	0.0949	2	1.424	1735
1 351 500	...	Dipper	AA	45/7	45	0.1733	3	7	0.1155	1	1.386	1521
1 272 000	...	Pheasant	AA	54/19	54	0.1535	3	19	0.0921	2	1.382	1634
1 272 000	...	Bittern	AA	45/7	45	0.1681	3	7	0.1121	1	1.345	1432
1 272 000	...	Skylark	AA	36/1	36	0.1880	3	1	0.1880	0	1.316	1286
1 192 500	...	Grackle	AA	54/19	54	0.1486	3	19	0.0892	2	1.338	1531
1 192 500	...	Bunting	AA	45/7	45	0.1628	3	7	0.1085	1	1.302	1342
1 113 000	...	Finch	AA	54/19	54	0.1436	3	19	0.0862	2	1.293	1430
1 113 000	...	Bluejay	AA	45/7	45	0.1573	3	7	0.1049	1	1.259	1254
1 033 500	...	Curlew	AA	54/7	54	0.1383	3	7	0.1383	1	1.245	1329
1 033 500	...	Ortolan	AA	45/7	45	0.1515	3	7	0.1010	1	1.212	1163
1 033 500	...	Tanager	AA	36/1	36	0.1694	3	1	0.1694	0	1.186	1044
954 000	...	Cardinal	AA	54/7	54	0.1329	3	7	0.1329	1	1.196	1227.1
954 000	...	Rail	AA	45/7	45	0.1456	3	7	0.0971	1	1.165	1074
954 000	...	Catbird	AA	36/1	36	0.1628	3	1	0.1628	0	1.140	964
900 000	...	Canary	AA	54/7	54	0.1291	3	7	0.1291	1	1.162	1158
900 000	...	Ruddy	AA	45/7	45	0.1414	3	7	0.0943	1	1.131	1013
795 000	...	Mallard	AA	30/19	30	0.1628	2	19	0.0977	2	1.140	1233.9
795 000	...	Condor	AA	54/7	54	0.1213	3	7	0.1213	1	1.092	1022
795 000	...	Tern	AA	45/7	45	0.1329	3	7	0.0886	1	1.063	895
795 000	...	Drake	AA	26/7	26	0.1749	2	7	0.1360	1	1.108	1093
795 000	...	Cuckoo	AA	24/7	24	0.1820	2	7	0.1213	1	1.092	1023
795 000	...	Coot	AA	36/1	36	0.1486	3	1	0.1486	0	1.040	803.6
715 500	...	Redwing	AA	30/19	30	0.1544	2	19	0.0926	2	1.081	1109.3
715 500	...	Starling	AA	26/7	26	0.1659	2	7	0.1290	1	1.051	983.7
715 500	...	Stilt	AA	24/7	24	0.1727	2	7	0.1151	1	1.036	921
666 600	...	Gannet	AA	26/7	26	0.1601	2	7	0.1245	1	1.014	916.2
666 600	...	Flamingo	AA	24/7	24	0.1667	2	7	0.1111	1	1.000	857.9
636 000	...	Egret	AA	30/19	30	0.1456	2	19	0.0874	2	1.019	987.2
636 000	...	Scoter	AA	30/7	30	0.1456	2	7	0.1456	1	1.019	995.1
636 000	...	Grosbeak	AA	26/7	26	0.1564	2	7	0.1216	1	0.990	874.2
636 000	...	Rook	AA	24/7	24	0.1628	2	7	0.1085	1	0.977	818.2
636 000	...	Swift	AA	36/1	36	0.1329	3	1	0.1329	0	0.930	642.8
636 000	...	Kingbird	AA	18/1	18	0.1880	2	1	0.1880	0	0.940	689.9
605 000	...	Teal	AA	30/19	30	0.1420	2	19	0.0852	2	0.994	938.6
605 000	...	Wood Duck	AA	30/7	30	0.1420	2	7	0.1420	1	0.994	946.5
605 000	...	Squab	AA	26/7	26	0.1525	2	7	0.1186	1	0.966	831.3
605 000	...	Peacock	AA	24/7	24	0.1588	2	7	0.1059	1	0.953	778.8
556 500	...	Eagle	AA	30/7	30	0.1362	2	7	0.1362	1	0.953	870.7
556 500	...	Dove	AA	26/7	26	0.1463	2	7	0.1138	1	0.927	765.2
556 500	...	Parakeet	AA	24/7	24	0.1523	2	7	0.1015	1	0.914	716.1
556 500	...	Osprey	AA	18/1	18	0.1758	2	1	0.1758	0	0.879	603.3
477 000	...	Hen	AA	30/7	30	0.1261	2	7	0.1261	1	0.883	746.4
477 000	...	Hawk	AA	26/7	26	0.1354	2	7	0.1053	1	0.858	655.3
477 000	...	Flicker	AA	24/7	24	0.1410	2	7	0.0940	1	0.846	613.9
477 000	...	Pelican	AA	18/1	18	0.1628	2	1	0.1628	0	0.814	517.3
397 500	...	Lark	AA	30/7	30	0.1151	2	7	0.1151	1	0.806	621.8
397 500	...	Ibis	AA	26/7	26	0.1236	2	7	0.0961	1	0.783	546.0
397 500	...	Brant	AA	24/7	24	0.1287	2	7	0.0858	1	0.772	511.4
397 500	...	Chickadee	AA	18/1	18	0.1486	2	1	0.1486	0	0.743	431.0
336 400	...	Oriole	AA	30/7	30	0.1059	2	7	0.1059	1	0.741	526.4
336 400	...	Linnet	AA	26/7	26	0.1137	2	7	0.0884	1	0.720	462.0
336 400	...	Merlin	AA	18/1	18	0.1367	2	1	0.1367	0	0.684	364.8
300 000	...	Ostrich	AA	26/7	26	0.1074	2	7	0.0835	1	0.680	412.2
266 800	...	Partridge	AA	26/7	26	0.1013	2	7	0.0788	1	0.642	366.9
266 800	...	Waxwing	AA	18/1	18	0.1217	2	1	0.1217	0	0.609	289.1
211 600	0000	Penguin	AA, A	6/1	6	0.1878	1	1	0.1878	0	0.563	290.8
211 300	...	Cochin	AA (HS)	12/7	12	0.1327	1	7	0.1327	1	0.664	526.8
203 200	...	Brahma	AA (HS)	16/19	16	0.1127	1	19	0.0977	2	0.714	674.6
190 800	...	Dorking	AA (HS)	12/7	12	0.1261	1	7	0.1261	1	0.631	475.7
176 900	...	Dotterel	AA (HS)	12/7	12	0.1214	1	7	0.1214	1	0.607	440.9



TABLE 1 Continued

Size		Code Words ^A	Class	Stranding Design Aluminum/ Steel	Stranding						Nominal O.D. of Conductors, in.	Mass, lb/1000 ft
cmil	AWG				Aluminum Wires			Steel Wires				
					Number	Diameter, in.	Layers	Number	Diameter, in.	Layers		
167 800	000	Pigeon	AA, A	6/1	6	0.1672	1	1	0.1672	0	0.502	230.5
159 000	...	Guinea	AA (HS)	12/7	12	0.1151	1	7	0.1151	1	0.576	396.3
134 600	...	Leghorn	AA (HS)	12/7	12	0.1059	1	7	0.1059	1	0.530	335.5
133 100	00	Quail	AA, A	6/1	6	0.1489	1	1	0.1489	0	0.447	182.8
110 800	...	Minorca	AA (HS)	12/7	12	0.0961	1	7	0.0961	1	0.481	276.3
105 600	0	Raven	AA, A	6/1	6	0.1327	1	1	0.1327	0	0.398	145.2
101 800	...	Petrel	AA (HS)	12/7	12	0.0921	1	7	0.0921	1	0.461	253.8
83 690	1	Robin	AA, A	6/1	6	0.1181	1	1	0.1181	0	0.354	115.0
80 000	...	Grouse	AA (HS)	8/1	8	0.1000	1	1	0.1670	0	0.367	148.8
66 360	2	Sparate	AA, A	7/1	7	0.0974	1	1	0.1299	0	0.325	106.63
66 360	2	Sparrow	AA, A	6/1	6	0.1052	1	1	0.1052	0	0.316	91.2
41 740	4	Swanate	AA, A	7/1	7	0.0772	1	1	0.1029	0	0.257	66.95
41 740	4	Swan	AA, A	6/1	6	0.0834	1	1	0.0834	0	0.250	57.35
33 090	5	...	A	6/1	6	0.0743	1	1	0.0743	0	0.223	45.51
26 240	6	Turkey	AA, A	6/1	6	0.0661	1	1	0.0661	0	0.198	36.02

^A Code words shown are provided here for information only. These code names apply to Class AA Bare Aluminum Conductors, Steel Reinforced (ACSR) as shown above. They do not apply to Class A products shown in the above table.

Conversion factors:

1 cmil = 5.067 E – 0.4 mm²

1 in. = 2.54 E + 01 mm

1 lb/1000ft = 1.488 E + 00 kg/km

1 ft = 3.048 E – 01 m

1 lb = 4.536 E – 01 kg

1 lbf = 4.448 E – 03 kN

- 5.1.2 Conductor size, circular-mil area or AWG (Section 9 and Table 1),
- 5.1.3 Number of wires, aluminum and steel (see Tables 1-5),
- 5.1.4 Type of steel core wire and type and area density (if applicable) of coating (see 6.2),
- 5.1.5 Direction of lay of outer layer of aluminum wires if other than right-hand (see 8.3),
- 5.1.6 Special tension test, if desired (see 15.3),
- 5.1.7 Place of inspection (Section 16),
- 5.1.8 Package size and type (see 17.1),
- 5.1.9 Heavy wood lagging, if required (see 17.3), and
- 5.1.10 Special package marking, if required (see 17.4).

6. Requirement for Wires

6.1 Before stranding, the aluminum wire used shall meet the requirements of Specification B230/B230M.

6.2 Before stranding, the steel core wire used shall meet the requirements of Specification B498/B498M, B606, B802/B802M, B803, B957, or B958, whichever is applicable.

7. Joints

7.1 Electric-butt welds, cold-pressure welds, and electric-butt, cold-upset welds in the finished individual aluminum wires composing the conductor may be made during the stranding process. No weld shall occur within 50 ft [15 m] of a weld in the same wire or in any other wire of the completed conductor (Explanatory Note 3).

7.2 There shall be no joints of any kind made in the finished zinc-coated or zinc-5% aluminum-mischmetal alloy coated steel wires.

8. Lay

8.1 The length of lay of the various layers of aluminum wires in a conductor shall conform to Table 5 (see Explanatory Note 4).

8.2 The length of lay of the various layers of steel wire shall conform to the requirements of B500/B500M.

8.3 The direction of lay of the outside layer of aluminum wires shall be right hand unless otherwise specified in the purchaser order. The direction of lay of the aluminum and steel wires shall be reversed in successive layers.

8.4 In a conductor having multiple layers of aluminum wires, the lay ratio of any aluminum layer shall be not greater than the lay ratio of the aluminum layer immediately beneath it. Similarly, in a conductor having multiple layers of steel wires in the core, the lay ratio of a steel layer shall not be greater than the lay ratio of the steel layer immediately beneath it.



TABLE 2 Construction Requirements—Aluminum Conductors, Steel Reinforced (ACSR)

Size, mm ²	Class	Stranding Design	Stranding						Nominal Outside Diameter of Conductors, mm	Mass, kg/km
			Aluminum Wires			Steel Wires				
			Number	Diameter, mm	Layers	Number	Diameter, mm	Layers		
1250	AA	84/19	84	4.35	4	19	2.61	2	47.85	4274
1250	AA	76/19	76	4.58	4	19	2.14	2	47.34	4023
1250	AA	72/7	72	4.70	4	7	3.13	1	46.99	3901
1120	AA	84/19	84	4.12	4	19	2.47	2	45.31	3833
1120	AA	76/19	76	4.33	4	19	2.02	2	44.74	3595
1120	AA	72/7	72	4.45	4	7	2.97	1	44.51	3499
1000	AA	84/19	84	3.89	4	19	2.33	2	42.77	3416
1000	AA	72/7	72	4.21	4	7	2.81	1	42.11	3132
900	AA	84/19	84	3.69	4	19	2.21	2	40.57	3073
900	AA	72/7	72	3.99	4	7	2.66	1	39.9	2812
800	AA	54/19	54	4.34	3	19	2.60	2	39.04	3015
800	AA	45/7	45	4.76	3	7	3.17	1	38.07	2652
710	AA	54/19	54	4.09	3	19	2.45	2	36.79	2678
710	AA	45/7	45	4.48	3	7	2.99	1	35.85	2351
630	AA	54/19	54	3.85	3	19	2.31	2	34.65	2375
630	AA	45/7	45	4.22	3	7	2.81	1	33.75	2084
560	AA	54/19	54	3.63	3	19	2.18	2	32.68	2112
560	AA	45/7	45	3.98	3	7	2.65	1	31.83	1854
500	AA	54/7	54	3.43	3	7	3.43	1	30.87	1889
500	AA	45/7	45	3.76	3	7	2.51	1	30.09	1656
450	AA	54/7	54	3.26	3	7	3.26	1	29.34	1706
450	AA	45/7	45	3.57	3	7	2.38	1	28.56	1492
400	AA	30/19	30	4.12	2	19	2.47	2	28.83	1824
400	AA	26/7	26	4.43	2	7	3.45	1	28.07	1622
400	AA	24/7	24	4.61	2	7	3.07	1	27.65	1515
355	AA	30/19	30	3.88	2	19	2.33	2	27.17	1620
355	AA	26/7	26	4.17	2	7	3.24	1	26.4	1435
355	AA	24/7	24	4.34	2	7	2.89	1	26.03	1343
315	AA	30/19	30	3.66	2	19	2.20	2	25.64	1443
315	AA	26/7	26	3.93	2	7	3.06	1	24.9	1277
315	AA	24/7	24	4.09	2	7	2.73	1	24.55	1194
315	AA	18/1	18	4.72	2	1	4.72	0	23.6	1014
280	AA	30/7	30	3.45	2	7	3.45	1	24.15	1291
280	AA	26/7	26	3.70	2	7	2.88	1	23.44	1131
280	AA	24/7	24	3.85	2	7	2.57	1	23.11	1058
280	AA	18/1	18	4.45	2	1	4.45	0	22.25	901.0
250	AA	30/7	30	3.26	2	7	3.26	1	22.82	1152
250	AA	26/7	26	3.50	2	7	2.72	1	22.16	1011
250	AA	24/7	24	3.64	2	7	2.43	1	21.85	946.0
250	AA	18/1	18	4.21	2	1	4.21	0	21.05	806.4
224	AA	30/7	30	3.08	2	7	3.08	1	21.56	1029
224	AA	26/7	26	3.31	2	7	2.57	1	20.95	904.0
224	AA	24/7	24	3.45	2	7	2.30	1	20.7	849.2
224	AA	18/1	18	3.98	2	1	3.98	0	19.9	720.7
200	AA	30/7	30	2.91	2	7	2.91	1	20.37	918.2
200	AA	26/7	26	3.13	2	7	2.43	1	19.81	808.3
200	AA	24/7	24	3.26	2	7	2.17	1	19.55	757.6
200	AA	18/1	18	3.76	2	1	3.76	0	18.8	643.2
180	AA	30/7	30	2.76	2	7	2.76	1	19.32	826.0
180	AA	26/7	26	2.97	2	7	2.31	1	18.81	728.6
180	AA	24/7	24	3.09	2	7	2.06	1	18.54	681.2
180	AA	18/1	18	3.57	2	1	3.57	0	17.85	579.9
160	AA	30/7	30	2.61	2	7	2.61	1	18.27	738.6
160	AA	26/7	26	2.80	2	7	2.18	1	17.74	648.0
160	AA	24/7	24	2.91	2	7	1.94	1	17.46	604.2
160	AA	18/1	18	3.36	2	1	3.36	0	16.8	513.7
140	AA	26/7	26	2.62	2	7	2.04	1	16.6	567.4
140	AA	24/7	24	2.73	2	7	1.82	1	16.38	531.8



TABLE 2 Continued

Size, mm ²	Class	Stranding Design	Stranding						Nominal Outside Diameter of Conductors, mm	Mass, kg/km
			Aluminum Wires			Steel Wires				
			Number	Diameter, mm	Layers	Number	Diameter, mm	Layers		
140	AA	18/1	18	3.15	2	1	3.15	0	15.75	451.5
125	AA	26/7	26	2.47	2	7	1.92	1	15.64	503.7
125	AA	24/7	24	2.58	2	7	1.72	1	15.48	474.9
125	AA	18/1	18	2.97	2	1	2.97	0	14.85	401.3
100	AA (HS)	16/19	16	2.82	1	19	2.44	2	17.84	972.4
100	AA (HS)	12/7	12	3.26	1	7	3.26	1	16.3	734.1
100	AA, A	6/1	6	4.61	1	1	4.61	0	13.83	404.8
90	AA (HS)	12/7	12	3.09	1	7	3.09	1	15.45	659.5
80	AA (HS)	12/7	12	2.91	1	7	2.91	1	14.55	584.9
80	AA, A	6/1	6	4.12	1	1	4.12	0	12.36	323.3
71	AA (HS)	12/7	12	2.74	1	7	2.74	1	13.7	518.6
63	AA (HS)	12/7	12	2.59	1	7	2.59	1	12.95	463.4
63	AA, A	6/1	6	3.66	1	1	3.66	0	10.98	255.2
56	AA (HS)	12/7	12	2.44	1	7	2.44	1	12.2	411.2
50	AA (HS)	12/7	12	2.30	1	7	2.30	1	11.5	365.4
50	AA, A	6/1	6	3.26	1	1	3.26	0	9.78	202.4
40	AA (HS)	8/1	8	2.52	1	1	4.20	0	9.24	217.9
40	AA, A	6/1	6	2.91	1	1	2.91	0	8.73	161.3
31.5	AA, A	7/1	7	2.39	1	1	3.19	0	7.97	148.4
31.5	AA, A	6/1	6	2.59	1	1	2.59	0	7.77	127.8
25	AA, A	7/1	7	2.13	1	1	2.84	0	7.1	117.8
25	AA, A	6/1	6	2.30	1	1	2.30	0	6.9	100.8
20	AA, A	7/1	7	1.91	1	1	2.55	0	6.37	94.80
20	AA, A	6/1	6	2.06	1	1	2.06	0	6.18	80.83
16	AA, A	6/1	6	1.84	1	1	1.84	0	5.52	64.49
12.5	AA, A	6/1	6	1.63	1	1	1.63	0	4.89	50.61

9. Construction

9.1 ACSR may be constructed using steel core wire with any one of two types of protective coatings. The acceptable core wires are:

- 9.1.1 Galvanized steel core wires, with coating Classes A or C in accordance with Specification B498/B498M;
- 9.1.2 High-strength galvanized steel core wire, coating Class A in accordance with Specification B606;
- 9.1.3 Zn-5Al-MM coated steel core wire, coating Class A, in accordance with Specification B802/B802M;
- 9.1.4 High-strength Zn-5Al-MM coated steel core wire, coating Class A in accordance with Specification B803;
- 9.1.5 Extra-high-strength galvanized steel core wire coating Class A in accordance with Specification B957;
- 9.1.6 Extra-high-strength Zn-5Al-MM coated steel core wire, coating Class A in accordance with Specification B958;
- 9.1.7 Ultra-high-strength galvanized steel core wire coating Class A in accordance with Specification B957; or
- 9.1.8 Ultra-high-strength Zn-5Al-MM coated steel core wire, coating Class A in accordance with Specification B958.

9.2 The number and diameter of aluminum and steel wires and the area of cross section of aluminum wires shall conform to the requirements prescribed in Tables 1-5.

9.3 Where compressed stranding is required in order to insulate the conductor properly, one or more aluminum layers of any stranded conductor consisting of 7 wires or more may be slightly compressed. The nominal diameter of the compressed conductor is 3 % below the nominal diameter of noncompressed conductor and the area of cross section after compressing is in accordance with Section 13.

9.4 For “HS” (High Strength) type conductors as denoted in Table 1 and Table 2, unless specified by the customer, the default strength of steel shall be regular strength Type GA2 to Specification B498/B498M or MA2 to Specification B802/B802M.

9.5 All steel wires shall lie naturally in their position in the stranded core, and where the core is cut, the wire ends shall remain in position or be readily replaced by hand and then remain approximately in position. This requirement also applies to the outer layer of aluminum wires of a conductor.

9.6 The stranded steel core shall be free from waviness and kinks.

9.7 Before stranding, aluminum and steel wires shall have approximately uniform temperatures.

9.8 The diameter of the finished conductor shall be not less than 99 % nor more than 101 % of that shown in Table 1 and Table 2 when measured with a diameter tape between the closing die(s) and the capstan of the strander.