



Designation: A648 – 18

Standard Specification for Steel Wire, Hard-Drawn for Prestressed Concrete Pipe¹

This standard is issued under the fixed designation A648; 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 two classes of uncoated, high-strength, hard-drawn steel wire for use in the manufacture of prestressed concrete pipe. In application, the wire is helically wrapped on the pipe maintaining tension by mechanical means not including drawing dies.

1.2 A supplementary requirement (S1) is provided for use where hydrogen embrittlement (HE) resistance testing is required by the purchaser. Supplementary requirement (S1), which establishes acceptance criteria for HE resistance testing, applies only when specified in the purchase order or contract.

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

1.4 The following caveat pertains only to the test method portions of this specification, 6.3.3 and 6.5.3: *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, 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 ASTM Standards:²

A370 Test Methods and Definitions for Mechanical Testing of Steel Products

A510 Specification for General Requirements for Wire Rods and Coarse Round Wire, Carbon Steel

A700 Guide for Packaging, Marking, and Loading Methods for Steel Products for Shipment

A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys

A1032 Test Method for Hydrogen Embrittlement Resistance for Steel Wire Hard-Drawn Used for Prestressed Concrete Pipe

E328 Test Methods for Stress Relaxation for Materials and Structures

2.2 ANSI Standard:³

C 304 Standard for Design of Prestressed Concrete Cylinder Pipe

3. Terminology

3.1 Definitions:

3.1.1 For definition of terms used in this specification, refer to Terminology A941.

4. Ordering Information

4.1 Orders for hard-drawn steel wire under this specification shall contain the following information:

4.1.1 Quantity (weight),

4.1.2 Name of material (hard-drawn steel wire for prestressed concrete pipe),

4.1.3 Wire diameter (see Table 1),

4.1.4 Class (Table 1), and

4.1.5 ASTM designation 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 Requirements for inspection (9.1),

4.2.2 Special package marking requirements (Section 12),

4.2.3 Supplementary Requirement S1, and

4.2.4 Other special requirements, if any.

5. Manufacture and Chemical Requirements

5.1 The steel shall be made by any commercially accepted process.

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

TABLE 1 Tensile Requirements

Wire Gage or Fraction, in.	Decimal Size, in. (mm)	Class II Wire				Class III Wire			
		Minimum Tensile Strength, ^A ksi (MPa)	Breaking Strength, lbf (kN)		Minimum Tensile Strength, ^A ksi (MPa)	Breaking Strength, lbf (kN)			
			min	max		min	max		
6	0.192 (4.88)	222 (1530)	6 430 (28.6)	7 300 (32.5)	252 (1740)	7 300 (32.5)	8 170 (36.3)		
¼	0.250 (6.35)	211 (1450)	10 360 (46.1)	11 830 (52.6)	240 (1650)	11 780 (52.4)	13 250 (58.9)		
⅝	0.312 (7.92)	201 (1390)	15 370 (68.4)	17 660 (78.6)	221 (1520)	16 900 (75.2)	19 190 (85.4)		

^A Based on nominal wire diameter.

TABLE 2 Chemical Requirements

NOTE 1—Class I wire has been discontinued.

NOTE 2—Where “. . .” appear in this table, there is no requirement or limit.

	Classes II and III
Carbon, %	0.50–0.85
Manganese, %	0.50–1.10
Phosphorus, max, %	0.030
Sulfur, max, %	0.035
Silicon, %	0.10–0.35
Nitrogen, max, %	0.007
Aluminum, %	...
Titanium, %	...
Chromium, %	...
Nickel, %	...
Molybdenum, %	...
Copper, %	...
Vanadium, %	...

5.2 The steel shall be free of injurious piping and undue segregation.

5.3 The wire shall be cold drawn to produce the prescribed mechanical properties. The wire manufacturer shall take dependable precautions during wire drawing to preclude detrimental strain aging of the wire.

NOTE 1—Allowing wire to remain at elevated temperatures, such as 400°F (204°C) for more than 5 s or 360°F (182°C) for more than 20 s, can result in detrimental strain aging of the wire. Detrimentially strain-aged wire typically has reduced ductility and increased susceptibility to hydrogen embrittlement.

5.4 There shall be no welds or joints in the finished wire. Any welds or joints made during manufacture to enable continuity of operations shall be removed.

5.5 Chemical Requirements:

5.5.1 The heat analysis of the steel shall conform to the chemical requirements specified in [Table 2](#).

5.5.2 An analysis of each heat of steel shall be furnished by the manufacturer showing the percentages of all the elements specified in [Table 2](#). The wire shall be subject to permissible variation for product analysis specified in Specification [A510](#), Table 7.

6. Mechanical Property Requirements

6.1 Mechanical property requirements are applicable only prior to or during pipe manufacture.

6.2 *Test Specimens*—It shall be permissible to take wire specimens for tensile and torsion tests from either end of a coil. Wire test specimens shall be representative of that coil’s wire drawing conditions with regard to wire temperature.

6.3 Tension Test:

6.3.1 *Tensile Requirements*—Tensile requirements shall conform to those prescribed in [Table 1](#) for the specified size and class.

6.3.2 *Number of Tests*—One test specimen shall be taken from each coil.

6.3.3 *Test Method*—Tension tests shall be made in accordance with Test Methods and Definitions [A370](#), Annex A4. Tension test reports shall include the coil number tested, the measured wire diameter, and the measured breaking strength.

6.3.4 *Reduction-of-Area Test*—The reduction of area requirement for the specimens used for the tension test in [6.2](#) shall be a minimum of 35 % for 0.192 in. (4.88 mm) wire and 30 % for larger wire as described and tested in accordance with Test Methods and Definitions [A370](#), Annex A4.

6.4 Relaxation Test:

6.4.1 *Number of Tests*—Relaxation test results shall be provided for purposes of qualifying the procedures used to manufacture wire for prestressed concrete pipe. Relaxation test results shall include one specimen from a minimum of three coils of wire from the same or different heats of steel where the wire specimens are of the same nominal size, the same class, and manufactured using the same drawing machine and drawing procedures. It shall be permissible to provide the relaxation test results from the wire manufacturer’s historical records.

6.4.2 *Test Method*—Wire shall be tested as described in Test Methods [E328](#).

6.4.3 *Conditions of Tests*—The conditions of the tests are:

6.4.3.1 At least one of the tests performed shall have a duration of 1000 h minimum, and all other tests shall have a duration of at least 200 h. Measurements shall be made and recorded for at least five data points during each time interval of (1) 0 to 10 h, (2) 10 to 100 h, and (3) 100 to 1000 h, except that, if a test is terminated in less than 1000 h, measurements shall be made for at least two data points in the third interval. For tests terminated in less than 1000 h, the expected relaxation of the specimen at 1000 h shall be determined from the linear-regression curve of stress loss on a logarithm time scale.

6.4.3.2 The temperature of the test specimen shall be maintained at 68 ± 3.5°F (20 ± 2°C).

6.4.3.3 The test specimen shall not be subjected to loading, including specimen straightening, prior to the relaxation test, except that it shall be permissible to straighten the specimen ends to fit in the testing machine jaws.

6.4.3.4 Loading shall be applied at an essentially constant rate over a period of not less than 3 min and not more than 5 min until the initial load is reached. Thereafter, the gage length

shall be maintained constant. Load-relaxation readings shall commence 1 min after the initial load has been reached.

6.4.3.5 The initial load shall be 70 % of the specified minimum breaking strength of the wire. Overstressing of the test specimen to a level greater than 70 % of the specified minimum breaking strength during loading shall not be permitted.

6.4.3.6 The test gage length shall be at least 60 times the nominal diameter of the wire.

6.4.3.7 The result of each relaxation test shall be reported either as the actual percent of stress loss after 1000 h or the extrapolated percent of stress loss after 1000 h as determined from the linear-regression curve.

NOTE 2—In accordance with ANSI/AWWA C 304, ordinary prestressed concrete pipe design is based on an assumed maximum wire relaxation of 7.48 % at 1000 h. Wire with higher relaxation can be used, but the higher relaxation loss must be known for consideration in the pipe design.

6.5 Torsion Test:

6.5.1 *Torsion Requirements*—Torsion requirements shall conform to those prescribed in Table 3 for the specified size and class.

6.5.2 *Number of Tests*—One test specimen shall be taken from each coil.

6.5.3 *Test Method*—Conduct the torsion test in accordance with the following:

6.5.3.1 Use a twist rate of 10 to 30 r/min.

6.5.3.2 Load the wire with an axial force of from 0.5 to 2 % of the minimum breaking strength of the wire.

6.5.3.3 Use a test specimen length, defined as the distance between the testing machine jaws, of a minimum of 8 in. (203 mm).

6.5.3.4 Use a minimum number of turns proportional to the length of the test specimen based upon Table 3.

6.5.3.5 The test shall be conducted to fracture, defined as complete separation of the broken ends. The test specimens shall be inspected for primary break shear area and longitudinal (spiral) splitting following completion of the torsion test.

(1) *Primary Break Shear*—The primary break face of the test specimen shall have a clean, flush, full shear face, perpendicular to the wire axis (see Fig. 1).

(2) *Longitudinal (Spiral) Splitting*—If the fractured specimen shows evidence of a spiral split, either visible without magnification (see Fig. 2) or by an offset in the wire surfaces (see Fig. 3) detectable with a fingernail, a retest of that coil shall be conducted in accordance with 6.5.3.5 (3).

(3) *Retest for Splitting in Torsion*—The retest specimen shall have a minimum length of 8 in. (203 mm). The retest shall consist of twisting the retest specimen proportionally to three twists per 8 in. (203 mm) specimen length, at which point the twisting shall be stopped and the specimen inspected while still

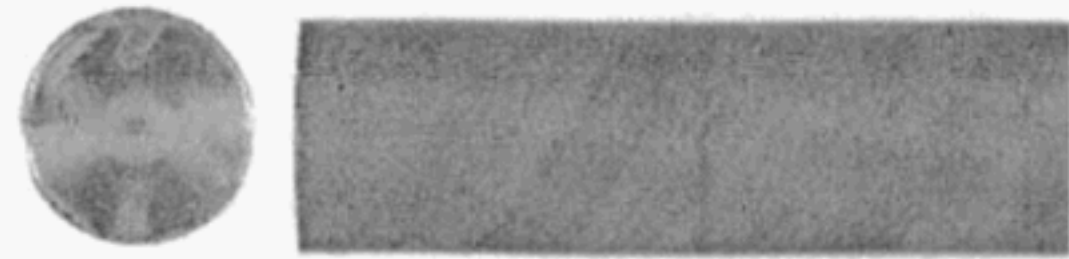


FIG. 1 Acceptable View of the Break Face

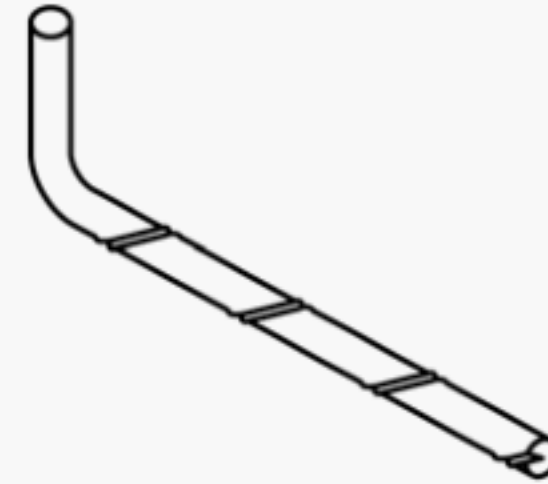


FIG. 2 Visible Longitudinal (Spiral) Splitting After Torsion Testing

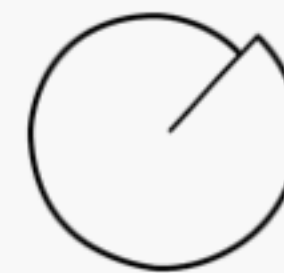


FIG. 3 End View of Offset Longitudinal (Spiral) Split After Torsion Testing

in the torsion machine. A spiral split in this specimen, either visible without magnification or detectable with a fingernail, shall be cause for rejection of the coil.

6.5.3.6 The tested coil number, specimen length, and total number of turns shall be recorded.

6.6 *Report of Mechanical Property Test Results*—The wire manufacturer shall furnish a report listing the tensile, reduction-of-area, and torsion test results.

7. Dimensions and Permissible Variations

7.1 The diameter of the wire shall not vary from that specified by more than ± 0.002 in. (0.05 mm) in diameter nor more than 0.002-in. (0.05-mm) out-of-round.

8. Workmanship, Finish, and Appearance

8.1 The surface of the wire as received shall be smooth and generally free of rust. A light oxidation film that does not cause pitting of the wire surface visible to a person with normal or corrected vision after wiping or light cleaning, shall not be cause for rejection. Coils of wire with visible pitting shall be rejected.

8.2 The wire shall not have detrimental piping, cross checking, torn surfaces, chatter marks, splits, die marks, scratches, pits, or seams.

8.3 The wire shall not be kinked, improperly cast, or show a wavy condition.

8.4 Each coil shall be one continuous length of wire, properly coiled.

8.5 The wire shall not be oiled or greased.

TABLE 3 Torsion Requirements

Wire Gage or Fraction in.	Decimal Size, in. (mm)	Class II and Class III min turns per 8 in. (203 mm)
6	0.192 (4.88)	10
1/4	0.250 (6.35)	8
5/16	0.312 (7.92)	7

9. Inspection

9.1 Inspection of the hard-drawn steel wire shall be agreed upon between the purchaser and the manufacturer as part of the purchase order or contract.

10. Certification

10.1 At the time of shipment, the purchaser shall be furnished with a written certification that specimens representing each lot have been either tested or inspected as required in this specification and the requirements have been satisfied. The certification shall include ASTM designation A648, year of issue, and revision letter, if any.

10.2 A material test report, certificate of inspection, or similar document printed from or used in electronic form from an electronic data interchange (EDI) transmission shall be regarded as having the same validity as a counterpart printed in the certifier's facility. The content of the EDI transmitted document shall meet the requirements of the invoked ASTM standard(s) and conform to any existing EDI agreement between the purchaser and the manufacturer. Notwithstanding the absence of a signature, the organization submitting the EDI transmission is responsible for the content of the report.

NOTE 3—The industry definition as invoked here is: EDI is the computer-to-computer exchange of business information in a standard format such as ANSI ASC X12.

11. Rejection, Retesting, and Rehearing

11.1 Failure of any specimen to meet the mechanical property requirements of this specification when tested by the manufacturer, except splitting during torsion testing, shall be cause either for rejection of the coil represented by the specimen or for retesting two additional specimens from that coil. If either additional specimen fails the retest for the mechanical property requirement in which the first specimen failed, the coil in question shall be rejected. Requirements for retesting coils which split during torsion testing are described in 6.5.3.5 (3).

11.2 Any rejection based on tests made in accordance with the specification shall be reported to the wire manufacturer within a reasonable period of time. The material shall be adequately protected and correctly identified so that the wire manufacturer may make a proper investigation.

12. Product Marking and Packaging

12.1 The size of the wire, purchaser's order number, ASTM specification and class number, heat number, coil number, and name of the manufacturer shall be marked on a durable tag securely attached to each coil of wire.

12.2 Unless otherwise specified, packaging shall be in accordance with the procedures in Practices A700.

13. Keywords

13.1 prestressed concrete pipe; prestressing; steel wire

SUPPLEMENTARY REQUIREMENTS

The following supplementary requirement shall apply only when specified in the purchaser order or contract.

S1. Acceptance Criteria for Hydrogen Embrittlement Resistance Testing

S1.1 *Test Results*—For a single diameter and class of wire, the results of hydrogen embrittlement tests performed in accordance with Test Method A1032 shall be submitted to the purchaser. No test shall result in a time-to-failure of less than 75 hours. The results shall be derived from tests conducted anytime within the previous 12 months on wire of the same diameter and class and made from the same rod source as the wire being furnished. The hydrogen embrittlement test report described in Test Method A1032 shall be submitted to the purchaser at the time of delivery of wire or as agreed between purchaser and wire manufacturer.

S1.2 *Test Specimens*—For a single diameter and class of wire, three wire test specimens shall be taken from each of three different rod heats from the same rod source, having chemical analyses that conform to the parameters stated in the purchase order or contract and also conforming to the Chemical Requirements listed in Table 2. All wire to be tested shall be manufactured using the same wire drawing procedure. Each of the test specimens shall be taken from a different coil of wire.

S1.3 *Alternate Test Specimens*—The wire manufacturer may elect, during time periods of limited wire demand, to take three wire test specimens for a single diameter and class of wire from one heat of rod from the same source to produce wire for a specific purchase order or contract and single production of wire. The wire shall meet all of the additional requirements in S1.2.

S1.4 *Retests*—If time-to-failure for one specimen from any heat is less than 75 hours, retesting of two specimens taken from test units from two additional coils from the same rod heat of steel shall be performed. If both retest specimens have time-to-failure of 75 hours or greater, those two results shall be reported. If either retest has a time-to-failure less than 75 hours, no wire drawn from the failing rod heat of steel shall be supplied to purchase orders or contracts requiring this supplementary requirement. To meet the requirements of S1.2, specimens representing a fourth heat of steel shall be then submitted for testing.

SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this standard since the last issue (A648 – 12) that may impact the use of this standard. (Approved March 1, 2018.)

- (1) Added Section **3**.
- (2) Revised Section **4**, **6.2**, **6.4.3.5**, **9.1**, and **10.1**.
- (3) Revised and combined Section 4, Manufacture, and Section 5, Chemical Requirements, into Section **5**, Manufacture and Chemical Requirements.

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