Standard Specification for
Steel Wire, High Tensile Strength, Cold Drawn

1 This specification covers round, uncoated, high tensile strength, cold-drawn steel spring wire, having properties and quality suitable for the manufacture of mechanical springs and wire forms subject to high static stresses or infrequent dynamic load, or both.

2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other.

2.1 ASTM Standards:
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
A510M Specification for General Requirements for Wire Rods and Coarse Round Wire, Carbon Steel (Metric)
A700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Shipment
A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products
A941 Terminology Relating to Steel, Stainless Steel, Related Alloys, and Ferroalloys
E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
B32.4 Preferred Metric Sizes for Round, Square, Rectangle, and Hexagon Metal Products

This standard is issued under the fixed designation A679/A679M; 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 (´) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This specification covers round, uncoated, high tensile strength, cold-drawn steel spring wire, having properties and quality suitable for the manufacture of mechanical springs and wire forms subject to high static stresses or infrequent dynamic load, or both.

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other.

2. Referenced Documents

2.1 ASTM Standards:
A370 Test Methods and Definitions for Mechanical Testing of Steel Products
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2.2 ANSI Standard:
B32.4 Preferred Metric Sizes for Round, Square, Rectangle, and Hexagon Metal Products

3. Terminology

3.1 Definitions—For definitions of terms used in this specification, refer to Terminology A941.

4. Ordering Information

4.1 It shall be the responsibility of the purchaser to specify all requirements that are necessary for material under this specification. Such requirements may include, but are not limited to, the following:

4.1.1 Quantity (mass),
4.1.2 Name of material (steel wire, high tensile strength, hard drawn),
4.1.3 Dimensions (Table 1 and Section 9),
4.1.4 Packaging (Section 15),
4.1.5 Heat analysis report, if requested (6.2),
4.1.6 Certification or test report, or both, if specified (Section 14), and
4.1.7 ASTM designation and year of issue.

NOTE 1—A typical ordering description is as follows: 20 Mg high tensile strength, hard-drawn steel mechanical spring wire, 5.00-mm diameter, 500-kg coils to ASTM A679/A679M dated ____ , or for inch-pound units, 40 000-lb high tensile strength, hard-drawn steel mechanical spring wire, 0.192-in. diameter, in 1000-lb coils to ASTM A679/A679M dated ____ .

4.2 Materials and Manufacture

5.1 The steel may be made by any commercially accepted steel making process. The steel may be either ingot cast or continuous strand cast. The rod to be used in the manufacture of wire furnished to this specification shall be in accordance with Specifications A510 or A510M.

5.2 The finished wire shall be free from detrimental pipe and undue segregation.

* A Summary of Changes section appears at the end of this standard
5.3 The wire shall be cold drawn to produce the desired mechanical properties.

5.4 The wire finish shall be suitable for forming or coiling. It is not intended that this material be furnished with a metallic coating.

6. Chemical Composition

6.1 The steel shall conform to the requirements for chemical composition prescribed in Table 2.

6.2 Heat Analysis—Each heat of steel shall be analyzed by the manufacturer to determine the percentage of elements prescribed in Table 2. This analysis shall be made from a test specimen preferably taken during the pouring of the heat. When requested, in the purchase order, the heat analysis shall be reported to the purchaser.

6.3 Product Analysis—An analysis may be made by the purchaser from finished wire representing each heat of steel. The chemical composition thus determined, as to elements required or restricted, shall conform to the product analysis requirements specified in Table 7 of Specifications A510 or A510M.

6.4 For referee purposes, Test Methods, Practices, and Terminology A751 shall be used.

7. Mechanical Properties

7.1 Tension Test:

7.1.1 Requirements—The material as represented by tension test specimens shall conform to the requirements prescribed in Table 1.

7.1.2 Number of Tests—One test specimen shall be taken for each 10 coils or fraction thereof, in a lot. Each heat in a given lot shall be tested.

7.1.3 Test Method—The tension test shall be made in accordance with Test Methods and Definitions A370.

7.2 Wrap Test:

7.2.1 Requirements—The material as represented by the wrap test specimens shall conform to the requirements specified in Table 3.

7.2.2 Number of Tests—One test specimen shall be taken for each 10 coils, or fraction thereof, in a lot. Each heat in a given lot shall be tested.

7.2.3 Location of Test—Test specimens shall be taken from either end of the coil.

7.2.4 Test Method—The wrap test shall be made in accordance with Test Methods and Definitions A370.

8. Metallurgical Requirements

8.1 Microstructure—The wire shall be cold drawn with a fine pearlite structure.

8.2 Surface Conditions—The wire surface shall not exhibit imperfections that exceed 3.5 % of the wire diameter or 0.25 mm (0.010 in.) in depth, whichever is smaller.

9. Dimensions and Permissible Variations

9.1 The permissible variations in the diameter of the wire shall be as specified in Table 4.

10. Workmanship, Finish, and Appearance

10.1 Workmanship—The wire shall not be kinked or improperly cast. To test for cast, one convolution of wire shall be cut from the coil and placed on a flat surface. The wire shall not spring up excessively nor show a wavy condition.

10.1.1 Each coil shall be one continuous length of wire, properly coiled and firmly tied. Welds made prior to cold drawing are permitted.

### Table 2 Chemical Requirements

<table>
<thead>
<tr>
<th>Element</th>
<th>Composition, %</th>
</tr>
</thead>
<tbody>
<tr>
<td>Carbon</td>
<td>0.65–1.00&lt;sup&gt;a&lt;/sup&gt;</td>
</tr>
<tr>
<td>Manganese</td>
<td>0.20–1.30&lt;sup&gt;a&lt;/sup&gt;</td>
</tr>
<tr>
<td>Phosphorus</td>
<td>0.040</td>
</tr>
<tr>
<td>Sulfur</td>
<td>0.080</td>
</tr>
<tr>
<td>Silicon</td>
<td>0.15–0.35</td>
</tr>
</tbody>
</table>

<sup>a</sup> Carbon in any one lot shall not vary more than 0.13 %.

<sup>a</sup> Manganese in any one lot shall not vary more than 0.30 %.

### Table 3 Wrap Test Requirements<sup>a</sup>

<table>
<thead>
<tr>
<th>SI Units</th>
<th>Diameter, mandrel size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mandrel Size</td>
<td>Diameter, mm</td>
</tr>
<tr>
<td></td>
<td>Over 0.50 to 3.00, incl</td>
</tr>
<tr>
<td></td>
<td>Over 3.00 to 5.00, incl</td>
</tr>
<tr>
<td>Inch-Pound Units</td>
<td>Diameter, in.</td>
</tr>
<tr>
<td>Mandrel Size</td>
<td>Over 0.020 to 0.162, incl</td>
</tr>
<tr>
<td></td>
<td>Over 0.162 to 0.207, incl</td>
</tr>
</tbody>
</table>

<sup>a</sup> The symbol "X" represents the diameter of the wire tested.
10.2 Appearance—The surface shall be smooth and free of rust with no imperfections such as pits or die marks that tend to impair the use of the wire for springs. Any other surface requirements shall be negotiated at the time of entry of the order.

11. Retests

11.1 If any test specimen exhibits obvious imperfections or shows the presence of a weld, it may be discarded and another specimen substituted.

12. Inspection

12.1 Unless otherwise specified in the contract or purchase order, the manufacturer is responsible for the performance of all inspection and test requirements specified in this specification. Except as otherwise specified in the contract or purchase order, the manufacturer may use his own or any other suitable facilities for the performance of the inspection and test requirements unless disapproved by the purchaser at the time the order is placed. The purchaser shall have the right to perform any of the inspections and tests set forth in this specification when such inspections and tests are deemed necessary to assure that the material conforms to prescribed requirements.

13. Rejection and Rehearing

13.1 Unless otherwise specified, any rejection based on tests made in accordance with these specifications shall be reported to the manufacturer as soon as possible so that an investigation may be initiated.

13.2 The material shall be adequately protected and correctly identified in order that the manufacturer is able to make a proper investigation.

14. Certification

14.1 When specified in the purchase order or contract, a producer’s or supplier’s certification shall be furnished to the purchaser that the material was manufactured, sampled, tested, and inspected in accordance with this specification and has been found to meet the requirements. When specified in the purchase order or contract, a report of the test results shall be furnished.

14.2 The certification shall include the specification number, year of issue, and revision letter, if any.

15. Marking for Shipment

15.1 The coil mass, dimensions, and the method of packaging shall be agreed upon between the manufacturer and purchaser.

15.2 A tag shall be securely attached to each coil of wire with identifying information as agreed upon by the purchaser and manufacturer.

15.3 Unless otherwise specified in the purchaser’s order, packaging, marking, and loading for shipments shall be in accordance with those procedures recommended by Practices A700.

15.4 Marking for shipment of material for civil agencies shall be in accordance with Fed. Std. No. 123.

15.5 Bar Coding—In addition to the previously-stated identification requirements, bar coding is acceptable as a supplementary identification method. Bar coding should be consistent with AIAG Standard 02.00. The bar code may be applied to a substantially affixed tag.

16. Keywords

16.1 hard drawn; high tensile; wire

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TABLE 4 Permissible Variations in Wire Diameter

<table>
<thead>
<tr>
<th>Diameter, mm</th>
<th>Permissible Variations, ±mm</th>
<th>Permissible Out-of-Round, ±mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>To 0.70, incl</td>
<td>0.02</td>
<td>0.02</td>
</tr>
<tr>
<td>0.70 to 2.00, incl</td>
<td>0.03</td>
<td>0.03</td>
</tr>
<tr>
<td>Over 2.00</td>
<td>0.05</td>
<td>0.05</td>
</tr>
</tbody>
</table>

Inch-Pound Units

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>0.020 to 0.028, incl</td>
<td>0.0008</td>
<td>0.0008</td>
</tr>
<tr>
<td>Over 0.028 to 0.075, incl</td>
<td>0.001</td>
<td>0.001</td>
</tr>
<tr>
<td>Over 0.075 to 0.207, incl</td>
<td>0.002</td>
<td>0.002</td>
</tr>
</tbody>
</table>

* For purposes of determining conformance with this specification, all specified limits are absolute as defined in Practice E29.
SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this standard since the last issue, A679/A679M – 00, that may impact the use of this standard. (Approved May 1, 2006.)

(1) In 2.4, removed the referenced document referring to MIL-STD-163. This standard is obsolete and all references were removed.

(2) In 15.4, removed the first sentence referring to MIL-STD-163.

(3) In 6.3, change the table reference from Table 10 to Table 7.

(4) Added summary of changes section.

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