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STANDARD

6934-2

First edition
1991-07-01

Steel for the prestressing of concrete —

Part 2:
Cold-drawn wire

Acier pour armatures de précontrainte —
Partie 2: Fil tréfilé à froid



Reference number
ISO 6934-2:1991(E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 6934-2 was prepared by Technical Committee ISO/TC 17, *Steel*.

ISO 6934 consists of the following parts, under the general title *Steel for the prestressing of concrete*:

- *Part 1: General requirements*
- *Part 2: Cold-drawn wire*
- *Part 3: Quenched and tempered wire*
- *Part 4: Strand*
- *Part 5: Hot-rolled steel bars with or without subsequent processing*

Annexes A and B of this part of ISO 6934 are for information only.

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Steel for the prestressing of concrete —

Part 2: Cold-drawn wire

1 Scope

This part of ISO 6934 specifies requirements for round, cold-drawn, high-tensile steel wire, either plain, indented, ribbed or crimped. The product is supplied as mill coil wire or straightened and stress-relieved wire in coils or cut lengths, according to the general requirements specified in ISO 6934-1.

2 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions of this part of ISO 6934. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements based on this part of ISO 6934 are encouraged to investigate the possibility of applying the most recent edition of the standard indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 6934-1:1991, *Steel for the prestressing of concrete — Part 1: General requirements.*

3 Definitions

For the purposes of ISO 6934, the definitions given in ISO 6934-1 apply.

4 Conditions of manufacture

The wire shall be manufactured from high carbon steel in accordance with ISO 6934-1.

The wire shall be supplied without welds or other joints.

5 Surface configuration

There are several types of surface configuration (ribs, indentations, crimps), the purpose of which is to improve bond properties between wire and concrete. The type of surface configuration shall be agreed between purchaser and manufacturer.

Examples of indentations and crimps are given in annex A.

6 Properties

The designations, data for information and required properties are given in table 1 and table 2.

6.1 Dimensions and properties of mill coil wire

6.1.1 Dimensions, masses and tensile properties

See table 1.

6.1.2 Elongation and ductility

The percentage total elongation at maximum force, measured on a length of 200 mm, shall be not less than 1,5 %.

All wires shall show a ductile fracture with a constriction visible to the naked eye.

All wires shall withstand a reverse bend test around the bend radius given in the last column of table 1. The minimum number of bends is four for plain wires and three for indented and ribbed wires.