



Standard Specification for Steel Wire, Oil-Tempered for Mechanical Springs¹

This standard is issued under the fixed designation A 229/A 229M; 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.

This specification has been approved for use by agencies of the Department of Defense. Consult the DoD Index of Specifications and Standards for the specific year of issue which has been adopted by the Department of Defense.

1. Scope

1.1 This specification covers two classes of oil-tempered steel spring wire intended especially for the manufacture of mechanical springs and wire forms.

1.2 The values stated in either SI (metric) 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 independent of the other.

2. Referenced Documents

2.1 *ASTM Standards:*

A 370 Test Methods and Definitions for Mechanical Testing of Steel Products²

A 510 Specification for General Requirements for Wire Rods and Coarse Round Wire, Carbon Steel²

A 510M Specification for General Requirements for Wire Rods and Coarse Round Wire, Carbon Steel [Metric]²

A 700 Practices for Packaging, Marking, and Loading Methods for Steel Products for Domestic Shipment³

A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products²

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications⁴

2.2 *American National Standard:*

B32.4M Preferred Metric Sizes for Round, Square, Rectangle, and Hexagon Metal Products⁵

2.3 *Military Standard:*

MIL-STD-163 Steel Mill Products, Preparation for Shipment and Storage⁶

2.4 *Federal Standard:*

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)⁶

2.5 *AIAG Standard:*

AIAG B-5 02.00 Primary Metals Identification Tag Application Standard⁷

3. Ordering Information

3.1 Material furnished under this specification should conform to the applicable requirements of the current edition of either specification A 510 or A-510M.

3.2 Orders for material under this specification should include the following information for each ordered item:

3.1.1 Quantity (mass or weight),

3.1.2 Name of material (oil-tempered steel mechanic spring wire) and class (Table 1),

3.1.3 Dimensions (Section 7),

3.1.4 Chemical composition (Table 2), if required,

3.1.5 Packaging (Section 12),

3.1.6 Cast or heat analysis report, if desired (see 5.2),

3.1.7 Certification or test report, or both, if specified (Section 12), and

3.1.8 ASTM designation and date of issue.

NOTE—A typical metric ordering description is as follows: 10 000 oil-tempered steel mechanical spring wire, Class I, 8.00 mm diameter, 250-kg coils to ASTM A 229M - xx, or for inch-pound units, 20 000 oil-tempered steel mechanical Spring Wire, Class I 0.315 in. diameter, 500-lb coils to ASTM A 229 - xx.

4. Materials and Manufacture

4.1 The steel may be made by any commercially accepted steel-making process. The steel may be either ingot cast strand cast.

4.2 The finished wire shall be free of detrimental pipe and undue segregation.

4.3 The wire shall be hardened and tempered to produce the desired mechanical properties.

5. Chemical Composition

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

5.2 *Cast or Heat Analysis*—Each cast or 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 pouring of the cast or heat. When requested, this shall be reported to the purchaser and shall conform to the requirements of Table 2.

5.3 *Product Analysis*—An analysis may be made by the purchaser from finished wire representing each cast or heat of steel. The chemical composition thus determined, as elements required or restricted, shall conform to the product analysis requirements specified in Table 10 of Specification A 510 or A 510M.

5.4 For referee purposes, Test Methods, Practices, and Terminology A 751 shall be used.

¹ This specification is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel, and Related Alloys, and is the direct responsibility of Subcommittee A01.03 on Steel Rod and Wire.

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² *Annual Book of ASTM Standards*, Vol 01.03.

³ *Annual Book of ASTM Standards*, Vol 01.05.

⁴ *Annual Book of ASTM Standards*, Vol 14.02.

⁵ Available from American National Standards Institute, 11 West 42nd Street, 13th Floor, New York, NY 10036.

⁶ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

⁷ Available from the Automotive Industry Action Group, 26200 Lahser, Suite 200, Southfield, MI 48034.

TABLE 1A Tensile Requirements, SI Units^A

Diameter, ^B mm	Class I		Class II	
	Tensile Strength, MPa		Tensile Strength, MPa	
	min	max	min	max
0.50	2050	2250	2230	2450
0.55	2020	2220	2220	2440
0.60	2000	2200	2210	2430
0.65	1950	2150	2190	2410
0.70	1950	2150	2170	2190
0.80	1900	2100	2140	2360
0.90	1850	2050	2100	2320
1.00	1800	2000	2060	2280
1.10	1780	1980	2030	2240
1.20	1750	1950	2000	2210
1.40	1700	1900	1950	2150
1.60	1650	1850	1900	2100
1.80	1620	1820	1860	2060
2.00	1600	1800	1820	2020
2.20	1580	1780	1790	1990
2.50	1550	1750	1750	1950
2.80	1520	1720	1710	1900
3.00	1500	1700	1690	1880
3.50	1450	1620	1640	1830
4.00	1400	1580	1600	1780
4.50	1380	1550	1560	1740
5.00	1350	1520	1520	1700
5.50	1320	1500	1500	1680
6.00	1300	1480	1480	1660
7.00	1280	1450	1450	1630
8.00	1250	1430	1430	1610
9.00	1220	1400	1410	1590
10.00	1200	1380	1400	1580
11.00	1180	1350	1380	1560
12.00	1150	1320	1360	1540
14.00	1120	1300	1340	1520
16.00	1120	1300	1320	1500

^A Tensile strength values for intermediate diameters may be interpolated.

^B Preferred sizes. For a complete list, refer to ANSI B32.4M, Preferred Metric Sizes for Round, Square, Rectangle, and Hexagon Metal Products.

6. Mechanical Properties

6.1 Tension Test:

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

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

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

6.1.4 Test Method—The tension test shall be made in accordance with Test Methods and Definitions A 370.

6.2 Wrap Test:

6.2.1 Requirements—Wire 4.00 mm or 0.162 in. and smaller in diameter shall wind on itself as an arbor without breakage. Larger diameter wire, up to and including 8.00 mm or 0.312 in. shall wind, without breakage, on a mandrel twice the wire diameter. Wrap test on wires over 8.00 mm or 0.312 in. diameter is not applicable.

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

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

6.2.4 Test Method—The wrap test shall be made in accordance with Test Methods and Definitions A 370, Supplement IV.

TABLE 1B Tensile Requirements, Inch-Pound Units

Diameter, ^A in.	Class I		Class II	
	Tensile Strength, ksi ^B		Tensile Strength, ksi	
	min	max	min	max
0.020	293	323	324	354
0.023	289	319	320	350
0.026	286	316	317	347
0.029	283	313	314	344
0.032	280	310	311	341
0.035	274	304	305	335
0.041	266	296	297	327
0.048	259	289	290	320
0.054	253	283	284	314
0.062	247	277	278	308
0.072	241	271	272	302
0.080	235	265	266	296
0.092	230	260	261	291
0.106	225	255	256	286
0.120	220	250	251	281
0.135	215	240	241	266
0.148	210	235	236	261
0.162	205	230	231	256
0.177	200	225	226	251
0.192	195	220	221	246
0.207	190	215	216	241
0.225	188	213	214	239
0.244	187	212	213	238
0.250	185	210	211	236
0.312	183	208	209	234
0.375	180	205	206	231
0.438	175	200	201	226
0.500	170	195	196	221
0.562	165	190	191	216
0.625	165	190	191	216

^A Tensile strength values for intermediate diameters may be interpolated.

TABLE 2 Chemical Requirements

Element	Composition, %
Carbon	0.55–0.85
Manganese	0.30–1.20 ^A
Phosphorus, max	0.040
Sulfur, max	0.050
Silicon	0.15–0.35

^A Generally 0.80/1.20 % manganese for diameter 5.00 mm or 0.192 in. and larger; 0.30/0.90 % for diameters less than 5.00 mm or 0.192 in. The choice of composition shall be optional with the manufacturer unless the purchaser definitely specifies otherwise.

7. Dimensions and Permissible Variations

7.1 The permissible variations in the diameter of the wire shall be as specified in Table 3A or Table 3B.

8. Workmanship and Appearance

8.1 The surface of the wire as received shall be free from rust and excessive scale. No serious die marks, scratches, or seams may be present.

8.2 The wire shall be uniform in quality and temper and shall not be wavy or crooked.

TABLE 3A Permissible Variations in Wire Diameter, SI Units^A

Diameter, mm	Permissible Variations, plus and minus, mm	Permissible Out-of-Round, mm
To 0.70, incl	0.02	0.02
Over 0.70 to 2.00, incl	0.03	0.03
2.00 to 9.00, incl	0.05	0.05
Over 9.00	0.08	0.08

^A For purposes of determining conformance with this specification, all specified limits are absolute as defined in Practice E 29.

TABLE 3B Permissible Variations in Wire Diameter, Inch-Pound Units^A

Diameter, in.	Permissible Variations, plus and minus, in.	Permissible Out-of-Round, in.
0.020 to 0.028, incl	0.0008	0.0008
Over 0.028 to 0.075, incl	0.001	0.001
Over 0.075 to 0.375, incl	0.002	0.002
Over 0.375	0.003	0.003

^A For purposes of determining conformance with this specification, all specified limits are absolute as defined in Practice E 29.

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

9. Retests

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

10. Inspection

10.1 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.

11. Rejection and Rehearing

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

11.2 The material must be adequately protected and

correctly identified in order that the manufacturer may make a proper investigation.

12. Certification

12.1 When specified in the purchase order or contract, manufacturer'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 test results shall be furnished.

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

13. Packaging, Marking, and Loading for Shipment

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

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

13.3 Unless otherwise specified in the purchaser's order, packaging, marking, and loading for shipments shall be in accordance with those procedures recommended by Practices A 700.

13.4 *For Government Procurement*—Packaging, packing, and marking of material for military procurement shall be in accordance with the requirements of MIL-STD-163, Level A, Level C, or commercial as specified in the contract purchase order. Marking for shipment of material for agencies shall be in accordance with Fed. Std. No. 123.

13.5 *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, Primary Metal Identification Tag Application. The bar code may be applied to a substantially affixed tag.

14. Keywords

14.1 oil-tempered; springs; wire

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