



Designation: A493 – 25

Standard Specification for Stainless Steel Wire and Wire Rods for Cold Heading and Cold Forging¹

This standard is issued under the fixed designation A493; 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 standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This specification covers cold-finished and hot-finished stainless steel wire and wire rods for cold heading or cold forging for applications, such as fasteners, where corrosion resistance is a factor.

1.2 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.

1.3 *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

[A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels](#)

[A555/A555M Specification for General Requirements for Stainless Steel Wire and Wire Rods](#)

[A751 Test Methods and Practices for Chemical Analysis of Steel Products](#)

3. Terminology

3.1 *Definitions*—For definitions of terms used in this specification, refer to Specification [A555/A555M](#).

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *cold heading, n*—a process that applies force with the use of a punch to the end of a metal blank that is in a die.

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 A01.17 on Flat-Rolled and Wrought Stainless Steel.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at www.astm.org/contact. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

3.2.2 *lightly drafted, n*—a process using a light cold reduction that assures tensile properties are below a specified maximum.

4. Ordering Information

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

- 4.1.1 Quantity (weight),
- 4.1.2 Size (diameter),
- 4.1.3 Type or UNS number (see [Table 1](#)),
- 4.1.4 Name (wire or wire rods),
- 4.1.5 ASTM designation and issue date,
- 4.1.6 Condition (see [6.2](#)),
- 4.1.7 Coating (see [6.3](#)),
- 4.1.8 Coil size (inside and outside diameter),
- 4.1.9 Special requirements, and
- 4.1.10 Supplementary requirements.

5. General Requirements for Delivery

5.1 In addition to the requirements of this specification, all requirements of the current editions of Specification [A555/A555M](#) shall apply. Failure to comply with the general requirements of Specification [A555/A555M](#) constitutes non-conformance with this specification.

NOTE 1—A typical ordering description is as follows: 5000 lb (2268 kg) 0.225 in. (5.72 mm) round Type 305 cold heading wire, lightly drafted, copper coated, 32 in. (813 mm) max OD—22 in. (559 mm) min ID, coils, ASTM Specification A493 – XX. End use: hex head machine bolts.

6. Manufacture

6.1 *Heat Treatment:*

6.1.1 Austenitic grades shall be annealed at 1800 °F (980 °C) minimum, so that grain boundary carbides enter into solution, and rapidly quenched to prevent grain boundary precipitation of carbides that would cause susceptibility to intergranular corrosion. See Supplementary Requirements.

6.1.2 Ferritic and martensitic grades shall be annealed to meet the requirements for mechanical properties.

6.2 *Condition:*

*A Summary of Changes section appears at the end of this standard

TABLE 1 Chemical Requirements

Grade		Composition, % ^A										
UNS Designation	AISI Type	Carbon	Manga-nese	Phos-phorus	Sulfur	Silicon	Chromium	Nickel	Copper	Molyb-denum	Nitrogen	Other Elements ^B
Austenitic Grades												
S 17710	...	0.15	2.00	0.045	0.030	1.00	17.0–19.0	8.0–10.0	...	...	...	Al 0.90–1.40
S 30200	302	0.15	2.00	0.045	0.030	1.00	17.0–19.0	8.0–10.0	1.00		0.10	
S 30400	304	0.08	2.00	0.045	0.030	1.00	18.0–20.0	8.0–10.5	1.00		0.10	
S 30403	304L	0.030	2.00	0.045	0.030	1.00	18.0–20.0	8.0–12.0	1.00		0.10	
S 30430		0.10	2.00	0.045	0.030	1.00	17.0–19.0	8.0–10.0	3.0–4.0			
S 30433		0.03	2.00	0.045	0.030	1.00	17.0–19.0	8.0–10.0	3.0–4.0			
S 30500	305	0.04	2.00	0.045	0.030	1.00	17.0–19.0	10.5–13.0	1.00			
S 31600	316	0.08	2.00	0.045	0.030	1.00	16.0–18.0	10.0–14.0		2.00–3.00	0.10	
S 31603	316L	0.030	2.00	0.045	0.030	1.00	16.0–18.0	10.0–14.0		2.00–3.00	0.10	
S 38400	384	0.04	2.00	0.045	0.030	1.00	15.0–17.0	17.0–19.0				
Ferritic Grades												
S 40940		0.06	1.00	0.045	0.040	1.00	10.5–11.7	0.50				Nb 10XC–0.75
S 42900	429	0.12	1.00	0.040	0.030	1.00	14.0–16.0					
S 43000	430	0.04	1.00	0.040	0.030	1.00	16.0–18.0					
S 44401	...	0.025	1.00	0.040	0.030	...	17.5–19.5	1.00		1.75–2.50	0.035	Ti+Nb 0.20+4x (C+N)–0.80
S 44625 ^C	...	0.010 ^C	0.40	0.020	0.020	0.40	25.0–27.5	0.50	0.2	0.75–1.50	0.015 ^C	Ni+Cu 0.5
S 44700 ^C	...	0.010 ^C	0.30	0.025	0.020	0.20	28.0–30.0	0.15	0.15	3.5–4.2	0.020 ^C	C+N 0.025
S 44800 ^C	...	0.010 ^C	0.30	0.025	0.020	0.20	28.0–30.0	2.00–2.50	0.15	3.5–4.2	0.020 ^C	C+N 0.025
Martensitic Grades												
S 41000	410	0.15	1.00	0.040	0.030	1.00	11.5–13.5					
S 42010	...	0.15–0.30	1.00	0.040	0.030	1.00	13.5–15.0	0.35–0.85		0.40–0.85		
S 42030	...	0.30	1.00	0.040	0.030	1.00	12.0–14.0		2.00–3.00	1.00–3.00		
S 43100	431	0.20	1.00	0.040	0.030	1.00	15.0–17.0	1.25–2.50				
S 44004	440C	0.95–1.20	1.00	0.040	0.030	1.00	16.0–18.0			0.75 max		

^A Maximum, unless range or minimum is indicated. Where ellipses (. . .) appear in this table, there is no requirement and the element need not be determined or reported.

^B Niobium and columbium are interchangeable names for the same element and both names are acceptable for use in A01.17 specifications.

^C Product analysis tolerance over the maximum limit for carbon and nitrogen to be 0.002 %.

6.2.1 Wire shall be furnished in one of the following conditions:

6.2.1.1 Lightly drafted (normal condition and need not be specified if this is condition desired),

6.2.1.2 Annealed, or

6.2.1.3 Drafted to a specified tensile strength range (as agreed upon between purchaser and producer).

6.2.2 Rods shall be furnished in the annealed condition, scale removed.

6.3 Coatings and Lubricants:

6.3.1 Coatings are necessary for most cold-heading or forming operations. An electroplated copper coating is often used. The following coatings may be specified: copper, lime, or special (as agreed upon between purchaser and producer).

6.3.2 Lubricants are applied over the coating during the final drafting operation performed by the producer. Soap is generally used. The following lubricants may be specified: soap, grease, or special (as agreed upon between purchaser and producer).

7. Chemical Requirements

7.1 The steel shall conform to the requirements for chemical composition specified in [Table 1](#).

7.2 Methods and practices relating to chemical analysis required by this specification shall be in accordance with Test Methods, Practices, and Terminology [A751](#).

8. Mechanical Requirements

8.1 The material shall conform to the requirements as to mechanical properties specified in [Table 2](#). Material can be manufactured to tensile strength ranges other than those shown in [Table 2](#). The producer should be consulted when material is required to tensile strength ranges other than those specified.

9. Resistance to Intergranular Corrosion

9.1 All austenitic grades in the annealed condition or annealed and lightly drafted condition shall be capable of passing Practice E of Practices [A262](#). When Supplementary