



Standard Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement¹

This standard is issued under the fixed designation A615/A615M; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This specification covers deformed and plain carbon-steel bars for concrete reinforcement in cut lengths and coils. Steel bars containing alloy additions, such as with the American Iron and Steel Institute and the Society of Automotive Engineers series of alloy steels, are permitted if the resulting product meets all the other requirements of this specification. The standard sizes and dimensions of deformed bars and their number designations are given in [Table 1](#). The text of this specification references notes and footnotes which provide explanatory material. These notes and footnotes (excluding those in tables) shall not be considered as requirements of the specification.

1.2 Bars are of four minimum yield strength levels; namely, 40 000 [280 MPa], 60 000 [420 MPa], 75 000 psi [520 MPa], and 80 000 [550 MPa], designated as Grade 40 [280], Grade 60 [420], Grade 75 [520], and Grade 80 [550], respectively.

1.3 Plain bars, in sizes up to and including 2½ in. [63.5 mm] in diameter in coils or cut lengths, when ordered shall be furnished under this specification in Grade 40 [280], Grade 60 [420], Grade 75 [520], and Grade 80 [550]. For ductility properties (elongation and bending), test provisions of the nearest smaller nominal diameter deformed bar size shall apply. Requirements providing for deformations and marking shall not be applicable.

NOTE 1—Welding of the material in this specification should be approached with caution since no specific provisions have been included to enhance its weldability. When steel is to be welded, a welding procedure suitable for the chemical composition and intended use or service should be used. The use of the latest edition of [AWS D 1.4/D 1.4M](#) is recommended. This document describes the proper selection of the filler metals and preheat/interpass temperatures, as well as performance and procedure qualification requirements.

1.4 This specification is applicable for orders in either inch-pound units (as Specification A615) or in SI units (as Specification A615M).

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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1.5 The values stated in either inch-pound units or SI units are to be regarded as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification.

1.6 *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

[A6/A6M](#) Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling

[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

[A706/A706M](#) Specification for Low-Alloy Steel Deformed and Plain Bars for Concrete Reinforcement

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

[E29](#) Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

2.2 AWS Standard:³

[AWS D 1.4/D 1.4M](#) Structural Welding Code—Reinforcing Steel

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 Welding Society (AWS), 550 NW LeJeune Rd., Miami, FL 33126, <http://www.aws.org>.

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

TABLE 1 Deformed Bar Designation Numbers, Nominal Weights [Masses], Nominal Dimensions, and Deformation Requirements

Bar Designation No.	Nominal Weight, lb/ft [Nominal Mass, kg/m]	Nominal Dimensions ^A			Deformation Requirements, in. [mm]		
		Diameter, in. [mm]	Cross-Sectional Area, in. ² [mm ²]	Perimeter, in. [mm]	Maximum Average Spacing	Minimum Average Height	Maximum Gap (Chord of 12.5 % of Nominal Perimeter)
3 [10]	0.376 [0.560]	0.375 [9.5]	0.11 [71]	1.178 [29.9]	0.262 [6.7]	0.015 [0.38]	0.143 [3.6]
4 [13]	0.668 [0.994]	0.500 [12.7]	0.20 [129]	1.571 [39.9]	0.350 [8.9]	0.020 [0.51]	0.191 [4.9]
5 [16]	1.043 [1.552]	0.625 [15.9]	0.31 [199]	1.963 [49.9]	0.437 [11.1]	0.028 [0.71]	0.239 [6.1]
6 [19]	1.502 [2.235]	0.750 [19.1]	0.44 [284]	2.356 [59.8]	0.525 [13.3]	0.038 [0.97]	0.286 [7.3]
7 [22]	2.044 [3.042]	0.875 [22.2]	0.60 [387]	2.749 [69.8]	0.612 [15.5]	0.044 [1.12]	0.334 [8.5]
8 [25]	2.670 [3.973]	1.000 [25.4]	0.79 [510]	3.142 [79.8]	0.700 [17.8]	0.050 [1.27]	0.383 [9.7]
9 [29]	3.400 [5.060]	1.128 [28.7]	1.00 [645]	3.544 [90.0]	0.790 [20.1]	0.056 [1.42]	0.431 [10.9]
10 [32]	4.303 [6.404]	1.270 [32.3]	1.27 [819]	3.990 [101.3]	0.889 [22.6]	0.064 [1.63]	0.487 [12.4]
11 [36]	5.313 [7.907]	1.410 [35.8]	1.56 [1006]	4.430 [112.5]	0.987 [25.1]	0.071 [1.80]	0.540 [13.7]
14 [43]	7.65 [11.38]	1.693 [43.0]	2.25 [1452]	5.32 [135.1]	1.185 [30.1]	0.085 [2.16]	0.648 [16.5]
18 [57]	13.60 [20.24]	2.257 [57.3]	4.00 [2581]	7.09 [180.1]	1.58 [40.1]	0.102 [2.59]	0.864 [21.9]

^A The nominal dimensions of a deformed bar are equivalent to those of a plain round bar having the same weight [mass] per foot [metre] as the deformed bar.

2.3 U.S. Military Standard:⁴

MIL-STD-129 Marking for Shipment and Storage

2.4 U.S. Federal Standard:⁴

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

5. Material and Manufacture

5.1 The bars shall be rolled from properly identified heats of mold-cast or strand-cast steel using the electric-furnace, basic-oxigen, or open-hearth process.

6. Chemical Composition

6.1 The chemical analysis of each heat of steel shall be determined in accordance with Test Methods, Practices, and Terminology **A751**. The manufacturer shall make the analysis on test samples taken preferably during the pouring of the heat. The percentages of carbon, manganese, phosphorus, and sulfur shall be determined. The phosphorus content thus determined shall not exceed 0.06 %.

6.2 A product check, for phosphorus, made by the purchaser shall not exceed that specified in **6.1** by more than 25 %.

7. Requirements for Deformations

7.1 Deformations shall be spaced along the bar at substantially uniform distances. The deformations on opposite sides of the bar shall be similar in size, shape, and pattern.

7.2 The deformations shall be placed with respect to the axis of the bar so that the included angle is not less than 45°. Where the line of deformations forms an included angle with the axis of the bar from 45 to 70° inclusive, the deformations shall alternately reverse in direction on each side, or those on one side shall be reversed in direction from those on the opposite side. Where the line of deformations is over 70°, a reversal in direction shall not be required.

7.3 The average spacing or distance between deformations on each side of the bar shall not exceed seven tenths of the nominal diameter of the bar.

7.4 The overall length of deformations shall be such that the gap (measured as a chord) between the ends of the deformations shall not exceed 12.5 % of the nominal perimeter of the bar. Where the ends terminate in a rib, the width of the rib shall be considered as the gap between these ends. The summation of the gaps shall not exceed 25 % of the nominal perimeter of the bar. The nominal perimeter of the bar shall be 3.1416 times the nominal diameter.

7.5 The spacing, height, and gap of deformations shall conform to the requirements prescribed in **Table 1**.

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *deformations, n*—transverse protrusions on a deformed bar.

3.1.2 *deformed bar, n*—steel bar with protrusions; a bar that is intended for use as reinforcement in reinforced concrete construction.

3.1.2.1 *Discussion*—The surface of the bar is provided with lugs or protrusions that inhibit longitudinal movement of the bar relative to the concrete surrounding the bar in such construction. The lugs or protrusions conform to the provisions of this specification.

3.1.3 *plain bar, n*—steel bar without protrusions.

3.1.4 *rib, n*—longitudinal protrusion on a deformed bar.

4. Ordering Information

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

4.1.1 Quantity (weight) [mass],

4.1.2 Name of the material (deformed and plain carbon-steel bars for concrete reinforcement),

4.1.3 Size,

4.1.4 Cut lengths or coils,

4.1.5 Deformed or plain,

4.1.6 Grade,

4.1.7 Packaging (see Section **20**),

4.1.8 ASTM designation and year of issue, and

4.1.9 Certified mill test reports (if desired). (See Section **16**.)

⁴ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>.



TABLE 2 Tensile Requirements

	Grade 40 [280] ^A	Grade 60 [420]	Grade 75 [520]	Grade 80 [550]
Tensile strength, min, psi [MPa]	60 000 [420]	90 000 [620]	100 000 [690]	105 000 [725]
Yield strength, min, psi [MPa]	40 000 [280]	60 000 [420]	75 000 [520]	80 000 [550]
Elongation in 8 in. [200 mm], min, %				
Bar Designation No.				
3 [10]	11	9	7	7
4, 5 [13, 16]	12	9	7	7
6 [19]	12	9	7	7
7, 8 [22, 25]	...	8	7	7
9, 10, 11 [29, 32, 36]	...	7	6	6
14, 18 [43, 57]	...	7	6	6

^A Grade 40 [280] bars are furnished only in sizes 3 through 6 [10 through 19].

8. Measurements of Deformations

8.1 The average spacing of deformations shall be determined by measuring the length of a minimum of ten spaces and dividing that length by the number of spaces included in the measurement. The measurement shall begin from a point on a deformation at the beginning of the first space to a corresponding point on a deformation after the last included space. Spacing measurements shall not be made over a bar area containing bar marking symbols involving letters or numbers.

8.2 The average height of deformations shall be determined from measurements made on not less than two typical deformations. Determinations shall be based on three measurements per deformation, one at the center of the overall length and the other two at the quarter points of the overall length.

8.3 Insufficient height, insufficient circumferential coverage, or excessive spacing of deformations shall not constitute cause for rejection unless it has been clearly established by determinations on each lot (Note 2) tested that typical deformation height, gap, or spacing do not conform to the minimum requirements prescribed in Section 7. No rejection shall be made on the basis of measurements if fewer than ten adjacent deformations on each side of the bar are measured.

NOTE 2—As used within the intent of 8.3, the term “lot” shall mean all the bars of one bar size and pattern of deformations contained in an individual shipping release or shipping order.

9. Tensile Requirements

9.1 The material, as represented by the test specimens, shall conform to the requirements for tensile properties prescribed in Table 2.

9.2 The yield point or yield strength shall be determined by one of the following methods:

9.2.1 The yield point shall be determined by the drop or halt of the gage of the tensile testing machine, where the steel tested has a sharp-knead or well-defined type of yield point.

9.2.2 Where the steel tested does not have a well-defined yield point, the yield strength shall be determined by the offset method (0.2 % offset), as described in Test Methods and Definitions A370. A second tensile test result shall also be required as indicated in 9.2.2.1.

9.2.2.1 When the offset method is used to determine the yield strength, the material, as represented by the test specimens shall conform to an additional requirement: the stress corresponding to a tensile strain of 0.0035 shall be a minimum of 60 000 psi [420 MPa] for Grade 60 [420], a minimum of

75 000 psi [520 MPa] for Grade 75 [520], and a minimum of 80 000 psi [550 MPa] for Grade 80 [550]. The value of stress corresponding to a tensile strain of 0.0035 shall be reported in the test report (16.1.2).

9.3 When material is furnished in coils, the test specimen shall be taken from the coil and straightened prior to placing it in the jaws of the tensile testing machine. Straightening of test specimens shall be done carefully to avoid formation of local sharp bends and to minimize cold work. (See Note 3.)

9.3.1 Test specimens taken from post-fabricated material shall not be used to determine conformance to this specification.

NOTE 3—Insufficient straightening prior to attaching the extensometer can result in lower-than-actual yield strength readings. Multiple bending distortion from mechanical straightening and fabricating machines can lead to excessive cold work, resulting in higher yield strengths, lower elongation values, and a loss of deformation height.

9.4 The percentage of elongation shall be as prescribed in Table 2.

10. Bending Requirements

10.1 The bend-test specimen shall withstand being bent around a pin without cracking on the outside radius of the bent portion. The requirements for degree of bending and sizes of pins are prescribed in Table 3. When material is furnished in coils, the test specimen shall be straightened prior to placing it in the bend tester.

10.2 The bend test shall be made on specimens of sufficient length to ensure free bending and with apparatus which provides:

10.2.1 Continuous and uniform application of force throughout the duration of the bending operation.

10.2.2 Unrestricted movement of the specimen at points of contact with the apparatus and bending around a pin free to rotate.

10.2.3 Close wrapping of the specimen around the pin during the bending operation.

10.3 It is permissible to use more severe methods of bend testing, such as placing a specimen across two pins free to rotate and applying the bending force with a fixed pin. When failures occur under more severe methods, retests shall be permitted under the bend-test method prescribed in 10.2.



TABLE 3 Bend Test Requirements

Bar Designation No.	Pin Diameter for Bend Tests ^A			
	Grade 40 [280]	Grade 60 [420]	Grade 75 [520]	Grade 80 [550]
3, 4, 5 [10, 13, 16]	$3\frac{1}{2} d^B$	$3\frac{1}{2} d$	$5d$	$5d$
6 [19]	$5d$	$5d$	$5d$	$5d$
7, 8 [22, 25]	...	$5d$	$5d$	$5d$
9, 10, 11 [29, 32, 36]	...	$7d$	$7d$	$7d$
14, 18 [43, 57] (90°)	...	$9d$	$9d$	$9d$

^A Test bends 180° unless noted otherwise.

^B d = nominal diameter of specimen.

11. Permissible Variation in Weight [Mass]

11.1 Deformed reinforcing bars shall be evaluated on the basis of nominal weight [mass]. The weight [mass] determined using the measured weight [mass] of the test specimen and rounding in accordance with Practice E29, shall be at least 94 % of the applicable weight [mass] per unit length prescribed in Table 1. In no case shall overweight [excess mass] of any deformed bar be the cause for rejection.

11.2 Weight [mass] variation for plain bars shall be computed on the basis of permissible variation in diameter. For plain bars smaller than $\frac{3}{8}$ in. [9.5 mm] in diameter, use Specification A510 [Specification A510M]. For larger bars up to and including $2\frac{1}{2}$ in. [63.5 mm] in diameter, use Specification A6/A6M.

12. Finish

12.1 The bars shall be free of detrimental surface imperfections.

12.2 Rust, seams, surface irregularities, or mill scale shall not be cause for rejection, provided the weight, dimensions, cross-sectional area, and tensile properties of a hand wire brushed test specimen are not less than the requirements of this specification.

12.3 Surface imperfections or flaws other than those specified in 12.2 shall be considered detrimental when specimens containing such imperfections fail to conform to either tensile or bending requirements. Examples include, but are not limited to, laps, seams, scabs, slivers, cooling or casting cracks, and mill or guide marks.

NOTE 4—Deformed reinforcing bars intended for epoxy coating applications should have surfaces with a minimum of sharp edges to achieve proper coverage. Particular attention should be given to bar marks and deformations where coating difficulties are prone to occur.

NOTE 5—Deformed reinforcing bars destined to be mechanically-spliced or butt-welded may require a certain degree of roundness in order for the splices to adequately achieve strength requirements.

13. Number of Tests

13.1 For bar sizes No. 3 to 11 [10 to 36], inclusive, one tension test and one bend test shall be made of the largest size rolled from each heat. If, however, material from one heat differs by three or more designation numbers, one tension and one bend test shall be made from both the highest and lowest designation number of the deformed bars rolled.

13.2 For bar sizes Nos. 14 and 18 [43 and 57], one tension test and one bend test shall be made of each size rolled from each heat.

13.3 For all bar sizes one set of dimensional property tests including bar weight [mass] and spacing, height, and gap of deformations shall be made of each bar size rolled from each heat.

14. Retests

14.1 If the results of an original tension specimen fail to meet the specified minimum requirements and are within 2000 psi [14 MPa] of the required tensile strength, within 1000 psi [7 MPa] of the required yield strength, or within two percentage units of the required elongation, a retest shall be permitted on two random specimens for each original tension specimen failure from the lot. Both retest specimens shall meet the requirements of this specification.

14.2 If a bend test fails for reasons other than mechanical reasons or flaws in the specimen as described in 14.4.2 and 14.4.3, a retest shall be permitted on two random specimens from the same lot. Both retest specimens shall meet the requirements of this specification. The retest shall be performed on test specimens that are at air temperature but not less than 60°F [16°C].

14.3 If a weight [mass] test fails for reasons other than flaws in the specimen as described in 14.4.3, a retest shall be permitted on two random specimens from the same lot. Both retest specimens shall meet the requirements of this specification.

14.4 If the original test or any of the random retests fails because of any reasons listed in 14.4.1, 14.4.2, or 14.4.3, the test shall be considered an invalid test:

14.4.1 The elongation property of any tension test specimen is less than that specified, and any part of the fracture is outside the middle half of the gage length, as indicated by scribe marks on the specimen before testing;

NOTE 6—Marking specimens with multiple scribe or punch marks can reduce the occurrence of fracture outside or near these marks and the need for declaring the test invalid.

14.4.2 Mechanical reasons such as failure of testing equipment or improper specimen preparation; and

14.4.3 Flaws are detected in a test specimen, either before or during the performance of the test.

14.5 The original results from 14.4.1, 14.4.2, or 14.4.3 shall be discarded and the test shall be repeated on a new specimen from the same lot.

15. Test Specimens

15.1 All mechanical tests shall be conducted in accordance with Test Methods and Definitions A370 including Annex A9.



15.2 Tension test specimens shall be the full section of the bar as rolled. The unit stress determination shall be based on the nominal bar area.

15.3 The bend-test specimens shall be the full section of the bar as rolled.

16. Test Reports

16.1 When specified in the purchase order, the following information shall be reported on a per heat basis. Report additional items as requested or desired.

16.1.1 Chemical analysis including carbon, manganese, phosphorus, and sulfur.

16.1.2 Tensile properties.

16.1.3 Bend test.

16.2 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 must meet the requirements of the invoked ASTM standard(s) and conform to any EDI agreement between the purchaser and the supplier. Notwithstanding the absence of a signature, the organization submitting the EDI transmission is responsible for the content of the report.

NOTE 7—The industry definition invoked here is: EDI is the computer to computer exchange of business information in a standard format such as ANSI ASC X12.

17. Inspection

17.1 The inspector representing the purchaser shall have free entry, at all times while work on the contract of the purchaser is being performed, to all parts of the manufacturer's works that concern the manufacture of the material ordered. The manufacturer shall afford the inspector all reasonable facilities to satisfy him that the material is being furnished in accordance with this specification. All tests (except product analysis) and inspection, shall be made at the place of manufacture prior to shipment, unless otherwise specified, and shall be so conducted as not to interfere unnecessarily with the operation of the works.

17.2 *For Government Procurement Only*—Except as otherwise specified in the contract, the contractor is responsible for the performance of all inspection and test requirements specified herein. The contractor shall be permitted to use his own or any other suitable facilities for the performance of the inspection and test requirements specified herein, unless disapproved by the purchaser at the time of purchase. The purchaser shall have the right to perform any of the inspections and tests at the same frequency as set forth in this specification, where such inspections are deemed necessary to ensure that material conforms to prescribed requirements.

18. Rejection and Rehearing

18.1 Any rejection based on testing undertaken by the purchaser shall be promptly reported to the manufacturer.

18.2 Samples tested that represent rejected material shall be preserved for two weeks from the date rejection is reported to the manufacturer. In case of dissatisfaction with the results of the tests, the manufacturer shall have the right to make claim for a rehearing within that time.

19. Marking

19.1 When loaded for mill shipment, bars shall be properly separated and tagged with the manufacturer's heat or test identification number.

19.2 Each manufacturer shall identify the symbols of his marking system.

19.3 All bars produced to this specification, except plain bars which shall be tagged for grade, shall be identified by a distinguishing set of marks legibly rolled onto the surface of one side of the bar to denote in the following order:

19.3.1 *Point of Origin*—Letter or symbol established as the manufacturer's mill designation.

19.3.2 *Size Designation*—Arabic number corresponding to bar designation number of **Table 1**.

19.3.3 *Type of Steel*—Letter *S* indicating that the bar was produced to this specification, or for Grades 60 [420] and 80 [550] bars only, letters *S* and *W* indicating that the bar was produced to meet both this specification and Specification **A706/A706M**.

19.3.4 *Minimum Yield Strength Designation*—For Grade 60 [420] bars, either the number 60 [4] or a single continuous longitudinal line through at least five spaces offset from the center of the bar side. For Grade 75 [520] bars, either the number 75 [5] or two continuous longitudinal lines through at least five spaces offset each direction from the center of the bar. For Grade 80 [550] bars, either the number 80 [6] or three continuous longitudinal lines through at least five spaces. (No marking designation for Grade 40 [280] bars.)

19.3.5 It shall be permissible to substitute: a metric size bar of Grade 280 for the corresponding inch-pound size bar of Grade 40, a metric size bar of Grade 420 for the corresponding inch-pound size bar of Grade 60, and a metric size bar of Grade 520 for the corresponding inch-pound size bar of Grade 75, and a metric size bar of Grade 550 for the corresponding inch-pound size bar of Grade 80.

20. Packaging and Package Marking

20.1 Packaging, marking, and loading for shipment shall be in accordance with Practices **A700**.

20.2 *For Government Procurement Only*—When specified in the contract or order, and for direct procurement by or direct shipment to the U.S. Government, marking for shipment, in addition to requirements specified in the contract or order, shall be in accordance with **MIL-STD-129** for military agencies and with **Fed. Std. No. 123** for civil agencies.

21. Keywords

21.1 concrete reinforcement; deformations (protrusions); steel bars

SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this standard since the last issue (A615/A615M – 09b) that may impact the use of this standard. (Approved March 1, 2012.)

(I) Revised **19.3.3.**

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