Designation: B 3 – 01

Standard Specification for Soft or Annealed Copper Wire[1]

This standard is issued under the fixed designation B 3; 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.

1. Scope

1.1 This specification covers drawn and annealed or soft round bare copper wire for electrical purposes (see Explanatory Note 1).

1.2 The values stated in inch-pound or SI units are to be regarded separately as standard. Each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the specification. For conductor sizes designated by AWG or kcmil sizes, the requirements in SI units are numerically converted from the corresponding requirements in inch-pound units. For conductor sizes designation by AWG or kcmil, the requirements in SI units have been numerically converted from corresponding values stated or derived in inch-pound units. For conductor sizes designated by SI units only, the requirements are stated or derived in SI units.

1.2.1 For density, resistivity and temperature, the values stated in SI units are to be regarded as standard.

2. Referenced Documents

2.1 The following documents of the issue in effect at the time of reference form a part of this specification to the extent referenced herein:

2.2 *ASTM Standards:*

B 49 Specification for Copper Redraw Rod for Electrical Purposes [2]

B 193 Test Method for Resistivity of Electrical Conductor Materials[3]

B 258 Specification for Standard Nominal Diameters and Cross-Sectional Areas of AWG Sizes of Solid Round Wires Used as Electrical Conductors[3]

2.3 *National Institute of Standards and Technology:*

NBS Handbook 100— *Copper Wire Tables*[4]

3. Ordering Information

3.1 Orders for material under this specification shall include the following information:

3.1.1 Quantity of each size,

3.1.2 Wire size: diameter in inches (see 5.4 and Table 1),

3.1.3 Type of copper, if special (Section 4),

3.1.4 Package size (see 10.1),

3.1.5 Special package marking, if required, and

3.1.6 Place of inspection (see 9.1).

4. Materials and Manufacture

4.1 The material shall be copper of such quality and purity that the finished product shall have the properties and characteristics prescribed in this specification.

NOTE 1—The following standards define the materials suitable for use: Specification B 49.

4.2 Copper bars of special qualities, forms, or types, as may be agreed upon between the manufacturer and the purchaser, and which will conform to the requirements prescribed in this specification may also be used.

5. General Requirements (see Section 7)

5.1 *Tensile Strength and Elongation*—The wire shall conform to the requirements for elongation prescribed in Table 1 (see Explanatory Note 2). No requirements for tensile strength are specified. For wire whose nominal diameter is more than 0.001 in. (0.025 mm) greater than a size listed in Table 1, but less than that of the next larger size, the requirements of the next larger size shall apply.

5.2 *Joints*—Necessary joints in the completed wire and in the wire and rods prior to final drawing shall be made in accordance with the best commercial practice.

5.3 *Resistivity*—The electrical resistivity 20°C shall not exceed 875.20 $\Omega \cdot lb/mile^2$ (0.15328 $\Omega \cdot g/m^2$).

5.4 *Dimensions and Permissible Variations*—The wire sizes shall be expressed as the diameter of the wire in decimal fractions of an inch to the nearest 0.0001 in. (0.001 mm) (0.0025 mm) (see Explanatory Note 3). For diameters under 0.0100 in. (0.2540 mm), the wire shall not vary from the specified diameter by more than plus and minus 0.0001 in. (0.0025 mm), and for diameters of 0.0100 in. and over the wire shall not vary from the specified diameter by more than plus and minus 1 %, expressed to the nearest 0.0001 in. (0.001 mm).

5.5 *Finish*—The wire shall be free of all imperfections not consistent with the best commercial practice.

6. Test Methods

6.1 *Tensile Strength and Elongation*—No test for tensile

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[2] *Annual Book of ASTM Standards*, Vol 02.01.

[3] *Annual Book of ASTM Standards*, Vol 02.03.

[4] Available from the National Technical Information Service, 5285 Port Royal Rd, Springfield, VA 22161.

TABLE 1 Tensile Requirements

Diameter		Area at 20°C			Elongation in 10 in. (254 mm), % min
in.	mm	cmils	in.^{2}	mm^2	
0.4600	11.684	211 600	0.1662	107.0	35
0.4096	10.404	167 800	0.1318	85.0	35
0.3648	9.266	133 100	0.1045	67.4	35
0.3249	8.252	105 600	0.08291	53.5	35
0.2893	7.348	83 690	0.06573	42.4	30
0.2576	6.543	66 360	0.05212	33.6	30
0.2294	5.827	52 620	0.04133	26.7	30
0.2043	5.189	41 740	0.03278	21.2	30
0.1819	4.620	33 090	0.02599	16.8	30
0.1620	4.115	26 240	0.02061	13.3	30
0.1443	3.665	20 820	0.01635	10.5	30
0.1285	3.264	16 510	0.01297	8.37	30
0.1144	2.906	13 090	0.01028	6.63	30
0.1019	2.588	10 380	0.008155	5.26	25
0.0907	2.304	8 230	0.00646	4.17	25
0.0808	2.052	6 530	0.00513	3.31	25
0.0720	1.829	5 180	0.00407	2.63	25
0.0641	1.628	4 110	0.00323	2.08	25
0.0571	1.450	3 260	0.00256	1.65	25
0.0508	1.290	2 580	0.00203	1.31	25
0.0453	1.151	2 050	0.00161	1.04	25
0.0403	1.024	1 620	0.00128	0.823	25
0.0359	0.912	1 290	0.00101	0.654	25
0.0320	0.813	1 020	0.000804	0.517	25
0.0285	0.724	812	0.000638	0.411	25
0.0253	0.643	640	0.000503	0.324	25
0.0226	0.574	511	0.000401	0.259	25
0.0201	0.511	404	0.000317	0.205	20
0.0179	0.455	320	0.000252	0.162	20
0.0159	0.404	253	0.000199	0.128	20
0.0142	0.361	202	0.000158	0.102	20
0.0126	0.320	159	0.000125	0.081	20
0.0113	0.287	128	0.000100	0.065	20
0.0100	0.254	100	0.0000785	0.051	15
0.0089	0.226	79.2	0.0000622	0.040	15
0.0080	0.203	64.0	0.0000503	0.032	15
0.0071	0.180	50.4	0.0000396	0.026	15
0.0063	0.160	39.7	0.0000312	0.020	15
0.0056	0.142	31.4	0.0000246	0.016	15
0.0050	0.127	25.0	0.0000196	0.013	15
0.0045	0.114	20.2	0.000 0159	0.010	15
0.0040	0.102	16.0	0.0000126	0.0081	15
0.0035	0.089	12.2	0.00000962	0.0062	15
0.0031	0.079	9.61	0.00000755	0.0049	15

strength shall be required.

6.1.1 Determine the elongation of wire whose nominal diameter is larger than 0.0808 in. (2.052 mm) in diameter as the permanent increase in length, expressed in percent of the original length, due to the breaking of the wire in tension, measured between gage marks placed originally 10 in. (254 mm) apart upon the test specimen (see Explanatory Note 4). The elongation of wire whose nominal diameter is 0.0808 in. (2.052 mm) and under may be determined as described above or by measurements made between the jaws of the testing machine. When the latter method is used, the zero length shall be the distance between the jaws at the start of the tension test and be as near 10 in. (254 mm) as practicable, and the final length shall be the distance between the jaws at the time of rupture. The fracture shall be between gage marks in the case of specimens so marked or between the jaws of the testing machine and not closer than 1 in. (25.4 mm) to either gage mark or either jaw.

6.2 *Resistivity*—Determine the electrical resistivity of the material in accordance with Test Method B 193 (see Explanatory Note 5). The purchaser may accept certification that the wire was drawn from stock meeting the International Standard for Annealed Copper instead of resistivity tests on the finished wire.

6.3 *Dimensional Measurements*—Make dimensional measurements with a micrometer caliper equipped with a vernier graduated in 0.0001 in. (0.001 mm). Take measurements on at least three places on each unit selected for this test. If accessible, take one measurement on each end and one near the middle. The average of the three measurements shall determine compliance with the requirements.

6.4 *Surface Finish*—Make a surface-finish inspection with the unaided eye (normal spectacles acceptable).

7. Conformance Criteria (see Explanatory Note 6)

7.1 Any lot of wire, the samples of which comply with the conformance criteria of this section, shall be considered as complying with the requirements of Section 5. Individual production units that fail to meet one or more of the requirements shall be rejected. Failure of a sample group from a lot to

meet one or more of the following criteria shall constitute cause for rejection of the lot. The conformance criteria for each of the prescribed properties given in Section 5 are as follows:

7.1.1 *Elongation*—The lot shall be considered conforming if the average elongation of the four specimens is not less than the appropriate elongation value in Table 1 plus 2.5 percentage points; however any individual production unit, the specimen from which has an elongation less than the appropriate elongation value in Table 1, shall be rejected.

7.1.1.1 The lot shall be considered to have failed to meet the elongation conformance criterion if the average of the four specimens is less than the elongation in Table 1 plus 2.5 percentage points *and* elongation of any of the individual specimens is less than the value in Table 1.

7.1.1.2 If the average of the four specimens is less than the elongation in Table 1 plus 2.5 percentage points and the elongation of each of the individual specimens is equal to or more than the value in Table 1, six additional specimens from six production units, other than the four originally sampled shall be tested. The lot shall be considered conforming if the elongation of each of the ten specimens is not less than the appropriate elongation value in Table 1, and the average of the ten specimens is not less than that value plus 2.5 percentage points. The lot shall be considered to have failed to meet the elongation requirement if any of the ten specimens is less than the appropriate elongation value in Table 1 or if the average of the ten specimens is less than that value plus 2.5 percentage points.

7.1.2 *Resistivity*—The electrical resistivity of each of the four specimens shall conform to the requirements of 5.3. Failure to meet these requirements shall constitute failure to meet the resistivity conformance criterion.

7.1.3 *Dimensions*—The dimensions of the first sample (Table 2) shall conform to the requirements of 5.4. If there are no failures, the lot conforms to this requirement. If there are failures but the number of these does not exceed the allowable defect number, c_2 (Table 2), for the respective number of units in the sample, a second sample equal to n_2 shall be taken and the total defects of the n_1 plus n_2 units shall not exceed the allowable defect number, c_2. Failure to meet this requirement shall constitute failure to meet the dimensional conformational criterion.

7.1.4 *Surface Finish*—The surface finish of the samples taken in accordance with Table 3 shall conform to the requirements of 5.5. The number of units in the sample showing surface defects not consistent with commercial practice shall not exceed the allowable defect number, *c*, in Table 3. Failure to meet this requirement shall constitute failure to meet the surface-finish conformance criterion.

TABLE 3 Sampling for Surface Finish and Packaging Inspection

Number of Units in Lot	Number of Units in Sample, *n*	Allowable Number of Defective Units, *c*
1 to 30, incl	all	0
31 to 50, incl	30	0
51 to 100, incl	37	0
101 to 200, incl	40	0
201 to 300, incl	70	1
301 to 500, incl	100	2
501 to 800, incl	130	3
Over 800	155	4

7.1.5 *Packaging*—Conformance to the packaging requirements specified by the purchaser shall be determined in accordance with Table 3. The number of units in the sample showing nonconformance to the requirement shall not exceed the allowable defect number, *c*, in Table 3. Failure to meet this requirement shall constitute failure to meet the packaging conformance criterion.

8. Density

8.1 For the purpose of calculating mass per unit length, cross-sections, etc., the density of the copper shall be taken as 8.89 g/cm^3(0.32117 lb/in.^{3}) at 20°C (see Explanatory Note 7).

9. Inspection

9.1 *General* (see Explanatory Note 6)—All tests and inspections shall be made at the place of manufacture unless agreed upon between the manufacturer and the purchaser at the time of purchase. The manufacturer shall afford the inspector representing the purchaser all reasonable facilities to satisfy him that the material is being furnished in accordance with this specification.

9.1.1 Unless otherwise agreed upon between the purchaser and the manufacturer, conformance of the wire to the various requirements listed in Section 5 shall be determined on samples taken from each lot of wire presented for acceptance.

9.1.2 The manufacturer shall, if requested prior to inspection, certify that all wire in the lot was made under such conditions that the product as a whole conforms to the requirements of this specification as determined by regularly made and recorded tests.

9.2 *Inspection and Testing Terms*:

9.2.1 *Lot*—A lot is any amount of wire of one type and size presented for acceptance at one time, such amount, however,

TABLE 2 Sampling for Dimensional Measurements

Number of Units in Lot	First Sample		Second Sample		
	Number of Units in Sample, n_1	Allowable Number of Defects in First Sample, c_1	Number of Units in Sample, n_2	n_1 plus n_2	Allowable Number of Defects in Both Samples, c_2
1 to 30, incl	all	0	...	...	...
15 to 50, incl	14	0	...	...	...
51 to 100, incl	19	0	23	42	1
101 to 200, incl	24	0	46	70	2
201 to 400, incl	29	0	76	105	3
401 to 800, incl	33	0	112	145	4
Over 800	34	0	116	150	4

not to exceed 100 000 lb (45 000 kg) (see Explanatory Note 8).

9.2.2 *Sample*—A sample is a quantity of production units (coils, reels, etc.) selected at random from the lot for the purpose of determining conformance of the lot to the requirements of this specification.

9.2.3 *Specimen*—A specimen is a length of wire removed for test purposes from any individual production unit of the sample.

9.3 *Sample Size*—The number of production units in a sample (see Explanatory Note 6) shall be as follows:

9.3.1 For elongation and resistivity determinations, the sample shall consist of four production units. From each unit, one test specimen of sufficient length shall be removed for the performance of the required tests.

9.3.2 For dimensional measurements, the sample shall consist of a quantity of production units shown in Table 2 under the heading "First Sample."

9.3.3 For surface-finish inspection and for packaging inspection (when specified by the purchaser at the time of placing the order) the sample shall consist of a quantity of production units shown in Table 3.

10. Packaging and Package Marking

10.1 Package sizes shall be agreed upon between the manufacturer and the purchaser in the placing of individual orders.

10.2 The wire shall be protected against damage in ordinary handling and shipping.

11. Keywords

11.1 copper electrical conductor; copper wire; electrical conductor; electrical conductor—copper; soft or annealed copper wire

EXPLANATORY NOTES

NOTE 1—Soft or annealed copper wire is wire which has been drawn to size by customary operations and then annealed. When necessary it is finished by cleaning to remove scale or oxide. The wire is soft and ductile, easily marred, and even stretched by careless handling. It is therefore necessary that the requirements of this specification relating to elongation properties and resisitivity refer to the wire as it is put up by the manufacturer, and before being put through processes incident to its use by the purchaser.

NOTE 2—Other tests than those provided in this specification have been considered at various times, such as twist tests, wrap tests, tests for elastic limit, etc. It is the opinion of the committee that twist and wrap tests on soft wire do not serve a useful purpose and should be regarded as undesirable, as well as inconclusive as to results and significance. Tests for values of elastic limit are likewise indefinite as to results.

NOTE 3—The values of the wire diameters in Table 1 are given to the nearest 0.0001 in. (0.001 mm) and correspond to the standard sizes given in Specification B 258. The use of gage numbers to specify wire sizes is not recognized in this specification because of the possibility of confusion. An excellent discussion of wire gages and related subjects is contained in *NIST Handbook 100*.

NOTE 4—In general, tested values of tensile strength are increased and tested values of elongation are reduced with increase of speed of the moving head of the testing machine in the tension testing of copper wire. In the case of tests on soft or annealed copper wire, however, the effects of speed of testing are not pronounced. Tests of soft wire made at speeds of moving head which under no-load conditions are not greater than 12 in./min (305 mm/min) do not alter the final results of tensile strength and elongation determinations to any practical extent.

NOTE 5—"Resistivity" is used in place of" percentage conductivity." The value of 0.15328Ω· g/m^2 at 20°C is the international standard for the resistivity of annealed copper equal to 100 % conductivity. This term means that a wire 1 m in length and weighing 1 g would have a resistance of 0.15328 Ω. This is equivalent to a resistivity value of 875.20 Ω·lb/mile^2 which signifies the resistance of a wire 1 mile in length weighing 1 lb. It is also equivalent, for example, to 1.7241 μΩ/cm of length of a bar 1 cm^2 in cross-section. A complete discussion of this subject is contained in *NBS Handbook 100.* Relationships which may be useful in connection with the value of resistivity prescribed in this specification are shown in Table 4.

NOTE 6—Cumulative results secured on the product of a single manufacturer, indicating continued conformance to the criteria, are necessary to ensure an over-all product meeting the requirements of this specification. The sample sizes and conformance criteria given for the various characteristics are applicable only to lots produced under these conditions.

NOTE 7—The value of density of copper is in accordance with the International Annealed Copper Standard. The corresponding value at 0°C is 8.90 g/cm^3(0.32150 lb/in^3.).

NOTE 8—A lot should comprise material taken from a product regularly meeting the requirements of this specification. Inspection of individual lots of less than 5000 lb (2270 kg) of wire cannot be justified economically. For small lots of 5000 lb or less, the purchaser may agree to the manufacturer's regular inspection of the product as a whole as evidence of acceptability of such small lots.

TABLE 4 Resistivity Relationships

Conductivity at (20°C), %	100.00
Ω·lb/mile^2	875.20
Ω·g/m^2	0.15328
Ω·cmil/ft	10.371
Ω·mm^2/m	0.017241
μΩ·in.	0.67879
μΩ·cm	1.7241