
**Steel for the prestressing of
concrete —**

**Part 4:
Strand**

*Acier pour armatures de précontrainte —
Partie 4: Torons*





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Published in Switzerland

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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 16, *Steels for the reinforcement and prestressing of concrete*.

This second edition cancels and replaces the first edition (ISO 6934-4:1991), which has been technically revised. It also incorporates the Technical Corrigenda ISO 6934-4:1991/Cor 1:1992 and ISO 6934-4:1991/Cor 1:2000.

The main changes compared to the previous edition are as follows:

- subclause [4.6](#) has been added to introduce finishing and appearance;
- [Figure 1](#) has been updated;
- subclause [6.5](#) and [Annex A](#) have been added to introduce and elaborate on stress corrosion;
- subclause [6.6](#) and [Annex B](#) have been added to introduce and elaborate on deflected tensile test;
- [Table 1](#) has been updated;
- in [Clause 7](#), the terminology "newtons per square millimetre" has been replaced with "MPa";
- in [Clause 8](#), packing and protection requirements has been added.

A list of all parts in the ISO 6934 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Steel for the prestressing of concrete —

Part 4: Strand

1 Scope

This document specifies requirements for steel strand which has been given a stress-relieving heat treatment according to the general requirements specified in ISO 6934-1. This document covers 10 grades of steel strand for use in prestressed concrete construction; each strand can contain either 2, 3, 7 or 19 individual wires. In case of any conflict between the requirements of this document and ISO 6934-1, the requirements of document prevail.

2 Normative reference

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

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

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 6934-1 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

3.1

compacted strand

strand which has been compressed (e.g. by cold working after stranding) and given a stress-relieving heat treatment before winding into reel form

4 Conditions of manufacture

4.1 Steel

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

4.2 Stress-relieving heat treatment

The strand shall be subjected to a low-temperature heat treatment as a continuous linear process by unreeling and running the strand through a suitable form of heating (see ISO 6934-1).

The strand shall be rewound into reels or onto reels having a core diameter which is sufficiently large to ensure that the strand shall be reasonably straight when unreeled (see 8.3).