



SPECIFICATION
FOR
EC GRADE ROD





1. SCOPE

This specification covers aluminum 1350 drawing stock 9.52 mm to 12.00 mm in diameter, in the tempers 1350-H14 and –H24, 1350-H12 and –H22 for drawing into wire for electrical conductors.

1. REQUIREMENTS

1.1. CHEMICAL COMPOSITION

1.1.1. The stock shall conform to the requirements of table 1 as to chemical composition. The determination of chemical composition shall be made in accordance with suitable chemical (Test Method E 34), spectrochemical (Test Method E 227), or other methods.

Element	Composition, %
Silicon, max	0.10
Iron, max	0.40
Copper, max	0.05
Manganese, max	0.01
Chromium, max	0.01
Zinc, max	0.05
Boron, max	0.05
Gallium, max	0.03
Vanadium plus titanium, total, max	0.02
Other elements, each, max	0.03
Other elements, total, max	0.10
Aluminum, min	99.50

Table1

1.2. TENSILE

Tension tests shall be made in accordance with Test Methods B 557. When tested in full section, the free length between jaws of the testing machine shall be at least 250 mm.

1.2.1. Limits:

1.2.1.1. STOCK

The tensile strength of respective tempers of stock shall conform to the requirements specified in table 2. All tensile test results shall be reported.

Temper	Tensile Strength MPa (N/mm ²)	Resistivity, Ω.mm ² /m, max	Equivalent Volume Conductivity, %IACS ¹ , min
1350-H12 and –H22	83-117	0.028035	61.5
1350-H14 and –H24	103-138	0.025080	61.4

Table2

¹ International Annealed Copper Standard



1.2.1.2. JOINTS

The tensile strength of joints made in the finished stock shall be not less than 76 MPa.

1.3. RESISTIVITY

1.3.1. The electrical resistivity of the stock in the temper supplied shall conform to the requirements specified in table 2. The resistivity tests shall be made on full-section samples of the stock in accordance with Test Method B 193.

1.4. DIAMETER AND PERMISSIBLE VARIATIONS

1.4.1. The diameter of the stock shall be specified in decimal fractions of an inch using three places of decimals or in millimeters using two places of decimals. The diameter of the stock shall be determined on at 10% of the coils in a lot. The diameter shall not vary from that specified by more than the permissible variation specified in table 3.

Specified Diameter, mm.	Tolerance, mm. Plus or Minus	
	Deviation of Mean Diameter from Specified Diameter	Deviation at Any Point from Specified Diameter
9.52-12.70	0.51	0.76

Table3

2. INSPECTION, TEST

2.1. Inspections and tests required by this Specification, shall be made by the manufacturer to purchaser.

3. PACKAGING, MARKING AND SHIPPING

3.1. The material shall be shipped in coils.

3.2. Each coil shall bear a tag showing the manufacturer's name or trademark, size, aluminum number, and temper of material. If additional information is to be required on the tags, it shall be arranged with the manufacturer at the time of purchase.

3.3. SIZE OF COIL

3.3.1. Weight of coil

✓ 2250 Kg (about 2 ton)

