

STRANDS & WIRES

FOR CONSTRUCTION
SECTOR



ushamartin.com

 **usha martin**

LRPC STRANDS- CONSTRUCTION PRODUCTS

Usha Martin's continued investment in technology and equipment consistently push products to the highest quality standards. Years of engineering excellence, demonstrates our commitment to our customers in the construction industry. To keep pace with new concepts and constructional revolutions, Usha Martin product basket encompasses a comprehensive range of LRPC strands, namely:

- Bright Low relaxation (LRPC)/Normal relaxation (NRPC) Strand
- Galvanized LRPC Strand
- Polymer Coated*Galvanized*/Bright LRPC Strand
 - ▶ Grease/Wax Filled - Un-bonded LRPC Strand.
 - ▶ Bonded LRPC Strand
- Plain, Indented & Ribbed high tensile steel wire for Prestressed concrete.

*LRPC Strands of all available sizes and grades can be polymer sheathed & galvanized in conformance to all national and international specifications.



NATIONAL PRESENCE



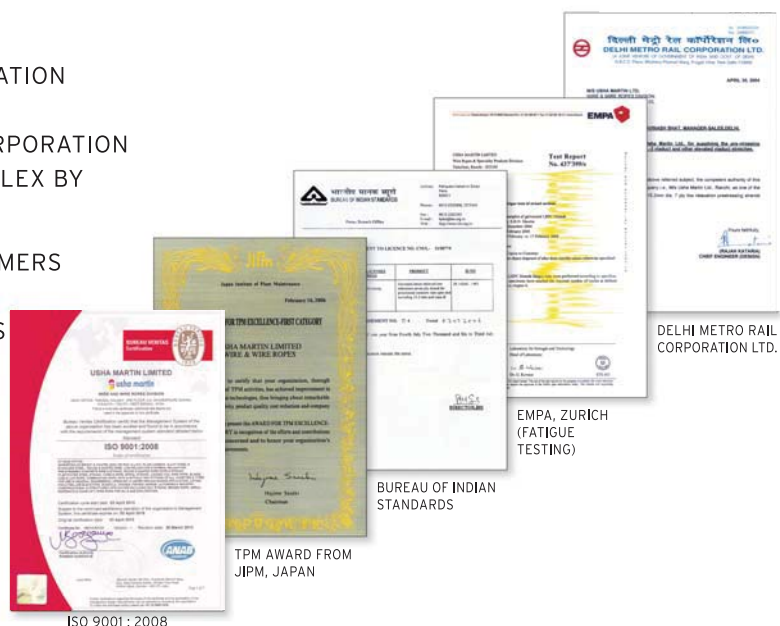
OUR VALUED CLIENTS

NATIONAL

- NATIONAL HIGHWAY AUTHORITY OF INDIA (NHA)
- PUBLIC WORKS DIVISION (PWD)
- NUCLEAR POWER CORPORATION
- DELHI METRO RAILWAY CORPORATION
- KOLKATA METRO RAILWAYS
- NATIONAL THERMAL POWER CORPORATION
- IT PARKS & MULTISTORIED COMPLEX BY PRIVATE CONTRACTORS

INTERNATIONAL OVERSEAS CUSTOMERS SPREAD OVER

- GULF & MIDDLE EAST COUNTRIES
- PAPUA NEW GUINEA
- BANGLADESH
- SOUTH AFRICA
- AUSTRALIA



HIGH TENSILE STEEL STRANDS

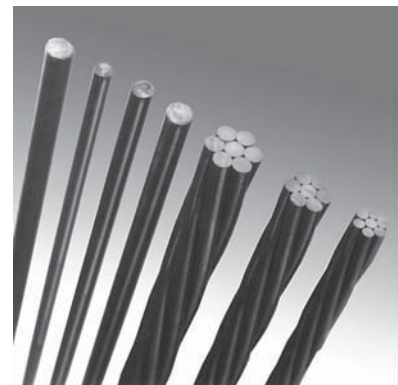
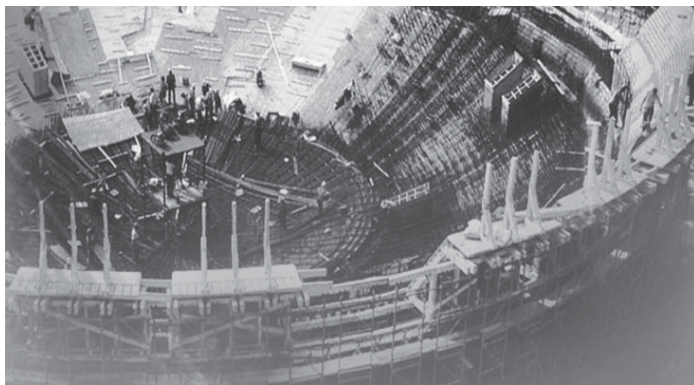
for Prestressed Concrete (Low Relaxation)

Why Low Relaxation Strands ?

A steel member that is prestressed and embedded in concrete, loses the initially applied stress exponentially with the passage of time. The utmost important factor attributing to this loss in stress is the stress relaxation property of the steel itself. By treating the steel through a thermomechanical process known as stabilising, the propensity of the steel to "relax" under a stressed condition is controlled to a great extent. Some of the main advantages that our customers derive by using low relaxation strands are listed below :

- Upto 10% reduction in steel requirement is possible.
- Saving in number of anchorages, ducts, sheathings, wedges and labour resulting in overall reduction of project cost.
- Reduction in concrete requirement due to reduced size of structural members.
- Thermo-mechanical processing during manufacture of LRPC Strands produces a nearly straight strand, thereby eliminating necessity for extra post straightening treatment.

Applications : Prestressed concrete girders for road, river & railway bridges and flyovers, prestressed concrete domes, buildings, silos, hangars, aquaducts, viaducts & railway sleepers.



Product Specifications Bright (Ungalvanized LRPC Strands)

INDIAN SPECIFICATIONS : IS-14268/1995

Class	Nominal Diameter of Strand	Tolerance	Nominal area of Strand	Minimum Breaking Strength of Strand		0.2 Proof load (90% of Breaking Strength)		Minimum % Elongation GL=600mm	Nominal Weight of Strand (Approx)	Relaxation Loss	Chemical Composition
	(mm)	(±mm)		(kN)	(kg)	(kN)	(kg)				
11	9.5	+0.66 -0.15	54.8	102.3	10434	92.1	9394	3.5	432	2.5 max. at 70% of specified min. breaking load after 1000 hours OR 1.8 max. at 70% of specified min. breaking load after 100 hours	S = .04 max. P = .04 max.
	11.1	+0.66 -0.15	74.2	137.9	14065	124.1	12658		582		
	12.7	+0.66 -0.15	98.7	183.7	18737	165.3	16860		775		
	15.2	+0.66 -0.15	140.0	260.7	26592	234.6	23929		1102		

BRITISH SPECIFICATIONS : BS-5896 : 1980

Type of Strand	Nominal Diameter	Tolerance of		Nominal area of Strand	Nominal Tensile strength	Specified Characteristic breaking strength	Load at 1% Elongation	Relaxation			Minimum Elongation at max load	Nominal Mass
		dia	Cross Sectional areas & mass					Initial load (% of actual breaking load)	Maximum after 1000 hrs	Class 1		
	(mm)	(±mm)		(mm ²)	(N/mm ²)	(kN)	(kN)	For all strands			(L ₀ ≥500mm)	(kg/1000m)
7 Wire Standard	9.3	±0.30 -0.15 +0.40 -0.20	+4% -2%	52	1770	92	81	60% 70% 80%	4.5% 8.0% 12%	1.0% 2.5% 4.5%	3.5%	408
	11.0			71	1770	125	110					557
	12.5			93	1770	164	144					730
	15.2			139	1670	232	204					1090
7 Wire Super	9.6	+0.30 -0.15 +0.40 -0.20	+4% -2%	55	1860	102	90	80%	12%	4.5%	3.5%	432
	11.3			75	1860	139	122					590
	12.9			100	1860	186	163					785
	15.7			150	1770	265	233					1180

ASTM SPECIFICATIONS : A416

Grade	Nominal Diameter of Strand		Tolerance		Nominal area of Strand		Minimum Breaking Strength of Strand		Minimum load at 1% Extension		Nominal Weight of Strand (Approx)		1000 hrs Relaxation	Minimum % Extension GL 600 mm
	(Inch)	(mm)	(±Inch)	(±mm)	(Inch ²)	(mm ²)	(lb)	(kN)	(lb)	(kN)	(lb/1000ft)	(kg/1000m)		
270	3/8	9.53	+0.026 +0.66 -0.006 -0.15		0.085	54.84	23000	102.30	20700	92.10	290	432	2.5% max. at 70% of specified min. breaking strength OR 3.5% max. at 80% of specified min. breaking strength.	3.5
	7/16	11.11			0.115	74.19	31000	137.90	27900	124.10	390	582		
	1/2	12.70			0.153	98.71	41300	183.70	37170	165.30	520	775		
	6/10	15.24			0.217	140.00	58600	260.70	52740	234.60	740	1102		

SPEC - prEN10138 - 3 : Dimension & Properties of Strands

Class	Steel Designation		Nominal ^{a*}				Specified			
	Steel Name	Steel Number	Diameter	Tensile Strength	Cross-Sectional Area ^{c*}	Mass	Permitted Deviation on Nominal Mass	Characteristic Value of Maximum Force	Maximum Value of Maximum Force	Characteristic Value of 0.1% Proof Force ^{d*}
				R _m ^{b*}				F _m	F _{m max}	F _{p 0.1}
			(mm)	(Mpa)	(mm ²)	(g/m)		(%)	(kN)	(kN)
A	Y1860S7	1.1366	9.0	1860	50	390	±2	93	106	80
			11.0		75	586		140	160	120
			12.5		93	726		173	198	149
			13.0		100	781		186	213	160
			15.2		140	1095		260	298	224
	Y1770S7	1.1365	15.2	1770	140	1095	±2	248	282	213
			16.0		150	1170		279	319	240
			15.2		140	1095		248	282	213
			16.0		150	1170		265	302	228

1 MPa = 1 N / mm²

Notes :

- a* The Nominal Modulus of Elasticity may be taken to be 195 GPa (kN/mm²)
- b* The Nominal Tensile Strength is calculated from the Nominal Cross-Sectional Area and the specified characteristic Maximum Force, rounded to the nearest 10 MPa.
- c* The Cross-Sectional Area is calculated from the Nominal Mass and Density of 7.81 kg/dm³
- d* The specified characteristics 0.1% Proof Force is approximately 86% of the specified characteristic Maximum Force

SPEC - AS - 1311 : Dimension, Masses and Minimum Breaking Force of 7 Wire Strand

Nominal Diameter of strand	Nominal area	Calculated mass	Minimum Breaking Force	Grade
(mm)	(mm ²)	(kg / 1000 m)	(kN)	
9.3	52	410	94	REGULAR
10.9	71	555	125	
12.7	94	740	165	
15.2	139	1090	227	
9.3	55	430	102	SUPER
10.9	75	590	138	
12.7	100	785	184	
15.2	143	1125	250	
15.2	143	1125	261	EXTRA - HIGH TENSILE

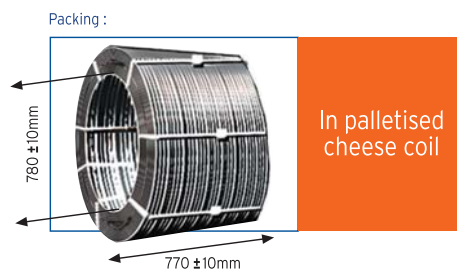


SPEC - ISO 6934 - 4 : 1991 (E) : Dimension, Masses and Tensile Properties of 7 Wire Strand

Type of Strand ^{1*}	Nominal Strand Diameter ^{1*}	Nominal Tensile Strength ^{1* 2*}	Nominal Cross-Sectional Area ^{2*}	Mass Per Length		Characteristic		
				Nominal	Permissible Deviation	Maximum Force ^{2* 3* 4*}	0.1% Proof Force ^{3* 4* 5*}	0.2% Proof Force ^{4* 5*}
(mm)	(mm)	(N/mm ²)	(mm ²)	(g/m)	(%)	(kN)	(kN)	(kN)
7-Wire Ordinary	9.5	1860	54.8	432.0	+4 -2	102.0	83.6	88.6
	10.8	1720	69.7	546.0		120.0	98.4	102.0
	11.1	1860	74.2	580.0		138.0	113.0	117.0
	12.4	1720	92.9	729.0		160.0	131.0	136.0
	12.7	1860	95.7	774.0		184.0	151.0	156.0
	15.2	1720	139.0	1101.0		239.0	196.0	203.0
	15.2	1860	139.0	1101.0		259.0	212.0	220.0

Notes :

- 1* The type of Strand, Nominal Diameter and Nominal Tensile Strength are for designation purposes only.
- 2* The nominal Tensile Strength is calculated from the nominal cross sectional area and the specified characteristic maximum force (see footnote 5*).
- 3* No single test result shall be less than 85% of the specified characteristic value.
- 4* Considering the small tolerance on mass per length, characteristic forces have been specified rather than stresses.
- 5* The 0.1% Proof Force is mandatory and the 0.2% Proof Force is for information only (see ISO 6934 - 1), except when otherwise agreed.



Additional Specifications

PC strands as per following can also be supplied in case of specific demands

- ISI4268, Class 1
- ASTM A416, Grade 250
- JIS G 3536, Grade SW PR7AL, SWPR7BL
- Normal Relaxation PC Strands as per IS6006

INTRODUCING FOR THE FIRST TIME IN INDIA

Galvanised LRPC Strands :

Apart from Bright LRPC Strands, for some application, particularly in the case of extreme corrosive environment, Usha Martin's Galvanized LRPC Strands provides the additional protection required, and can be manufactured to customer requirements.

The physical and mechanical properties of the galvanized strands manufactured from hot - dip galvanized wires are at par with the bright strands for that particular diameter. Galvanization increases the resistance to corrosion led fatigue thereby resulting in enhanced service life.

Zinc coating weight can be supplied as per the customer requirements, varying from 190 - 340 gm/sq m.



Polymer Coated Galvanized / Bright LRPC Strand :

The extruded thermoplastic coating becomes an integral part of the strand and is highly recommended for construction industry. The coating seals out contaminants, cushions the strands, resists abrasion and increases the life cycle capability of the structure.

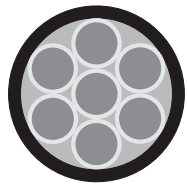
Usha Martin's extensive background in cable sheathing technology and extrusion capability facilitates products with smooth, uniform and concentric coating of Polymer with premium quality. Usha Martin offers a selection of choices of types (family), thickness and colours (UV stabilized) of Polymers suitable for LRPC strand sheathing.



Grease Filled - Un-bonded LRPC Strand-For Post Tensioning

This speciality LRPC Strand may be bright or galvanized depending upon the environment, is coated with a corrosion resistant / water repellent - high temperature grease / wax to fill the interstices between the wires followed by a co-extrusion of an UV stabilized Polymer layer with thickness (min 0.5 mm, max as per customer's requirement). Usha Martin's Galvanized Un-bonded LRPC strands has an excellent durability and provides perfect protection against corrosion through tri-

complimentary nested barrier formed by (1) galvanization followed by (2) anti-corrosive, water repellent - grease / wax coating in the interstices (3) UV stabilized polymer



- Zinc coating
- Anti-corrosion High Temperature Grease
- UV Stabilised Polymer

sheath, This particular arrangement also enables monitoring of strands, by replacing a post-tensioned strand at regular interval.

Bonded LRPC Strand (Galvanized/Bright) - For Stay Cables

Bonding implies adhesion of the polymer sheath with the steel surface of the LRPC Strand. Bonded LRPC Strands exhibits a strong bonding strength and conforms to the requirement of the customers. The state of art sheathing lines and stringent control parameters during manufacture, particularly with regard to diametrical concentricity of sheathing, consents Bridge Designers to bundle Usha Martin strands with confidence.

Properties of Sheathed Galvanized/Bright LRPC Strand Post Tensioning /Stay Applications

Application	LRPC Variants	Sheathing Thickness(mm)		Polymer Type (UV Stabilized)**	Zinc Coating weight
		Min	Max		g/m ²
Post Tensioning	Unbonded (Grease Filled)	0.5	As per Customer's Requirement	PP-Standard Colour Orange OR PE-Standard Colour Black	190-340
Stay Cables	Bonded				

Note:

PP : POLYPROPYLENE , PE : POLYETHYLENE

** Apart from the standard colours shown in the table, other colours can also be supplied as per customers requirement

HIGH TENSILE STEEL WIRES

for Pre-stressed Concrete (Plain, Indented, Ribbed)

Applications : Concrete poles, Railway sleepers, Hume pipes, Bridges.

BRITISH SPECIFICATIONS : BS-5896:1980

Nominal Diameter	Tolerance	Nominal UTS	Minimum Spec. Characteristics 0.1% Proof Load	Minimum load at 1% Elongation	Minimum Elongation % GL 200 mm	Reverse Bend	
						Minimum Number	Radius of Bend
(mm)	(±mm)	(kg/mm ²)	(kN)	(kN)	(%)	(nos.)	(mm)
7.0	0.05	160	50.1	51.3	3.5	4 for	20
6.0	0.05	170	39.3	40.2	-do-	smooth	15
6.0	0.05	180	41.6	42.6	-do-	wires	15
5.0	0.05	170	27.2	21.8	-do-	3 for	15
5.0	0.05	180	28.8	29.5	-do-	indented	15
4.5	0.05	165	21.4	21.9	-do-	wires	15
4.0	0.04	170	17.5	17.9	-do-		10
4.0	0.04	180	18.5	19.0	-do-		10

Notes :

- Maximum relaxation values after 100 hrs. as per Class 1 of BS specification
- Coil weights and IDs shall be as per table below

INDIAN SPECIFICATIONS : IS-1785 Part-1 (Stress Relieved)

Nominal Diameter	Tolerance	Nominal UTS	Minimum Elongation GL=200 mm	Bend Minimum Value	Bend Radius	Minimum 0.2% Proof Stress	Coil I.D.	Coil weights for stress relieved wires
(mm)	(±mm)	(kg/mm ²)	(%)	(nos.)	(mm)		(metre)	(kg)
2.5	0.025	205	2.5	3	7.5	85% of min. Tensile Strength for all wires.	1.5	200-300
3.0	0.04	190	2.5	3	10.0		1.5	200-300
4.0	0.05	175	3.0	3	12.5		1.5	300-500
5.0	0.05	160	4.0	3	15.0		1.5	300-500
7.0	0.05	150	4.0	3	20.0		2.0	300-600
8.0	0.05	140	4.0	3	25.0		2.0	300-600



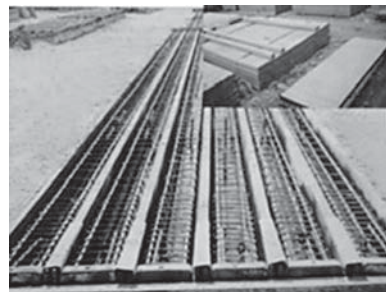
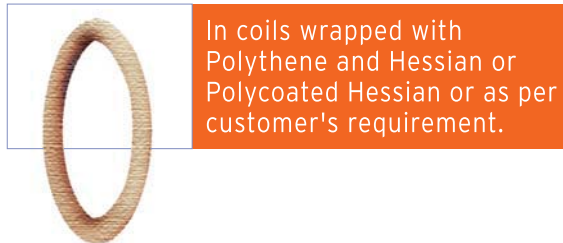
INDIAN SPECIFICATIONS : IS-6003 (Stress Relieved & indented)

Nominal Diameter	Tolerance	Nominal UTS	Minimum Elongation GL=200 mm	Bend Minimum Value	Bend Radius	Minimum 0.2% Proof Stress	Coil I.D.	Coil weights for stress relieved wires
(mm)	(±mm)	(kg/mm ²)	(%)	(nos.)	(mm)		(metre)	(kg)
3.0	0.05	190	2.5	3	10.0	85% of minimum specified UTS for all wires.	1.5	200-300
4.0	0.05	175	3.0	3	12.5		1.5 - 2.0	300-500
5.0	0.05	160	4.0	3	15.0		1.5 - 2.0	300-500

Notes :

- Apart from plain wires, we can also produce two side/ indented wires and ribbed wires
- In sizes 7.00 and 8.00mm stress relieved wire we can also manufacture 160 kg/mm² minimum tensile.
- Relaxation values at initial stress 70% of min. UTS for all wires are 5% max. after 1000 hrs. or 3.5% max. after 100 hrs.
- Wires can be supplied in uncoiled condition or can be coated with water soluble rust preventive oil
- We can also produce wires in higher sizes conforming to the above specifications.
- We can also manufacture High tensile Steel Wires as per other standards.
- Wires of higher diameters can also be produced as per customers requirement.

Packing :



Corporate Office

USHA MARTIN LIMITED

2A, Shakespeare Sarani, 'Mangal Kalash', Kolkata - 700071
Phone: +91 33 3980 0300, Fax: +91 33 2282 9029/ 3980 0500
Email: feedback@ushamartin.co.in
CIN: L31400WB1986PLC091621

Domestic Offices

East Regional Office

USHA MARTIN LIMITED

2A, Shakespeare Sarani
'Mangal Kalash'
Kolkata - 700071
Phone: +91 33 3980 0300/ 0458
Fax: +91 33 2282 9029/ 3980 0500
Email: marketing-east@ushamartin.com

South Regional Office

USHA MARTIN LIMITED

Plot No. L9 (1), Phase-II
Sipcot Industrial Park, Sriperumbudur
Kancheepuram - 602105
Chennai, Tamilnadu
Phone: +91 44 3717 5100 (24 Lines)
Fax: +91 44 3717 5200
Email: marketing-south@ushamartin.com

North Regional Office

USHA MARTIN LIMITED

701, 'Surya Kiran'
19, Kasturba Gandhi Marg
New Delhi - 100 001
Phone: +91 11 2331 5156 / 5157 / 5158
2371 1232 / 2371 5220
Fax: +91 11 2332 0723 / 5586
Email: marketing-north@ushamartin.com

West Regional Office

USHA MARTIN LIMITED

168, CST Road,
Agarwal Industrial Estate
Kalina, Santa Cruz (E)
Mumbai - 400 098
Phone: +91 22 3064 5400
Fax: +91 22 2652 6774
Email: marketing-west@ushamartin.com

Overseas Offices

USHA MARTIN UK LIMITED

Tasman House, Mariner Court
Clydebank, Glasgow, UK G81 2NR, UK
Tel: + 44 (0)141 951 8801
Fax: + 44 (0) 141 951 8802
Email: marketing-uk@ushamartin.com

EUROPEAN MANAGEMENT & MARINE CORP.

Howe Moss Place, Kirkhill Industrial Estate
Dyce, Aberdeen AB 21 OGS, Scotland, U.K
Ph: +44 1224 77 5151
Fax: +44 1224 775252
Email: info@emmcorg.com

BRUNTON SHAW UK

(A Division of Usha Martin UK Limited)
Sandy Lane, Workshop, S80 3ES, UK
Tel: + 44 1909 537 600
Fax: + 44 1909 500 199
Email: info@brunton-shaw.co.uk

DE RUITER STAALKABEL B.V.

Ringerstraat 7, 3164 BA, Sliedrecht
Holland
Tel: + 31 (0)184 49 9999
Fax: +31 (0) 184 41 8351
Email: sales@drstk.nl

USHA MARTIN AMERICAS, INC

701 Plastics Avenue, Houston
Texas 77020, USA
Ph: +1 713 676 1800
Fax: +1 713 676 1166
Email: marketing-us@ushamartin.com

USHA MARTIN AUSTRALIA PTY LTD

Unit 2/ 468-470, Victoria Street
St.Wetherill Park, NSW 2164, Australia
Ph: +61 296 094971
Fax: +61 297 566516
Email: marketing-australia@ushamartin.com

USHA MARTIN SINGAPORE PTE LIMITED

91 Tuas Bay Drive, Usha Martin Building,
Singapore - 637307
Ph: +65 6265 7756
Fax: +65 6265 7226
Email: marketing-singapore@ushamartin.com

USHA MARTIN VIETNAM CO. LTD

823 Huynh Tan Phat, Hamlet 6
Phu Xuan Commune Nha Be District
Ho Chi Minh City, S.R Vietnam
Tel: +84 8 3781 8196
Fax: +84 8 3781 8171
HP: +84 903702469
Email : marketing-vietnam@ushamartin.com

PT. USHA MARTIN INDONESIA

Konica Building 3A Fl
Jl. Gunung Sahari Raya 78
Jakarta 10610 - Indonesia
Ph: +62 21 42870794
Fax: +62 21 42870795
Email: marketing-indonesia@ushamartin.com

BRUNTON WOLF WIRE ROPES FZCO

P.O. Box. 17491, M00301
Jebel Ali Free Zone, Dubai, U.A.E
Tel: + 971 04 8838151
Fax: + 971 04 8838152
Email: marketing-bsme@ushamartin.com

USHA SIAM STEEL INDUSTRIES PUBLIC CO. LTD

209 K-Tower-B, 22nd Floor, Unit 3/1
Sukhumvit 21 Road (Asok)
Bangkok - 10110, Thailand
Tel: +662 261 7361 to 64
Fax: +662 640 8227
Email: marketing-thailand@ushamartin.com

USHA MARTIN EUROPE B.V.

Leerlooierstraat 3
2984 BK Ridderkerk
Holland
Phone: +31 (0)180 74 50 99
Mobile: +31 (0)635 11 29 31
E-mail: d.gelton@ushamartineurope.com

USHA MARTIN CHINA CO. LTD.

No. 122, East FuTe No. 1 Rd. Wai Gao Qiao Free Trade Zone,
Shanghai, P.R. China (Shanghi) Pilot Free Trade Zone,
Postal Code: 200131
Tel: +86 21 6858 8699
Fax: +86 21 6858 8711
Email: yhw@umchina.com.cn