



Designation: A1124/A1124M – 23

Standard Specification for Textured Epoxy-Coated Steel Reinforcing Bars¹

This standard is issued under the fixed designation A1124/A1124M; 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 deformed steel reinforcing bars with protective epoxy coating applied by the electrostatic spray method followed by a texturing surface treatment material.

NOTE 1—The coating applicator is identified throughout this specification as the manufacturer.

1.2 Other organic coatings and texturing surface treatment materials may be used provided they meet the requirements of this specification.

1.3 Requirements for coatings are contained in Annex A1 of Specification [A775/A775M](#).

1.4 Requirements for texturing surface treatment material are contained in [Annex A1](#).

1.5 Requirements for patching material are contained in Annex A2 of Specification [A775/A775M](#).

1.6 Guidelines for construction practices at the job-site are presented in [Appendix X1](#).

1.7 This specification is applicable for orders in either inch-pound units (as Specification A1124) or SI units [as Specification A1124M].

1.8 The values stated in either inch-pound units or SI units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.9 *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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.10 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the*

Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.

2. Referenced Documents

2.1 ASTM Standards:²

[A615/A615M](#) Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement

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

[A775/A775M](#) Specification for Epoxy-Coated Steel Reinforcing Bars

[A944](#) Test Method for Comparing Bond Strength of Steel Reinforcing Bars to Concrete Using Beam-End Specimens

[A996/A996M](#) Specification for Rail-Steel and Axle-Steel Deformed Bars for Concrete Reinforcement

[A1035/A1035M](#) Specification for Deformed and Plain, Low-Carbon, Chromium, Steel Bars for Concrete Reinforcement

[B117](#) Practice for Operating Salt Spray (Fog) Apparatus

[D374/D374M](#) Test Methods for Thickness of Solid Electrical Insulation

[D2967](#) Test Method for Corner Coverage of Powder Coatings

[D3170](#) Test Method for Chipping Resistance of Coatings

[D4060](#) Test Method for Abrasion Resistance of Organic Coatings by the Taber Abraser

[D7127](#) Test Method for Measurement of Surface Roughness of Abrasive Blast Cleaned Metal Surfaces Using a Portable Stylus Instrument (Withdrawn 2021)³

[E2937](#) Guide for Using Infrared Spectroscopy in Forensic Paint Examinations

[G8](#) Test Methods for Cathodic Disbonding of Pipeline Coatings

[G14](#) Test Method for Impact Resistance of Pipeline Coatings (Falling Weight Test)

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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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 The last approved version of this historical standard is referenced on www.astm.org.

G20 Test Method for Chemical Resistance of Pipeline Coatings

G62 Test Methods for Holiday Detection in Pipeline Coatings

2.2 ACI Standards:⁴

ACI 301 Specifications for Structural Concrete

2.3 AMPP Standards:⁵

RP-287-87 Field Measurement of Surface Profile of Abrasive Blast-Cleaned Steel Surface Using a Replica Tape

SSPC-PA 2 Measurement of Dry Coating Thickness with Magnetic Gages

SSPC-SP 10 Near-White Blast Cleaning

SSPC-VIS 1 Pictorial Surface Preparation Standards for Painting Steel Surfaces

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *conversion coating, n*—preparation of the blast-cleaned steel surface prior to coating application that is designed to pretreat the metal to promote coating adhesion, reduce metal-coating reactions, improve corrosion resistance, and increase blister resistance.

3.1.2 *disbonding, n*—loss of adhesion between the fusion-bonded epoxy coating and the steel reinforcing bar.

3.1.3 *fusion-bonded epoxy coating, n*—product containing pigments, thermosetting epoxy resins, crosslinking agents, and other additives, which is applied in the form of a powder onto a clean, heated metallic substrate and fuses to form a continuous barrier coating.

3.1.4 *holiday, n*—discontinuity in a coating that is not discernible to a person with normal or corrected vision.

3.1.5 *patching material, n*—liquid two-part epoxy coating used to repair damaged or uncoated areas.

3.1.6 *R_v, n*—the vertical distance between the highest peak and lowest valley in a sampling length averaged over the five sampling lengths comprising the evaluation length measured in accordance with Test Method D7127.

3.1.7 *texturing surface treatment material, n*—a product applied immediately following the application of a fusion-bonded epoxy coating to improve bond strength to concrete.

3.1.8 *wetting agent, n*—material that lowers the surface tension of water allowing it to penetrate more effectively into small discontinuities in the coating, giving a more accurate indication of the holiday count.

4. Ordering Information

4.1 Orders for textured epoxy-coated steel reinforcing bars under this specification shall contain the following information:

4.1.1 Specification and year of issue for the reinforcing bars to be coated (5.1),

4.1.2 Quantity of bars,

4.1.3 Size and grade of bars, and

4.1.4 ASTM designation A1124/A1124M and year of issue.

4.2 The purchaser shall have the option to specify additional requirements, including but not limited to the following:

4.2.1 Requirements for review of test data to demonstrate that the powder coating meets Annex A1 (5.2),

4.2.2 Representative sample of epoxy powder coating (5.3),

4.2.3 Requirements for review of test data to demonstrate that the textured coating meets Annex A1 (5.4),

4.2.4 Representative sample of texturing surface treatment material (5.5),

4.2.5 Quantity of patching material (5.6.2),

4.2.6 Specific requirements for test frequency (9.1),

4.2.7 A report of the results of the tests performed on the coated steel reinforcing bars (14.1),

4.2.8 Requirements for inspection (12.1),

4.2.9 Manufacturer qualification and certification requirements (if any), and

4.2.10 Other special requirements, if any.

NOTE 2—It is recommended that the coating application procedures and processes be audited by an independent certification program for epoxy coating applicator plants such as that provided by the Concrete Reinforcing Steel Institute, or equivalent.⁶

NOTE 3—A typical ordering description is as follows: Deformed Grade 60 bars to ASTM A615 – ____; 20 000 ft, No. 6, 40 ft 0 in. long in secured lifts with sufficient spacers or padding, or both; textured epoxy-coated to ASTM A1124 – ____; including written certifications for the powder coating and coated bars, and 1 qt of patching material.

Deformed Grade 420 bars to ASTM A615M – ____; 6000 m, No. 19, 12 m long in secured lifts with sufficient spacers or padding, or both; textured epoxy-coated to ASTM A1124M – ____; including written certifications for the powder coating and coated bars, and 1 L of patching material.

5. Materials

5.1 Steel reinforcing bars to be coated shall meet the requirements of one of the following specifications: A615/A615M, A706/A706M, A996/A996M, or A1035/A1035M, as specified by the purchaser and shall be free of contaminants such as oil, grease, or paint.

NOTE 4—Prior to coating, the steel reinforcing bars should be inspected for their suitability for coating. Bars with sharp edges on the deformations, rolled-in slivers, or other surface imperfections are difficult to coat properly and should not be coated. The coating will flow away from the sharp edges and may result in inadequate coating thickness at these points.

5.2 The powder coating shall meet the requirements of Annex A1 of Specification A775/A775M. Upon request, the purchaser shall be provided with the test report for review.

5.2.1 A written certification shall be furnished to the purchaser that properly identifies the number of each lot of powder coating used in the order, material quantity represented, date of manufacture, name and address of the powder coating manufacturer, and a statement that the supplied powder coating is the same composition as that qualified according to Annex A1 of Specification A775/A775M.

5.2.2 The powder coating shall be stored in a temperature-controlled environment following the written recommendations of the powder coating manufacturer until ready for use.

⁴ Available from American Concrete Institute (ACI), 38800 Country Club Dr., Farmington Hills, MI 48331-3439, <http://www.concrete.org>.

⁵ Available from Association for Materials Protection and Performance (AMPP), 15835 Park Ten Place, Houston, TX 77084, <https://www.ampp.org>.

⁶ CRSI Voluntary Certification Program for Fusion Bonded Epoxy Coating Applicator Plants.