



Designation: A975 – 24

# Standard Specification for Double-Twisted Hexagonal Mesh Gabions and Revet Mattresses (Metallic-Coated Steel Wire or Metallic-Coated Steel Wire With Polymer Coating)<sup>1</sup>

This standard is issued under the fixed designation A975; 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 gabions and revet mattresses produced from double-twisted metallic-coated wire mesh, and metallic-coated wire for lacing wire, stiffeners, and fasteners used for manufacturing, assembling, and installation of the product. This specification also covers gabions and revet mattresses in which the wire mesh, lacing wire, and stiffeners are polymer coated after the metallic coating.

1.2 Double-twisted wire mesh for gabions and revet mattresses is produced in different styles, based on type of coating, as described in Section 4.

1.3 *Units*—The values stated in SI units are to be regarded as standard. The values given in parentheses after SI units are provided for information only and are not considered standard.

1.4 This specification references notes and footnotes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of this specification.

1.5 The following safety hazards caveat pertains only to the test methods portion, Section 13, of this specification: *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 consult and establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.6 *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.*

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee A05 on Metallic-Coated Iron and Steel Products and is the direct responsibility of Subcommittee A05.12 on Wire Specifications.

Current edition approved Nov. 1, 2024. Published November 2024. Originally approved in 1997. Last previous edition approved in 2023 as A975 – 23. DOI: 10.1520/A0975-24.

## 2. Referenced Documents

### 2.1 ASTM Standards:<sup>2</sup>

- A90/A90M Test Method for Weight [Mass] of Coating on Iron and Steel Articles with Zinc or Zinc-Alloy Coatings
- A313/A313M Specification for Stainless Steel Spring Wire
- A370 Test Methods and Definitions for Mechanical Testing of Steel Products
- A428/A428M Test Method for Weight [Mass] of Coating on Aluminum-Coated Iron or Steel Articles
- A641/A641M Specification for Zinc-Coated (Galvanized) Carbon Steel Wire
- A764 Specification for Metallic Coated Carbon Steel Wire, Coated at Size and Drawn to Size for Mechanical Springs
- A809 Specification for Aluminum-Coated (Aluminized) Carbon Steel Wire
- A856/A856M Specification for Zinc-5 % Aluminum-Mischmetal Alloy-Coated Carbon Steel Wire
- A902 Terminology Relating to Metallic Coated Steel Products
- B117 Practice for Operating Salt Spray (Fog) Apparatus
- D412 Test Methods for Vulcanized Rubber and Thermoplastic Elastomers—Tension
- D746 Test Method for Brittleness Temperature of Plastics and Elastomers by Impact
- D792 Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement
- D1242 Test Methods for Resistance of Plastic Materials to Abrasion (Withdrawn 2003)<sup>3</sup>
- D1499 Practice for Filtered Open-Flame Carbon-Arc Exposures of Plastics
- D2240 Test Method for Rubber Property—Durometer Hardness
- G23 Practice for Operating Light-Exposure Apparatus (Carbon-Arc Type) With and Without Water for Exposure

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [www.astm.org/contact](http://www.astm.org/contact). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

<sup>3</sup> The last approved version of this historical standard is referenced on [www.astm.org](http://www.astm.org).

\*A Summary of Changes section appears at the end of this standard

### 3. Terminology

#### 3.1 Definitions:

3.1.1 Refer to Terminology A902 for general terminology relating to metallic-coated steel products.

#### 3.2 Definitions of Terms Specific to This Standard:

3.2.1 *double-twisted wire mesh, n*—a nonraveling mesh made by twisting continuous pairs of wires through three one-half turns (commonly called double-twisted) to form hexagonal-shaped openings which are then interconnected to adjacent wires to form hexagonal openings.

3.2.2 *edge wire, n*—a terminal wire used to edge the wire mesh parallel to the double twist by continuously weaving it into the wire mesh.

3.2.3 *fastener, n*—an alternate method to lacing wire used for binding operations for gabions and revet mattresses.

3.2.4 *gabion, n*—a double-twisted wire mesh container of variable sizes, uniformly partitioned into internal cells, interconnected with other similar units, and filled with stone at the project site to form flexible, permeable, monolithic structures such as retaining walls, sea wall, channel linings, revetments, and weirs for erosion control projects (see Fig. 1 and Fig. 2).

3.2.5 *lacing wire, n—for gabions and revet mattresses, a* metallic-coated steel wire or metallic-coated steel wire with polymer coating used to assemble and interconnect empty units, to close and secure stone-filled units, and for internal stiffeners.

3.2.6 *revet mattress, n*—a double-twisted wire mesh container uniformly partitioned into internal cells with relatively small height in relation to other dimensions, having smaller mesh openings than the mesh used for gabions; revet mattresses are generally used for riverbank protection and channel linings (see Fig. 3).

3.2.7 *seldge wire, n*—a terminal wire used to edge the wire mesh perpendicular to the double twist by mechanically wrapping the mesh wires around it at least 2.5 times or by inserting it throughout the twists and folding one mesh length.

3.2.8 *stiffener, n—for gabions, a* length of metallic-coated steel wire or metallic-coated steel wire with polymer coating used for support of facing by connecting the front panel to the back panel of a gabion (stiffener formed at the project site using wire having the same diameter as for the lacing wire (see Table 1) or across the corners of a gabion cell using preformed stiffener having a diameter as specified in Table 1).

#### 3.3 Abbreviations:

3.3.1 PVC—poly(vinyl chloride).

3.3.2 Zn-5Al-MM—zinc-5 % aluminum-mischmetal alloy.

### 4. Classification

4.1 Double-twisted wire gabions and revet mattresses are classified according to coating, as follows:

4.1.1 *Style 1*, consists of double-twisted wire mesh made from wire which is zinc coated before being double-twisted into mesh. Fasteners, lacing wire, and stiffeners are produced from zinc-coated wire.

4.1.2 *Style 2*, consists of double-twisted wire mesh made from wire which is coated with Zn-5Al-MM before being double-twisted into mesh. Fasteners, lacing wire, and stiffeners are also produced from Zn-5Al-MM coated wire.

4.1.3 *Style 3*, consists of double-twisted mesh, lacing wire, and stiffeners as Style 1 and overcoated with polymer. Fasteners shall be of stainless steel wire.

4.1.4 *Style 4*, consists of double-twisted mesh made from wire which is aluminum-coated before being double-twisted into mesh. Fasteners, lacing wire, and stiffeners are also produced from aluminum-coated wire.

### 5. Ordering Information

5.1 Orders for material to this specification shall include the following information:

- 5.1.1 Quantity (number of units) as shown on plan,
- 5.1.2 Product type (gabions or revet mattresses),
- 5.1.3 Size (length by width by height),
- 5.1.4 Style of coating (Section 4), including the specific style to be furnished, or all acceptable styles,
- 5.1.5 ASTM designation and year of issue,
- 5.1.6 Any special requirements (see 8.2.5), and
- 5.1.7 Certification, if required (see Section 15).

NOTE 1—A typical ordering description is as follows: 100 gabions, 2 m by 1 m by 1 m or (6 ft by 3 ft by 3 ft), 100 revet mattresses 4 m by 2 m by 0.23 m or (12 ft by 6 ft by 0.75 ft), and 100 lids 4 m by 2 m or (12 ft by 6 ft) as shown on plans; Style 1, 2, 3, or 4 with required fasteners or lacing wire and stiffeners; conforming to Specification A975.

### 6. Material and Manufacture

6.1 The wire used in the manufacture of double-twisted mesh for use in gabions and revet mattresses shall conform to the specifications shown in 6.1.1, 6.1.2, 6.1.3, or 6.1.4 as appropriate for the style ordered, except that the tensile strength shall conform to 7.1.

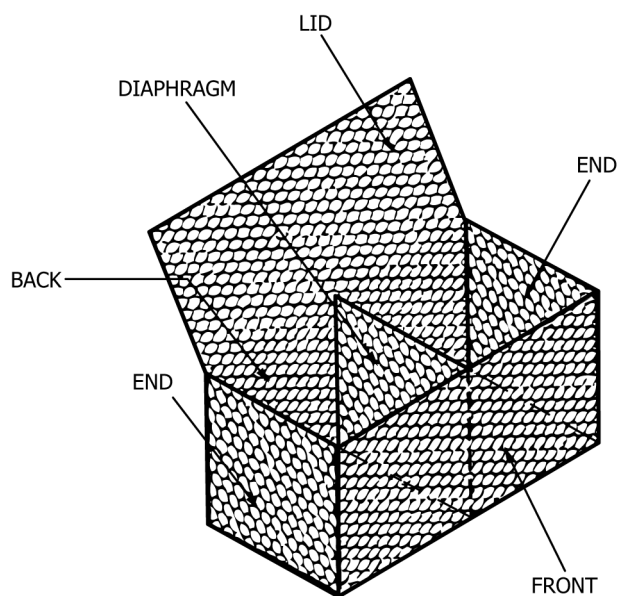


FIG. 1 Gabion

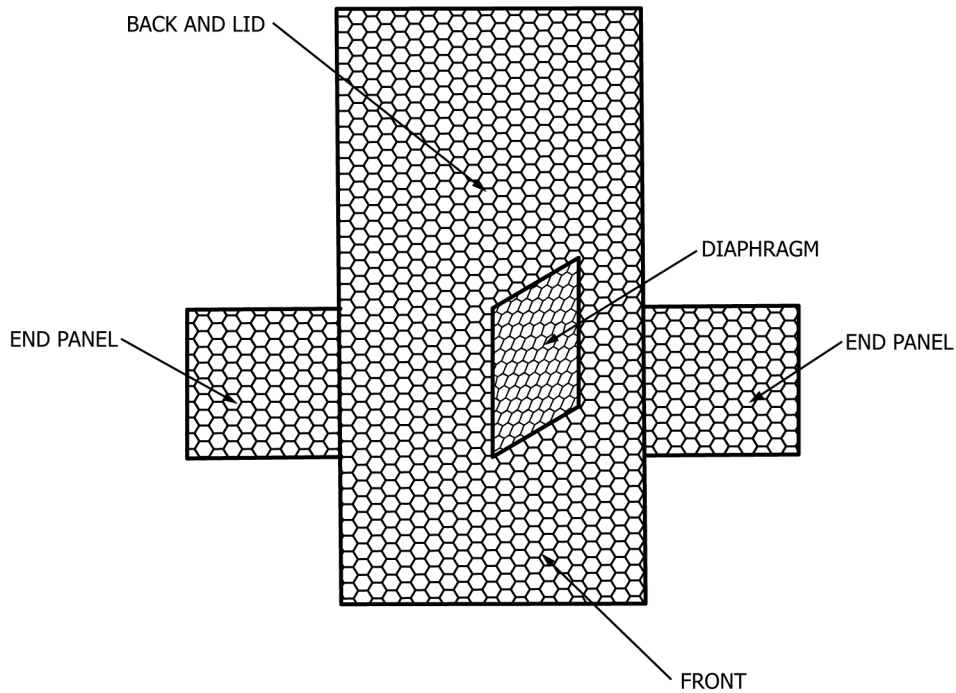


FIG. 2 Mechanically Manufactured Gabion

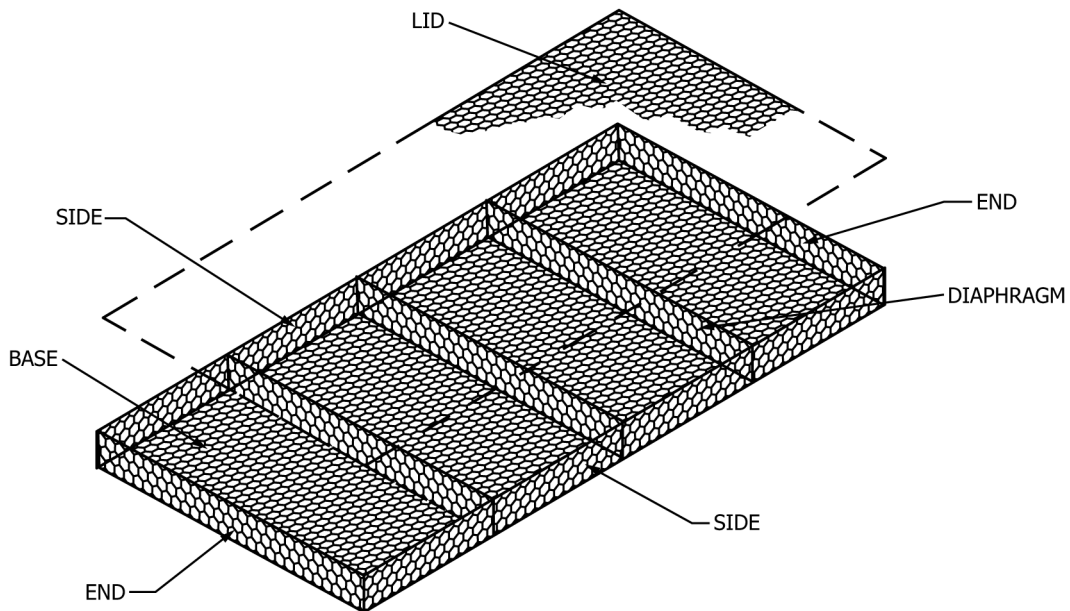


FIG. 3 Revet Mattress

6.1.1 Style 1 double-twisted mesh shall be manufactured from zinc-coated steel wire conforming to Specification [A641/A641M](#), Class 3 coating, soft or medium temper.

6.1.2 Style 2 double-twisted mesh shall be manufactured from Zn-5Al-MM-coated steel wire conforming to Specification [A856/A856M](#), Class 3 coating, soft or medium temper.

6.1.3 Style 3 double-twisted mesh shall be manufactured from the same type of metallic-coated steel wire as Style 1 with an additional polymer coating extruded onto the metallic-coated steel wire. The polymer coating shall conform to the performance properties in [8.2](#).

6.1.3.1 Original or modified thermoplastic polymers along with their application methods can be permitted, as long as their performance is equivalent to the performance requirements of the PVC coating.

6.1.4 Style 4 double-twisted mesh shall be manufactured from aluminum-coated steel wire conforming to Specification [A809](#), soft or medium temper.

6.2 Lacing wire and stiffeners shall be made of wire having the same coating material as the double-twisted wire mesh furnished on the order and conforming to Specifications