



Designation: **F620 – 11 (Reapproved 2015) F620 – 20**

Standard Specification for Titanium Alloy Forgings for Surgical Implants in the Alpha Plus Beta Condition¹

This standard is issued under the fixed designation F620; 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 the requirements for titanium alloy forgings for surgical implants, in the alpha plus beta condition, when the material forged conforms to Specifications **F136** (UNS R56401), **F1295** (UNS R56700), **F1472** (UNS R56400), or **F2066** (UNS R58150).

1.2 The SI units in this standard are the primary units. The values stated in either primary SI units or secondary inch-pound 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~~ nonconformance with the standard.

1.3 *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.*

1.4 *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

E8/E8M Test Methods for Tension Testing of Metallic Materials

E10 Test Method for Brinell Hardness of Metallic Materials

E18 Test Methods for Rockwell Hardness of Metallic Materials

E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E92 Test Methods for Vickers Hardness and Knoop Hardness of Metallic Materials <https://standards.iteh.ai/>

E165 Practice for Liquid Penetrant Testing for General Industry

E539 Test Method for Analysis of Titanium Alloys by Wavelength Dispersive X-Ray Fluorescence Spectrometry

E1409 Test Method for Determination of Oxygen and Nitrogen in Titanium and Titanium Alloys by Inert Gas Fusion

E1447 Test Method for Determination of Hydrogen in Titanium and Titanium Alloys by Inert Gas Fusion Thermal Conductivity/Infrared Detection Method

E2371 Test Method for Analysis of Titanium and Titanium Alloys by Direct Current Plasma and Inductively Coupled Plasma Atomic Emission Spectrometry (Performance-Based Test Methodology)

E2994 Test Method for Analysis of Titanium and Titanium Alloys by Spark Atomic Emission Spectrometry and Glow Discharge Atomic Emission Spectrometry (Performance-Based Method)

F67 Specification for Unalloyed Titanium, for Surgical Implant Applications (UNS R50250, UNS R50400, UNS R50550, UNS R50700)

F136 Specification for Wrought Titanium-6Aluminum-4Vanadium ELI (Extra Low Interstitial) Alloy for Surgical Implant Applications (UNS R56401)

F601 Practice for Fluorescent Penetrant Inspection of Metallic Surgical Implants

¹ This specification is under the jurisdiction of ASTM Committee F04 on Medical and Surgical Materials and Devices and is the direct responsibility of Subcommittee F04.12 on Metallurgical Materials.

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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.

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

[F1295](#) Specification for Wrought Titanium-6Aluminum-7Niobium Alloy for Surgical Implant Applications (UNS R56700)
[F1472](#) Specification for Wrought Titanium-6Aluminum-4Vanadium Alloy for Surgical Implant Applications (UNS R56400)
[F2066](#) Specification for Wrought Titanium-15 Molybdenum Alloy for Surgical Implant Applications (UNS R58150)
[IEEE/ASTM SI 10](#) American National Standard for the Use of the International System of Units (SI): The Modern Metric System

2.2 ISO Standard:³

[ISO 9001](#) Quality Management Systems ~~management systems~~ requirement

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *lot*—the total number of forgings produced from the same heat under the same conditions and heat treated at essentially the same time.

4. Ordering Information

4.1 Inquiries and orders for forgings under this specification shall include the following information:

4.1.1 Quantity, number of ~~pieces~~, pieces;

4.1.2 ASTM designation and date of issue, material ~~grade~~, grade;

4.1.3 ~~Condition~~, Condition;

4.1.4 Mechanical ~~properties~~, properties;

4.1.5 ~~Finish~~, Finish;

4.1.6 Applicable dimensions or drawing ~~number~~, number;

4.1.7 Special tests, if ~~any~~, any; and

4.1.8 Other requirements.

5. Materials and Manufacture

5.1 Material for forgings shall be bars or wire fabricated in accordance with Specification [F136](#), [F1295](#), [F1472](#), or [F2066](#).

5.2 The material shall be forged by hammering, pressing, extruding, or upsetting and shall be processed, if practicable, so as to cause metal flow during the hot-working operation in the direction most favorable for resisting stresses encountered in service, as may be indicated to the fabricator by the purchaser.

5.3 Forgings shall be free of splits, scale, cracks, flaws, and other imperfections not consistent with good commercial practice (see [Note 1](#)). Offset or mismatch allowance, dependent upon part size and configuration, shall be within standard forging tolerances.

NOTE 1—Compliance to these requirements may be verified by ~~Test Method Practice E165~~ or Practice [F601](#) or other suitable methods). ~~20~~

5.4 After all hot-working operations have been completed, the forgings shall receive an annealing treatment consisting of heating the parts to an appropriate elevated temperature for a specified dwell time followed by appropriate cooling to meet the applicable metallurgical requirements specified herein.

5.5 Optional identification marks, including the manufacturer's logo, material designation, heat code number, and impression ~~number~~, number may be placed upon each forging, the method and location of which shall be specified by the purchaser.

6. Chemical Composition

6.1 When specified by the purchaser, the chemical composition of either the forging bars or the completed forgings shall be determined and confirmed by the forger, and shall meet the product check analysis limits of the appropriate material specification.

6.1.1 Hydrogen content shall be determined on annealed forgings. Samples for hydrogen analysis shall be taken after descaling, pickling, or chemical milling, if these operations are performed.

6.2 For referee purposes, Test Methods [E539](#), [E1409](#), [E1447](#), ~~and E2371~~ and [E2994](#) shall be used.

7. Mechanical Requirements

7.1 The mechanical properties of forgings shall be tested by the forger and shall comply with the minimum mechanical properties as specified in Specifications [F136](#), [F1295](#), [F1472](#), or [F2066](#).

7.1.1 Test specimens shall be taken from a representative forging if possible, or from a representative forged test bar. A representative test bar may only be used if the configuration is such that a test bar cannot be obtained. Any specially forged test bar must be annealed with the forgings it represents.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.