



Designation: F2181 – 20

Standard Specification for Wrought Seamless Stainless Steel Tubing for Surgical Implants¹

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1. Scope*

1.1 This specification covers the requirements for five compositions of wrought seamless stainless steel tubing for the manufacture of surgical implants. Material shall conform to the applicable requirements of Specification F138, F1314, F1586, F2229, or F2581. This specification addresses those product variables that differentiate wrought seamless tubing from the bar and wire product forms covered in these specifications.

1.2 This specification applies to cold finished, straight length tubing from 3 to 34 mm [0.125 to 1.315 in.] nominal outside diameter (OD) and 0.5 mm [0.020 in.] and greater nominal wall thickness.

1.3 The specifications in 2.1 are referred to as the ASTM material standard(s) in this specification.

1.4 The values stated in either SI units or inch-pound units are to be regarded separately as standard. Inch-pound units are shown in brackets. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other and values from the two systems shall not be combined.

1.5 *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.*

1.6 *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.*

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. Referenced Documents

2.1 ASTM Material Standards:²

F138 Specification for Wrought 18Chromium-14Nickel-2.5Molybdenum Stainless Steel Bar and Wire for Surgical Implants (UNS S31673)

F1314 Specification for Wrought Nitrogen Strengthened 22 Chromium-13 Nickel-5 Manganese-2.5 Molybdenum Stainless Steel Alloy Bar and Wire for Surgical Implants (UNS S20910)

F1586 Specification for Wrought Nitrogen Strengthened 21Chromium-10Nickel-3Manganese-2.5Molybdenum Stainless Steel Alloy Bar for Surgical Implants (UNS S31675)

F2229 Specification for Wrought, Nitrogen Strengthened 23Manganese-21Chromium-1Molybdenum Low-Nickel Stainless Steel Alloy Bar and Wire for Surgical Implants (UNS S29108)

F2581 Specification for Wrought Nitrogen Strengthened 11Manganese-17Chromium-3Molybdenum Low-Nickel Stainless Steel Alloy Bar and Wire for Surgical Implants (UNS S29225)

2.2 ASTM Standards:

A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels

A269 Specification for Seamless and Welded Austenitic Stainless Steel Tubing for General Service

A632 Specification for Seamless and Welded Austenitic Stainless Steel Tubing (Small-Diameter) for General Service

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

F2257 Specification for Wrought Seamless or Welded and Drawn 18 Chromium-14Nickel-2.5Molybdenum Stainless Steel Small Diameter Tubing for Surgical Implants (UNS S31673)

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

IEEE/ASTM SI 10 American National Standard for Use of the International System of Units (SI): The Modern Metric System

2.3 ISO Standards:³

ISO 5832-1 Implants for Surgery—Metallic Materials—Part 1: Wrought Stainless Steel

ISO 5832-9 Implants for Surgery—Metallic Materials—Part 9: Wrought High Nitrogen Stainless Steel

ISO 9001 Quality Management System—Requirements

ISO 13485 Medical Devices—Quality Management Systems—Requirements for Regulatory Purposes

2.4 ASME Standard:⁴

ASME Y14.5.1M Mathematical Definition of Dimensioning and Tolerancing Principles

of the tube. Sample concentricity shall be expressed as a percent of the wall thickness and shall be calculated using the following equation:

$$\text{sample concentricity percent} = 2 \times \left(\frac{A - B}{A + B} \right) \times 100$$

where:

A = sample maximum wall, and

B = sample minimum wall.

3.1.9 *sample maximum wall thickness*—the largest individual wall thickness measurement taken around the circumference on any one transverse cross section of a single sample of tube.

3.1.10 *sample minimum wall thickness*—the smallest individual wall thickness measurement taken around the circumference on any one transverse cross section of a single sample of tube.

4. General Requirements for Delivery

4.1 In addition to the requirements of this specification, all applicable requirements of the appropriate ASTM material standard shall apply.

4.2 In addition to the requirements of this specification, all applicable seamless tubing requirements of Specification A269 or Specification A632 shall apply. Flare testing is not applicable.

4.3 If a conflict exists between this specification and those listed in Section 2, or if a conflict exists between those specifications listed in 2.1 and those listed in 2.2 and 2.3, the following order of precedence applies: (1) this specification, (2) the ASTM material standard referenced on the purchase order, and (3) all other referenced specifications.

5. Ordering Information

5.1 Inquiries and orders for material under this specification should include the following information:

- 5.1.1 Quantity (weight, total length, or number of pieces),
- 5.1.2 This ASTM specification and date of issue,
- 5.1.3 The appropriate ASTM material standard and date of issue,
- 5.1.4 Units to be certified—SI or inch-pound,
- 5.1.5 Condition (see 6.2),
- 5.1.6 Surface finish (see 6.3),
- 5.1.7 Applicable dimensions including OD and ID, OD and wall or ID and wall, length (exact, random, multiples), or engineering drawing reference number,
- 5.1.8 Dimensional tolerances (see Table 1 and Table 2),
- 5.1.9 Special requirements or supplements, if any, and
- 5.1.10 Certification requirements.

6. Materials and Manufacture

6.1 Method of Manufacture:

6.1.1 Tubing shall be made by the seamless process in which the tube periphery is continuous at all stages of the process.

6.2 Condition:

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *individual wall thickness measurement*—any one of the wall thickness measurements taken around the circumference on any one transverse cross section of a single sample of the tube.

3.1.2 *lot*—the total number of product produced from the same melt heat under the same conditions at essentially the same time.

3.1.3 *lot average concentricity*—the arithmetic average of the sample concentricities measured on a statistically representative number of samples from the lot.

3.1.4 *lot average wall thickness*—the arithmetic average of the sample average wall thicknesses measured on a statistically representative number of samples from the lot.

3.1.5 *nominal outside diameter (OD)*—the outside diameter specified on the purchaser's order or engineering drawing without regard to tolerance.

3.1.6 *nominal wall thickness*—the wall thickness specified on the purchaser's order or engineering drawing without regard to tolerance.

3.1.7 *sample average wall thickness*—the arithmetic average of all individual wall thickness measurements measured around the circumference on any one transverse cross section of a single sample of tube.

3.1.8 *sample concentricity*—two times the offset between the centers of the two circles representing the outside diameter (OD) and the inside diameter (ID) of the tube.

3.1.8.1 *Discussion*—For the purposes of this specification, the sample minimum wall and the sample maximum wall measured on any one transverse cross section of a single sample shall be used to calculate sample concentricity. The sample maximum and sample minimum wall thickness shall be the largest and smallest, respectively, of no less than four individual wall thickness measurements taken at uniformly spaced locations around the circumference of a single sample

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

⁴ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

TABLE 1 Permissible Variation in OD Dimensions

Nominal OD, mm [in.]	Permissible Variation from Nominal ^A	
	Standard Tolerance, mm [in.]	Half Standard Tolerance, ^B mm [in.]
3.2 to 12.7 excl. [0.125 to 0.500]	± 0.050 [0.002]	±0.025 [0.001]
12.7 to 25.4 excl. [0.500 to 1.00]	±0.075 [0.003]	±0.038 [0.0015]
25.4 to 34 incl. [1.00 to 1.315]	±0.100 [0.004]	±0.050 [0.002]

^A Unless otherwise specified, size tolerances are plus and minus as shown in the table. When required by the purchaser, tolerances may be specified all plus and nothing minus, or all minus and nothing plus, or any combination of plus and minus if the total spread in size tolerance is not less than the total spread shown in the table.

^B Half standard tolerance may be used when specifying tubing for use on machining centers with tight collet clearance.

TABLE 2 Permissible Variation in ID Dimensions

Nominal ID, mm [in.]	Permissible Variation from Nominal, mm [in.] ^A
Up to 12.7 excl. [0.500]	±0.050 [0.002]
12.7 to 25.4 excl. [0.500 to 1.00]	±0.075 [0.003]
25.4 and over [1.00]	±0.100 [0.004]

^A Unless otherwise specified, size tolerances are plus and minus as shown in the table. When required by the purchaser, tolerances may be specified all plus and nothing minus, or all minus and nothing plus, or any combination of plus and minus if the total spread in size tolerance is not less than the total spread shown in the table.

6.2.1 Tubing shall be furnished, as specified, in the annealed, cold worked, medium hard, hard, or extra hard condition as defined in the appropriate ASTM material standard.

6.3 Surface Finish:

6.3.1 The tubing outer surface shall be furnished with a pickled, cold drawn, bright annealed, ground, or polished finish. Outer surface roughness shall be 0.8 μm [30 $\mu\text{in.}$] Ra maximum.

6.3.2 The tubing inner surface shall be furnished with a pickled, cold drawn, bright annealed, or abrasive conditioned finish. Inner surface roughness shall be 1.5 μm [60 $\mu\text{in.}$] Ra maximum.

6.3.3 The method used to determine surface roughness shall be agreed upon between the purchaser and supplier.

7. Chemical Composition, Metallurgical Requirements, and Mechanical Properties

7.1 The chemical composition, metallurgical requirements, and mechanical properties of the finished tube shall conform to the requirements of the appropriate ASTM material standard. Alternative mechanical properties may be agreed upon between the purchaser and the supplier.

7.2 If both tensile properties and hardness are specified on the purchase order, tensile properties shall be used to accept or reject the tubing. Hardness shall be reported for information only.

8. Permissible Outer and Inner Surface Imperfections

8.1 For tubes with wall thickness greater than or equal to 1.5 mm [0.060 in.] and less than 6.5 mm [0.250 in.], neither outer

nor inner surface imperfections shall exceed 0.08 mm [0.003 in.] in depth. For tubes with wall thickness greater than or equal to 6.5 mm [0.250 in.], neither outer nor inner surface imperfections shall exceed 0.13 mm [0.005 in.] in depth. For tubes with wall thickness less than 1.5 mm [0.060 in.], outer and inner surface imperfection depth shall be agreed upon between purchaser and supplier.

8.2 The method of inspecting for these imperfections shall be negotiated between the purchaser and supplier.

8.3 Outer surface imperfections may be removed by grinding or polishing providing that the resultant wall thickness does not violate the minimum wall thickness. The ground or polished surface shall meet the surface finish requirements of 6.3.1.

9. Special Tests

9.1 The material shall conform to the special test requirements of the appropriate ASTM material standard.

9.2 When required by the appropriate ASTM material standard, both OD and ID surfaces of the finished tube shall be capable of passing the intergranular corrosion susceptibility test in accordance with Practice E of Practices A262.

10. Dimensions and Permissible Variation

10.1 Units of Measure:

10.1.1 *Selection*—This specification requires that the purchaser selects the units of measure (SI or inch-pound) to be used for product certification. In the absence of a stated selection of units on the purchase order, this selection may be expressed by the purchaser in several alternate forms listed in order of precedence.

10.1.1.1 If the purchaser and supplier have a history of using specific units, these units shall continue to be certified until expressly changed by the purchaser.

10.1.1.2 In the absence of historic precedence, if the units used to define the product on the purchaser's PO, specification, and engineering drawing are consistent, these units shall be used by the supplier for product certification.

10.1.1.3 If the purchaser's selection of units is unclear, the units of measure shall be agreed upon between purchaser and supplier.

10.1.2 *Conversion of Units*—If the supplier's test equipment does not report in the selected units, the test equipment units may be converted to the selected units for certification purposes. Accurate arithmetic conversion and proper use of significant digits should be observed when performing this conversion. **IEEE/ASTM SI 10** provides guidelines for the use of SI units. Annex A provides conversion tables and Annex B provides rules for conversion and significant digits.

10.2 Permissible Variation in Dimensions:

10.2.1 *OD and ID*—The permissible variations of OD and ID from the nominal dimension on the purchase order or engineering drawing are listed in **Tables 1 and 2**.

10.2.2 Wall Thickness:

10.2.2.1 The range of total wall variation (including concentricity and average wall variation) shall not exceed 14 % (± 7 %) of nominal wall thickness.