



Designation: F560 – 22

Standard Specification for Unalloyed Tantalum for Surgical Implant Applications (UNS R05200, UNS R05400)¹

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1. Scope*

1.1 This specification covers chemical, mechanical, and metallurgical requirements for unalloyed tantalum plate, sheet, strip, bar, and wire used in the manufacture of surgical implants.

1.2 *Units*—The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, to ensure conformance with the standard, each system shall be used independently of the other and values from the two systems shall not be combined.

1.3 *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
 - E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
 - F981 Practice for Assessment of Compatibility of Biomaterials for Surgical Implants with Respect to Effect of Materials on Muscle and Insertion into Bone
 - IEEE/ASTM SI 10 American National Standard for Metric Practice

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.

2.2 *ISO Standards:*³

- ISO 6892 Metallic Materials—Tensile Testing at Ambient Temperature
- ISO 9001 Quality Management Systems—Requirements
- ISO 13485 Medical Devices—Quality Management Systems—Requirements for Regulatory Purposes
- ISO 13782 Implants for Surgery—Metallic Materials—Unalloyed Tantalum for Surgical Implant Applications

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *bar*—material 3.15 to 63.5 mm [0.125 to 2.5 in.] in diameter in round, hexagonal, or octagonal cross section supplied in straight lengths.

3.1.2 *lot*—all material produced from the same ingot or a single powder blend with the same cross section under the same conditions at essentially the same time.

3.1.3 *plate*—a flat product more than 4.75 mm [0.1875 in.] in thickness.

3.1.4 *sheet*—a flat product 150 mm [6 in.] or more in width and from 0.13 to 4.75 mm [0.005 to 0.1875 in.] in thickness.

3.1.5 *strip*—a flat product less than 150 mm [6 in.] in width and from 0.13 to 4.75 mm [0.005 to 0.1875 in.] in thickness, which may be supplied in coil.

3.1.6 *wire*—material up to 3.15 mm [0.124 in.] in diameter furnished in coils or on spools or reels.

4. Ordering Information

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

- 4.1.1 Quantity (weight or number of pieces);
- 4.1.2 ASTM designation, alloy number, and date of issue;
- 4.1.3 Units to be used for certification (SI or inch-pound);
- 4.1.4 Composition designation (see 5.1);
- 4.1.5 Form (strip, sheet, plate, bar, wire) (see 3.1);

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

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

4.1.6 Condition (see 5.4);

4.1.7 Applicable dimensions, including size, thickness, width, and length (random, exact, multiples), or drawing number;

4.1.8 Special tests;

4.1.9 Special requirements; and

4.1.10 Mechanical properties (if applicable for special conditions) (see 7.1).

5. Materials and Manufacture

5.1 Material covered by this specification shall be made from vacuum-arc melted or electron-beam melted ingots (R05200) or powder-metallurgy consolidated (R05400) unalloyed tantalum.

5.2 The various tantalum mill products covered by this specification are formed with the conventional extrusion, forming, swaging, rolling, and drawing equipment normally available in metalworking plants.

5.3 *Finish*—The mill product may be furnished as descaled or pickled, abrasive blasted, chemically milled, ground, machined, peeled, polished, or as specified by the purchaser.

5.4 *Condition*:

5.4.1 Flat mill products shall be supplied in the cold-worked, cold-worked and stress-relieved, or annealed condition.

5.4.2 Bar and wire products shall be supplied in the annealed or cold-worked condition.

6. Chemical Requirements

6.1 The material shall conform to the chemical composition requirements in Table 1.

6.1.1 Requirements for the major and minor elemental constituents are listed in Table 1. Also listed are important residual elements. Analysis for elements not listed in Table 1 is not required to certify compliance with this specification.

6.1.2 All commercial metals contain small amounts of elements other than those that are specified. It is neither practical nor necessary to specify limits for unspecified

TABLE 1 Chemical Requirements

Element	Compositions, max % (mass/mass)	
	R05200 ^A	R05400 ^B
Carbon	0.010	0.010
Oxygen	0.015	0.030
Nitrogen	0.010	0.010
Hydrogen	0.0015	0.0015
Niobium	0.10	0.10
Iron	0.010	0.010
Titanium	0.010	0.010
Tungsten	0.050	0.050
Molybdenum	0.020	0.020
Silicon	0.005	0.005
Nickel	0.010	0.010
Cobalt	<0.1	<0.1
Tantalum	balance ^C	balance ^C

^A Electron-beam or vacuum-arc cast tantalum.

^B Sintered tantalum.

^C Approximately equal to the difference of 100 % and the sum percentage of the other specified elements. The percentage of the tantalum difference is not required to be reported.

elements, whether residual elements or trace elements, that can be present. The producer is permitted to analyze for unspecified elements and is permitted to report such analyses. The presence of an unspecified element and the reporting of an analysis for that element shall not be a basis for rejection.

6.1.3 Intentional elemental additions other than those specified in Table 1 are not permitted.

6.2 The ingot analysis shall be considered the chemical analysis for products supplied under this specification.

6.3 When requested by the purchaser at the time of purchase, the supplier shall furnish a report certifying the values of carbon, oxygen, nitrogen, and hydrogen as specified in Table 2 for each lot of material supplied.

TABLE 2 Additional Chemical Requirements for Finished Product (When Specified by the Purchaser)

Element	Compositions, Maximum % (mass/mass)	
	R05200 ^A	R05400 ^B
Carbon	0.020	0.020
Oxygen	0.025	0.035
Nitrogen	0.010	0.010
Hydrogen	0.0015	0.0015

^A Electron-beam or vacuum-arc cast tantalum.

^B Sintered tantalum.

7. Mechanical Properties

7.1 The material supplied under this specification shall conform to the mechanical property requirements in Tables 3 and 4. Mechanical properties for material in conditions other than those included in Tables 3 and 4 shall be specified by the purchaser.

7.2 Specimens for tension tests shall be prepared and tested in accordance with Test Methods E8/E8M. Tensile properties shall be determined using a strain rate of 0.003 to 0.007 mm/mm/min [in./in./min] through yield and then the crosshead speed may be increased so as to produce fracture in approximately one additional minute.

7.3 *Number of Tests*:

7.3.1 *Bar and Wire*—Perform at least one tension for each lot. Should any of these test pieces not meet the specified requirements, test two additional test pieces representative of the same lot, in the same manner, for each failed test piece. The lot shall be considered in compliance only if all additional test pieces meet the specified requirements.

7.3.2 Tensile test results for which any specimen fractures outside the gage length shall be considered acceptable if the elongation meets the minimum requirements specified. Refer to Test Methods E8/E8M, subsections 7.11.4 and 7.11.5.

7.3.3 If the elongation is less than the minimum requirement, discard the test and retest. Retest one specimen for each specimen that did not meet the minimum requirements.

7.3.4 *Sheet, Strip, and Plate*—Perform at least one tension test for each lot. Tension property requirements apply in both the longitudinal and transverse directions. Tests in the transverse direction need be made only on product from which a specimen is not less than 200 mm [8.0 in.] in length for sheet

TABLE 3 Mechanical Properties, Flat Mill Products

Condition	Thickness, mm [in.]	Minimum Ultimate Tensile Strength, MPa [psi]	Minimum Yield Strength, (0.2% offset) MPa [psi]	Minimum Elongation ^A in 25 mm [1 in.] %
Cold worked Stress relieved	all	520 [75 000]	345 [50 000]	2
	0.13 to 0.26 [0.0051 to 0.01] over 0.26 [0.01]	380 [55 000]	240 [35 000]	5
Annealed	0.13 to 0.26 [0.0051 to 0.01]	210 [30 000]	140 [20 000]	20
	over 0.26 to 0.5 [0.010 to 0.020]	210 [30 000]	140 [20 000]	25
	over 0.51 [0.020]	210 [30 000]	140 [20 000]	30

^A Elongation of material 1.6 mm [0.063 in.] or greater in diameter (D) or width (W) shall be measured using a gage length of 50 mm [2 in.] or 4D or 4W. The gage length shall be reported with the test results. The method for determining elongation of material under 1.6 mm [0.063 in.] in diameter or thickness may be negotiated. Alternately, a gage length corresponding to ISO 6892 (5.65 square root of S_o , where S_o is the original cross-sectional area) may be used when agreed upon between the supplier and purchaser.

TABLE 4 Mechanical Properties, Bar and Wire Products

Condition	Diameter, mm [in.]	Minimum Ultimate Tensile Strength, MPa [psi]	Minimum Yield Strength, (0.2% offset) MPa [psi]	Minimum Elongation, % ^A
Cold Worked	all	480 [70 000]	345 [50 000]	1
Annealed	0.12 to under 0.25 [0.005 to 0.0099]	240 [35 000]	...	8
	0.25 to 0.38 [0.010 to 0.0149]	240 [35 000]	...	10
	over 0.38 to 0.63 [0.015 to 0.0249]	240 [35 000]	...	15
	over 0.63 to 3.14 [0.025 to 0.1249]	210 [30 000]	...	20
	over 3.14 to 63.5 [0.125 to 2.5]	170 [25 000]	140 [20 000]	25

^A Elongation of material 1.6 mm [0.063 in.] or greater in diameter (D) or width (W) shall be measured using a gage length of 50 mm [2 in.] or 4D or 4W. The gage length shall be reported with the test results. The method for determining elongation of material under 1.6 mm [0.063 in.] in diameter or thickness may be negotiated. Alternately, a gage length corresponding to ISO 6892 (5.65 square root of S_o , where S_o is the original cross-sectional area) may be used when agreed upon between supplier and purchaser.

and 64 mm [2.5 in.] in length for plate can be taken. Should any of these test pieces not meet the specified requirements, test two additional test pieces representative of the same lot, in the same manner, for each failed test piece. The lot shall be considered in compliance only if both additional test pieces meet the specified requirements.

8. Dimensions, Mass, and Permissible Variations

8.1 Units of Measure:

8.1.1 *Selection*—This specification requires that the purchaser select 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 (PO), this selection may be expressed by the purchaser in several alternate forms listed in order of precedence.

8.1.1.1 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.

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

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

8.1.2 *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 of **IEEE/ASTM SI 10** provides conversion tables and Annex B of **IEEE/ASTM SI 10** provides rules for conversion and significant digits.

9. Certification

9.1 The supplier shall provide a certification that the material was manufactured and tested in accordance with the requirements of this specification. A report of the test results shall be furnished to the purchaser at the time of shipment.

10. Quality Management System Requirements

10.1 The supplier shall maintain a quality management system such as defined in ISO 9001, ISO 13485, or similar quality management system.