



Standard Specification for Tungsten Wire for Electron Devices and Lamps¹

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This standard has been approved for use by agencies of the Department of Defense. Consult the DoD Index of Specifications and Standards for the specific year of issue which has been adopted by the Department of Defense.

1. Scope

1.1 This specification covers three types of drawn wire suitable for fabrication into parts for electron tubes, lamps, and other devices; and one type of rod for metal-to-glass sealing (grid wire is excepted):

1.1.1 *Type 1A*—Commercially pure nonsag wire (Note 2 and Note 3).

1.1.2 *Type 1B*—Commercially pure rod suitable for metal-to-glass sealing.

1.1.3 *Type 2A*—Thoriated filament wire containing 1 % thoria.

1.1.4 *Type 2B*—Thoriated filament wire containing 2 % thoria.

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.3 Types 1A and 1B are designated as UNS R07005. Type 2A is designated as UNS R07911. Type 2B is designated as UNS R07912.

1.4 The following precautionary caveat pertains only to the Chemical Analysis, Section 12 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 establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

NOTE 1—A dimensional measurement method for testing nonsag tungsten wire above 0.030 in. (0.76 mm) in diameter is provided in Test Method F 269.

NOTE 2—Acceptance of nonsag wire characteristics for particular applications of size shall be by agreement between producer and consumer based on either a flashed microstructure as shown by photomicrographs, or on dimensional measurement limits determined in accordance with Test Method F 269.

2. Referenced Documents

2.1 ASTM Standards:

¹ This specification is under the jurisdiction of ASTM Committee F-1 on Electronics and is the direct responsibility of Subcommittee F01.03 on Metallic Materials.

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F 16 Test Methods for Measuring Diameter or Thickness of Wire and Ribbon for Electronic Devices and Lamps²

F 204 Test Method for Surface Flaws in Tungsten Seal Rod and Wire²

F 205 Test Method for Measuring Diameter of Fine Wire by Weighing²

F 219 Test Methods of Testing Fine Round and Flat Wire for Electron Devices and Lamps²

F 269 Test Method for Sag of Tungsten Wire²

2.2 Military Standards:

MIL-STD-105 Sampling Procedures and Tables for Inspection by Attributes³

MIL-STD-129 Marking for Shipment and Storage³

3. Terminology

3.1 Definition of Terms Specific to This Standard:

3.1.1 *wire*—The term wire as used in this specification applies to all drawn material that is spooled or coiled, and to short cut lengths 0.020 in. (0.51 mm) or less in diameter.

3.1.2 *nonsag or doped tungsten wire*—This term designates a wire which, when recrystallized, shows elongated interlocking grains.

3.1.3 *rod*—The term rod as used in this specification applies to centerless ground material 0.020 in. (0.51 mm) or larger in diameter, in short cut lengths or random cut lengths.

4. Ordering Information

4.1 Orders for wire and rod furnished to this specification shall include the following information:

4.1.1 Length in metres, or quantity of short cut lengths,

4.1.2 Type and UNS No. (Section 1),

4.1.3 Straightness (Section 10),

4.1.4 Finish (Section 8),

4.1.5 Weight or size (Section 7) and tolerance, and

4.1.6 Specification number.

NOTE 3—A typical ordering description for straight chemically cleaned wire is as follows: xxxx metres, tungsten wire, Type 1A UNS R07005, straightened, Finish 2; 280.8 mg/200 mm (± 3 %), to ASTM F288 – XX.

² Annual Book of ASTM Standards, Vol 10.04.

³ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

5. Chemical Composition

5.1 The wire and rod shall conform to the chemical requirements specified in Table 1. The sample for analysis shall be representative of the lot submitted. Lot size, sample size, and sampling method shall be as agreed upon by the supplier and purchaser.

6. Physical Properties

6.1 *Tensile Strength*—The tensile strength of a 10-in. (250-mm) gage length of wire in grams per milligram per 200 mm shall be within the limits specified in Table 2 when tested in accordance with 13.1.

6.2 *General Ductility Requirements*—The ductility of Types 1A, 2A, and 2B wire shall be sufficient to meet the following requirements:

6.2.1 *Wire up to 75 mg/200 mm, Inclusive*—Six 1-m lengths shall be tested in accordance with 13.2. The wire shall not break more than two times in the six tests. Where required, a lower limit may be negotiated between purchaser and seller.

6.2.2 *Wire over 75 mg/200 mm*—Thirty successive close-wound turns completely around mandrels shall be free of splitting or cracking when tested in accordance with 13.2.2 and examined at a magnification of 30×.

6.2.3 *Special Ductility Requirements*—Wire for certain applications may require a special ductility as agreed upon between the purchaser and the seller.

6.3 *Surface Defects*—Type 1B rod shall not show faults when tested in accordance with 13.5.

7. Dimensions, Weights, and Permissible Variations

7.1 Dimensional tolerances for Type 1A (nonsag) wire for use as incandescent filaments shall conform to the requirements specified in Table 3.

NOTE 4—Tolerances are industry standards; closer tolerances may be obtained in certain instances, usually at a premium.

7.2 Out-of-roundness of wire or rod over 0.020 in. (0.51 mm) in diameter shall be within 5 % of the maximum diameter, when measured by a method agreed upon by supplier and purchaser. A referee method for this test is contained in Procedure B of Test Methods F 16.

7.3 Weight/Diameter Conversion Formulas:

7.3.1 The weight of Type 1A wire and Type 1B rod (density 19.17), is as follows:

$$wt \text{ in mg/200 mm} = (\text{diameter in mils})^2 \times 1.943, \text{ or} \\ (\text{diameter in mm})^2 \times 3011 \quad (1)$$

7.3.2 The weight of Type 2A wire (density 18.80), is as follows:

$$wt \text{ in mg/200mm} = (\text{diameter in mils})^2 \times 1.905, \text{ or} \\ (\text{diameter in mm})^2 \times 2953$$

TABLE 1 Chemical Requirements^A

| Type, UNS number | Thoria, weight % | Tungsten, weight % |
|--------------------|------------------|--------------------|
| 1A and 1B (R07005) | | 99.95 min |
| 2A (R07911) | 0.8 min, 1.2 max | balance |
| 2B (R07912) | 1.7 min, 2.2 max | balance |

^AFor all Types:
Other elements (each)—100 ppm max.
Total other elements—500 ppm max.

7.3.3 The weight of Type 2B wire (density 18.50), is as follows:

$$wt \text{ in mg/200mm} = (\text{diameter in mils})^2 \times 1.875, \text{ or} \\ (\text{diameter in mm})^2 \times 2906$$

8. Workmanship, Finish, and Appearance

8.1 Furnish the wire in the following finishes:

8.1.1 *Finish 1*—Black, as-drawn,

8.1.2 *Finish 2*—Chemically cleaned,

8.1.3 *Finish 3*—Chemically cleaned and stress-relieved.

8.1.4 *Finish 4*—Reducing atmosphere cleaned and annealed,

8.1.5 *Finish 5*—Etched, and

8.1.6 *Finish 6*—Electropolished.

8.2 The rod shall be furnished in the following finish:

8.2.1 *Finish 7*—Centerless ground.

9. General Requirements

9.1 The material shall be smooth, free of twists, bends, kinks, curls, and as free of dents, swaging marks, scratches, die marks, laps, seams, splits, slivers, inclusions, bumps, pits, grooves, cracks, and other physical defects when examined at a magnification of 30× as best commercial practice will permit.

9.2 Unless black finish is specified, all types of wire shall have a clean finish, free of graphite, grease, oil, and lubricants. All finishes shall be as free of dirt, oxide, stains, scale, and other surface defects, as best commercial practice permits. Wire for hooks, supports, springs, anchors, and mesh shall have a bright smooth surface free of cracks, holes, or craters when examined at a magnification of 10×.

9.3 Rod of Type 1B shall have a bright smooth surface and be capable of making acceptable metal-to-glass seals when tested in accordance with Test Method F 204.

10. Straightness

10.1 When ordered as straightened, straightness of wire 3.00 mg/200 mm and larger shall be specified as the radius of curvature or camber of a given length of wire as agreed upon between the purchaser and supplier. For wire under 3.00 mg/200 mm, alternative methods for straightness requirements may be used as agreed upon between the purchaser and the supplier.

11. Coiling and Spooling

11.1 Spools and bands shall be clean and free of open seams or projections which might catch or tangle the wire during winding or unwinding.

11.2 Wire shall be furnished in one continuous length and wound smoothly with no loose turns. There shall be no piling up of turns such as to prevent free unwinding or cause kinks or bends when the wire is removed from the spool. The outer end shall be attached firmly to the spool or band by suitable means.

11.3 Spool and band dimensions are shown in Table 4.

11.4 Except for Finishes 5 and 6, no spools or bands in any one shipment shall contain less than 300 m of wire for sizes up to 35 mg/200 mm; not less than 200 m of wire between 35 and 50 mg/200 mm, and not less than 100 m between 50 and 100