



Designation: F961 – 08

Standard Specification for 35Cobalt-35Nickel-20Chromium-10Molybdenum Alloy Forgings for Surgical Implants (UNS R30035)¹

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1. Scope*

1.1 This specification covers the requirements for 35cobalt-35nickel-20chromium-10molybdenum alloy (UNS R30035) in the form of forgings, used for the manufacture of surgical implants.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

2. Referenced Documents

2.1 ASTM Standards:²

A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products

E8 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E92 Test Method for Vickers Hardness of Metallic Materials (Withdrawn 2010)³

E112 Test Methods for Determining Average Grain Size

E140 Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, and Scleroscope Hardness

E165 Practice for Liquid Penetrant Examination for General Industry

E354 Test Methods for Chemical Analysis of High-Temperature, Electrical, Magnetic, and Other Similar Iron,

Nickel, and Cobalt Alloys

F562 Specification for Wrought 35Cobalt-35Nickel-20Chromium-10Molybdenum Alloy for Surgical Implant Applications (UNS R30035)

F601 Practice for Fluorescent Penetrant Inspection of Metallic Surgical Implants

F688 Specification for Wrought Cobalt-35Nickel-20Chromium-10Molybdenum Alloy Plate, Sheet, and Foil for Surgical Implants (UNS R30035)

F981 Practice for Assessment of Compatibility of Biomaterials for Surgical Implants with Respect to Effect of Materials on Muscle and Bone

2.2 ISO Standards:⁴

ISO 5832-6 Implants for Surgery—Metallic Materials—Part 6: Wrought Cobalt-Nickel-Chromium-Molybdenum Alloy

ISO 9001 Quality Management Systems—Requirements

2.3 American Society for Quality Control Standard:⁵

ASQ C1 Specification of General Requirements for a Quality Program

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *lot, n*—the total number of forgings produced from the same heat under the same conditions 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,

4.1.2 ASTM designation and date of issue,

4.1.3 Mechanical properties (if applicable, for special conditions),

4.1.4 Form,

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

4.1.6 Condition,

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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.

³ The last approved version of this historical standard is referenced on www.astm.org.

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

⁵ Available from American Society for Quality (ASQ), 600 N. Plankinton Ave., Milwaukee, WI 53203, <http://www.asq.org>.

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

- 4.1.7 Finish,
- 4.1.8 Special tests (if any), and
- 4.1.9 Other requirements.

5. Materials and Manufacture

5.1 Material for forgings shall be bars or wire fabricated in accordance with Specification **F562** or Specification **F688**. The material shall be generally in the solution-annealed condition with a finish suitable for forging.

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, inequalities, 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 **E165** or Practice **F601** or other suitable method.

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, may be placed upon each forging, the method and location of which shall be as specified by the purchaser.

6. Chemical Requirements

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 analysis limits of the appropriate material specification.

6.2 For referee purposes, Test Methods **E354** and **A751** shall be used.

7. Mechanical Requirements

7.1 Tensile Properties:

7.1.1 The mechanical properties of forgings shall be tested by the forger and shall comply with the minimum mechanical properties as specified in Specification **F562**.

7.1.2 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 forgings it represents.

7.1.3 Specimens for tension tests shall be machined and tested in accordance with Test Methods **E8**.

7.2 Number of Tests:

7.2.1 Perform at least one tension test from each lot in the longitudinal direction. Should this test result 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.

7.2.2 Tensile tests results for which any specimen fractures outside the gage length shall be considered acceptable, if both the elongation and reduction of area meet the minimum requirements specified. Refer to sections 7.11.4 and 7.12.5 of Test Methods **E8**.

7.2.3 If either the elongation or reduction of area 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 Hardness:

7.3.1 Hardness values shall be determined in accordance with Test Methods **E10** or Test Methods **E18**.

7.3.2 When desired, hardness limits may be specified on the purchase order or drawing and shall be determined in accordance with Test Methods **E10** or **E18**.

NOTE 2—When desired, Brinell hardness may be taken as described in Test Method **E10** or Vickers hardness may be taken as described in Test Method **E92** and converted to Rockwell hardness in accordance with Hardness Conversion Tables **E140**.

8. Special Tests

8.1 The grain size shall be agreed upon between the purchaser and the supplier and shall be tested in accordance with Test Methods **E112**.

8.2 Any other special requirements shall be specified by the purchaser.

9. Significance of Numerical Limits

9.1 The following applies to all specified numerical limits in this specification. To determine conformance to these limits, an observed or calculated value shall be rounded to the nearest unit in the last right hand digit used in expressing the specification limit, in accordance with the rounding method of Practice **E29**.

10. Certification

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

11. Quality Program Requirements

11.1 The supplier shall maintain a quality program such as that which is defined in Specification **ASQ C1** or **ISO 9001**.

12. Keywords

12.1 cobalt alloys (for surgical implants); cobalt-nickel-chromium-molybdenum alloys; forgings; surgical implants; metals (for surgical implants)