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## Standard Specification for Titanium and Titanium Alloy Forgings<sup>1</sup>

This standard is issued under the fixed designation B 381; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

### 1. Scope\*

- 1.1 This specification<sup>2</sup> covers 39 grades of annealed titanium and titanium alloy forgings as follows:
- 1.1.1 *Grade F-1*—Unalloyed titanium,
  - 1.1.2 *Grade F-2*—Unalloyed titanium,
    - 1.1.2.1 *Grade F-2H*—Unalloyed titanium (Grade 2 with 58 ksi minimum UTS),
  - 1.1.3 *Grade F-3*—Unalloyed titanium,
  - 1.1.4 *Grade F-4*—Unalloyed titanium,
  - 1.1.5 *Grade F-5*—Titanium alloy (6 % aluminum, 4 % vanadium),
  - 1.1.6 *Grade F-6*—Titanium alloy (5 % aluminum, 2.5 % tin),
  - 1.1.7 *Grade F-7*—Unalloyed titanium plus 0.12 to 0.25 % palladium,
    - 1.1.7.1 *Grade F-7H*—Unalloyed titanium plus 0.12 to 0.25 % palladium (Grade 7 with 58 ksi minimum UTS),
  - 1.1.8 *Grade F-9*—Titanium alloy (3 % aluminum, 2.5 % vanadium),
  - 1.1.9 *Grade F-11*—Unalloyed titanium plus 0.12 to 0.25 % palladium,
  - 1.1.10 *Grade F-12*—Titanium alloy (0.3 % molybdenum, 0.8 % nickel),
  - 1.1.11 *Grade F-13*—Titanium alloy (0.5 % nickel, 0.05 % ruthenium),
  - 1.1.12 *Grade F-14*—Titanium alloy (0.5 % nickel, 0.05 % ruthenium),
  - 1.1.13 *Grade F-15*—Titanium alloy (0.5 % nickel, 0.05 % ruthenium),
  - 1.1.14 *Grade F-16*—Unalloyed titanium plus 0.04 to 0.08 % palladium,
    - 1.1.14.1 *Grade F-16H*—Unalloyed titanium plus 0.04 to 0.08 % palladium (Grade 16 with 58 ksi minimum UTS),
  - 1.1.15 *Grade F-17*—Unalloyed titanium plus 0.04 to 0.08 % palladium,
  - 1.1.16 *Grade F-18*—Titanium alloy (3 % aluminum, 2.5 % vanadium) plus 0.04 % to 0.08 % palladium,
  - 1.1.17 *Grade F-19*—Titanium alloy (3 % aluminum, 8 % vanadium, 6 % chromium, 4 % zirconium, 4 % molybdenum),
  - 1.1.18 *Grade F-20*—Titanium alloy (3 % aluminum, 8 % vanadium, 6 % chromium, 4 % zirconium, 4 % molybdenum) plus 0.04 to 0.08 % palladium,
  - 1.1.19 *Grade F-21*—Titanium alloy (3 % aluminum, 2.7 % niobium, 15 % molybdenum, 0.25 % silicon),
  - 1.1.20 *Grade F-23*—Titanium alloy (6 % aluminum, 4 % vanadium, extra low interstitials, ELI),
  - 1.1.21 *Grade F-24*—Titanium alloy (6 % aluminum, 4 % vanadium) plus 0.04 to 0.08 % palladium,
  - 1.1.22 *Grade F-25*—Titanium alloy (6 % aluminum, 4 % vanadium) plus 0.3 to 0.8 % nickel and 0.04 to 0.08 % palladium,
  - 1.1.23 *Grade F-26*—Unalloyed titanium plus 0.08 to 0.14 % ruthenium,
    - 1.1.23.1 *Grade F-26H*—Unalloyed titanium plus 0.08 to 0.14 % ruthenium (Grade 26 with 58 ksi minimum UTS),
  - 1.1.24 *Grade F-27*—Unalloyed titanium plus 0.08 to 0.14 % ruthenium,
  - 1.1.25 *Grade F-28*—Titanium alloy (3 % aluminum, 2.5 % vanadium plus 0.08 to 0.14 % ruthenium),
  - 1.1.26 *Grade F-29*—Titanium alloy (6 % aluminum, 4 % vanadium, extra low interstitial, ELI plus 0.08 to 0.14 % ruthenium),
  - 1.1.27 *Grade F-30*—Titanium alloy (0.3 % cobalt, 0.05 % palladium),
  - 1.1.28 *Grade F-31*—Titanium alloy (0.3 % cobalt, 0.05 % palladium),
  - 1.1.29 *Grade F-32*—Titanium alloy (5 % aluminum, 1 % vanadium, 1 % tin, 1 % zirconium, 0.8 % molybdenum),
  - 1.1.30 *Grade F-33*—Titanium alloy (0.4 % nickel, 0.015 % palladium, 0.025 % ruthenium, 0.15 % chromium),
  - 1.1.31 *Grade F-34*—Titanium alloy (0.4 % nickel, 0.015 % palladium, 0.025 % ruthenium, 0.15 % chromium),
  - 1.1.32 *Grade F-35*—Titanium alloy (4.5 % aluminum, 2 % molybdenum, 1.6 % vanadium, 0.5 % iron, 0.3 % silicon),
  - 1.1.33 *Grade F-36*—Titanium alloy (45 % niobium),
  - 1.1.34 *Grade F-37*—Titanium alloy (1.5 % aluminum), and

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee B10 on Reactive and Refractory Metals and Alloys and is the direct responsibility of Subcommittee B10.01 on Titanium.

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<sup>2</sup> For ASME Boiler and Pressure Vessel Code applications, see related Specification SB-381 in Section II of that Code.

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

1.1.35 *Grade F-38*—Titanium alloy (4 % aluminum, 2.5 % vanadium, 1.5 % iron).

NOTE 1—H grade material is identical to the corresponding numeric grade (that is, Grade 2H = Grade 2) except for the higher guaranteed minimum UTS, and may always be certified as meeting the requirements of its corresponding numeric grade. Grades 2H, 7H, 16H, and 26H are intended primarily for pressure vessel use.

The H grades were added in response to a user association request based on its study of over 5200 commercial Grade 2, 7, 16, and 26 test reports, where over 99 % met the 58 ksi minimum UTS.

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*:<sup>3</sup>

B 348 [Specification for Titanium and Titanium Alloy Bars and Billets](#)

E 8 [Test Methods for Tension Testing of Metallic Materials](#)

E 29 [Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)

E 539 [Test Method for X-Ray Fluorescence Spectrometric Analysis of 6Al-4V Titanium Alloy](#)

E 1409 [Test Method for Determination of Oxygen and Nitrogen in Titanium and Titanium Alloys by the Inert Gas Fusion Technique](#)

E 1447 [Test Method for Determination of Hydrogen in Titanium and Titanium Alloys by Inert Gas Fusion Thermal Conductivity/Infrared Detection Method](#)

E 1941 [Test Method for Determination of Carbon in Refractory and Reactive Metals and Their Alloys](#)

E 2371 [Test Method for Analysis of Titanium and Titanium Alloys by Atomic Emission Plasma Spectrometry](#)

E 2626 [Guide for Spectrometric Analysis of Reactive and Refractory Metals](#)

## 3. Terminology

### 3.1 *Definitions of Terms Specific to This Standard*:

3.1.1 *bar, n*—a hot rolled, forged or cold worked semifinished solid section product whose cross sectional area is less than 16 in.<sup>2</sup>(10 323 mm<sup>2</sup>).

3.1.2 *billet, n*—a solid semifinished section, hot rolled or forged from an ingot, with a cross sectional area greater than 16 in.<sup>2</sup>(10 323 mm<sup>2</sup>).

3.1.3 *forging, n*—any product of work on metal formed to a desired shape by impact or pressure in hammers, forging machines, upsetters presses or related forming equipment.

## 4. Ordering Information

4.1 Orders for forgings under this specification shall include the following information, as applicable:

4.1.1 Grade number (Section 1),

4.1.2 Tensile properties (Table 1),

4.1.3 Dimensions and tolerances (Section 10),

4.1.4 Sampling, mechanical properties (Section 8),

4.1.5 Methods for chemical analysis (Section 6),

4.1.6 Marking (Section 17),

4.1.7 Packaging (Section 17),

4.1.8 Certification (Section 16),

4.1.9 Disposition of rejected material (Section 14), and

4.1.10 Supplementary requirements (S1).

## 5. Materials and Manufacture

5.1 Material conforming to the latest revision of Specification B 348 shall be used when producing forgings to this specification.

## 6. Chemical Composition

6.1 The grades of titanium and titanium alloy metal covered by this specification shall conform to the requirements as to chemical composition prescribed in Table 2.

6.1.1 The elements listed in Table 2 are intentional alloy additions or elements which are inherent to the manufacturer of titanium sponge, ingot or mill product.

6.1.1.1 Elements other than those listed in Table 2 are deemed to be capable of occurring in the grades listed in Table 2 by and only by way of unregulated or unanalyzed scrap additions to the ingot melt. Therefore, product analysis for elements not listed in Table 2 shall not be required unless specified and shall be considered to be in excess of the intent of this specification.

<sup>3</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

**TABLE 1 Tensile Requirements<sup>A</sup>**

| Grade                | Tensile Strength, min |        | Yield Strength (0.2 % Offset), min or Range |                  | Elongation in 4D,<br>min, %         | Reduction of Area,<br>min, % |
|----------------------|-----------------------|--------|---|------------------|-------------------------------------|------------------------------|
|                      | ksi                   | (MPa)  | ksi   | (MPa)            |                                     |                              |
| F-1                  | 35                    | (240)  | 20  | (138)            | 24                                  | 30                           |
| F-2                  | 50                    | (345)  | 40  | (275)            | 20                                  | 30                           |
| F-2H <sup>B,C</sup>  | 58                    | (400)  | 40  | (275)            | 20                                  | 30                           |
| F-3                  | 65†                   | (450)† | 55  | (380)            | 18                                  | 30                           |
| F-4                  | 80†                   | (550)† | 70  | (483)            | 15                                  | 25                           |
| F-5                  | 130                   | (895)  | 120   | (828)            | 10                                  | 25                           |
| F-6                  | 120                   | (828)  | 115   | (795)            | 10                                  | 25                           |
| F-7                  | 50                    | (345)  | 40  | (275)            | 20                                  | 30                           |
| F-7H <sup>B,C</sup>  | 58                    | (400)  | 40  | (275)            | 20                                  | 30                           |
| F-9                  | 120                   | (828)  | 110   | (759)            | 10                                  | 25                           |
| F-9 <sup>D</sup>     | 90                    | (620)  | 70  | (483)            | 15                                  | 25                           |
| F-11                 | 35                    | (240)  | 20  | (138)            | 24                                  | 30                           |
| F-12                 | 70                    | (483)  | 50  | (345)            | 18                                  | 25                           |
| F-13                 | 40                    | (275)  | 25  | (170)            | 24                                  | 30                           |
| F-14                 | 60                    | (410)  | 40  | (275)            | 20                                  | 30                           |
| F-15                 | 70                    | (483)  | 55  | (380)            | 18                                  | 25                           |
| F-16                 | 50                    | (345)  | 40  | (275)            | 20                                  | 30                           |
| F-16H <sup>B,C</sup> | 58                    | (400)  | 40  | (275)            | 20                                  | 30                           |
| F-17                 | 35                    | (240)  | 20  | (138)            | 24                                  | 30                           |
| F-18                 | 90                    | (620)  | 70  | (483)            | 15                                  | 25                           |
| F-18 <sup>D</sup>    | 90                    | (620)  | 70  | (483)            | 12                                  | 20                           |
| F-19 <sup>E</sup>    | 115                   | (793)  | 110   | (759)            | 15                                  | 25                           |
| F-19 <sup>F</sup>    | 135                   | (930)  | 130 to 159                                  | (897) to (1096)  | 10                                  | 20                           |
| F-19 <sup>G</sup>    | 165                   | (1138) | 160 to 185                                  | (1104) to (1276) | 5                                   | 20                           |
| F-20 <sup>E</sup>    | 115                   | (793)  | 110   | (759)            | 15                                  | 25                           |
| F-20 <sup>F</sup>    | 135                   | (930)  | 130 to 159                                  | (897) to (1096)  | 10                                  | 20                           |
| F-20 <sup>G</sup>    | 165                   | (1138) | 160 to 185                                  | (1104) to (1276) | 5                                   | 20                           |
| F-21 <sup>E</sup>    | 115                   | (793)  | 110   | (759)            | 15                                  | 35                           |
| F-21 <sup>F</sup>    | 140                   | (966)  | 130 to 159                                  | (897) to (1096)  | 10                                  | 30                           |
| F-21 <sup>G</sup>    | 170                   | (1172) | 160 to 185                                  | (1104) to (1276) | 8                                   | 20                           |
| F-23                 | 120                   | (828)  | 110   | (759)            | 10                                  | 25                           |
| F-23 <sup>D</sup>    | 120                   | (828)  | 110   | (759)            | 7.5 <sup>H</sup> , 6.0 <sup>I</sup> | 25                           |
| F-24                 | 130                   | (895)  | 120   | (828)            | 10                                  | 25                           |
| F-25                 | 130                   | (895)  | 120   | (828)            | 10                                  | 25                           |
| F-26                 | 50                    | (345)  | 40  | (275)            | 20                                  | 30                           |
| F-26H <sup>B,C</sup> | 58                    | (400)  | 40  | (275)            | 20                                  | 30                           |
| F-27                 | 35                    | (240)  | 20  | (138)            | 24                                  | 30                           |
| F-28                 | 90                    | (620)  | 70  | (483)            | 15                                  | 25                           |
| F-28 <sup>D</sup>    | 90                    | (620)  | 70  | (483)            | 12                                  | 20                           |
| F-29                 | 120                   | (828)  | 110   | (759)            | 10                                  | 25                           |
| F-29 <sup>D</sup>    | 120                   | (828)  | 110   | (759)            | 7.5 <sup>H</sup> , 6.0 <sup>I</sup> | 15                           |
| F-30                 | 50                    | (345)  | 40  | (275)            | 20                                  | 30                           |
| F-31                 | 65                    | (450)  | 55  | (380)            | 18                                  | 30                           |
| F-32                 | 100                   | (689)  | 85  | (586)            | 10                                  | 25                           |
| F-33                 | 50                    | (345)  | 40  | (275)            | 20                                  | 30                           |
| F-34                 | 65                    | (450)  | 55  | (380)            | 18                                  | 30                           |
| F-35                 | 130                   | (895)  | 120   | (828)            | 5                                   | 20                           |
| F-36                 | 65                    | (450)  | 60 to 95                                    | (410 to 655)     | 10                                  | ...                          |
| F-37                 | 50                    | (345)  | 31  | (215)            | 20                                  | 30                           |
| F-38                 | 130                   | (895)  | 115   | (794)            | 10                                  | 25                           |

<sup>A</sup> These properties apply to forgings having a cross section no greater than 3 in.<sup>2</sup>(1935 mm<sup>2</sup>). Mechanical properties of forgings having greater cross sections shall be negotiated between the manufacturer and the purchaser.

<sup>B</sup> Material is identical to the corresponding numeric grade (that is, Grade F-2H = Grade F-2) except for the higher guaranteed minimum UTS, and may be dual certified with its corresponding numeric grade. Grade F-2H, F-7H, F-16H, and F-26H are intended primarily for pressure vessel use.

<sup>C</sup> The H grades were added in response to a user association request based on its study of over 5200 commercial Grade 2, 7, 16, and 26 test reports where over 99 % met the 58 ksi minimum UTS.

<sup>D</sup> Properties for material in transformed-beta condition.

<sup>E</sup> Properties for material in the solution treated condition.

<sup>F</sup> Properties for solution treated and aged condition-Moderate strength (determined by aging temperature).

<sup>G</sup> Properties for solution treated and aged condition-High Strength (determined by aging temperature).

<sup>H</sup> For product section or wall thickness values <1.0 in.

<sup>I</sup> For product section or wall thickness values ≤1.0 in.

† Tensile strength for Grade F-3 and F-4 was corrected editorially.





Composition, %

| Element                    | F-13    | F-14    | F-15    | F-16    | F-16H   | F-17    | F-18    | F-19 | F-20      | F-21 | F-22 | F-23 | F-24 |
|----------------------------|---------|---------|---------|---------|---------|---------|---------|------|-----------|------|------|------|------|
| ..                         | 0.08    | 0.25    | 0.03    | 0.015   | ..      | 0.30    | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| Cobalt                     | ..      | ..      | ..      | ..      | ..      | ..      | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| F-16H                      | ..      | ..      | ..      | ..      | ..      | ..      | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| Molybdenum                 | ..      | ..      | ..      | ..      | ..      | ..      | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| Molybdenum-                | ..      | ..      | ..      | ..      | ..      | ..      | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| Chromium                   | ..      | ..      | ..      | ..      | ..      | ..      | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| F-17                       | 0.08    | 0.18    | 0.03    | 0.015   | ..      | 0.20    | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| Nickel                     | 0.4-0.6 | 0.4-0.6 | 0.4-0.6 | 0.015   | ..      | ..      | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| Nickel-                    | ..      | ..      | ..      | ..      | ..      | ..      | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| Niobium                    | ..      | ..      | ..      | ..      | ..      | ..      | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| F-18                       | 0.08    | 0.15    | 0.03    | 0.015   | ..      | 0.25    | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| Zirconium                  | ..      | ..      | ..      | ..      | ..      | ..      | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| Zirconium-                 | ..      | ..      | ..      | ..      | ..      | ..      | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| Silicon                    | ..      | ..      | ..      | ..      | ..      | ..      | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| F-19                       | 0.05    | 0.12    | 0.03    | 0.02    | ..      | 0.30    | ..      | ..   | 0.04-0.08 | ..   | ..   | ..   | ..   |
| Residuals, D,E,F max       | 0.1     | 0.1     | 0.1     | 0.1     | 0.1     | 0.1     | 0.1     | 0.15 | 0.15-0.25 | ..   | ..   | ..   | ..   |
| Residuals, D,E,F max each- | 3.5-4.5 | 5.5-6.5 | ..      | 3.5-4.5 | ..      | ..      | ..      | 0.15 | ..        | ..   | ..   | ..   | ..   |
| F-20                       | 0.05    | 0.12    | 0.03    | 0.02    | 0.30    | 3.0-4.0 | 0.1     | 0.15 | ..        | ..   | ..   | ..   | ..   |
| Titanium <sup>g</sup>      | balance | balance | balance | balance | balance | balance | balance | 0.15 | ..        | ..   | ..   | ..   | ..   |
| Titanium <sup>g</sup> -    | 3.5-4.5 | ..      | ..      | ..      | 0.15    | 0.4     | ..      | ..   | ..        | ..   | ..   | ..   | ..   |
| F-21                       | 0.05    | 0.17    | 0.03    | 0.015   | balance | 0.4     | ..      | ..   | ..        | ..   | ..   | ..   | ..   |



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| Element                | F-24      | F-25      | F-26  | F-26H    | F-27    | F-14,0-28 | F-29      |
|------------------------|-----------|-----------|-------|----------|---------|-----------|-----------|
| 0.40                   | 0.05      | 0.05      | 0.03  | 0.03     | 0.03    | 0.03      | 0.03      |
| Nitrogen-max           | ..        | ..        | ..    | ..       | ..      | ..        | ..        |
| Nitrogen, max -        | ..        | ..        | ..    | ..       | ..      | ..        | ..        |
| Carbon, max            | 0.08      | 0.13      | 0.03  | 0.08     | 0.08    | 0.08      | 0.08      |
| F-23                   | 0.08      | 0.13      | 0.03  | 0.08     | 0.08    | 0.08      | 0.08      |
| Hydrogen, B,C max      | 0.015     | 0.0125    | 0.015 | 0.015    | 0.015   | 0.015     | 0.015     |
| Hydrogen, B,C max5-4.5 | ..        | ..        | ..    | ..       | ..      | ..        | ..        |
| Iron, max              | 0.40      | 0.40      | 0.30  | 0.30     | 0.20    | 0.25      | 0.25      |
| Iron, max-             | ..        | ..        | ..    | ..       | ..      | ..        | ..        |
| Oxygen, max            | 0.20      | 0.20      | 0.25  | 0.25     | 0.20    | 0.25      | 0.25      |
| F-24                   | 0.08      | 0.20      | 0.05  | 0.015    | 0.40    | 0.45      | 0.45      |
| Vanadium               | 3.5-4.5   | 3.5-4.5   | ..    | ..       | ..      | ..        | ..        |
| Vanadium-              | ..        | ..        | ..    | ..       | ..      | ..        | ..        |
| F-25                   | 2.0-3.0   | 3.5-4.5   | ..    | ..       | ..      | ..        | ..        |
| F-25                   | 0.08      | 0.5-4.5   | ..    | ..       | ..      | ..        | ..        |
| Ti                     | ..        | ..        | ..    | ..       | ..      | ..        | ..        |
| Tin                    | ..        | ..        | ..    | ..       | ..      | ..        | ..        |
| Palladium              | 0.04-0.08 | 0.04-0.08 | 0.40  | 5.5-6.75 | 3.5-4.5 | 0.04-0.08 | 0.04-0.08 |
| Palladium-             | 0.1       | 0.4       | ..    | ..       | ..      | ..        | ..        |
| F-26                   | 0.08      | 0.25      | 0.03  | 0.015    | 0.1     | ..        | ..        |
| Cobalt                 | ..        | ..        | ..    | ..       | ..      | ..        | ..        |
| Cobalt30               | ..        | ..        | ..    | ..       | ..      | ..        | ..        |
| Molybdenum             | ..        | ..        | ..    | ..       | ..      | ..        | ..        |
| Molybdenum-            | ..        | ..        | ..    | ..       | ..      | ..        | ..        |