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## Standard Specification for Wrought Stainless Steels for Surgical Instruments<sup>1</sup>

This standard is issued under the fixed designation F899; 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.

*This standard has been approved for use by agencies of the Department of Defense.*

### 1. Scope\*

1.1 This specification covers the chemistry requirements for wrought stainless steels used for the manufacture of surgical instruments. The data contained in Tables 1-4 of this specification, including typical hardness values, common heat treating cycles, and examples of selected stainless steels that have been used for surgical instruments, is provided for reference only. Mechanical property requirements, heat treating requirements, hardness requirements and all other requirements except chemistry are governed by the appropriate material standards as referenced below or as agreed upon between purchaser and supplier.

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>2</sup>

A276 [Specification for Stainless Steel Bars and Shapes](#)

A313/A313M [Specification for Stainless Steel Spring Wire](#)

A314 [Specification for Stainless Steel Billets and Bars for Forging](#)

A480/A480M [Specification for General Requirements for Flat-Rolled Stainless and Heat-Resisting Steel Plate, Sheet, and Strip](#)

A484/A484M [Specification for General Requirements for Stainless Steel Bars, Billets, and Forgings](#)

A555/A555M [Specification for General Requirements for Stainless Steel Wire and Wire Rods](#)

A564/A564M [Specification for Hot-Rolled and Cold-Finished Age-Hardening Stainless Steel Bars and Shapes](#)

A582/A582M [Specification for Free-Machining Stainless Steel Bars](#)

A751 [Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products](#)

#### 2.2 ISO Standards:<sup>3</sup>

ISO 7153/1 [Instruments For Surgery—Metallic Materials—Part 1: Stainless Steel](#)

ISO 9001 [Quality Management Systems—Requirements](#)

#### 2.3 American Society for Quality (ASQ) Standard:<sup>4</sup>

ASQ C1 [Specification of General Requirements for a Quality Program](#)

### 3. Classification and Type

3.1 *Classes*—Stainless steel material requirements for surgical instruments shall conform to one of the following classes, as specified:

3.1.1 *Class 3*—Austenitic Stainless Steel.

3.1.2 *Class 4*—Martensitic Stainless Steel.

3.1.3 *Class 5*—Precipitation Hardening Stainless Steel.

3.1.4 *Class 6*—Ferritic Stainless Steel.

3.2 *Type*—Where applicable, the commercially recognized type of stainless steel is included in Tables 5 and 6.

<sup>1</sup> 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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<sup>2</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.

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

<sup>4</sup> 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.

**TABLE 1 Typical Maximum Hardness for Selected Class 4 Martensitic Stainless Steels in The Annealed Condition<sup>A</sup>**

Type	Typical Maximum Brinell Hardness <sup>B</sup>
410	210
410X	220
416	262
416 Mod	262
420A	220
420B	235
420 Mod	255
420X	262
420C	262
420F	262
420F Mod	262
431	285
440A	285
440B	285
440C	285
440F	285
UNS S42026	260
UNS S42010	235

<sup>A</sup> Excludes billets and bars for forging.

<sup>B</sup> Or equivalent Rockwell hardness.

#### 4. Ordering Information

4.1 Inquiries and orders for material under this specification shall include the following information as agreed upon by purchaser and supplier:

- 4.1.1 Quantity (weight or number of pieces),
- 4.1.2 Classification, optional,
- 4.1.3 Type,
- 4.1.4 Form,
- 4.1.5 Condition (see 5.1),
- 4.1.6 Finish (see 5.3),
- 4.1.7 Mechanical properties or hardness, and
- 4.1.8 Applicable dimensions including size, thickness, width, and length (exact, random, or multiples) or drawing number.

#### 5. Manufacture

5.1 *Condition*—Stainless steels shall be furnished to the purchaser, as specified, in the hot-finished, cold-finished, annealed, solution-treated, solution-treated and aged, quench-hardened and tempered, or as specified by the purchaser. (Note that highly hardenable martensitic stainless billets and bars such as Types 420A, 420B, 420C, 420 Mod, 420F, 420F Mod., 440A, 440B, and 440C intended for forging are commonly annealed prior to shipment and so specified in order to avoid the possibility of thermal cracking. Other hardenable martensitic grades such as Types 403, 410, 416, 416 Mod., and 431, which also may require annealing, depending on their composition and size, are furnished suitable for cold cutting when so specified on the purchase order.)

5.2 *Conditioning*—Billet and bar intended for forging may be conditioned by chipping, grinding, or other suitable means to remove injurious surface defects.

5.3 *Finish*—Types of finish available for bar and wire products are cold drawn, pickled, ground, ground and polished, or as specified in the purchase order.

#### 6. General Requirements for Delivery

6.1 In addition to the chemistry requirements of this specification, all requirements of the current editions of Specifications A276, A313/A313M, A314, A480/A480M, A484/A484M, A555/A555M, A564/A564M, A582/A582M, and A751 shall apply where applicable, as agreed upon between purchaser and supplier.

6.2 This specification compliments the ISO applicable document covering stainless steel for surgical instruments and, by reference, includes all of the stainless grades in ISO 7153/1.

#### 7. Chemical Requirements

7.1 The heat analysis shall conform to the requirements as to chemical composition specified in Tables 5-8.

7.2 UNS designations have been added to Tables 5-8 to provide an easy cross reference to a common numbering system. In order to ensure consistency in the materials used for the manufacture of surgical instruments, compositional limits tighter than typical UNS limits have been established for certain elements (as denoted by an asterisk). For example, more restrictive carbon and sulfur limits are specified in Table 7.

7.3 The chemical composition requirements for Types 301, 303, 304, 316, 410, 420A, 420B, 420C, and 430F also meet the composition requirements in ISO 7153/1.

**TABLE 2 Typical Heat Treating Cycles and Resultant Hardness Values for Selected Class 4 Martensitic Stainless Steels**

Type	Typical Hardening <sup>A</sup> Heat Treatment	Typical Hardness at Indicated Tempering Temperature <sup>B</sup>			Type	Typical Hardening <sup>A</sup> Heat Treatment	Typical Hardness at Indicated Tempering Temperature <sup>B</sup>		
		°F	°C	(HRC)			°F	°C	(HRC)
410	1850°F (1010°C) + Oil quench or air cool	500	260	43	420C	1900°F (1038°C) + Warm oil quench	300	149	58
		700	371	43			400	204	55/56
		900 <sup>C</sup>	482	42			500	260	53/54
		1000 <sup>C</sup>	538	30			600	315	53/54
		1100	593	24			700	371	54/55
410X	1875°F (1024°C) + Oil quench or air cool	500	260	46	420F	1900°F (1038°C) + Warm oil quench	800 <sup>D</sup>	427	55
		700	371	46/47			300	149	52
		900 <sup>C</sup>	482	48			400	204	52
		1000 <sup>C</sup>	538	44			500	260	50
		1100	593	31			600	315	50
416 Mod	1800°F (982°C) + Oil quench	300	149	38	420F Mod	1900°F (1038°C) + Warm oil quench	700	371	49
		500	260	37			800 <sup>D</sup>	427	49
		700	371	37			300	149	53
		900 <sup>C</sup>	482	35			400	204	50
		1000 <sup>C</sup>	538	30			500	260	48
416	1800°F (982°C) + Oil quench	1100	593	22	UNS S42026	1920°F (1050°C)+ oil quench or pressure gas	600	315	48
		300	149	41			700	371	48
		500	260	39			800 <sup>D</sup>	427	48
		700	371	41			400	204	56
		900 <sup>C</sup>	482	36			500	260	54/55
420A	1850°F (1010°C) + Warm oil quench	1000 <sup>C</sup>	538	31	431	1900°F (1038°C) + Oil quench	600	315	53/54
		1100	593	26			700	371	42
		300	149	53			900 <sup>C</sup>	482	45
		400	204	50			1100 <sup>C</sup>	593	34
		500	260	48			300	149	56/57
420B	1900°F (1038°C) + Warm oil quench	600	315	48	440A	1900°F (1038°C) + Warm oil quench	400	204	56
		700	371	48			500	260	54
		800 <sup>D</sup>	427	48			600	315	51/52
		300	149	52			700	371	51
		400	204	52			800 <sup>D</sup>	427	50
420B	1900°F (1038°C) + Warm oil quench	500	260	50	440B	1900°F (1038°C) + Warm oil quench	300	149	58/59
		600	315	50			400	204	56/57
		700	371	49			500	260	53/54
		800 <sup>D</sup>	427	49			600	315	53
		300	149	52			700	371	54
420 Mod	180°F (1010°C) + oil quench or pressure gas	400	204	55	440C	1900°F (1038°C) + Warm oil quench	800 <sup>D</sup>	427	54
		500	260	54			300	149	60
		600	315	53			400	204	59
		300	149	52			500	260	57
		400	204	52			600	315	56
420X	1900°F (1038°C) + Warm oil quench	500	260	50	440F	1900°F (1038°C) + Warm oil quench	700	371	56
		600	315	50			800 <sup>D</sup>	427	56
		700	371	49			300	149	60
		800 <sup>D</sup>	427	49			400	204	59
		300	149	52			500	260	57
S42010	1900°F (1038°C) + Warm Oil Quench	400	204	50	440F	1900°F (1038°C) + Warm oil quench	600	315	56
		500	260	47			700	371	56
		600 <sup>E</sup>	316	47			800 <sup>D</sup>	427	56
		700	371	48			300	149	60
		850	454	48			400	204	59

<sup>A</sup> Time at temperature depends on section size. Controlled heat treating atmosphere or alternate quench media may be used in accordance with good commercial practice.

<sup>B</sup> Temper at least one hour at indicated temperature and air cool. Large section sizes require longer time at temperature.

<sup>C</sup> Tempering in the range of 750/1050°F (399/566°C) results in decreased impact strength and reduced corrosion resistance.

<sup>D</sup> Tempering over 800°F (427°C) results in reduced corrosion resistance.

<sup>E</sup> Tempering above 600°F (316°C) results in reduced toughness.

7.4 Methods and practices relating to chemical analysis required by this specification shall be in accordance with Test Methods, Practices, and Terminology A751.

## 8. Mechanical Requirements

8.1 Material shall conform to the mechanical property requirements cited in the appropriate ASTM standards (see 2.1) or shall meet the mechanical property requirements specified by the purchaser.

8.2 When desired, Brinell hardness number (HB), Rockwell hardness, B scale (HRB) or Rockwell hardness, C scale (HRC), limits may be specified. Typical hardness values for selected Class 4 martensitic stainless steels in the annealed condition are listed