



Designation: F75-07 Designation: F75 - 12

## Standard Specification for Cobalt-28 Chromium-6 Molybdenum Alloy Castings and Casting Alloy for Surgical Implants (UNS R30075)<sup>1</sup>

This standard is issued under the fixed designation F75; 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 covers the requirements for cobalt-28 chromium-6 molybdenum alloy unfinished investment product castings for surgical implant applications and casting alloy in the form of shot, bar, or ingots to be used in the manufacture of surgical implants. This specification does not apply to completed surgical implants made from castings.~~

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

1.1 This specification covers the chemical, mechanical, and metallurgical requirements for cobalt-28 chromium-6 molybdenum alloy unfinished investment product castings for surgical implant applications and casting alloy in the form of shot, bar, or ingots to be used in the manufacture of surgical implants. This specification does not apply to completed surgical implants made from castings.

1.2 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, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

### 2. Referenced Documents

#### 2.1 ASTM Standards:<sup>2</sup>

A957 Specification for Investment Castings, Steel and Alloy, Common Requirements, for General Industrial Use

E3 Guide for Preparation of Metallographic Specimens

E88/E8M Test Methods for Tension Testing 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

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

E407 Practice for Microetching Metals and Alloys

E601 Test Method for Measuring Electromotive Force (emf) Stability of Base-Metal Thermoelement Materials with Time in Air

F629 Practice for Radiography of Cast Metallic Surgical Implants

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

#### 2.2 Aerospace Material Specification:<sup>3</sup>

AMS 2248 Chemical Check Analysis Limits: Corrosion and Heat Resistant Steels and Alloys, Maraging and Other Highly-Alloyed Steels, and Iron Alloys

AMS 2269 Chemical Check Analysis Limits: Nickel, Nickel Alloys and Cobalt Alloys

#### 2.3 ISO Standards:<sup>4</sup>

ISO 5832-4 Implants for Surgery—Metallic Materials—Part 4: Cobalt-Chromium-Molybdenum Casting Alloy

ISO 6892 Metallic Materials—Tensile Testing at Ambient Temperature

ISO 9001 Quality Management Systems—Requirements

<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.

Current edition approved Jan. 1, 2007. Published January 2007. Originally approved in 1967. Last previous edition approved in 2001 as F75-01. DOI: 10.1520/F0075-07.

Current edition approved May 15, 2012. Published June 2012. Originally approved in 1967. Last previous edition approved in 2007 as F75 - 075. DOI: 10.1520/F0075-12.

<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 Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

<sup>4</sup> 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.

2.4 American Society for Quality Standard:  
ASQ C1 Specification of General Requirements for a Quality Program

### 3. Terminology

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

3.1.1 *investment casting, n*—a metal casting that is produced in a mold obtained by investing (surrounding) an expendable pattern with a ceramic slurry that is allowed to solidify. The expendable pattern may consist of wax, plastic, or other material and is removed prior to filling the mold with liquid metal.

3.1.2 *master heat, n*—a quantity of metal processed in a single furnace or refining vessel at one time in such a manner as to produce the desired composition and properties.

3.1.3 *sub-heat, n*—a portion of a master heat remelted without additional processing for pouring into castings. *Synonyms:* melt, production heat.

NOTE 1—Terminology section in accordance with Specification A957.

### 4. Ordering Information

4.1 Include with inquiries and orders for material under this specification ~~shall include~~ the following information:

4.1.1 Quantity (number of product castings or weight of casting alloy),

4.1.2 ASTM designation and date of issue,

4.1.3 Form (product casting, shot, bar, ingot),

4.1.4 Applicable dimensions or drawing number,

4.1.5 Condition (as-cast, hot isostatically pressed (HIP), solution annealed, and so forth),

4.1.6 Special tests, if any, and

4.1.7 Other requirements.

4.1.3 Units to be certified—SI or inch-pound.

4.1.4 Form (product casting, shot, bar, ingot),

4.1.5 Applicable dimensions or drawing number,

4.1.6 Condition (as-cast, hot isostatically pressed (HIP), solution annealed, and so forth),

4.1.7 Special tests, if any, and

4.1.8 Other requirements.

### 5. Materials and Manufacturing Requirements for Product Castings

5.1 Final thermal processing for castings, if any, shall be specified by mutual agreement between the supplier and purchaser.

5.2 Castings shall be free of visible investment shell material and scale when examined without magnification.

5.3 Welding may be used to repair castings as agreed upon between supplier and purchaser.

5.3.1 Weld repair shall be performed in accordance with written procedures by individuals certified to perform those procedures.

5.3.2 Weld filler metal conforming to the chemistry of Table 1 shall be used when it is needed.

5.3.3 Weld repair, if any, shall be performed before final thermal processing.

NOTE 2—Under certain circumstances, a weld repair may act as a stress riser. Therefore, care should be exercised in the location and extent of weld repair as it relates to regions of the implant where significant stresses might occur.

**TABLE 1 Chemical Composition**

Element	Composition, % (Mass/Mass)	
	min	max
Chromium	27.00	30.00
Molybdenum	5.00	7.00
Nickel	...	0.50
Iron	...	0.75
Carbon	...	0.35
Silicon	...	1.00
Manganese	...	1.00
Tungsten	...	0.20
Phosphorous	...	0.020
Sulfur	...	0.010
Nitrogen	...	0.25
Aluminum	...	0.10
Titanium	...	0.10
Boron	...	0.010
Cobalt <sup>A</sup>	balance	balance

<sup>A</sup> Approximately equal to the difference of 100 % and the sum percentage of the other specified elements. The percentage of the cobalt difference is not required to be reported.