



Designation: **F560—08 F560/F560M – 13**

Standard Specification for Unalloyed Tantalum for Surgical Implant Applications (UNS R05200, UNS R05400)¹

This standard is issued under the fixed designation ~~F560~~F560/F560M; 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 reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

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

1. Scope*

1.1 This specification covers the chemical, mechanical, and metallurgical requirements for unalloyed tantalum plate, sheet, strip, ~~rod, bar,~~ and wire used in the manufacture of surgical implants.

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values ~~given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered~~ stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values of the two systems may result in non-conformance with this standard.

2. Referenced Documents

2.1 ASTM Standards:²

~~E8E8/E8M~~ Test Methods for Tension Testing of Metallic Materials

~~E29~~ Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

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

~~IEEE/ASTM SI 10~~ American National Standard for Use of the International System of Units (SI): The Modern Metric System

2.2 American Society for Quality Control Standard:³

~~ASQ-C1~~ Specifications of General Requirements for a Quality Program

2.2 ISO Standard:Standards:³

~~ISO 6892~~ Metallic Materials Tensile Testing at Ambient Temperature

~~ISO 9001~~ Quality Management Systems—Requirements

~~ISO 13782~~ Implants for Surgery—Metallic Materials—Unalloyed Tantalum for Surgical Implant Applications

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *lot*—all material produced from the same ingot or a single powder blend with the same cross section under the same conditions at essentially the same time.

3.1.2 *plate*—a flat product more than ~~0.1875 in. (4.7 mm)~~4.75 mm [0.1875 in.] in thickness.

3.1.3 *rod—bar*—material ~~0.125 to 2.5 in. (3.18 to 63.50 mm)~~3.15 to 63.5 mm [0.125 to 2.5 in.] in diameter in round, hexagonal, or octagonal cross section supplied in straight lengths.

3.1.4 *sheet*—a flat product ~~6 in. (152.4 mm)~~150 mm [6 in.] or more in width and from ~~0.005 to 0.1875 in. (0.13 to 4.76 mm)~~0.13 to 4.75 mm [0.005 to 0.1875 in.] in thickness.

¹ 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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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 Available from American Society for Quality (ASQ), 600 N. Plankinton Ave., Milwaukee, WI 53203.

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

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

3.1.5 *strip*—a flat product, may be supplied in coil, less than 6 in. (152.4 mm) product less than 150 mm [6 in.] in width and from 0.005 to 0.1875 in. (0.13 to 4.76 mm) in thickness. 0.13 to 4.75 mm [0.005 to 0.1875 in.] in thickness, may be supplied in coil.

3.1.6 *wire*—material to 0.124 in. (0.254 to 3.15 mm) up to 3.15 mm [0.124 in.] in diameter furnished in coils or on spools or reels.

4. Ordering Information

4.1 Inquiries and orders under this specification shall include the following information:

4.1.1 Quantity (weight or number of pieces),

4.1.2 ASTM designation, alloy number, and date of issue,

4.1.3 Units to be used for certification—SI or inch-pound.

4.1.4 Composition designation (see 5.1)

4.1.5 Form (strip, sheet, plate, ~~rod~~, bar, wire) (see 3.1),

4.1.6 Condition (see 5.4),

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

4.1.8 Special tests,

4.1.9 Special requirements, and

4.1.10 Mechanical properties (if applicable for special conditions) (see 7.1).

5. Materials and Manufacture

5.1 Material covered by this specification shall be made from vacuum-arc melted or electron-beam melted ingots (R05200) or powder-metallurgy consolidated (R05400) unalloyed tantalum.

5.2 The various tantalum mill products covered by this specification are formed with the conventional extrusion, forming, swaging, rolling, and drawing equipment normally available in metalworking plants.

5.3 *Finish*—The mill product may be furnished as descaled or pickled, abrasive blasted, chemically milled, ground, machined, peeled, polished, or as specified by the purchaser.

5.4 *Condition*:

5.4.1 Flat mill products shall be supplied in the cold-worked, cold-worked and stress-relieved or annealed condition.

5.4.2 ~~Rod~~ Bar and wire products shall be supplied in the annealed or cold worked condition.

6. Chemical Requirements

6.1 The material shall conform to the chemical composition requirements in Table 1.

6.1.1 Requirements for the major and minor elemental constituents are listed in Table 1. Also listed are important residual elements. Analysis for elements not listed in Table 1 is not required to certify compliance with this specification.

6.2 The ingot analysis shall be considered the chemical analysis for products supplied under this specification.

6.3 When requested by the purchaser at the time of purchase, the supplier shall furnish a report certifying the values of carbon, oxygen, nitrogen, and hydrogen as specified in Table 2 for each lot of material supplied.

TABLE 1 Chemical Requirements

Element	Compositions, max % mass/mass	
	R05200 ^A	R05400 ^B
Carbon	0.010	0.010
Oxygen	0.015	0.03
Oxygen	0.015	0.030
Nitrogen	0.010	0.010
Hydrogen	0.0015	0.0015
Niobium	0.10	0.10
Iron	0.010	0.010
Titanium	0.010	0.010
Tungsten	0.050	0.050
Molybdenum	0.020	0.020
Silicon	0.005	0.005
Nickel	0.010	0.010
Tantalum	balance ^C	balance ^C

^A Electron-beam or vacuum-arc cast tantalum.

^B Sintered tantalum.

^C The percentage of tantalum is determined by difference and need not be determined or certified.

**TABLE 2 Additional Chemical Requirements for Finished Product
(When Specified by the Purchaser)**

Element	Compositions, Maximum % mass/mass	
	R05200 ^A	R05400 ^B
Carbon	0.020	0.020
Oxygen	0.025	0.035
Nitrogen	0.010	0.010
Hydrogen	0.0015	0.0015

^A Electron-beam or vacuum-arc cast tantalum.

^B Sintered tantalum.

7. Mechanical Properties

7.1 The material supplied under this specification shall conform to the mechanical property requirements in **Tables 3 and 4**. Mechanical properties for material in conditions other than those included in **Tables 3 and 4** shall be specified by the purchaser.

7.2 Specimens for tension tests shall be machined/prepared and tested in accordance with Test Methods **E8E8/E8M**. Tensile properties shall be determined using a strain rate of 0.003 to 0.007 in./in./min (mm/mm/min) 0.076 to 0.178 mm/mm/min [0.003 to 0.007 in./in./min] through yield and then the crosshead speed may be increased so as to produce fracture in approximately one additional minute.

7.3 Number of Tests:

7.3.1 *Bar and Wire*—Perform at least one tension for each lot. Should any of these test pieces 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/all additional test pieces meet the specified requirements.

7.3.2 Tensile test 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 Test Method **E8E8/E8M**, sections 7.11.4 and 7.11.5.

7.3.3 If either the elongation or the 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.

TABLE 3 Mechanical Properties, Flat Mill Products

Condition	Thickness, in. (mm)	Ultimate Tensile Strength, min, psi (MPa)	Yield Strength, (0.2% offset) min, psi (MPa)	Elongation ^A in 1 inch (25.4 mm), min, %
Gold-worked Stress-relieved	all	75 000 (517)	50 000 (345)	2
	0.0051 to 0.010 (0.13 to 0.26)	55 000 (379)	35 000 (241)	5
	over 0.010 to 0.020 (0.26 to 0.51)	55 000 (379)	35 000 (241)	10
Annealed	over 0.020 (0.51)	55 000 (379)	35 000 (241)	10
	0.0051 to 0.010 (0.13 to 0.26)	30 000 (207)	20 000 (138)	20
	over 0.010 to 0.020 (0.26 to 0.51)	30 000 (207)	20 000 (138)	25
	over 0.020 (0.51)	30 000 (207)	20 000 (138)	30

TABLE 3 Mechanical Properties, Flat Mill Products

Condition	Thickness, mm [in.]	Minimum Ultimate Tensile Strength, MPa [psi]	Minimum Yield Strength, (0.2% offset) MPa [psi]	Minimum Elongation ^A in 25 mm [1 in.] %
Cold worked Stress relieved	all	520 [75 000]	345 [50 000]	2
	0.13 to 0.26 [0.0051 to 0.01]	380 [55 000]	240 [35 000]	5
	over 0.26 [0.01]	380 [55 000]	240 [35 000]	10
Annealed	0.13 to 0.26 [0.0051 to 0.01]	210 [30 000]	140 [20 000]	20
	over 0.26 to 0.5 [0.010 to 0.020]	210 [30 000]	140 [20 000]	25
	over 0.51 [0.020]	210 [30 000]	140 [20 000]	30

^A Elongation of material 0.063 in. (1.6 mm) 1.6 mm [0.063 in.] or greater in diameter (D) or width (W) shall be measured using a gage length of 2 in. 50 mm [2 in.] or 4D or 4W. The gage length must shall be reported with the test results. The method for determining elongation of material under 0.063 in. (1.6 mm) 1.6 mm [0.063 in.] in diameter or thickness may be negotiated. Alternately, a gage length corresponding to ISO 6892 may be used when agreed upon between supplier and purchaser. (5.65 square root of So, where So is the original cross sectional area) area may be used when agreed upon between the supplier and purchaser.