



Designation: **B265—13a B265 – 13a^{ε1}**

Standard Specification for Titanium and Titanium Alloy Strip, Sheet, and Plate¹

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

^{ε1} NOTE—H grades in Table 1 were editorially corrected in March 2014.

1. Scope*

- 1.1 This specification² covers annealed titanium and titanium alloy strip, sheet, and plate as follows:
- 1.1.1 *Grade 1*—UNS R50250. Unalloyed titanium,
 - 1.1.2 *Grade 2*—UNS R50400. Unalloyed titanium,
 - 1.1.2.1 *Grade 2H*—UNS R50400. Unalloyed titanium (Grade 2 with 58 ksi (400 MPa) minimum UTS),
 - 1.1.3 *Grade 3*—UNS R50550. Unalloyed titanium,
 - 1.1.4 *Grade 4*—UNS R50700. Unalloyed titanium,
 - 1.1.5 *Grade 5*—UNS R56400. Titanium alloy (6 % aluminum, 4 % vanadium),
 - 1.1.6 *Grade 6*—UNS R54520. Titanium alloy (5 % aluminum, 2.5 % tin),
 - 1.1.7 *Grade 7*—UNS R52400. Unalloyed titanium plus 0.12 to 0.25 % palladium,
 - 1.1.7.1 *Grade 7H*—UNS R52400. Unalloyed titanium plus 0.12 to 0.25 % palladium (Grade 7 with 58 ksi (400 MPa) minimum UTS),
 - 1.1.8 *Grade 9*—UNS R56320. Titanium alloy (3.0 % aluminum, 2.5 % vanadium),
 - 1.1.9 *Grade 11*—UNS R52250. Unalloyed titanium plus 0.12 to 0.25 % palladium,
 - 1.1.10 *Grade 12*—UNS R53400. Titanium alloy (0.3 % molybdenum, 0.8 % nickel),
 - 1.1.11 *Grade 13*—UNS R53413. Titanium alloy (0.5 % nickel, 0.05 % ruthenium),
 - 1.1.12 *Grade 14*—UNS R53414. Titanium alloy (0.5 % nickel, 0.05 % ruthenium),
 - 1.1.13 *Grade 15*—UNS R53415. Titanium alloy (0.5 % nickel, 0.05 % ruthenium),
 - 1.1.14 *Grade 16*—UNS R52402. Unalloyed titanium plus 0.04 to 0.08 % palladium,
 - 1.1.14.1 *Grade 16H*—UNS R52402. Unalloyed titanium plus 0.04 to 0.08 % palladium (Grade 16 with 58 ksi (400 MPa) minimum UTS),
 - 1.1.15 *Grade 17*—UNS R52252. Unalloyed titanium plus 0.04 to 0.08 % palladium,
 - 1.1.16 *Grade 18*—UNS R56322. Titanium alloy (3 % aluminum, 2.5 % vanadium) plus 0.04 to 0.08 % palladium,
 - 1.1.17 *Grade 19*—UNS R58640. Titanium alloy (3 % aluminum, 8 % vanadium, 6 % chromium, 4 % zirconium, 4 % molybdenum),
 - 1.1.18 *Grade 20*—UNS R58645. Titanium alloy (3 % aluminum, 8 % vanadium, 6 % chromium, 4 % zirconium, 4 % molybdenum) plus 0.04 % to 0.08 % palladium,
 - 1.1.19 *Grade 21*—UNS R58210. Titanium alloy (15 % molybdenum, 3 % aluminum, 2.7 % niobium, 0.25 % silicon),
 - 1.1.20 *Grade 23*—UNS R56407. Titanium alloy (6 % aluminum, 4 % vanadium with extra low interstitial elements, ELI),
 - 1.1.21 *Grade 24*—UNS R56405. Titanium alloy (6 % aluminum, 4 % vanadium) plus 0.04 % to 0.08 % palladium,
 - 1.1.22 *Grade 25*—UNS R56403. Titanium alloy (6 % aluminum, 4 % vanadium) plus 0.3 % to 0.8 % nickel and 0.04 % to 0.08 % palladium,
 - 1.1.23 *Grade 26*—UNS R52404. Unalloyed titanium plus 0.08 to 0.14 % ruthenium,
 - 1.1.23.1 *Grade 26H*—UNS R52404. Unalloyed titanium plus 0.08 to 0.14 % ruthenium (Grade 26 with 58 ksi (400 MPa) minimum UTS),
 - 1.1.24 *Grade 27*—UNS R52254. Unalloyed titanium plus 0.08 to 0.14 % ruthenium,

¹ 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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² For ASME Boiler and Pressure Vessel Code applications see related Specifications SB-265 in Section II of that Code.

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

- 1.1.25 *Grade 28*—UNS R56323. Titanium alloy (3 % aluminum, 2.5 % vanadium) plus 0.08 to 0.14 % ruthenium,
- 1.1.26 *Grade 29*—UNS R56404. Titanium alloy (6 % aluminum, 4 % vanadium with extra low interstitial elements, ELI) plus 0.08 to 0.14 % ruthenium,
- 1.1.27 *Grade 30*—UNS R53530. Titanium alloy (0.3 % cobalt, 0.05 % palladium),
- 1.1.28 *Grade 31*—UNS R53532. Titanium alloy (0.3 % cobalt, 0.05 % palladium),
- 1.1.29 *Grade 32*—UNS R55111. Titanium alloy (5 % aluminum, 1 % tin, 1 % zirconium, 1 % vanadium, 0.8 % molybdenum),
- 1.1.30 *Grade 33*—UNS R53442. Titanium alloy (0.4 % nickel, 0.015 % palladium, 0.025 % ruthenium, 0.15 % chromium),
- 1.1.31 *Grade 34*—UNS R53445. Titanium alloy (0.4 % nickel, 0.015 % palladium, 0.025 % ruthenium, 0.15 % chromium),
- 1.1.32 *Grade 35*—UNS R56340. Titanium alloy (4.5 % aluminum, 2 % molybdenum, 1.6 % vanadium, 0.5 % iron, 0.3 % silicon),
- 1.1.33 *Grade 36*—UNS R58450. Titanium alloy (45 % niobium),
- 1.1.34 *Grade 37*—UNS R52815. Titanium alloy (1.5 % aluminum),
- 1.1.35 *Grade 38*—UNS R54250. Titanium alloy (4 % aluminum, 2.5 % vanadium, 1.5 % iron), and
- 1.1.36 *Grade 39*—UNS R53390. Titanium alloy (0.25 % iron, 0.4 % silicon).

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.

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*:³

[E8 Test Methods for Tension Testing of Metallic Materials](#)

[E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)

[E290 Test Methods for Bend Testing of Material for Ductility](#)

[E539 Test Method for Analysis of Titanium Alloys by X-Ray Fluorescence Spectrometry](#)

[E1409 Test Method for Determination of Oxygen and Nitrogen in Titanium and Titanium Alloys by Inert Gas Fusion](#)

[E1447 Test Method for Determination of Hydrogen in Titanium and Titanium Alloys by Inert Gas Fusion Thermal Conductivity/Infrared Detection Method](#)

[E1941 Test Method for Determination of Carbon in Refractory and Reactive Metals and Their Alloys by Combustion Analysis](#)

[E2371 Test Method for Analysis of Titanium and Titanium Alloys by Direct Current Plasma and Inductively Coupled Plasma Atomic Emission Spectrometry \(Performance-Based Test Methodology\)](#)

[E2626 Guide for Spectrometric Analysis of Reactive and Refractory Metals \(Withdrawn 2017\)](#)⁴

3. Terminology

3.1 *Definitions of Terms Specific to This Standard*:

3.1.1 Any product 0.187 in. (4.75 mm) and under in thickness and less than 24 in. (610 mm) in width is classified as strip; products 0.187 in. (4.75 mm) and under in thickness and 24 in. (610 mm) or more in width are classified as sheet; any product over 0.187 in. (4.75 mm) in thickness and over 10 in. (254 mm) in width is classified as plate.

4. Ordering Information

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

4.1.1 Grade number (Section 1),

4.1.2 Product limitations (Section 3),

4.1.3 Special mechanical properties (Table 1),

4.1.4 Marking (Section 16),

4.1.5 Finish (Section 8),

4.1.6 Packaging (Section 16),

4.1.7 Additional required reports (Section 15), and

4.1.8 Disposition of rejected material (Section 14).

5. Chemical Composition

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

³ 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.

⁴ The last approved version of this historical standard is referenced on www.astm.org.

TABLE 1 Tensile Requirements^A

Grade	Tensile Strength, min		Yield Strength, 0.2 % Offset				Elongation in 2 in. or 50 mm, min, %	Bend Test (Radius of Mandrel) ^B	
	ksi	MPa	min		max			Under 0.070 in. (1.8 mm) in Thickness	0.070 to 0.187 in. (1.8–4.75 mm) in Thickness
			ksi	MPa	ksi	MPa			
1	35	240	20	138	45	310	24	1.5T	2T
2	50	345	40	275	65	450	20	2T	2.5T
2H ^{C,D}	58	400	40	275	65	450	20	2T	2T
2H ^{C,D}	58	400	40	275	65	450	20	2T	2.5T†
3	65	450	55	380	80	550	18	2T	2.5T
4	80	550	70	483	95	655	15	2.5T	3T
5	130	895	120	828	10 ^E	4.5T	5T
6	120	828	115	793	10 ^E	4T	4.5T
7	50	345	40	275	65	450	20	2T	2.5T
7H ^{C,D}	58	400	40	275	65	450	20	2T	2T
7H ^{C,D}	58	400	40	275	65	450	20	2T	2.5T†
9	90	620	70	483	15 ^F	2.5T	3T
11	35	240	20	138	45	310	24	1.5T	2T
12	70	483	50	345	18	2T	2.5T
13	40	275	25	170	24	1.5T	2T
14	60	410	40	275	20	2T	2.5T
15	70	483	55	380	18	2T	2.5T
16	50	345	40	275	65	450	20	2T	2.5T
16H ^{C,D}	58	400	40	275	65	450	20	2T	2T
16H ^{C,D}	58	400	40	275	65	450	20	2T	2.5T†
17	35	240	20	138	45	310	24	1.5T	2T
18	90	620	70	483	15 ^F	2.5T	3T
19 ^{G,H}	115	793	110	759	15	3T	3T
20 ^{G,H}	115	793	110	759	15	3T	3T
21 ^{G,H}	115	793	110	759	15	3T	3T
23	120	828	110	759	10	4.5T	5T
24	130	895	120	828	10	4.5T	5T
25	130	895	120	828	10	4.5T	5T
26	50	345	40	275	65	450	20	2T	2.5T
26H ^{C,D}	58	400	40	275	65	450	20	2T	4T
26H ^{C,D}	58	400	40	275	65	450	20	2T	2.5T†
27	35	240	20	138	45	310	24	1.5T	2T
28	90	620	70	483	15	2.5T	3T
29	120	828	110	759	10	4.5T	5T
30	50	345	40	275	65	450	20	2T	2.5T
31	65	450	55	380	80	550	18	2T	2.5T
32	100	689	85	586	10 ^E	3.5T	4.5T
33	50	345	40	275	65	450	20	2T	2.5T
34	65	450	55	380	80	550	18	2T	2.5T
35	130	895	120	828	5	8T	8T
36	65	450	60	410	95	655	10	4.5T	5T
37	50	345	31	215	65	450	20	2T	2.5T
38	130	895	115	794	10	4T	4.5T
39	75	515	60	410	90	620	20	2T	2.5T

^A Minimum and maximum limits apply to tests taken both longitudinal and transverse to the direction of rolling. Mechanical properties for conditions other than annealed or plate thickness over 1 in. (25 mm) may be established by agreement between the manufacturer and the purchaser.

^B Bend to **Radius of Mandrel**, *T* equals the thickness of the bend test specimen. Bend tests are not applicable to material over 0.187 in. (4.75 mm) in thickness.

^C 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. Grade 2H, 7H, 16H, and 26H are intended primarily for pressure vessel use.

^D 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.

^E For Grades 5, 6 and 32 the elongation on materials under 0.025 in. (0.635 mm) in thickness may be obtained only by negotiation.

^F Elongation for continuous rolled and annealed (strip product from coil) for Grade 9 and Grade 18 shall be 12 % minimum in the longitudinal direction and 8 % minimum in the transverse direction.

^G Properties for material in the solution treated condition.

^H Material is normally purchased in the solution treated condition. Therefore, properties for aged material shall be negotiated between manufacturer and purchaser.

†Editorially corrected.

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

5.1.1.1 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.

5.1.1.2 Elements intentionally added to the melt must be identified, analyzed, and reported in the chemical analysis.

5.2 When agreed upon by producer and purchaser and requested by the purchaser in his written purchase order, chemical analysis shall be completed for specific residual elements not listed in this specification.

TABLE 2 Continued

Composition, Weight Percent^{A,B,C,D,E}

Grade	UNS Number	Carbon, max.	Oxygen range or max.	Nitrogen, max.	Hydrogen, max.	Iron range or max.	Aluminum	Vanadium	Palladium	Ruthenium	Nickel	Molybdenum	Chromium	Cobalt	Zirconium	Niobium	Tin	Silicon	Other Elements, max. each	Other Elements, max. total
32	R55111	0.08	0.11	0.03	0.015	0.25	4.5-5.5	0.6-1.4	--	--	--	0.6-1.2	--	--	0.6-1.4	--	0.6-1.4	0.06-0.14	0.1	0.4
33	R53442	0.08	0.25	0.03	0.015	0.30	--	--	0.01-0.02	0.02-0.04	0.35-0.55	--	0.1-0.2	--	--	--	--	--	0.1	0.4
34	R53445	0.08	0.35	0.05	0.015	0.30	--	--	0.01-0.02	0.02-0.04	0.35-0.55	--	0.1-0.2	--	--	--	--	--	0.1	0.4
35	R56340	0.08	0.25	0.05	0.015	0.20-0.80	4.0-5.0	1.1-2.1	--	--	--	1.5-2.5	--	--	--	--	--	0.20-0.40	0.1	0.4
36	R58450	0.04	0.16	0.03	0.015	0.03	--	--	--	--	--	--	--	--	--	42.0-47.0	--	--	0.1	0.4
37	R52815	0.08	0.25	0.03	0.015	0.30	1.0-2.0	--	--	--	--	--	--	--	--	--	--	--	0.1	0.4
38	R54250	0.08	0.20-0.30	0.03	0.015	1.2-1.8	3.5-4.5	2.0-3.0	--	--	--	--	--	--	--	--	--	--	0.1	0.4
39	R53390	0.08	0.15	0.03	0.015	0.15-0.40	--	--	--	--	--	--	--	--	--	--	--	0.30-0.50	0.1	0.4

^A At minimum, the analysis of samples from the top and bottom of the ingot shall be completed and reported for all elements listed for the respective grade in this table.

^B Final product hydrogen shall be reported. Ingot hydrogen need not be reported. Lower hydrogen may be obtained by negotiation with the manufacturer.

^C Single values are maximum. The percentage of titanium is determined by difference.

^D Other elements need not be reported unless the concentration level is greater than 0.1 % each, or 0.4 % total. Other elements may not be added intentionally. Other elements may be present in titanium or titanium alloys in small quantities and are inherent to the manufacturing process. In titanium these elements typically include aluminum, vanadium, tin, chromium, molybdenum, niobium, zirconium, hafnium, bismuth, ruthenium, palladium, yttrium, copper, silicon, cobalt, tantalum, nickel, boron, manganese, and tungsten.

^E The purchaser may, in the written purchase order, request analysis for specific elements not listed in this specification.

5.3 *Product Analysis*—Product analysis tolerances do not broaden the specified heat analysis requirements but cover variations between laboratories in the measurement of chemical content. The manufacturer shall not ship material that is outside the limits specified in **Table 2** for the applicable grade. Product analysis limits shall be as specified in **Table 3**.

5.4 At least two samples for chemical analysis shall be tested to determine chemical composition. Samples shall be taken from the ingot or the extremes of the product to be analyzed.

6. Mechanical Properties

6.1 Material supplied under this specification shall conform to the mechanical property requirements given in **Table 1** for the grade specified.

6.2 Tension testing specimens are to be machined and tested in accordance with Test Methods **E8**. Tensile properties shall be determined using a strain rate of 0.003 to 0.007 in./in./min through the specified yield strength, and then increasing the rate so as to produce failure in approximately one additional minute.

6.3 For sheet and strip, the bend test specimen shall withstand being bent cold through an angle of 105° without fracture in the outside of the bent portion. The bend shall be made on a **radius** equal to that shown in **Table 1** for the applicable grade. The bends are to be made in accordance with Test Method **E290**, using Method 1, Guided Bend Test described in paragraph 3.6, bent through 105°, and allowed to spring back naturally. The surface of the specimen must include the original material surface with no material removal or surface conditioning, except corners may be rounded to a maximum radius of 0.032 in. (0.8 mm). The width of the bend shall be at least 5 times the thickness. The test report shall, at minimum, indicate acceptable or unacceptable results.

7. Permissible Variations in Dimensions

7.1 Dimensional tolerances on titanium and titanium alloy material covered by this specification shall be as specified in **Tables 4-13**, as applicable.

TABLE 3 Permissible Variations in Product Analysis

Element	Product Analysis Limits, max or Range, %	Permissible Variation in Product Analysis
Aluminum	0.5 to 2.5	±0.20
Aluminum	2.5 to 6.75	±0.40
Carbon	0.10	+0.02
Chromium	0.1 to 0.2	±0.02
Chromium	5.5 to 6.5	±0.30
Cobalt	0.2 to 0.8	±0.05
Hydrogen	0.02	+0.002
Iron	0.80	+0.15
Iron	1.2 to 1.8	±0.20
Molybdenum	0.2 to 0.4	±0.03
Molybdenum	0.6 to 1.2	±0.15
Molybdenum	1.5 to 4.5	±0.20
Molybdenum	14.0 to 16.0	±0.50
Nickel	0.3 to 0.9	±0.05
Niobium	2.2 to 3.2	±0.15
Niobium	>30	±0.50
Nitrogen	0.05	+0.02
Oxygen	0.30	+0.03
Oxygen	0.31 to 0.40	±0.04
Palladium	0.01 to 0.02	±0.002
Palladium	0.04 to 0.08	±0.005
Palladium	0.12 to 0.25	±0.02
Ruthenium	0.02 to 0.04	±0.005
Ruthenium	0.04 to 0.06	±0.005
Ruthenium	0.08 to 0.14	±0.01
Silicon	0.06 to 0.50	±0.02
Tin	0.6 to 3.0	±0.15
Vanadium	0.6 to 4.5	±0.15
Vanadium	7.5 to 8.5	±0.40
Zirconium	0.6 to 1.4	±0.15
Residuals ^A (each)	0.15	+0.02

^A A residual is an element present in a metal or alloy in small quantities and is inherent to the manufacturing process but not added intentionally. In titanium these elements include aluminum, vanadium, tin, iron, chromium, molybdenum, niobium, zirconium, hafnium, bismuth, ruthenium, palladium, yttrium, copper, silicon, cobalt, tantalum, nickel, boron, manganese and tungsten.