



Designation: F2066/F2066M – 13

Standard Specification for Wrought Titanium-15 Molybdenum Alloy for Surgical Implant Applications (UNS R58150)¹

This standard is issued under the fixed designation F2066/F2066M; 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 (ε) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This specification covers the chemical, mechanical, and metallurgical requirements for wrought titanium-15 molybdenum alloy to be used in the manufacture of surgical implants (1).²

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 each other. Combining values from the two systems may result in non-conformance with the standard.

2. Referenced Documents

2.1 ASTM Standards:³

- E8/E8M Test Methods for Tension Testing of Metallic Materials
- E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- E112 Test Methods for Determining Average Grain Size
- 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 the Inert Gas Fusion Technique
- 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 Refrac-

tory 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)

F67 Specification for Unalloyed Titanium, for Surgical Implant Applications (UNS R50250, UNS R50400, UNS R50550, UNS R50700)

F748 Practice for Selecting Generic Biological Test Methods for Materials and Devices

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

F1408 Practice for Subcutaneous Screening Test for Implant Materials

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

2.2 Aerospace Material Specifications:⁴

AMS 2249 Chemical Check Analysis Limits, Titanium and Titanium Alloys

AMS 2631 Ultrasonic Inspection — Titanium and Titanium Alloy Bar and Billet

AMS 2380 Approval and Control of Premium Quality Titanium Alloys

2.3 ISO Standards:⁵

ISO 6892 Metallic Materials — Tensile Testing at Ambient Temperature

ISO 9001 Quality Management Systems Requirements

2.4 American Society for Quality Standard:

ASQ C1 Specification of General Requirements for a Quality Control Program⁶

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.

Current edition approved Oct. 1, 2013. Published November 2013. Originally approved in 2001. Last previous edition approved in 2011 as F2066 – 11. DOI: 10.1520/F2066_F2066M-13.

² The boldface numbers in parentheses refer to the list of references at the end of this standard.

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.

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

⁴ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

⁵ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁶ 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

3.1.1 *alpha + beta annealed, n*—the condition of the material that is obtained if, following the final hot-working or cold-working operation, the mill product may be rapidly quenched, for example, by water quenching or pressurized helium gas, from a temperature below the beta transus of approximately 1382°F [750°C].

3.1.2 *alpha + beta annealed + aged, n*—the condition of the material that is obtained by reheating the alpha + beta annealed material to a time-temperature combination below the beta transus to increase the strength of the alloy.

3.1.3 *beta annealed, n*—the condition of the material that is obtained if, following the final hot-working or cold-working operation, the mill product is rapidly quenched, for example, by water quenching or pressurized helium gas quench, from a temperature above the beta transus of approximately 1382°F [750°C].

3.1.4 *beta transus, n*—the minimum temperature at which the alpha plus beta phase can transform to 100 % beta phase.

4. Product Classification

4.1 *Strip*—Any product under 0.1875 in. [4.76 mm] in thickness and under 24 in. [610 mm] wide.

4.2 *Sheet*—Any product under 0.1875 in. [4.76 mm] in thickness and 24 in. [610 mm] or more in width.

4.3 *Plate*—Any product 0.1875 in. [4.76 mm] thick and over and 10 in. [254 mm] wide and over, with a width greater than five times the thickness. Any plate up to 4 in. [101.60 mm], thick inclusive, is covered by this specification.

4.4 *Bar*—Rounds, flats, or other shapes from 0.1875 in. [4.76 mm] to 4 in. [101.60 mm] in diameter or thickness. (Other sizes and shapes by special order.)

4.5 *Forging Bar*—Bar as described in 4.4 used for production of forgings, may be furnished in the hot worked condition.

4.6 *Wire*—Rounds, flats, or other shapes less than 3/16 in. [4.76 mm] in diameter or thickness.

4.7 *Other*—Other forms and shapes, including tubing, may be provided by agreement between purchaser and supplier.

5. Ordering Information

5.1 Include with inquiries and orders for material under this specification the following information.

- 5.1.1 Quantity,
- 5.1.2 Applicable ASTM designation and date of issue,
- 5.1.3 Form (strip, sheet, plate, bar, forging bar, wire, other),
- 5.1.4 Condition (see Section 3 and 6.2),
- 5.1.5 Mechanical properties (if applicable for special conditions),
- 5.1.6 Finish (see 6.1),
- 5.1.7 Applicable dimensions including size, thickness, width, length, or drawing number,
- 5.1.8 Special tests, if any, and
- 5.1.9 Special requirements.

6. Materials and Manufacture

6.1 *Finish*—The mill product may be furnished to the implant manufacturer as descaled or pickled, abrasive-blasted,

chemically milled, ground, machined, peeled, polished, combinations of these operations, or as specified by the purchaser. On billets, bars, plates, and forgings, it is permissible to remove minor surface imperfections by grinding if the resultant area meets the dimensional and surface finish requirements of this specification.

6.2 Condition:

6.2.1 *Beta Annealed*—Material shall be furnished in the beta annealed condition. Two classes of beta annealed sheet, strip, and plate are available. If no class is chosen, Class 1 product shall be provided.

6.2.2 *Alpha + Beta Annealed*—Material shall be furnished in the alpha + beta annealed condition.

6.2.3 *Alpha + Beta Annealed + Aged*—Material shall be furnished in the alpha + beta annealed + aged condition.

7. Chemical Requirements

7.1 The heat analysis shall conform to the chemical composition of **Table 1**. Ingot analysis may be used for reporting all chemical requirements, except hydrogen. Samples for hydrogen shall be taken from the finished mill product, and the supplier shall not ship material with chemistry outside the requirements specified in **Table 1**.

7.1.1 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 verify compliance with this specification.

7.2 Product Analysis:

7.2.1 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 1**. The product analysis tolerances shall conform to the product tolerances in **Table 2**.

7.2.2 The product analysis is either for the purpose of verifying the composition of a heat or manufacturing lot or to determine variations in the composition within the heat.

7.2.3 Acceptance or rejection of a heat or manufacturing lot of material may be made by the purchaser on the basis of this product analysis. Product analyses outside the tolerance limits allowed in **Table 2** are cause for rejection of the product. A referee analysis may be used if agreed upon by the supplier and purchaser.

7.2.4 For referee purposes, use Test Methods, **E539**, **E1409**, **E1447**, **E1941**, and **E2371** or other analytical methods agreed upon between the purchaser and the supplier.

TABLE 1 Chemical Requirements

Element	Composition, %, (Mass/Mass)
Nitrogen, max	0.05
Carbon, max	0.10
Hydrogen, max	0.015
Iron, max	0.10
Oxygen, max	0.20
Molybdenum	14.00-16.00
Titanium ^A	balance

^A The percentage of titanium is determined by difference and need not be determined or certified.