



Designation: B348/B348M – 21

Standard Specification for Titanium and Titanium Alloy Bars and Billets¹

This standard is issued under the fixed designation B348/B348M; 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.

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

1. Scope*

1.1 This specification² covers annealed titanium and titanium alloy bars and billets 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 % 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 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.

Current edition approved Nov. 1, 2021. Published December 2021. Originally approved in 1959. Last previous edition approved in 2019 as B348/B348M – 19. DOI: 10.1520/B0348_B0348M-21.

² For ASME Boiler and Pressure Vessel Code applications see related Specification SB-348 in Section II of that Code.

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 %–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,

1.1.25 *Grade 28*—UNS R56323. Titanium alloy (3 % aluminum, 2.5 % vanadium plus 0.08–0.14 % ruthenium),

1.1.26 *Grade 29*—UNS R56404. Titanium alloy (6 % aluminum, 4 % vanadium, extra low interstitial, 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),

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



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 41*—UNS R56461. Titanium alloy (6 % aluminum, 1 % iron).

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 state in either inch-pound units or SI units are to be regarded separately as standard. The values stated in each system are not exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in nonconformance with the specification.

1.3 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

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

E539 Test Method for Analysis of Titanium Alloys by Wavelength Dispersive 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

E2994 Test Method for Analysis of Titanium and Titanium Alloys by Spark Atomic Emission Spectrometry and Glow Discharge Atomic Emission Spectrometry (Performance-Based Method)

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *bar, n*—a hot rolled, forged, extruded or cold worked semi-finished solid section product whose cross sectional area is equal to or less than 16 in.² [10 323 mm²]; rectangular bar must be less than or equal to 10 in. [254 mm] in width and greater than 0.1875 in. [4.8 mm] in thickness.

3.1.1.1 *Discussion*—Extruded bar has been approved for use on unalloyed titanium grades 1, 2, 3 and 4 only. Other grades may be produced via the extrusion process with agreement between the producer and the purchaser.

3.1.2 *billet, n*—a solid semi-finished section hot worked or forged from an ingot, with a cross sectional area greater than 16 in.² [10 323 mm²] whose width is less than five times its thickness.

3.1.3 *heat analysis, n*—chemical determination based on analysis of ingot or alternate (see Table 1 footnote A, and 9.2); check analysis limits do not apply for Heat Analysis/Producer Ingot Analysis.

3.1.4 *product analysis, n*—an analysis based on semi-finished or final product; the purchaser may apply check analysis limits to determine compliance with the specification; check analysis limits are not for producer's use at producer ingot acceptance.

3.1.5 *check analysis limits, n*—Table 3, Permissible Variations in Product Analysis: Percentages above and below those listed in Table 1, when tested on product, by or for the purchaser, or acceptable to purchaser to show compliance with a given specification.

4. Ordering Information

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

4.1.1 Grade number (Section 1);

4.1.2 Product classification (Section 3);

4.1.3 Chemistry (Table 1);

4.1.4 Condition required for Grades 9, 18, 20, 21, 23, 28, and 29;

4.1.5 Mechanical properties (Table 2);

4.1.6 Marking (Section 16);

4.1.7 Finish (Section 8);

4.1.8 Packaging (Section 16);

4.1.9 Required reports (Section 15); and

4.1.10 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 requirements as to chemical composition prescribed in Table 1.

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.