



Designation: F15 – 04 (Reapproved 2022)

Standard Specification for Iron-Nickel-Cobalt Sealing Alloy¹

This standard is issued under the fixed designation F15; 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 an iron-nickel-cobalt alloy, UNS K94610 containing nominally 29 % nickel, 17 % cobalt, and 53 % iron, in the forms of wire, rod, bar, strip, sheet, and tubing, intended primarily for sealing to glass in electronic applications.

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.

1.3 The following hazard caveat pertains only to the test method portion, Sections 13 and 14 of this specification. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *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:*²

E3 Guide for Preparation of Metallographic Specimens

E8 Test Methods for Tension Testing of Metallic Materials [Metric] E0008_E0008M

E18 Test Methods for Rockwell Hardness of Metallic Materials

E92 Test Methods for Vickers Hardness and Knoop Hardness of Metallic Materials

E112 Test Methods for Determining Average Grain Size

E140 Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, Scleroscope Hardness, and Leeb Hardness

E228 Test Method for Linear Thermal Expansion of Solid Materials With a Push-Rod Dilatometer

F14 Practice for Making and Testing Reference Glass-Metal Bead-Seal

F140 Practice for Making Reference Glass-Metal Butt Seals and Testing for Expansion Characteristics by Polarimetric Methods

F144 Practice for Making Reference Glass-Metal Sandwich Seal and Testing for Expansion Characteristics by Polarimetric Methods

3. Ordering Information

3.1 Orders for material under this specification shall include the following information:

3.1.1 Size,

3.1.2 Temper (Section 6),

3.1.3 Surface finish (Section 10),

3.1.4 Marking and packaging (Section 17), and

3.1.5 Certification if required.

4. Chemical Requirements

4.1 The material shall conform to the requirements as to chemical composition prescribed in Table 1.

5. Surface Lubricants

5.1 All lubricants used during cold-working operations, such as drawing, rolling, or spinning, shall be capable of being removed readily by any of the common organic degreasing solvents.

6. Temper

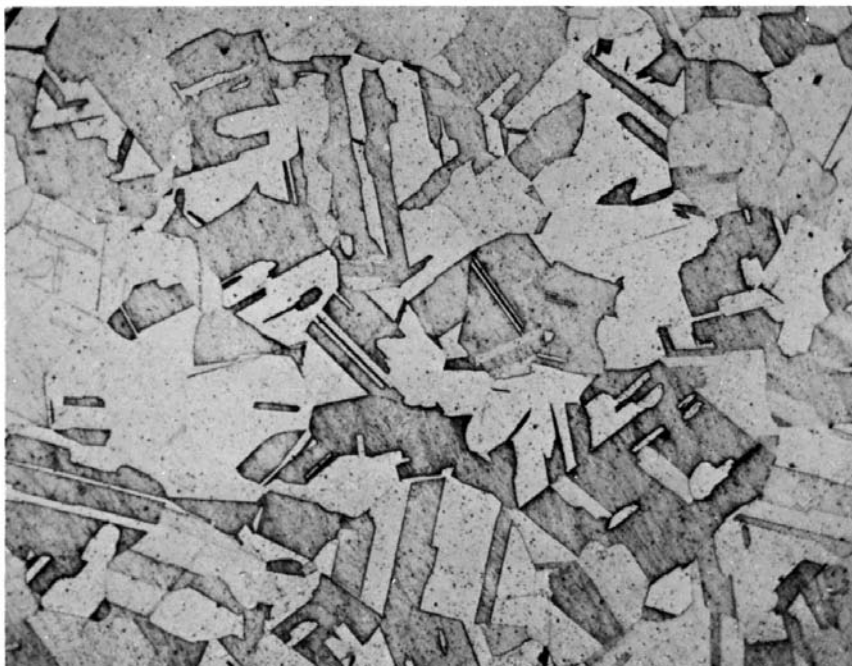
6.1 The desired temper of the material shall be specified in the purchase order.

6.2 *Tube*—Unless otherwise agreed upon by the supplier or manufacturer and the purchaser, these forms shall be given a final bright anneal by the manufacturer and supplied in the annealed temper.

¹ This specification is under the jurisdiction of ASTM Committee F01 on Electronics and is the direct responsibility of Subcommittee F01.03 on Metallic Materials, Wire Bonding, and Flip Chip.

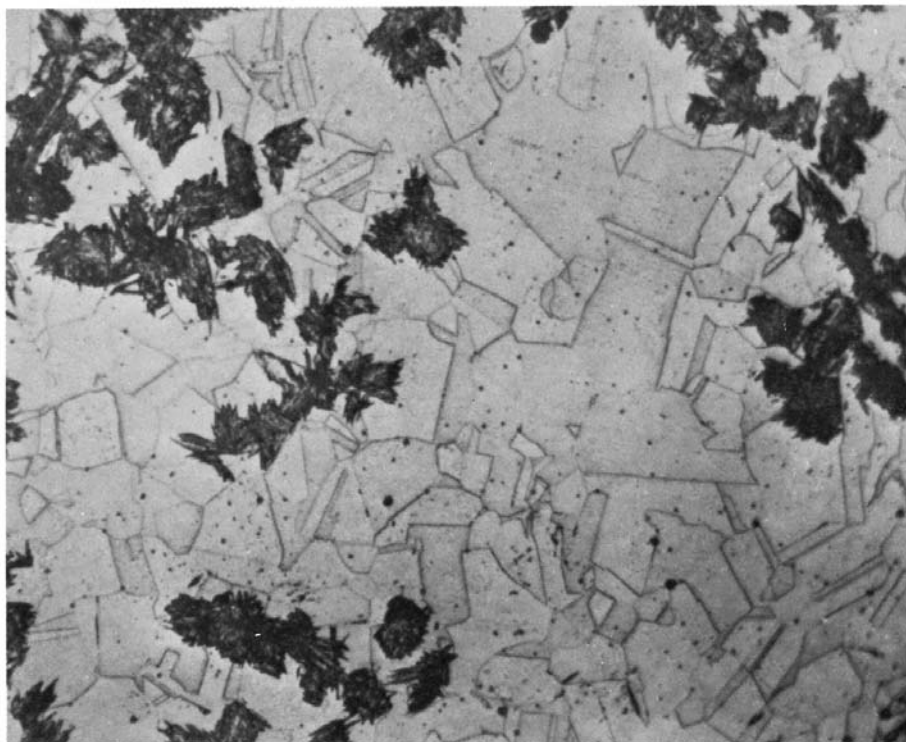
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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.



150x

FIG. 1 Normal Annealed Specimen Showing No Transformation



150x

FIG. 2 Partially Transformed Specimen