



Standard Specification for Zirconium Sponge and Other Forms of Virgin Metal for Nuclear Application¹

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1. Scope

1.1 This specification covers one grade of virgin zirconium metal commonly designated as sponge because of its porous, sponge-like texture, but it may also take other forms such as chunklets.

1.2 The one grade described is designated as Reactor Grade R60001, suitable for use in nuclear applications. The main characteristic of the reactor grade is its low nuclear cross section as achieved by removal of hafnium. The manufacturer must use procedures to prevent contamination with other high cross-section materials.

1.3 Unless a single unit is used, for example corrosion mass gain in mg/dm², the values stated in either inch-pound or SI units are to be regarded separately as standard. The values stated in each system are not exact equivalents; therefore each system must be used independently of the other. SI values cannot be mixed with inch-pound values.

1.4 *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications²

3. Terminology

3.1 Lot Definitions:

3.1.1 *castings*—a lot shall consist of all castings produced from the same pour.

3.1.2 *ingot*—no definition required.

3.1.3 *rounds, flats, tubes, and wrought powder metallurgical products (single definition, common to nuclear and non-nuclear standards)*—a lot shall consist of a material of the same size, shape, condition, and finish produced from the same ingot or powder blend by the same reduction schedule and the same heat treatment parameters. Unless otherwise agreed between manufacturer and purchaser, a lot shall be limited to the product of an 8 h period for final continuous anneal, or to a single furnace load for final batch anneal.

3.1.4 *sponge*—a lot shall consist of a single blend produced at one time.

3.1.5 *weld fittings*—definition is to be mutually agreed upon between manufacturer and the purchaser.

4. Ordering Information

4.1 Purchase orders for material under this specification shall include the following information, as required, to describe adequately the desired material:

4.1.1 Quantity,

4.1.2 Name of material,

4.1.3 Grade designation, and

4.1.4 ASTM designation and year of issue.

NOTE 1—A typical ordering description is as follows: 5000 lb (2000 kg) reactor grade zirconium, Grade R60001, ASTM Specification B 349 - 01.

4.2 In addition to the data specified in 4.1, the following options and points of agreement between the manufacturer and the purchaser shall be specified in the purchase order, as required.

4.2.1 Sampling and duplicate samples (see 7.1 and 7.2).

4.2.2 Certification reports (Section 13), and

4.2.3 Packaging (Section 15).

5. Materials and Manufacture

5.1 Zirconium metal is usually prepared by reduction of zirconium tetrachloride, and gets its physical characteristics from the processes involved in production. These characteristics may be expected to vary greatly with manufacturing methods. This specification, however, is not limited to material prepared by reduction of tetrachloride or to material of any specific physical form.

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² *Annual Book of ASTM Standards*, Vol 14.02.

5.2 Only virgin zirconium metal, in identified, uniform, well-mixed blends, shall be supplied under this specification.

6. Chemical Composition

6.1 The zirconium metal supplied under this specification shall conform to the requirements for chemical composition prescribed in Table 1.

7. Sampling

7.1 A blend of sponge shall be sampled by running a full quantity through a proportioner or splitter to obtain a representative sample of at least 1 % of the blend weight. The samples for chemical analyses shall be made on a compacted briquette and an evaluation ingot. The method for splitting this sample and preparing an evaluation ingot and compacted briquette shall be agreed upon between the manufacturer and the purchaser.

7.1.1 The evaluation ingot shall be greater than 30 lb (14 kg).

7.1.2 The compacted briquette shall be at least 1 lb (0.5 kg).

7.2 When specified in the purchase order, a duplicate sample or portions of the briquette and evaluation ingot shall be supplied to the purchaser.

7.3 For metal forms other than sponge, such as chunklets, the sampling procedures shall be as agreed upon between purchaser and manufacturer.

8. Methods of Chemical Analysis

8.1 Preparation of Sample:

8.1.1 Compact the sponge sample taken in accordance with Section 7 into a consumable electrode and melt to ingot form in an arc furnace of a type conventionally used for reactive metals. The ingot shall be prepared for analysis by either of the following two methods:

8.1.1.1 Take a longitudinal section through the center of the ingot. Sample this section and analyze by appropriate means at a minimum of three places at approximately equal intervals diagonally from the top to the bottom of the section.

8.1.1.2 Samples for chemical tests shall be taken from solid metal below the surface porosity of the as-cast ingot. The samples shall be taken from a minimum of three places equally spaced along the axial length of the ingot.

8.2 Analytical samples for the determination of chlorine must be taken from the sponge, since this element is volatilized in melting. Obtain this sample by drilling a compacted sample of the sponge or chunklets. Sample the briquette by drilling, without water or other lubricant, a minimum of three holes, each $\frac{3}{8}$ in. (9.5 mm) or larger in diameter, at equal intervals on a circle, concentric with the rounded surface of the briquette. Reject chips until the flutes of the drill are $\frac{1}{4}$ in. (6 mm) below the surface of the briquette. Take the sample chips from this point until the point of the drill is within $\frac{1}{4}$ in. (6 mm) of the opposite surface of the briquettes. Crush chips taken in this manner to pass a No. 4 (4760- μ m) sieve and thoroughly mix.

8.3 Analyze one of the samples taken in accordance with 8.1.1 for its uranium content. Analyze all samples taken in accordance with 8.1.1 for all elements listed in Table 1 except for chlorine and uranium.

8.4 *Analysis*—Analysis shall be made using the manufacturer's standard methods. In the event of disagreement as to the chemical composition of the metal, chemical analysis for referee purposes shall be determined by a mutually acceptable laboratory. The average of the analyses for each impurity shall conform to the requirements of this specification, with no individual value greater than 30 % above the maximum specified limit for that impurity. Practice E 29 shall be used to establish significant digits.

9. Particle Size

9.1 Zirconium sponge supplied under this specification shall pass a 1 in. (25 mm) screen and shall contain less than 2 % minus 20 mesh particles.

10. Retest

10.1 If any sample or specimen exhibits obvious contamination, or improper preparation, or flaws which disqualify it as a representative sample, the sample shall be discarded and a new sample or specimen substituted.

11. Rejection

11.1 Rejection for failure of the material to meet the requirements of this specification shall be reported to the manufacturer within 60 calendar days from the receipt of the material by the purchaser. Unless otherwise specified, rejected material may be returned to the manufacturer at the manufacturer's expense, unless the purchaser receives, within three weeks of the notice of rejection, other instructions for disposition.

12. Referee

12.1 In the event of disagreement between the manufacturer and the purchaser on the conformance of the material to the requirements of this specification or any special test specified by the purchaser, a mutually acceptable referee shall perform the tests in question. The results of the referee's testing shall be used in determining conformance of the material to this specification.

TABLE 1 Chemical Requirements of Zirconium Sponge, Reactor Grade R60001

Element	Permissible Impurities, max, ppm
Aluminum	75
Boron	0.5
Cadmium	0.5
Carbon	250
Chlorine	1300
Chromium	200
Cobalt	20
Copper	30
Hafnium	100
Iron	1500
Manganese	50
Molybdenum	50
Nickel	70
Nitrogen	50
Oxygen	1400
Silicon	120
Titanium	50
Tungsten	50
Uranium (total)	3.0



13. Certification

13.1 When specified in the purchase order or contract, a producer's or supplier's certification shall be furnished to the purchaser that the material was manufactured, sampled, tested, and inspected in accordance with this specification and has been found to meet the requirements. When specified in the purchase order or contract, a report of the test results shall be furnished.

14. Product Marking

14.1 The containers shall be legibly and permanently marked with the following information:

- 14.1.1 Purchase order number,
- 14.1.2 Name of material,
- 14.1.3 Particle size range,
- 14.1.4 Net weight,

14.1.5 ASTM designation, and

14.1.6 Date packed.

15. Packaging and Package Marking

15.1 The method of packaging shall be as agreed upon by the manufacturer and the purchaser. Packaging shall be such as to assure safe delivery when shipped by any common carrier. The size and nature of the containers used are generally determined by the time and length of storage and the amount of handling involved. Where fire hazards or sponge deterioration during prolonged storage are primary considerations, zirconium sponge should be packed in airtight, moisture-proof, sealed metal cans or drums which have been backfilled with argon.

16. Keywords

16.1 nuclear; virgin zirconium metal; zirconium sponge

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