



Standard Specification for Pig Tin¹

This standard is issued under the fixed designation B 339; 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 approval. 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 Department of Defense.

1. Scope

1.1 This specification covers refined tin in pig form recovered and cast from primary and secondary tin-bearing materials. One grade of tin metal is specified and is designated by the grade letter shown in Table 1.

1.2 The percent values of tin contained are to be regarded as the standard.

1.3 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

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

E 46 Test Methods for Chemical Analysis of Lead- and Tin-Base Solder³

E 51 Method for Spectrographic Analysis of Tin Alloys by the Powder Technique⁴

E 57 Method for Chemical Analysis of White Metal Bearing Alloys⁵

E 88 Practice for Sampling Nonferrous Metals and Alloys in Cast Form for Determination of Chemical Composition⁶

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *pig*—an oblong or square mass of metal that has been cast while still molten into a mold that gives the metal its particular shape.

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.02 on Refined Lead, Tin, Antimony, and Their Alloys.

Current edition approved Oct. 10, 2000. Published November 2000. Originally published as B 339-67. Last previous edition B 339-95.

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

³ Discontinued—See 1994 *Annual Book of ASTM Standards*, Vol 03.05.

⁴ Discontinued—See 1984 *Annual Book of ASTM Standards*, Vol 03.06.

⁵ Discontinued—See 1987 *Annual Book of ASTM Standards*, Vol 03.05.

⁶ *Annual Book of ASTM Standards*, Vol 03.05.

TABLE 1 Chemical Composition and Impurity Contents

Element	Composition, - wt%		
	Grade "A"	Grade "A" for the Manufacture of Tinplate	Ultra Pure Grade
Tin, min	99.85	99.85	99.95
Antimony, max	0.04	0.04	0.005
Arsenic, max	0.05	0.05	0.005
Bismuth, max	0.030	0.030	0.015
Cadmium, max	0.001	0.001	0.001
Copper, max	0.04	0.04	0.005
Iron, max	0.010	0.010	0.010
Lead, max	0.05	0.010	0.001
Ni + Co, max	0.01	0.01	0.010
Sulfur, max	0.01	0.01	0.010
Zinc, max	0.005	0.005	0.005
Silver, max	0.01	0.01	0.010
Other impurities ^A		0.010	0.010

^A Maximum per impurity not listed above.

4. Ordering Information

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

- 4.1.1 ASTM designation and year of issue,
- 4.1.2 Quantity in weight, metric tons or kilograms,
- 4.1.3 Shape and size,
- 4.1.4 Method of manufacturing (Section 5),
- 4.1.5 Chemistry (Section 6),
- 4.1.6 Product marking (Section 16), and
- 4.1.7 Packaging (Section 17).

5. Materials and Manufacture

5.1 The refined tin shall be produced from primary, secondary, or a combination of tin-bearing materials to obtain the requirements of this specification.

5.2 The refined metal for Grade A tin may be manufactured by fire refining, vacuum refining, electrolytic or electrowinning refining methods, or a combination of these methods.

6. Chemical Composition

6.1 The tin shall conform to the requirements as to chemical composition prescribed in Table 1.

7. Methods of Chemical Analysis

7.1 An analysis of each lot shall be made by the supplier. The analysis shall be made from representative test samples

obtained from the lot during pouring or from the final pig product. The chemical composition determined shall conform to the requirements of Table 1.

7.2 If a product analysis is desired by the purchaser, it shall be made in the purchaser's laboratory or elsewhere. Such analysis may be made by various methods including, but not limited to, wet chemical or spectrographic techniques.

8. Lot

8.1 All tin of Grade A produced and cast at one time shall constitute a lot for chemical analysis. Each pig of the lot shall bear a single identifying number that can be related to the manufacturing lot. This lot number can be cast, metal die stamped, or marked legibly upon each pig.

9. Workmanship, Finish, and Appearance

9.1 The manufacturer shall use care to have each lot of tin material as uniform in quality as possible.

9.2 The pigs shall be clean and reasonably free of adhering foreign material.

10. Sampling for Chemical Analysis

10.1 Care must be taken to ensure that the sample selected for testing is representative of the material. The method of sampling for chemical analysis shall be agreed upon mutually between the supplier and the purchaser and shall consist of one of the following methods:

- 10.1.1 Test samples taken from the lot during casting or
- 10.1.2 Test samples taken from the final solidified cast pig product.

10.2 *Sampling From the Lot During Casting*—The supplier may obtain representative chill cast samples from the lot of molten metal during casting. The shape of the cast sample shall be agreed upon by all parties concerned. The molten metal shall be mechanically stirred and dip samples taken. If the material is produced in a pot or kettle, the material shall be drossed, stirred, and dip samples taken. If the facility does not allow for dip sampling, the samples shall be taken at the beginning, at the middle, and at the end of the pour. The sampling ladle must be clean and heated and the molten metal cast into chilled molds which produce forms suitable for instrument use, drilling of cast sample, or sawing of cast sample. Samples drawn at the producers plant shall be from a clean bath of metal with all dross having been removed.

10.3 Sampling of Cast Pig Product:

10.3.1 If the pigs are of standard form (see Fig. 1), the sample for chemical analysis shall be taken in accordance with 10.3.3.1, 10.3.3.2, or 10.3.3.4. If the pigs differ in shape and size from those shown in Fig. 1, the supplier and purchaser should agree mutually as to the method to follow in sampling such pigs.

10.3.2 *Sampling*—A portion representative of the total shipment shall be selected at random for the final sample. For lots containing at least 55 115 lb (25 000 kg) of pig tin, one pig shall be taken for every 10 000 lb (4530 kg) or part thereof. For smaller lots, five pigs shall be taken at random. In case of shipment lots less than five pigs, each pig shall be sampled at least once or as many times as may be necessary to provide a

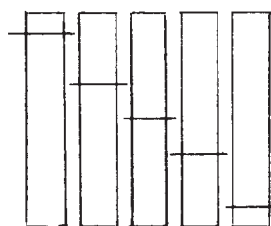
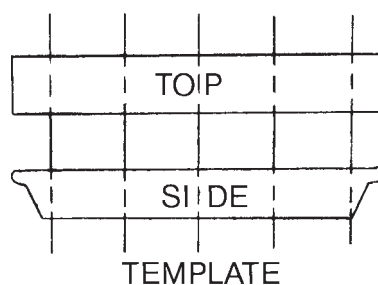


FIG. 1 Pig Tin Sampling Methods

sufficient sample for analysis. A minimum of five pigs is preferred for sampling. If a shipment is comprised of batches identified by heat numbers, each heat should be sampled as a separate lot.

10.3.3 *Sample Preparation*—Each pig should be cleaned thoroughly to rid the surface of dirt or adhering foreign material prior to sampling by one of the following methods: sawing, drilling, or melting.

10.3.3.1 *Sawing*—The pigs selected shall be sawed completely through as illustrated in Fig. 1 (one cut per pig) or shall be sawed half way across from both sides as illustrated in Fig. 2 and Fig. 3 (two cuts on each pig). The sawings from all the pigs shall be mixed thoroughly and quartered, and the samples for analysis taken from the mixed material. The sawings must be free of extraneous material introduced from the saw blade. All sawings should be screened to remove any coagulated saw chips and treated with a strong magnet to remove iron introduced by sawing. No lubricant shall be used when sawing.

10.3.3.2 *Drilling*—The pigs shall be drilled all the way through the depth of pig as shown in Fig. 4 (one hole per pig) or drilled half way through the depth of pig from top and bottom as shown in Fig. 5 (two holes 1/2 depth per pig). A drill size of about 1/2 in. (12.7 mm) in diameter is preferred and in no instance shall the drill size be less than 3/8 in. (9.5 mm) in diameter. A standing drill or bench drill should be used whenever possible, as hand held drills are normally high speed, therefore creating problems with drill breakage. In drilling, the holes shall be spaced along a diagonal line from one corner of

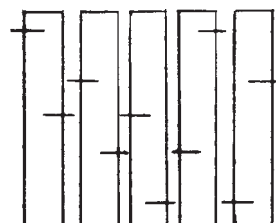


FIG. 2 Pigs Sampled in Sets of Five According to Template as Shown Above

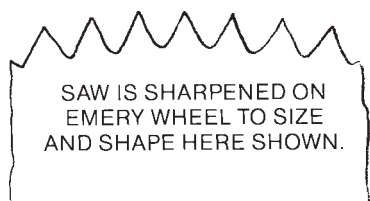


FIG. 3 Method of Sampling Tin by Sawing

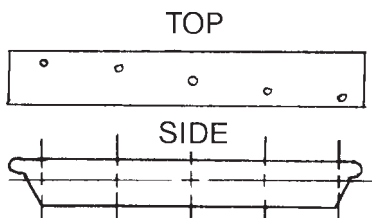


FIG. 4 Template

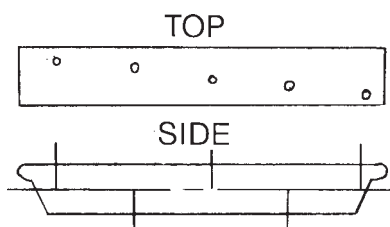
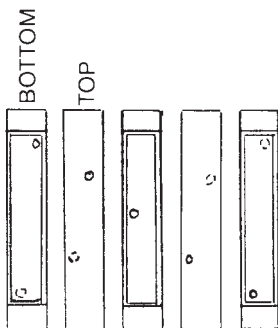


FIG. 4. TEMPLATE



NOTE 1—Pigs selected for sampling shall be placed side by side, every other pig bottom up and sampled according to template in sets of five pigs each as indicated above. The pigs shall be drilled at least halfway through. When a larger sample is desired the pigs shall be turned over and sampled on the other side.

FIG. 5 Template—Method of Sampling Tin by Drilling

the pig to the opposite corner. No lubricant shall be used in drilling. The drillings shall be clipped into pieces not over 1/2 in. in length, mixed thoroughly, quartered, and treated with a strong magnet to remove iron introduced by the drilling.

10.3.3.3 The saws, drills, cutter, or other tools used for sampling shall be thoroughly cleaned prior to use. The cleaning of the test samples shall include machining the test pieces in several positions to remove oxidized surfaces not as specified in Fig. 1. Metal pieces so produced are not to be included in any sample. Whenever possible, it is preferred that the sampling tools used are not composed of material that could cause contamination. Tools made of iron may contaminate the tin sample if the iron particles embedded in the soft tin are not completely removed by magnetic separation.

10.3.3.4 *Melting*—Whole pigs or portions of pigs produced by sawing or drilling shall be melted under palm oil in a clean vessel and heated to the auto ignition point (600°F (316°C)) of palm oil, and must be stirred immediately prior to sampling. The molten tin shall be chill cast into shapes for use in the spectrographic analysis, or chill cast into thin sample bars not to exceed 3/8 in. (9.5 mm) thick for sawing. Residual palm oil in the surface should be removed in hot distilled water with a suitable detergent. For sample bars, saw cuts shall be made halfway across the bar from each side and staggered so they are 3/64 in. (12.5 mm) apart; the sawings so produced are treated in accordance with 10.3.3.1.

10.3.4 *Sample Size:*

10.3.4.1 For spectrographic analysis, three samples shall be prepared of a size and shape satisfactory for use by the laboratory at which the analysis is to be made.

10.3.4.2 For wet chemical analysis, each prepared sample (sawings or drillings) shall weigh at least 1 1/3 lb (600 g).

10.3.5 Aspects of sampling and sample preparation not specifically covered in this specification shall be carried out in accordance with Practice E 88.

11. Significance of Numerical Limits

11.1 For the purpose of determining compliance with the specified limits for requirements of the properties listed in Table 1, an observed value or a calculated value shall be rounded as indicated in accordance with the rounding method of Practice E 29.

12. Test Method

12.1 Analyze the sample of tin for impurities in accordance with Test Methods E 46 or Methods E 51 or E 57.

12.2 An alternative method that may be used by the purchaser is the wet chemical method; however, this method is not acceptable in the case of disagreement.

13. Inspection

13.1 Inspection may be made at the manufacturer's factory where the material is made, or at the point where it is received, at the option of the purchaser.

13.2 If the purchaser elects to have inspection made at the manufacturer's factory or at a public warehouse, the manufacturer shall afford the inspector representing the purchaser all reasonable facilities to satisfy him that the material is being furnished in accordance with this specification. All tests and inspection shall be so conducted as not to interfere with the operation of the factory.

14. Rejection and Rehearing

14.1 *Rejection*—Material that fails to conform to the requirements of this specification may be rejected. Rejection should be reported to the supplier promptly and in writing. In case of dissatisfaction with the results of the test, the supplier may make claim for a rehearing.

14.2 Rejection shall be considered as follows:

14.2.1 Variation in weight, quantity, dimensions, or quality.

14.2.2 *Chemical Composition:*

14.2.2.1 In case of dispute, the pigs shall be sampled in the presence of both parties in accordance with 10.3.

14.2.2.2 The resulting sample (at least 4 lb (1800 g)) shall be mixed and separated into three equal parts, each of which shall be placed in a sealed package, one for the supplier, one for the purchaser, and one for the umpire, if necessary. The manufacturer and purchaser shall each make an analysis, and if the results do not establish or dismiss the claim to the satisfaction of both parties, the sample shall be submitted to a mutually agreed upon umpire, who shall determine the question of fact, and whose determination shall be final.

14.3 *Rehearing*—In the event of disagreement between the supplier and the purchaser on the conformance of the material to the requirements of this specification, a mutually acceptable umpire shall perform the test in accordance with an agreed upon method. The results of the umpire's testing shall be used in determining conformance of the material to this specification.

14.4 The expenses of the umpire shall be paid by the loser or divided in proportion to the concession made in the case of a compromise. In case of rejection being established, the damages shall be limited to the payment of freight both ways by the supplier for substitution of an equivalent weight of material conforming to this specification.

15. Certification

15.1 When specified in the purchase order or contract, a supplier's certificate of analysis and weight certificate shall be

furnished to the purchaser that the material was manufactured and inspected in accordance with this specification and has been found to meet the requirements.

16. Product Marking

16.1 A brand or trademark by which the supplier can be identified shall be cast upon each pig.

17. Packaging and Package Marking

17.1 Unless otherwise specified, pig tin purchased under this specification shall be stacked in a self-palletizing secure bundle or double strapped with steel bands to ensure safe delivery to their destination when properly transported by any common carrier.

18. Special Requirements

18.1 By agreement between the purchaser and the supplier, analysis may be required and limits established for elements or compounds not specified in Table 1.

18.2 Special sampling, marking, color coding, and other quality requirements not covered by this specification shall be as agreed upon between the supplier and the purchaser.

19. Keywords

19.1 chemical composition; lot; metal; pig; refined; sampling; tin

ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.

This standard is copyrighted by ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org).