CLAIMS

1. An aqueous pharmaceutical composition stabilized for long term storage comprising:
   etanercept at 25 to 75 mg/ml;
   a polysorbate or poloxamer surfactant at 0.01 to 0.05% w/v;
   a metal ion selected from the group consisting of calcium, magnesium and zinc, wherein the metal ion is present at 2 mM to 20 mM;
   a buffer;
   wherein the composition has a pH of between 6 and 7, and the composition is free of arginine.

2. The stabilized composition of claim 1 wherein the surfactant is selected from the group consisting of polysorbate 80, polysorbate 60, polysorbate 40 and polysorbate 20.

3. The stabilized composition of claim 2 wherein the surfactant comprises polysorbate 80.

4. The stabilized composition of claim 1 wherein the composition has (i) less than 2500 particles/ml having a size of 5-10µm; (ii) less than 3500 particles/ml having size of about 2-5µm and (iii) less than 700 particles/ml having size of about 1-2 µm.

5. The stabilized composition of claim 1 wherein; etanercept is present at 25 to 50 mg/ml; the metal ion is magnesium; and wherein the composition further comprises sucrose or trehalose at 0.5 to 6 wt%; NaCl at 25 to 150 mM; and the buffer is sodium phosphate at 1 to about 30 mM.

6. The stabilized composition of claim 1 wherein the metal ion is magnesium and wherein the composition further comprises NaCl at 0 to 100 mM; and the buffer is sodium phosphate at 1 to 30 mM.

7. A vial or injection device containing the etanercept formulation of claim 1 in final dosage form.

8. A vial or injection device containing the etanercept formulation of claim 5 in final dosage form.

9. A vial or injection device containing the etanercept formulation of claim 6 in final dosage form.

10. The stabilized composition of claim 5 wherein the composition has (i) less than 2500 particles/ml having a size of 5-10µm; (ii) less than 3500 particles/ml having size of about 2-5µm and (iii) less than 700 particles/ml having size of about 1-2 µm.

11. The stabilized composition of claim 6 wherein the composition has (i) less than 2500 particles/ml having a size of 5-10µm; (ii) less than 3500 particles/ml having size of about 2-5µm and (iii) less than 700 particles/ml having size of about 1-2 µm.

12. The stabilized composition of claim 1, wherein a number of sub-visible particles per ml of the formulation having size of 1-10µm is at least about 50% lower than in the same composition having no surfactant.