

CUSTOMER: BS-TECH ROLLING MILL, S. L

ORDER NO.: 1235

Centrifugal Casting

DRAWING NO.: 00001.01.2620.02.001

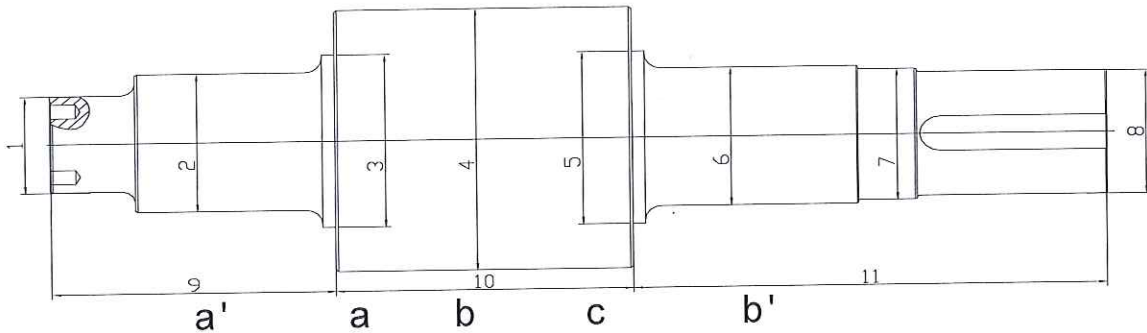
MATERIAL: SG Pearlitic

HEAT NO.: 16-04-06-A1

ROLL NO.: A1604-438

INSPECTION DATE: Jun.05 .2016

MAKING NO.: A1604-438



Final hardness (HSC)

a'	a	b	c	b'
41	53	55	55	40

Dimension In (mm)

	drawing size	inspectio size		drawing size	inspectio size
1	$\Phi 220_{-0.079}^{-0.050}$	-0.07	7	$\Phi 270_{+0.034}^{+0.066}$	+0.06
2	$\Phi 280_{+0.094}^{+0.126}$	+0.11	8	$\Phi 260_{+0.158}^{+0.190}$	+0.17
3	$\Phi 355_{+0.021}^{+0.057}$	+0.04	9	430	430
4	$\Phi 580$	+1	10	800	800
5	$\Phi 355_{+0.021}^{+0.057}$	+0.04	11	655	655
6	$\Phi 280_{+0.094}^{+0.126}$	+0.11			

Chemical Composition(%)

Working Depth In (mm)

C	Si	Mn	P	S	Ni	Cr	Mo
3.16	1.71	0.52	0.036	0.008	1.66	0.33	0.33

Top Side	Bottom Side
100	100

ULTRASONIC INSPECTION CERTIFICATE: No Defect in the Composite Layer

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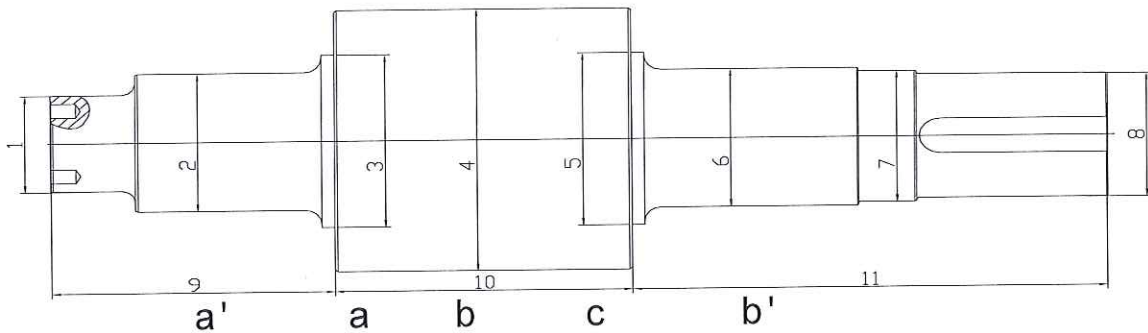
MATERIAL: SG Pearlitic

HEAT NO.: 16-04-12-A1

ROLL NO.: A1604-547

INSPECTION DATE: Jun.05 .2016

MAKING NO.: A1604-547



Final hardness (HSC)

a'	a	b	c	b'
41	52	52	52	40

Dimension In (mm)

	drawing size	inspectio size		drawing size	inspectio size
1	$\Phi 220^{+0.050}_{-0.079}$	-0.06	7	$\Phi 270^{+0.066}_{+0.034}$	+0.05
2	$\Phi 280^{+0.126}_{+0.094}$	+0.11	8	$\Phi 260^{+0.190}_{+0.158}$	+0.17
3	$\Phi 355^{+0.057}_{+0.021}$	+0.03	9	430	430
4	$\Phi 580$	+1	10	800	800
5	$\Phi 355^{+0.057}_{+0.021}$	+0.04	11	655	655
6	$\Phi 280^{+0.126}_{+0.094}$	+0.11			

Chemical Composition(%)

Working Depth In (mm)

C	Si	Mn	P	S	Ni	Cr	Mo
3.15	1.71	0.53	0.035	0.011	1.62	0.35	0.36

Top Side	Bottom Side
100	100

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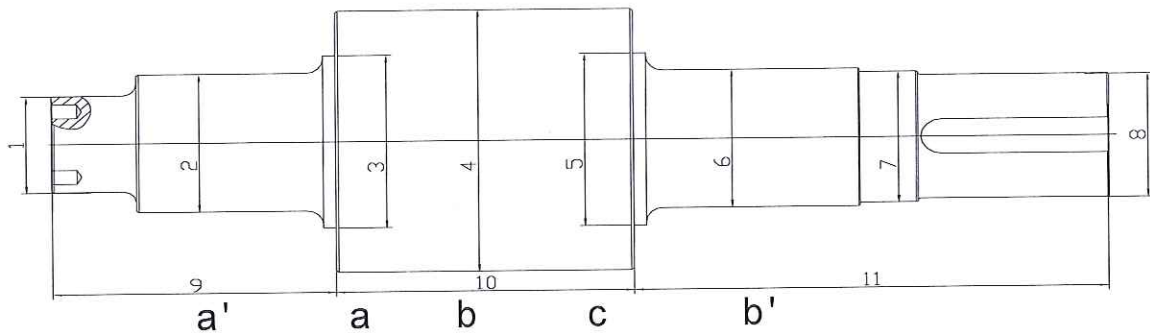
MATERIAL: SG Pearlitic

HEAT NO.: 16-04-16-A1

ROLL NO.: A1604-587

INSPECTION DATE: Jun.05 .2016

MAKING NO.: A1604-587



Final hardness (HSC)

a'	a	b	c	b'
41	54	54	55	40

Dimension In (mm)

	drawing size	inspectio size		drawing size	inspectio size
1	$\Phi 220^{+0.050}_{-0.079}$	-0.07	7	$\Phi 270^{+0.066}_{+0.034}$	+0.06
2	$\Phi 280^{+0.126}_{+0.094}$	+0.12	8	$\Phi 260^{+0.190}_{+0.158}$	+0.17
3	$\Phi 355^{+0.057}_{+0.021}$	+0.05	9	430	430
4	$\Phi 580$	+1	10	800	800
5	$\Phi 355^{+0.057}_{+0.021}$	+0.05	11	655	655
6	$\Phi 280^{+0.126}_{+0.094}$	+0.12			

Chemical Composition(%)

Working Depth In (mm)

C	Si	Mn	P	S	Ni	Cr	Mo
3.18	1.65	0.52	0.033	0.007	1.62	0.38	0.34

Top Side	Bottom Side
100	100

ULTRASONIC INSPECTION CERTIFICATE: No Defect in the Composite Layer