

CUSTOMER: BS-TECH ROLLING MILL, S. L

ORDER NO.: 1235

Centrifugal Casting

DRAWING NO.: 00001.01.2720.32.001

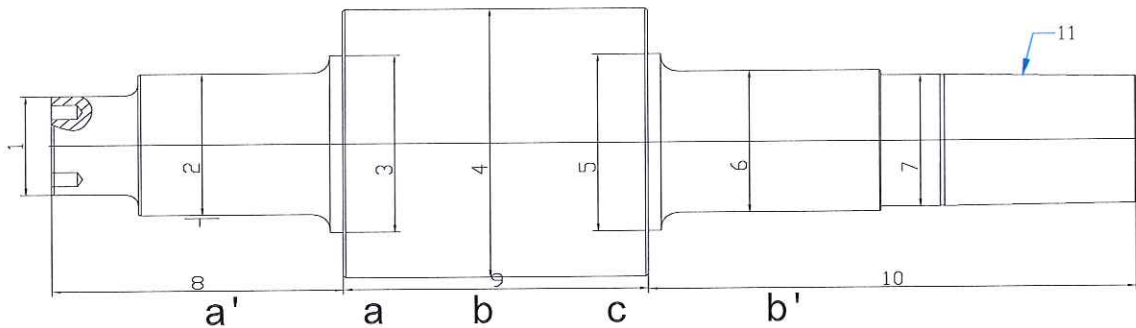
MATERIAL: SG Acicular

HEAT NO.: 16-03-23-B1

ROLL NO.: B1603-669

INSPECTION DATE: Jun.05 .2016

MAKING NO.: B1603-669



Final hardness (HSC)

a'	a	b	c	b'
41	69	68	68	40

Dimension In (mm)

	drawing size	inspectio size		drawing size	inspectio size
1	$\Phi 140_{-0.068}^{-0.043}$	-0.05	7	$\Phi 190_{+0.031}^{+0.060}$	+0.04
2	$\Phi 200_{+0.050}^{+0.079}$	+0.075	8	388	388
3	$\Phi 275_{+0.020}^{+0.052}$	+0.03	9	600	600
4	$\Phi 420$	+1	10	564	564
5	$\Phi 275_{+0.020}^{+0.052}$	+0.04	11	1:30	CONFIRMED
6	$\Phi 200_{+0.050}^{+0.079}$	+0.075			

Chemical Composition(%)

Working Depth In (mm)

C	Si	Mn	P	S	Ni	Cr	Mo
3.19	1.45	0.49	0.041	0.012	3.19	0.59	0.68

Top Side	Bottom Side
65	65

ULTRASONIC INSPECTION CERTIFICATE: No Defect in the Composite Layer

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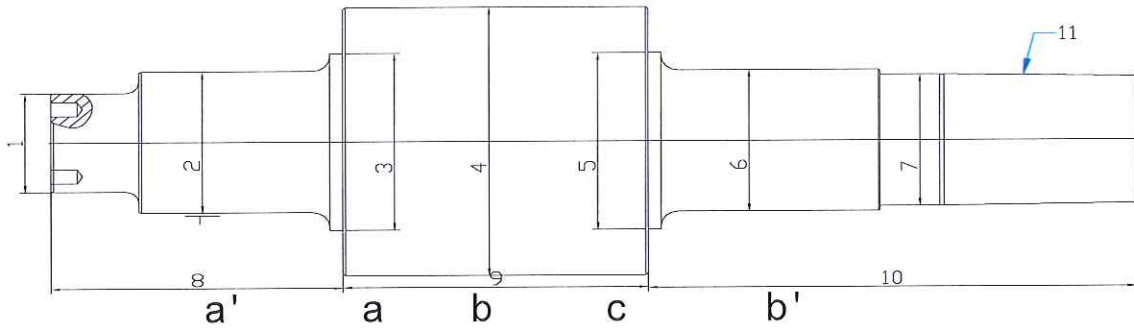
MATERIAL: SG Acicular

HEAT NO.: 16-03-26-B1

ROLL NO.: B1603-727

INSPECTION DATE: Jun.05 .2016

MAKING NO.: B1603-727



Final hardness (HSC)

a'	a	b	c	b'
41	70	70	70	40

Dimension In (mm)

	drawing size	inspectio size		drawing size	inspectio size
1	$\Phi 140^{+0.043}_{-0.068}$	-0.06	7	$\Phi 190^{+0.060}_{+0.031}$	+0.05
2	$\Phi 200^{+0.079}_{+0.050}$	+0.075	8	388	388
3	$\Phi 275^{+0.052}_{+0.020}$	+0.05	9	600	600
4	$\Phi 420$	+1	10	564	564
5	$\Phi 275^{+0.052}_{+0.020}$	+0.05	11	1:30	CONFIRMED
6	$\Phi 200^{+0.079}_{+0.050}$	+0.075			

Chemical Composition(%)

Working Depth In (mm)

C	Si	Mn	P	S	Ni	Cr	Mo
3.15	1.48	0.57	0.042	0.012	3.22	0.6	0.63

Top Side	Bottom Side
65	65

ULTRASONIC INSPECTION CERTIFICATE: No Defect in the Composite Layer

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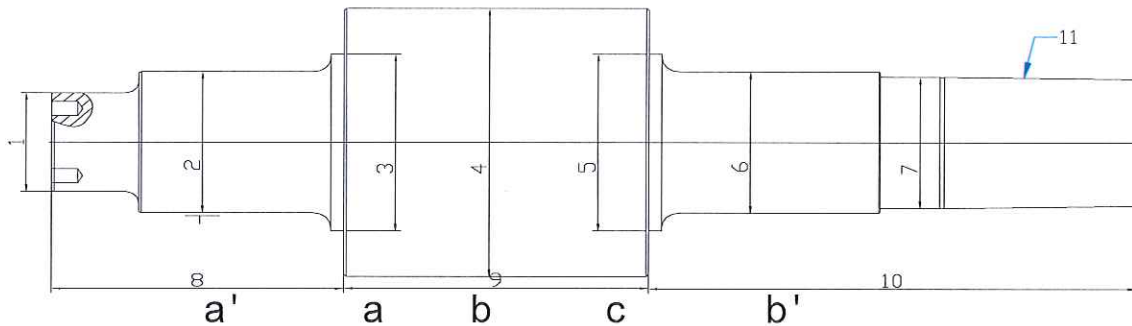
MATERIAL: SG Acicular

HEAT NO.: 16-03-26-B1

ROLL NO.: B1603-728

INSPECTION DATE: Jun.05 .2016

MAKING NO.: B1603-728



Final hardness (HSC)

a'	a	b	c	b'
42	69	69	68	41

Dimension In (mm)

	drawing size	inspection size		drawing size	inspection size
1	$\Phi 140_{-0.068}^{-0.043}$	-0.06	7	$\Phi 190_{+0.031}^{+0.060}$	+0.05
2	$\Phi 200_{+0.050}^{+0.079}$	+0.075	8	388	388
3	$\Phi 275_{+0.020}^{+0.052}$	+0.05	9	600	600
4	$\Phi 420$	+1	10	564	564
5	$\Phi 275_{+0.020}^{+0.052}$	+0.04	11	1:30	CONFIRMED
6	$\Phi 200_{+0.050}^{+0.079}$	+0.075			

Chemical Composition(%)

Working Depth In (mm)

C	Si	Mn	P	S	Ni	Cr	Mo	Top Side	Bottom Side
3.15	1.48	0.57	0.042	0.012	3.22	0.6	0.63	68	68

ULTRASONIC INSPECTION CERTIFICATE: No Defect in the Composite Layer