

CUSTOMER: BS-TECH ROLLING MILL, S. L

ORDER NO.: 1235

Centrifugal Casting

DRAWING NO.: 00001.01.2870.02.001

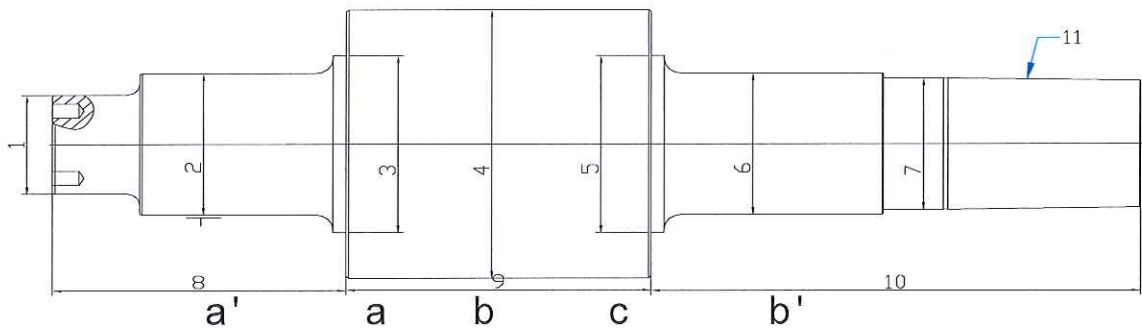
MATERIAL: SG Acicular II

HEAT NO.: 16-04-11-B1

ROLL NO.: B1604-422

INSPECTION DATE: Jun.06 .2016

MAKING NO.: B1604-422



Final hardness (HSC)

a'	a	b	c	b'
41	71	70	71	40

Dimension In (mm)

	drawing size	inspectio size		drawing size	inspectio size
1	$\Phi 100_{-0.058}^{-0.036}$	-0.05	7	$\Phi 167_{+0.027}^{+0.052}$	+0.04
2	$\Phi 180_{+0.043}^{+0.068}$	+0.06	8	365	365
3	$\Phi 237_{+0.017}^{+0.046}$	+0.04	9	800	800
4	$\Phi 360$	+1	10	519	519
5	$\Phi 237_{+0.017}^{+0.046}$	+0.03	11	1:30	CONFIRMED
6	$\Phi 180_{+0.043}^{+0.068}$	+0.06			

Chemical Composition(%)

Working Depth In (mm)

C	Si	Mn	P	S	Ni	Cr	Mo
3.28	1.45	0.73	0.046	0.01	3.59	0.61	0.71

Top Side	Bottom Side
45	45

ULTRASONIC INSPECTION CERTIFICATE: No Defect in the Composite Layer

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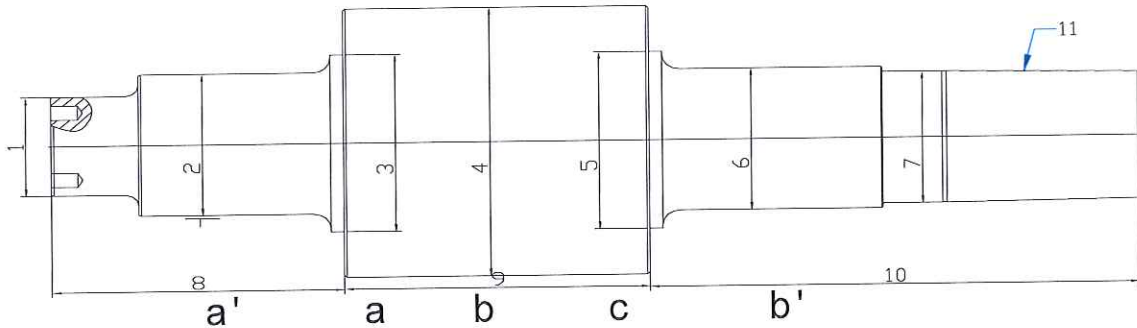
MATERIAL: SG Acicular II

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ROLL NO.: B1604-423

INSPECTION DATE: Jun.06 .2016

MAKING NO.: B1604-423



Final hardness (HSC)

a'	a	b	c	b'
41	72	72	72	40

Dimension In (mm)

	drawing size	inspectio size		drawing size	inspectio size
1	$\Phi 100^{+0.036}_{-0.058}$	-0.05	7	$\Phi 167^{+0.052}_{+0.027}$	+0.04
2	$\Phi 180^{+0.068}_{+0.043}$	+0.06	8	365	365
3	$\Phi 237^{+0.046}_{+0.017}$	+0.03	9	800	800
4	$\Phi 360$	+1	10	519	519
5	$\Phi 237^{+0.046}_{+0.017}$	+0.03	11	1:30	CONFIRMED
6	$\Phi 180^{+0.068}_{+0.043}$	+0.06			

Chemical Composition(%)

Working Depth In (mm)

C	Si	Mn	P	S	Ni	Cr	Mo
3.28	1.45	0.73	0.046	0.01	3.59	0.61	0.71

Top Side	Bottom Side
55	55

ULTRASONIC INSPECTION. CERTIFICATE: No Defect in the Composite Layer

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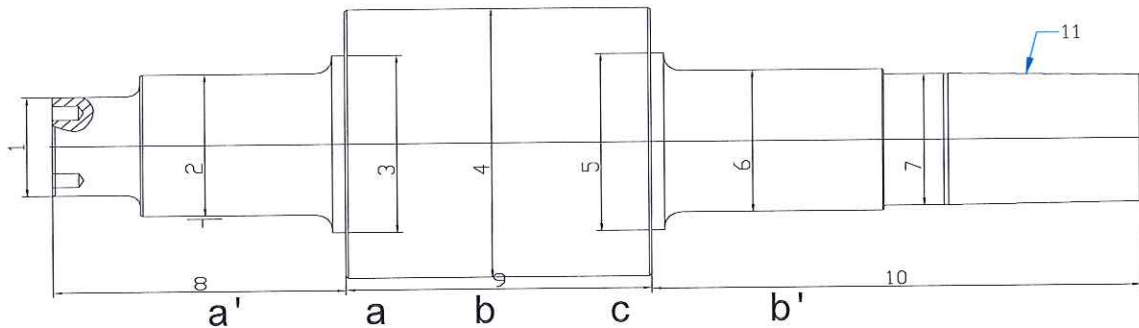
MATERIAL: SG Acicular II

HEAT NO.: 16-04-15-B1

ROLL NO.: B1604-481

INSPECTION DATE: Jun.06 .2016

MAKING NO.: B1604-481



Final hardness (HSC)

a'	a	b	c	b'
41	70	68	69	40

Dimension In (mm)

	drawing size	inspectio size		drawing size	inspectio size
1	$\Phi 100^{+0.036}_{-0.058}$	-0.05	7	$\Phi 167^{+0.052}_{+0.027}$	+0.04
2	$\Phi 180^{+0.068}_{+0.043}$	+0.06	8	365	365
3	$\Phi 237^{+0.046}_{+0.017}$	+0.03	9	800	800
4	$\Phi 360$	+1	10	519	519
5	$\Phi 237^{+0.046}_{+0.017}$	+0.03	11	1:30	CONFIRMED
6	$\Phi 180^{+0.068}_{+0.043}$	+0.06			

Chemical Composition(%)

Working Depth In (mm)

C	Si	Mn	P	S	Ni	Cr	Mo
3.17	1.54	0.72	0.043	0.013	3.5	0.62	0.69

Top Side	Bottom Side
45	45

ULTRASONIC INSPECTION CERTIFICATE: No Defect in the Composite Layer