

voestalpine BÖHLER Edelstahl GmbH & Co KG
Mariazellerstrasse 25 / 8605 Kapfenberg / AUSTRIA

Nr. / No.: 281466 / C1 / 2021.06.17
Rev.: 0 / 1 / 2021.11.30
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<p>Besteller/Purchaser/Acheteur: Uddeholm Ltd</p> <p>Bestell-Nr./Purchaser order No./No. de commande: 4502954284 / 2019.11.22</p> <p>Werksauftrags-Nr./Works order-No./No. de la commande de l'usine: 0002257811 / 2019.11.25</p> <p>Prüfgegenstand/Object of test/Objet d'examen: BÖHLER A903 W-Nr. 1.4462 bar, rolled, solution annealed, quenched ECOBANK ISO 286/2 ITk12</p>	<p>Empfänger/Consignee/Destinaire: BUL Rexdale Aerospace</p> <p>Empfängerref.-Nr./Receiver reference-No./Référence destinaire: </p> <p>Lieferschein-Nr./Delivery note-No./Avis d'expédition du client: 51724463. / 2020.06.08</p> <p>Anforderungen/Requirements/Exigence: BUUK UNS 31803/32205 Rev.5, 26 May 2011 Norsok Standard M-650 Edition 4, September 2011 Norsok Standard M-630 Edition 6, October 2013 Norsok MDS D47 Rev.5 Böhler QTR No.011 Rev.No.0 ANSI/NACE MR0175/ISO 15156-3:2015 Ultrasonic inspection acc.to API 6A PSL 3 Heat treatment inspection acc.to API 6A PSL 3 EN10088-1:2014 (*) X2CrNiMoN22-5-3 ASTM A182/A182M-19 ASTM A276/A276M-17 ASTM A314-19 ASTM A479/A479M-18 ASME BPVC.II.A-2019 SA-276 ASME BPVC.II.A-2019 SA-479/SA-479M ASME BPVC.II.A-2019 SA-182/SA-182M (*) chemistry only</p> <p>UNS S31803, F51 and UNS S32205, F60 Pressure equipment directive PED 2014/68/EU</p>																
<p>Volume of delivery</p> <table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th>Pcs./Los</th> <th>Dimensions</th> <th>Length</th> <th>No. of Pieces</th> <th>Weight kgs</th> <th>Mat.-ID</th> <th>Test No.</th> <th>Heat No.</th> </tr> </thead> <tbody> <tr> <td>10/1</td> <td>RD 3 in</td> <td>118,1102-196,8504 in</td> <td> </td> <td>563.0</td> <td>7NTA</td> <td>1880856-1</td> <td>E11483</td> </tr> </tbody> </table>		Pcs./Los	Dimensions	Length	No. of Pieces	Weight kgs	Mat.-ID	Test No.	Heat No.	10/1	RD 3 in	118,1102-196,8504 in		563.0	7NTA	1880856-1	E11483
Pcs./Los	Dimensions	Length	No. of Pieces	Weight kgs	Mat.-ID	Test No.	Heat No.										
10/1	RD 3 in	118,1102-196,8504 in		563.0	7NTA	1880856-1	E11483										
<p>Reduction ratio Reduction ratio = 21 : 1</p>																	
<p>Quality heat treatment Heat treatment monitoring method in compliance with API 6A PSL3</p> <table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th> </th> <th>Temperature</th> <th>Soak time</th> <th>Cooling</th> </tr> </thead> <tbody> <tr> <td>Solution annealed</td> <td>1060°C</td> <td>0.5 h M</td> <td>Water</td> </tr> </tbody> </table> <p>M...Holding time at nominal temperature after center of material has reached the tolerance limit.</p>			Temperature	Soak time	Cooling	Solution annealed	1060°C	0.5 h M	Water								
	Temperature	Soak time	Cooling														
Solution annealed	1060°C	0.5 h M	Water														

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Chemical Composition (%)										
Chemical Composition Steelmaking Process: Airmelt										Heat No.
C	Si	Mn	P	S	Cr	Mo	Ni	W	Cu	E11483
0,020	0,55	1,21	0,018	0,0005	22,87	3,15	5,86	<0,05	0,18	
Al	N	FL014*								E11483
0,010	0,17	35,99								

*FL014 = Cr+3,3*Mo+16*N

Steelmaking Process = **Airmelt (EAF+AOD)**

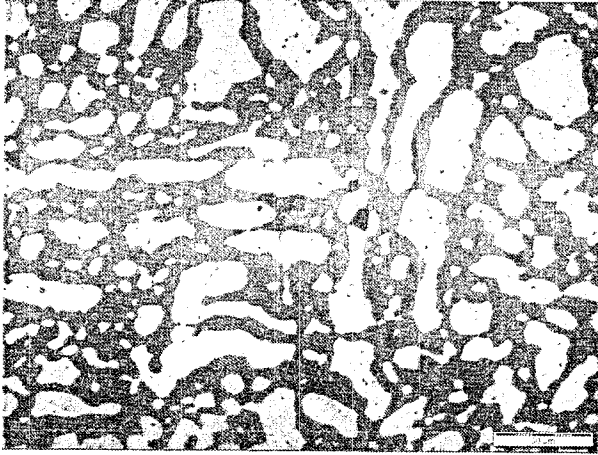
Ferrite content examination
 Ferrite content evaluation performed by Element Materials Technology.
 See attached test certificate REF No P 043654 Issue 1, REF No P 043661 Issue 1.
 Testing standard = ASTM E562-19, point count method
 Orientation/Location = QA (transverse, rim), Q2 (transverse, 1/2 Radius (1/4T))
The material fulfills the requirements

Microstructural examination
 Testing standard = ASTM A 923-14 method A
 Etchant = ASTM E 407 reagent 98 (NaOH)
 Magnification = 50:1, 100:1, 500:1

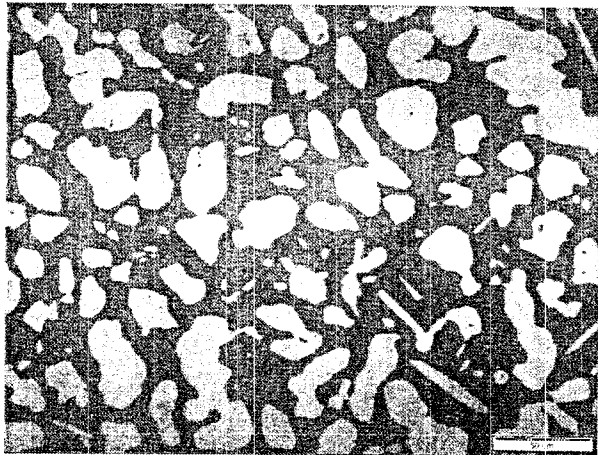
	Rim	1/2 Radius (1/4T)
Microstructure	Austenitic - Ferritic, free from precipitates	Austenitic - Ferritic, free from precipitates

The material is free from intermetallic and deleterious third phases (max. 0,05% of total area).

Photomicrographs
 The microstructural photographs were examined at 500x using light microscopy.



Location = Rim
 Magnification = 500:1
 Orientation = **transverse**



Location = 1/2 Radius (1/4T)
 Magnification = 500:1
 Orientation = **transverse**

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Mechanical Properties

The QTC is a prolongation of the final heat treated bar.

Tensile test properties

Orientation and location of the tensile test properties.

L2 = longitudinal, 1/2 Radius (1/4T); LZ = longitudinal, center; Q2 = transverse, 1/2 Radius (1/4T)

Tensile test in delivery condition

Test no.	*Piece no.	Testing standard	Location	Temp. grad C	Yield Strength	Ultimate Tensile Strength	Elongation	Reduction of Area
					YS0.2 MPa	UTS MPa	A4 %	RoA %
					>=450	680 - 795	>=25	>=45
1880856-1	1	ASTM A 370-19 01.07.2019	L2	23	538	738	42	82

Impact test properties

Orientation and location of the impact test properties.

L2 = longitudinal, 1/2 Radius (1/4T); LZ = longitudinal, center; Q2 = transverse, 1/2 Radius (1/4T)

Impact test in delivery condition

Test no.	*Piece no.	Testing standard	Location	Temp. grad C	Impact energy	Lateral expansion	Shear area
					Charpy-V J	mm	%
					info	info	info
1880856-1	51	ASTM A370-19 01.07.2019	L2	-50	314 331 344	2,24 2,27 2,46	100 100 100
					>=45	info	info
1880856-1	51	ASTM A370-19 01.07.2019	L2	-46	309 312 339	2,20 2,18 2,31	100 100 100
					info	info	info
1880856-1	51	ASTM A370-19 01.07.2019	Q2	-50	194 101 212	1,87 1,07 2,01	70 50 75

Hardness test in delivery condition

Test no.	Piece no.	Testing standard	Location	HRC
				<=28
1880856-1	51	ASTM E18-19 01.02.2019	1/2 Radius (1/4T)	<20
1880856-1	51	ASTM E18-19 01.02.2019	1/2 Radius (1/4T)	<20
1880856-1	51	ASTM E18-19 01.02.2019	1/2 Radius (1/4T)	<20

Corrosion examination
Pitting corrosion

Testing standard = ASTM G48 method A Test period = 24h Test temperature = 35°C Pickling solution = 20 % HNO3 + 5 % HF Pickling period = 5 min. Pickling temperature = 60°C Location = Norsok MDS D47 Rev.5 Weight loss = 0.00 g/m ² , no pitting at 20x magnification	Testing standard = ASTM G48 method A Test period = 24h Test temperature = 35°C Pickling solution = unpickled Pickling period = unpickled Pickling temperature = unpickled Location = Norsok MDS D47 Rev.5 Weight loss = 0.01 g/m ² , no pitting at 20x magnification
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Non-Destructive examination
Material identification test

 Inspection quantity = 100% of the bars
Böhler A903 confirmed
Ultrasonic examination

 Inspection quantity = 100% of the bars
 Inspection specification = ASTM A388/A388M-19
 Evaluation standard = API Specification 6A Twenty-first Edition - PSL 3
 Inspection technique = Phased Array (straight-beam technique from the outside diameter)
The material fulfills the requirements
Surface examination

 Inspection quantity = 100% of the bars
 Inspection technique = Eddy - Current test (ET)
The material is without unacceptable surface defects
Statements

 The material is free of mercury contamination.
 No weld repair has been performed on this material.
 Country of origin and melt: AUSTRIA

Attachment

 Ultrasonic Report
 Operators Qualification
 Furnace chart
 Element Materials Technology test certificates REF No P 043654 Issue 1 and REF No P 043661 Issue 1

Radioaktivitätskontrolle/Radioactivity inspection: Co-60<0,1Bq/g

 Hiermit kleiner als Grenzwert in der anzuwendenden Spezifikation IAEA RS-G-1.7 für unbedenkliche Stoffe.
 Therefore smaller than upper limit required according to specification IAEA RS-G-1.7 for inoffensive material.

 Wir bestätigen hiermit, dass die obengenannten Erzeugnisse den Bestellvorschriften entsprechen.
 We hereby certify that the above mentioned products are consistent with the order prescriptions.

 Zeichen des Lieferwerks:
 Brand of Manufacturer:

 Besichtigung und Nachmessung: Keine Beanstandung
 Inspection and Checking of Dimensions: Satisfactory


 Zeichen des Prüfers:
 Symbol of Inspector:

 voestalpine BÖHLER Edelstahl GmbH & Co KG
 Mariazellerstrasse 25
 8605 Kapfenberg, AUSTRIA
www.boehler-edelstahl.com

 Abteilung / Department
B10CERMAT

 AUSSTELLER /
 ORIGINATOR

Ackerer


 Abnahmebeauftragter
 Inspection Representative

voestalpine BÖHLER Edelstahl GmbH & Co KG
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Abteilung/Department EWW/C		Wärmebehandlungsprotokoll heat treating report			
Fa./Los Nr.: works order: 1880856 / 01-0 - 18		Gewicht: / weight: 695 kg		Charge: / heat no.: E11483	
Marke: / material: A903		WBH Sch.: / code: L01		PP/EKK Nr.: _	
Abmessung: / dimension: 0x79 mm					
Vergüteeinlage: continuous heat treating plant: Ofen Nr.: furnace no.: 88		Ofenklasse: furnace class: 3 (+/-8°C)		Ofenqualifizierung lt. AMS2750 letztgültige Rev. furnace qualification per AMS2750 latest rev.:	
Solldaten / nominal values lt. EV2 3600/0021/30/letztgültige Rev. / per production prescription					
Gesamt-Ofenzeit (+/-13%): total time: 6000 Sek.		Ofentemperatur: furnace temperature: 1060 °C			
Wassertemperatur: water temperature: min. 5°C, max. 32°C		Materialhaltezeit: soak time mind.30	Polymer Temperatur: polymer temperature: min. __°C, max. __°C		
Abkühlmedium: quenching medium: Ablöschen (water)		Luftgebläse (+/-10%): ventilator: _ Sek.		Tauchzeit (+/-25%): immersion time: 1400 Sek.	
Istdaten / process data					
Auflage Nr.: / lot no.: 9245					
Materialeintritt: / material entrance time: 25.02.2020 23:55:25		gesamte Ofenzeit: total time: 6015 Sek.		Materialaustritt: / exit time: 26.02.2020 01:35:40	
Polymertemp. Eintritt/Entrance: _ °C polymer temp. Austritt/exit: _ °C		Luftgebläse: _ Sek.		Eintr.: - Austr.: -	
Abkühlbecken/Quench tank: WB - 88		Wassertemp.: Eintritt/Entrance: 19 °C 26.02.2020 01:35:49 water temp.: Austritt/exit: 19 °C 26.02.2020 01:59:12		Tauchzeit: 1403 Sek.	
Die Richtigkeit der durchgeführten Wärmebehandlung wird bestätigt: The correctness of the conducted heat treatment is confirmed: Die Prozessdaten werden statistisch ausgewertet process data are statistically evaluated Datum: 27.02.20 date: Unterschrift: signature:					

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UT		PRÜFBERICHT REPORT PROCES-VERBAL TYPE C		Besteller Purchaser Client: CDN VOESTALPINE HIGH PERFORMA 1907		Werks Auftrag Working Order Commande interne: 2257511 (FA 1650855/1/0)		Pos. tem. Repère: 1			
Nr./No./No: 38-0144-2020		Bestell-Nr. Order No. No. de commande: 4502954284		Prüfobjekt Test object Pièce contrôlée: Stabstahl / steel bars		Kerzeichnung Identification Heat, Material, Working Order					
Seite Page: 01 von of sur: 01		Stückzahl Quantity Quantité: 1 Stk.		Schmelze-Nr. Heat No. No. de coulée: E11483							
Abmessung Dimension Dimensions: RD 76,2 mm		Werkstoff Material Matériau: A903		Fertigungsstufe Stage of production Etat d'avancement de fabrication: Lieferzustand / delivery condition							
Oberflächenzust. Surface cond. Etat de surface: geschält+poliert / peeled+polished		Gewicht Weight Poids: 563 kg		Wärmebehandlung Heat treatment Traitement thermique: lösungsgeglüht / solution annealed							
Prüfbereich Inspection area Pièce à essai: Gesamte Stablänge / whole length		Prüfverfahren Inspection specification Spécification de contrôle: API 6A PSL3 - 21st Edition ASTM A 388-19		Prüfung Inspection coverage Etendue du contrôle: siehe Skizze / see sketch							
Beurteilungsstandard Evaluation standard Critères d'acceptation: It. acc. to API 6A PSL3 - ASTM A 388-19		ZFP-Arbeitsvorschrift NDT procedure Procédure FND: AV2/36/5125/74 Rev. 01 + Scan Plan API 6A PS_3 -PAT-Rund-WP Rev. 02		Zeichnungs-Nr., Schmelze-Nr., oder Ersatz-Nr. Drawing No., forging No., or rolling No. No. de plan, No. de forgeage ou No. de laminage: 0442							
EKK (FF / WP) Nr. Traveler (FF / WP) No. No. de fiche suivante		Registrierung Recording level Segni d'anregistrement: It. acc. to API 6A PSL3 + ASTM A 388-19		Schritt / Prüf-Nr. Step / Test no. No. d'opération							
Skizze Sketch Esquisse											
Prüfer-Nr. Equipment No. Appareil No.: ROWA B65/120 PAT 719260		Kopie mittel Couplant Produit de coulage: Wasser / water		Justierung Adjustment Ajustage: DAC							
Justerkörper Testblock Bloc d'étalonnage: Nr. 132E		Referenzreflektor Reference reflector Reflecteur de référence: ø 1,19 mm FBH (-16,1 dB = 3 mm FBH)		S/N-Abstand Signal to noise distance Rapport signal sur bruit: > 6 dB							
Transferkorrektur (weitere Korr.) Transfer correction (further corr.) Correcteur de transfert (correction additionnelle): < 2 dB											
Einstrahl-Pos. Position of incidence Direction of incidence	Prüfkopf Probe Pouteur	Frequenz Frequency MHz/Mc	Einstrahlwinkel Angle of incidence Ang e d'incidence	Schalllaufweg Sound path Forcours du son mm	Schallschw. Sound att. Attenuation du son dB,m	Anzeigentiefe Indication depth Profondeur de l'indication mm	Anzeigenlänge Indication length Longueur de l'indication mm	RSE-Wert OSR value Reflecteur d'essai de référence	dB zu Referenz dB to reference dB à la référence	Echoform Type of echo Type d'écho	RWE-Abfall Loss of BWE dB Appareil de l'Echo de fond dB
A	5MHz/224EU-R120mmCCV/90DEG	5	0°	76,2	< 2	keine registrierpflichtigen Anzeigen no indications above recording level					---
Prüfergebnis Test result: Résultat: <input checked="" type="checkbox"/> Entspricht <input type="checkbox"/> nicht der Vorschrift		Datum Date: 11.03.2020		Prüfer / Stufe Operator / Level Opérateur / Niveau de qualification: Kapfenberg, Abt. / Dep. EWV/F		Prüfer / Stufe Operator / Level Opérateur / Niveau de qualification: Broidler H. LI		Datum Date: 11.03.2020		Prüfer / Stufe Operator / Level Opérateur / Niveau de qualification: Eberl G. LI	
Kunde Customer Client:		Autorisierter / Sachverständiger Authorized inspector Agent de l'organisme de contrôle:		Prüferantwortlicher / Stufe Supervisor / Level Responsable de contrôle / Niveau de qualification: ISO 9712		Prüferantwortlicher / Stufe Supervisor / Level Responsable de contrôle / Niveau de qualification: ISO 9712					

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Akkreditierte Konformitätsbewertungsstelle nach EN ISO/IEC 17024
Accredited Conformity assessment body to EN ISO/IEC 17024
Organisme de évaluation de la conformité a la EN ISO/IEC 17024
Identifikationsnummer: 909
ANERKANNTE UNABHÄNGIGE PRÜFSTELLE
gemäß Art. 13 Druckgeräterichtlinie 97/23/EG



CERTIFICATE ZERTIFIKAT CERTIFICAT

Hiermit zertifizieren wir die Kompetenz
We hereby certify the competence *Nous certifions la compétence*

Herrn Hermann Breidler

geboren am 31.03.1976
date of birth
né (e) le

Register Nr. 01/26968/2/01516
Registration N°
N° d'immatriculation

für/for/pour

Prüfverfahren und Stufe
NDT method and level
Méthode contrôle et niveau

Ultraschallprüfung UT Stufe 2 (zwei)

Industrie-*/Produktsektoren**
Industrial-/Product sectors***
Secteurs industriels-/produits***

Herstellung

nach den Normen
based on the Standards
en selon des normes

ÖNORMEN: EN ISO 9712, M 3042, M 3041

Gültigkeit der Zertifizierung
Validity of the certification *Validité de la certification*


06.10.2015 bis 05.10.2020

Österreichische Gesellschaft für Zerstörungsfreie Prüfung
Austrian Society for Nondestructive Testing *Association d'Autriche des Essais Non Destructifs*


A 1015 Wien, 31.08.2015

für den Zentralen Programmausschuss der Zertifizierungsstelle
for the Steering Committee of the Certifying Body
Comité de Direction de l'organisme de certification

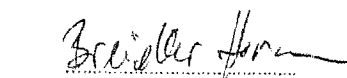
für die Zertifizierungsstelle
for the Certifying Body
pour l'organisme de certification


der Präsident
the president le président
Dipl.-Ing. Dr. Stefan Haas




der Prüfungsbeauftragte
the examiner l'examinateur
Dipl.-Ing.(FH) G. Idinger (0238)

- * Herstellung (enthält c, f, i, v, wp)
Dienstleistungsprüfung bei Fertigung und Instandhaltung,
eingeschlossen Herstellung (enthält c, f, v, i, wp, u.a)
Eisenbahn-Instandhaltung (enthält c, f, v, wp, u.a)
Luft- und Raumfahrt (enthält c, f, v, i, wp, p, u.a)
** Produktsektoren gemäß ÖNORM EN ISO 9712


Unterschrift des Inhabers
Signature of holder *Signature du titulaire*

Der Zertifikatsinhaber verpflichtet sich zur Einhaltung der Ethischen Regeln (RÖIZ 760/Rev.04)
Jede missbräuchliche Verwendung dieses Zertifikates und inkorrekte Hinweise darauf werden gesetzlich geahndet
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REF No P 043654 : Issue 1
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Ord No 105/320208/C3.03.2020
Date Tested 13/03/20
Date Reported 13/03/20
Date Received 12/03/20

- Item - SPECIMEN ID: 51, FERRITE CONTENT
LISA ORDER No: 20A19755, POSITION: QA
TESTING PROCEDURE: TP-FGM-0001-00
HEAT NUMBER: E11483, FA Number: 1880856/1/0
- Specification - ASTM E562-19

Micro Examination - ASTM E562-19			
	Position	Details	Comments
001:Ferrite Count	QA	N/A	VOLUME FERRITE PHASE COUNT = 52.00%. SEE APPX

Certificate Comments

----- End of Text -----

Tested by Element Pilsen s.r.o.



Testing laboratory No. 1685, accredited by Czech Accreditation Institute to CSN EN ISO/IEC 17025:2005.
Registered Office: Element Materials Technology Pilsen s.r.o., Podnikatelska 39, 301 00, Pilsen, Czech Republic. IC: 25235540, DIČ: CZ25235540
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TEST CERTIFICATE

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REF No P 043661 : Issue 1
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Ord No 105/320208/03.03.2020
Date Tested 13/03/20
Date Reported 13/03/20
Date Received 12/03/20

Item - SPECIMEN ID: 51, FERRITE CONTENT
LISA ORDER No: 20A19755 , POSITION: Q2
TESTING PROCEDURE: TP-FGM-0001-00
HEAT NUMBER: E11483, FA Number: 1880856/1/0

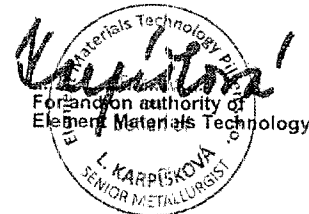
Specification - ASTM E562-19

Micro Examination - ASTM E562-19			
	Position	Details	Comments
001:Ferrite Count	Q2	N/A	VOLUME FERRITE PHASE COUNT = 52.10%. SEE APPX

Certificate Comments

----- End of Text -----

Tested by Element Pilsen s.r.o.



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