MBH ANALYTICAL LTD

HOLLAND HOUSE • QUEENS ROAD • BARNET • EN5 4DJ • ENGLAND • TEL: +44 (0)20 8441 2024 • FAX: +44 (0)20 8449 0810
email: info@mbh.co.uk web: www.mbh.co.uk

CERTIFICATE OF ANALYSIS

215X HB1 (batch P)

Certified Reference Material Information

Type:	NICKEL HASTELLOY B-TYPE (CHILL CAST)
Form and Size:	Disc ~40mm diameter
Manufactured by:	Polycast Ltd
Certified and Supplied by:	MBH Analytical Ltd

Assigned Values

Percentage element by weight

Element	C	Si	S	P	Mn	Fe	Cr
Value [1]	**0.0422**	**0.150**	**0.0506**	**0.0056**	**0.697**	**5.78**	**1.090**
Uncertainty [2]	0.0013	0.005	0.0015	0.0006	0.008	0.03	0.009

Element	Cu	Mo	Co	Nb	V	N	Ni
Value [1]	**0.0718**	**33.04**	**0.252**	**0.203**	**0.504**	**0.0156**	**58.00**
Uncertainty [2]	0.0009	0.14	0.003	0.005	0.006	0.0005	0.12

Definitions

[1] The certified values are the present best estimates of the true content for each element. Each value is a panel consensus, based on the averaged results of an interlaboratory testing programme, detailed on page 3.

[2] The uncertainty values are generated from the 95% confidence interval derived from the wet analysis results, in combination with a statistical assessment of the homogeneity data, as described on page 2.

Certified by:

on 14th September 2015

MBH ANALYTICAL LIMITED _____

C Eveleigh

Method of Preparation

This reference material was produced from commercial-purity metals, and master alloys. The discs are the product of one melt poured into a sequence of multiple chill moulds with feeding systems designed to ensure sound discs. Approximately 2mm has been removed from the cast faces of the discs to minimise surface effects.

Sampling

Samples for chemical analysis were taken from various positions throughout the casting process. At least 15% of all discs were selected for non-destructive homogeneity testing.

Homogeneity

The discs were checked for sample and batch uniformity using an optical emission spectrometer.

Using the meaned data from each surface, standard deviation values were derived for each element as an indicator of any non-homogeneity (as determined for the specific sample size taken by the spectrometer).

Chemical Analysis

Analysis was carried out on millings taken from samples representative of the product. It was performed by a panel of laboratories mostly operating within the terms of EN ISO/IEC 17025 - 2005, using documented standard reference methods and validated by appropriate reference materials.

The individual values listed overpage are the average of each analyst's results.

Estimation of Uncertainties

Each element certified has been analysed by several laboratories, and 95% half-width confidence intervals ($C_{(95\%)}$) for the resultant mean values have been derived by the method shown on page 3.

As a separate exercise, the degree of non-homogeneity of the batch for each element has been quantified by a programme of non-destructive application testing, described above.

The final certified uncertainty for each element has been derived by combining these two factors, using the square-root of the summed squares.

Traceability

Much of the analytical work performed to assess this material has been carried out by laboratories with proven competence, as indicated by their accreditation to ISO 17025. It is an implicit requirement for this accreditation that analytical work should be performed with due traceability, via an unbroken chain of comparisons, each with stated uncertainty, to primary standards such as the mole, or to nationally- or internationally-recognised reference materials. In addition, some of the results derived as part of this testing programme have traceability to NIST standards, as part of the analytical calibration or process control.

Usage

Intended use:	With optical emission and X-ray fluorescence spectrometers.
Recommended method of use:	Nickel-base alloys are generally prepared by linishing, milling, turning or polishing. However, users are recommended to follow the calibration and sample preparation procedures specified by the relevant instrument manufacturer. Preparation should be the same for reference materials and the samples for test. A minimum of five consistent replicate analyses is recommended to provide the necessary sample size. Users are advised to check against possible bias between reference materials and production samples due to differences in metallurgical history, and be aware of possible inter-element effects.

Analytical Data

Percentage element by weight

Sample	C	Si	S	P	Mn	Fe	Cr
1	0.0397	0.140	0.0470	0.0043	0.684	5.729	1.067
2	0.0400	0.145	0.0481	0.0046	0.690	5.742	1.077
3	0.0406	0.147	0.0484	0.0050	0.695	5.753	1.077
4	0.0410	0.147	0.0492	0.0050	0.696	5.758	1.077
5	0.0415	0.152	0.0495	0.0054	0.697	5.760	1.078
6	0.0420	0.154	0.0496	0.0054	0.698	5.770	1.080
7	0.0423	0.154	0.0497	0.0060	0.699	5.795	1.080
8	0.0425	0.161	0.0504	0.0060	0.699	5.797	1.084
9	0.0426		0.0505	0.0062	0.700	5.798	1.099
10	0.0445		0.0520	0.0065	0.701	5.817	1.101
11	0.0449		0.0521	0.0074	0.706	5.819	1.102
12	0.0452		0.0532			5.825	1.104
13			0.0538			5.831	1.107
14			0.0550				1.120
Mean	**0.0422**	**0.150**	**0.0506**	**0.0056**	**0.697**	**5.784**	**1.090**
Std Dev	0.0018	0.007	0.0023	0.0009	0.006	0.034	0.015
C (95%)	0.0012	0.005	0.0013	0.0006	0.004	0.021	0.009

Sample	Cu	Mo	Co	Nb	V	N	Ni
1	0.0695	32.82	0.244	0.193	0.488	0.0147	57.75
2	0.0700	32.86	0.246	0.195	0.496	0.0149	57.87
3	0.0700	32.95	0.246	0.197	0.496	0.0150	57.92
4	0.0707	32.98	0.248	0.199	0.497	0.0150	58.00
5	0.0710	32.98	0.250	0.204	0.497	0.0155	58.00
6	0.0712	33.02	0.250	0.205	0.498	0.0158	58.05
7	0.0719	33.20	0.252	0.207	0.500	0.0160	58.05
8	0.0723	33.21	0.252	0.208	0.503	0.0160	58.11
9	0.0724	33.32	0.253	0.211	0.507	0.0167	58.21
10	0.0727		0.255	0.211	0.512	0.0168	
11	0.0728		0.256		0.519		
12	0.0740		0.258		0.520		
13	0.0745		0.260		0.521		
Mean	**0.0718**	**33.04**	**0.252**	**0.203**	**0.504**	**0.0156**	**58.00**
Std Dev	0.0015	0.17	0.005	0.007	0.011	0.0007	0.14
C (95%)	0.0009	0.13	0.003	0.005	0.006	0.0005	0.10

Note: $C_{(95\%)}$ is the 95% half-width confidence interval derived from the equation:

$$C_{(95\%)} = (t \times SD)/\sqrt{n}$$

where n is the number of available values, t is the Student's t value for n-1 degrees of freedom, and SD is the standard deviation of the test results.

Participating Laboratories

Exova Ltd	Middlesbrough, England	UKAS accreditation 0239
Sheffield Assay Office	Sheffield, England	UKAS accreditation 0012
Birmingham Assay Office	Birmingham, England	UKAS accreditation 0667
Metals Technology (Testing) Ltd	Sheffield, England	UKAS accreditation 0963
Genitest, Inc	Montreal, Canada	PRI accreditation 123077
Shanghai Jinyi Test Technology Co	Shanghai, China	CNAL accreditation 0783
Shandong Metallurgical & Science Research	Jinan, Shandong, China	CNAS accreditation 1461
Bureau Veritas CPS Pvt Ltd	Chennai, India	NABL accreditation 0025
TCR Engineering Services Ltd	Mumbai, India	NABL accreditation 0367
Raghavendra Spectrometallurgical Lab.	Bangalore, India	NABL accreditation 0371
Instytut Metalurgii Zelaza	Gliwice, Poland	PCA accreditation AB554
Tec-Eurolab	Campogalliano, Italy	ACCREDIA accreditation 52
PT Geoservices Ltd	Cikarang, Indonesia	
London & Scandinavian Met Co Ltd	Rotherham, England	
Coleshill Laboratories Ltd	Birmingham, England	
Analyticka Laborator Lithea sro	Brno, Czech Republic	

Note: to achieve the above accreditation (eg UKAS, etc), test houses are required to demonstrate conformity to the general requirements of EN ISO/IEC 17025.

Analytical Methods Used

ELEMENT	RESULT No. & METHOD			
	ICP-AES	FAAS	OTHER	
Carbon	-	-	all	combustion (IR or volumetric detection)
Silicon	2, 5-7	-	1, 4	photometric (molybdenum blue)
			3, 8	gravimetric (perchloric acid)
Sulfur	1, 8	-	2-7, 9-14	combustion (IR or volumetric detection)
Phosphorus	1, 4-6, 8-10	-	2, 7	volumetric (alkalimetric)
			3, 11	photometric (molybdenum blue)
Manganese	3-5, 7-11	2	1	volumetric (arsenite)
			6	photometric (periodate)
Iron	3-5, 7-13	1, 6	2	volumetric (dichromate)
Chromium	1-4, 8-11, 13	6, 7	5, 12	volumetric (ferrous ammonium sulfate)
			14	photometric (diphenyl carbazide)
Copper	3-9, 11-13	2, 10	1	photometric (BCO)
Molybdenum	1, 2, 6, 8, 9	-	3-5	gravimetric (α-benzoin oxime)
			7	photometric (thiocyanate)
Cobalt	1, 3-5, 8, 9, 11-13	2, 10	6	photometric (nitroso-R)
			7	volumetric (iodine)
Niobium	1, 2, 4-9	-	3	photometric (chlorosulfophenol)
			10	ICP-MS
Vanadium	1, 3-6, 8-12	2, 7	13	volumetric (ferrous ammonium sulfate)
Nitrogen	-	-	1-4, 8-10	inert gas fusion (thermal conductivity)
			5, 7	volumetric (hydrochloric acid)
			6	photometric (Nessler's reagent)
Nickel	1, 5, 7	9	2, 6	gravimetric (dimethyl glyoxime)
			3, 4	photometric (dimethyl glyoxime)
			8	volumetric (diethyl glyoxime/EDTA)

Notes

This Certified Reference Material has been produced and certified, wherever possible, in accordance with the requirements of ISO Guide 34-2009, ISO Guide 31-2015 and ISO Guide 35-2006, taking into account the requirements of the ISO Guide to the Expression of Uncertainty in Measurement (GUM).

The unidirectional solidification effects associated with chill casting have led to the formation of inhomogeneous segregates in the rear portion of the disc. However, testing has shown that the above certification is applicable from the front face of the disc to a depth of 12mm. Material to the rear of the disc, to a depth of ~3mm, is not certified.

This material will remain stable provided adequate precautions are taken to protect it from cross-contamination, extremes of temperature and atmospheric moisture. All production records will be retained for a period of 20 years from the date of this certificate. Technical support for this certification will therefore expire in September 2035, although we reserve the right to make changes as issue revisions, in the intervening period.

The manufacture, analysis and certification of this product were supervised by C Eveleigh, PhD, Technical Director, MBH Analytical Ltd.

The material to which this certificate of analysis refers is supplied subject to our general conditions of sale.