

CERTIFICATE OF ANALYSIS**28X 6253 (batch S)****Certified Reference Material Information**

Type: NICKEL INCONEL 625-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	Cu	Fe	Nb
Value ¹	0.129	1.15	0.0143	0.0211	0.501	0.298	5.57	4.31
Uncertainty ²	0.002	0.03	0.0008	0.0014	0.005	0.003	0.04	0.03

Element	Cr	Mo	Co	Ti	Ta	Ni	N
Value ¹	21.96	8.98	0.420	0.085	0.041	56.25	0.083
Uncertainty ²	0.10	0.06	0.004	0.004	0.003	0.09	0.002

Note: values given in parentheses are not certified - they are provided for information only.

Definitions

- ¹ The above 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:

MBH ANALYTICAL LIMITED _____

on 7th November 2016

C Eveleigh



Method of Preparation

This reference material was produced from commercial-purity nickel, 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, discussed 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 finishing, 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.

For OES, 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	Cu	Fe	Nb
1	0.125	1.096	0.0120	0.0197	0.494	0.291	5.502	4.261
2	0.125	1.105	0.0120	0.0198	0.496	0.293	5.517	4.264
3	0.127	1.106	0.0133	0.0200	0.496	0.294	5.557	4.267
4	0.127	1.117	0.0136	0.0200	0.500	0.295	5.560	4.268
5	0.128	1.138	0.0140	0.0204	0.502	0.297	5.597	4.280
6	0.128	1.140	0.0141	0.0205	0.504	0.298	5.606	4.301
7	0.129	1.160	0.0144	0.0210	0.505	0.299	5.618	4.313
8	0.131	1.179	0.0145	0.0212	0.505	0.302	5.619	4.322
9	0.131	1.181	0.0148	0.0219	0.510	0.304		4.333
10	0.132	1.191	0.0152	0.0236		0.305		4.349
11	0.132	1.217	0.0153	0.0237		0.305		4.361
12	0.133	1.229	0.0157					4.366
13	0.133		0.0158					
14			0.0159					
Mean	0.129	1.154	0.0143	0.0211	0.501	0.298	5.572	4.307
Std Dev	0.003	0.045	0.0013	0.0014	0.005	0.005	0.045	0.039
C_(95%)	0.002	0.029	0.0007	0.0010	0.004	0.003	0.038	0.025

Sample	Cr	Mo	Co	Ti	Ta	Ni	N
1	21.80	8.880	0.406	0.0798	0.0360	56.17	0.0784
2	21.84	8.895	0.414	0.0815	0.0375	56.18	0.0796
3	21.84	8.897	0.419	0.0822	0.0384	56.20	0.0813
4	21.85	8.945	0.419	0.0823	0.0409	56.22	0.0818
5	21.87	8.970	0.420	0.0830	0.0436	56.22	0.0831
6	21.90	8.980	0.421	0.0855	0.0442	56.23	0.0834
7	21.91	8.986	0.421	0.0885	0.0443	56.28	0.0839
8	21.97	8.990	0.421	0.0903	0.0457	56.28	0.0847
9	21.98	8.996	0.422	0.0925		56.34	0.0850
10	22.15	9.012	0.428			56.39	0.0862
11	22.18	9.059	0.432				0.0886
12	22.22	9.073					
13		9.081					
Mean	21.96	8.982	0.420	0.0851	0.0413	56.25	0.0833
Std Dev	0.15	0.066	0.007	0.0044	0.0036	0.07	0.0030
C_(95%)	0.09	0.040	0.004	0.0034	0.0030	0.05	0.0020

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
Metals Technology (Testing) Ltd	Sheffield, England	UKAS accreditation 0963
Laboratory Testing, Inc	Hatfield, PA, USA	A2LA accreditation 0117
Shanghai Jinyi Test Tech Co	Shanghai, China	CNAS accreditation L0041
Shandong Metallurgical & Science Research	Jinan, Shandong, China	CNAS accreditation 1461
Bureau Veritas CPS Pvt	Chennai, India	NABL accreditation 0025
Raghavendra SpectroMet Laboratory	Bangalore, India	NABL accreditation T371
Genitest Inc	Montreal, Canada	PRI accreditation 123077
Tec-Eurolab	Campogalliano, Italy	ACCREDIA accreditation 52
Instytut Metalurgii Zelaza	Gliwice, Poland	PCA accreditation AB554
London & Scandinavian Met Co	Rotherham, England	
Coleshill Laboratories Ltd	Birmingham, England	
Lithea sro	Brno, Czech Republic	
Mineral & Metallurgical Laboratories	Bangalore, India	

Note: to achieve the above accreditation (UKAS, NATA, 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, 9, 11, 12	-	1, 3, 6, 8, 10 gravimetric (perchloric acid) 4 photometric (molybdenum blue)
Sulfur	8, 14	-	1-7, 9-13 combustion (IR or volumetric detection)
Phosphorus	2-5, 7-11	-	1, 6 volumetric (alkalimetric)
Manganese	1-3, 3-6, 8, 9	2	1, 7 volumetric (arsenite)
Copper	1-4, 6-11	5	
Iron	1-4, 8	-	5-7 volumetric (dichromate)
Niobium	1-3, 5, 8-12	-	4 ICP-MS 6 photometric (chlorosulfophenol) 7 gravimetric (cupferron)
Chromium	1, 2, 6, 10, 11	-	3-5, 7-9, 12 volumetric (ferrous ammonium sulfate)
Molybdenum	1-3, 6, 8, 9, 11-13	5	4, 10 photometric (thiocyanate) 7 gravimetric (α benzoin oxime)
Cobalt	1, 3, 4, 6-11	5	2 volumetric (iodine)
Titanium	1-4, 6-9	-	5 photometric (DAP)
Tantalum	1-5, 7, 8	-	6 ICP-MS
Nickel	1, 3-5	-	2 photometric (dimethyl glyoxime) 6-10 gravimetric (dimethyl glyoxime)
Nitrogen	1	-	1, 3, 5, 8-11 inert gas fusion (thermal conductivity) 2, 4, 7 volumetric (hydrochloric acid) 6 photometric (Nessler's reagent)

Notes

This Certified Reference Material has been produced and certified in accordance with the requirements of ISO Guide 34-2009, ISO Guide 31-2000 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 sample also contains approximately 0.08% of aluminium.

This material will remain stable indefinitely, 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 November 2036 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.