

# CERTIFICATE OF ANALYSIS

**32X ALB11 (batch A)**

## Certified Reference Material Information

Type: ALUMINIUM BRONZE (CHILL CAST)  
Form and Size: Disc 40mm Diameter x ~15mm Thickness  
Manufactured by: Polycast Ltd  
Certified and Supplied by: MBH Analytical Ltd

## Assigned Values

### Percentage element by weight

Element	Sn	Pb	Zn	Fe	Ni	Al	Si	Mn
Value <sup>1</sup>	0.0289	0.118	0.576	3.81	4.33	8.80	0.069	1.13
Uncertainty <sup>2</sup>	0.0013	0.002	0.010	0.03	0.03	0.04	0.005	0.02

Element	Co	P	Mg	Be	Sb	Bi	Se	Cu
Value <sup>1</sup>	0.089	0.045	0.075	0.0194	0.093	0.120	0.006	80.58
Uncertainty <sup>2</sup>	0.003	0.002	0.003	0.0004	0.003	0.003	0.001	0.10

## Definitions

- <sup>1</sup> 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.
- <sup>2</sup> 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 31<sup>st</sup> August 2009

C Eveleigh



## **Method of Preparation**

This reference material was produced from commercial-purity metals, binaries 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. One disc was checked for vertical uniformity using the same method.

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: Copper alloys are generally prepared by machining on a mill or a lathe. 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	Sn	Pb	Zn	Fe	Ni	Al	Si	Mn
1	0.0263	0.115	0.551	3.751	4.286	8.709	0.0637	1.080
2	0.0263	0.115	0.556	3.763	4.288	8.722	0.0640	1.098
3	0.0275	0.115	0.562	3.790	4.288	8.743	0.0644	1.103
4	0.0284	0.116	0.566	3.800	4.291	8.772	0.066	1.116
5	0.0291	0.116	0.568	3.80	4.292	8.78	0.068	1.127
6	0.0294	0.117	0.573	3.814	4.303	8.780	0.0700	1.133
7	0.0297	0.118	0.582	3.820	4.314	8.782	0.0714	1.146
8	0.0303	0.118	0.582	3.825	4.345	8.802	0.0723	1.15
9	0.0305	0.119	0.588	3.839	4.35	8.806	0.0743	1.155
10	0.0317	0.120	0.590	3.840	4.356	8.82	0.0744	1.158
11		0.120	0.590	3.851	4.361	8.85		1.164
12		0.123	0.601	3.880	4.390	8.888		1.176
13					4.396	8.910		
14					4.428			
<b>Mean</b>	<b>0.0289</b>	<b>0.118</b>	<b>0.576</b>	<b>3.81</b>	<b>4.33</b>	<b>8.80</b>	<b>0.069</b>	<b>1.134</b>
<b>Std Dev</b>	0.0018	0.002	0.015	0.04	0.05	0.06	0.004	0.030
<b>C<sub>(95%)</sub></b>	0.0013	0.002	0.010	0.02	0.03	0.04	0.003	0.019

Sample	Co	P	Mg	Be	Sb	Bi	Se	Cu
1	0.0852	0.0400	0.067	0.0180	0.0856	0.112	0.0047	80.46
2	0.0853	0.0431	0.0674	0.0185	0.0872	0.114	0.0047	80.52
3	0.0855	0.0432	0.070	0.0189	0.0886	0.115	0.0050	80.56
4	0.0864	0.0443	0.0720	0.0191	0.0896	0.120	0.005	80.61
5	0.0872	0.0448	0.0736	0.0192	0.0917	0.120	0.0055	80.62
6	0.0873	0.0455	0.0749	0.0195	0.0922	0.121	0.0056	80.65
7	0.0883	0.0461	0.0759	0.0197	0.0940	0.121	0.0061	80.65
8	0.0908	0.0477	0.0761	0.0199	0.0945	0.122	0.0065	
9	0.0913	0.0480	0.0765	0.0200	0.0988	0.124	0.0068	
10	0.0929	0.0490	0.0787	0.020	0.0991	0.124	0.0074	
11	0.0942		0.0814	0.020	0.0994	0.125		
12	0.0946		0.0845	0.0201				
<b>Mean</b>	<b>0.089</b>	<b>0.0452</b>	<b>0.075</b>	<b>0.0194</b>	<b>0.093</b>	<b>0.120</b>	<b>0.0057</b>	<b>80.58</b>
<b>Std Dev</b>	0.004	0.0027	0.005	0.0007	0.005	0.004	0.0009	0.07
<b>C<sub>(95%)</sub></b>	0.002	0.0019	0.003	0.0004	0.003	0.003	0.0007	0.07

Note: C<sub>(95%)</sub> 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

Bodycote Materials Testing  
Sheffield Assay Office  
Universal Scientific Laboratory Pty Ltd  
Genitest, Inc  
Institute of Iron & Steel Technology  
Luo Yang Copper  
Sargam Metals Pvt Ltd  
TCR Engineering Services Ltd  
Raghavendra Spectromet Laboratory  
Institute of Non-Ferrous Metals  
London & Scandinavian Met Co  
Colonial Metals Co  
De Bruyn Spectroscopic Solutions Ltd  
Coleshill Laboratories Ltd

Middlesbrough, England  
Sheffield, England  
Milperra, NSW, Australia  
Montreal, Canada  
Shanghai, China  
Luo Yang, He Nan, China  
Chennai, India  
Mumbai, India  
Bangalore, India  
Gliwice, Poland  
Rotherham, England  
Columbia, PA, USA  
Johannesburg, South Africa  
Birmingham, England

UKAS accreditation 0239  
UKAS accreditation 0012  
NATA accreditation 0492  
PRI accreditation 123077  
CNAL accreditation 0783  
CNAL accreditation 0173  
NABL accreditation 0025  
NABL accreditation 0367  
NABL accreditation 0371  
PCA accreditation AB274

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

## Analytical Methods Used

ELEMENT	RESULT No. & METHOD		
	ICP-AES	FAAS	OTHER
Tin	3, 4, 6-10	1, 5	2 photometric (phenyl fluorone)
Lead	4-6, 9, 11, 12	3, 7, 8, 10	1, 2 volumetric (EDTA)
Zinc	2, 5-7, 9-12	1, 3, 4, 8	
Iron	1, 3, 4, 6, 7, 9-11	2, 5, 8	12 volumetric (dichromate)
Nickel	1-5, 13, 14	8, 9, 11, 12	6 volumetric (EDTA/dimethyl glyoxime)
Aluminium	1-5, 12, 13	7, 8	7, 10 gravimetric (dimethyl glyoxime)
			6 gravimetric (oxide)
			9 photometric (chrome azurol S)
			10 volumetric (EDTA)
			11 XRF
Silicon	1, 3, 4, 6, 9	-	2 ICP-MS
Manganese	2-6, 9, 11	1, 7, 8, 10	5, 7, 8, 10 photometric (molybdenum blue)
Cobalt	1-3, 6, 7, 10-12	4, 5, 8, 9	12 photometric (periodate)
Phosphorus	1-3, 5, 8-10	-	4 volumetric (alkalimetric)
Magnesium	1-3, 6, 7, 10-12	4, 5, 8, 9	6, 7 photometric (molybdenum yellow)
Beryllium	1, 3-5, 7-12	2, 6	
Antimony	1-3, 7-9, 11	4-6, 10	
Bismuth	1-3, 5-7, 11	4, 8-10	
Selenium	2-5, 7-10	1, 6	
Copper	7	-	1, 2, 4 electrogravimetric
			3, 5, 6 volumetric (thiosulfate)

## Notes

This Certified Reference Material has been produced and certified in accordance with the requirements of ISO Guide 34-2000, 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 semi-chill casting have led to the formation of inhomogeneous segregates in the rear portion of the disc. The above certification is therefore only 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 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. This certification will therefore expire in August 2029, although we reserve the right to make changes as issue revisions, in the intervening period.

This material is also available in the form of chippings.

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.