

CERTIFICATE OF ANALYSIS

57X AlCu28 (batch A)

Reference Material Information

| | |
|----------------------------|-------------------------------|
| Type: | ALUMINIUM-COPPER ALLOY (CAST) |
| Form and Size: | Disc ~50mm diameter |
| Manufactured by: | MBH Analytical Ltd |
| Certified and Supplied by: | MBH Analytical Ltd |

Assigned Values

Percentage element by weight

| Element | Cu | Si | Fe | Mn | Ni | Mg | Zn | Sn |
|--------------------------|-------|------|------|--------|--------|--------|------|--------|
| Value ¹ | 27.78 | 5.44 | 0.22 | 0.0032 | 0.0030 | 0.0020 | 5.42 | 0.0023 |
| Uncertainty ² | 0.13 | 0.06 | 0.03 | 0.0002 | 0.0003 | 0.0003 | 0.05 | 0.0003 |

Definitions

- ¹ The stated 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 27th January 2014
C Eveleigh



Method of Preparation

This reference material was produced from commercial-purity aluminium. The main alloys and trace elements were added as pure elements or master alloys. The melt was degassed using sodium-free flux, prior to casting by sequential transfer of aliquots into individual iron moulds.

Sampling

Samples for chemical analysis were taken from various positions throughout the casting process. Approximately 10% 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: 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 | Cu | Si | Fe | Mn | Ni | Mg | Zn | Sn |
|--------------------------|--------------|--------------|--------------|---------------|---------------|---------------|--------------|---------------|
| 1 | 27.63 | 5.350 | 0.208 | 0.0026 | 0.0026 | 0.0016 | 5.370 | 0.0018 |
| 2 | 27.64 | 5.397 | 0.215 | 0.0028 | 0.0027 | 0.0018 | 5.382 | 0.0021 |
| 3 | 27.68 | 5.421 | 0.215 | 0.0030 | 0.0029 | 0.0018 | 5.394 | 0.0022 |
| 4 | 27.85 | 5.455 | 0.218 | 0.0030 | 0.0030 | 0.0018 | 5.440 | 0.0022 |
| 5 | 27.86 | 5.468 | 0.220 | 0.0032 | 0.0030 | 0.0020 | 5.457 | 0.0025 |
| 6 | 27.90 | 5.491 | 0.229 | 0.0033 | 0.0031 | 0.0020 | 5.470 | 0.0027 |
| 7 | 27.92 | 5.500 | 0.229 | 0.0033 | 0.0034 | 0.0027 | | 0.0028 |
| 8 | | | 0.230 | 0.0034 | | | | |
| 9 | | | | 0.0036 | | | | |
| 10 | | | | 0.0036 | | | | |
| Mean | 27.78 | 5.440 | 0.221 | 0.0032 | 0.0030 | 0.0020 | 5.419 | 0.0023 |
| Std Dev | 0.13 | 0.054 | 0.008 | 0.0003 | 0.0003 | 0.0004 | 0.042 | 0.0004 |
| C_(95%) | 0.12 | 0.050 | 0.007 | 0.0002 | 0.0002 | 0.0003 | 0.044 | 0.0003 |

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 |
| Universal Scientific Laboratory Pty Ltd | Milperra, NSW, Australia | NATA accreditation 0492 |
| Institute of Iron & Steel Technology | Shanghai, China | CNAL accreditation 0783 |
| Luo Yang Copper | Luo Yang, He Nan, China | CNAL accreditation 0173 |
| South-West Aluminium Group | Jiulong Puo, Sichuan, China | CNAL accreditation T007 |
| Sargam Metals Pvt Ltd | Chennai, India | NABL accreditation 0025 |
| Raghavendra Spectromet Laboratory | Bangalore, India | NABL accreditation 0371 |
| TCR Engineering Services Ltd | Mumbai, India | NABL accreditation 0367 |
| Coleshill Laboratories Ltd | Birmingham, England | |

Note: to achieve the above accreditation (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 |
| Copper | 4 | 2 | 1, 5-7 3 | volumetric (thiosulfate) electrogravimetric |
| Silicon | 6, 7 | - | 1, 3, 5 | photometric (molybdenum blue) |
| Iron | 3, 4, 7, 8 | 2, 6 | 2, 4 | gravimetric (perchloric acid) |
| Manganese | 2, 4-6, 9 | 1, 7, 10 | 1, 5 | photometric (orthophenanthroline) |
| Nickel | 1-4 | 5, 6 | 3, 8 | photometric (period ate) |
| Magnesium | 1, 4-7 | 2, 3 | 7 | volumetric (EDTA) |
| Zinc | 2, 3, 6 | 1, 5 | 4 | volumetric (EDTA) |
| Tin | 2-5, 8 | 1, 6 | 7 | photometric (phenylfluorone) |

Notes

This Reference Material has been produced and certified, wherever possible, 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). However, it has not been granted CRM status.

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 10mm. Material to the rear of the disc, to a depth of ~5mm, 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 January 2034, 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.