

# HEAT TREATMENT CERTIFICATE

Registration No.

**PS8**

Identification

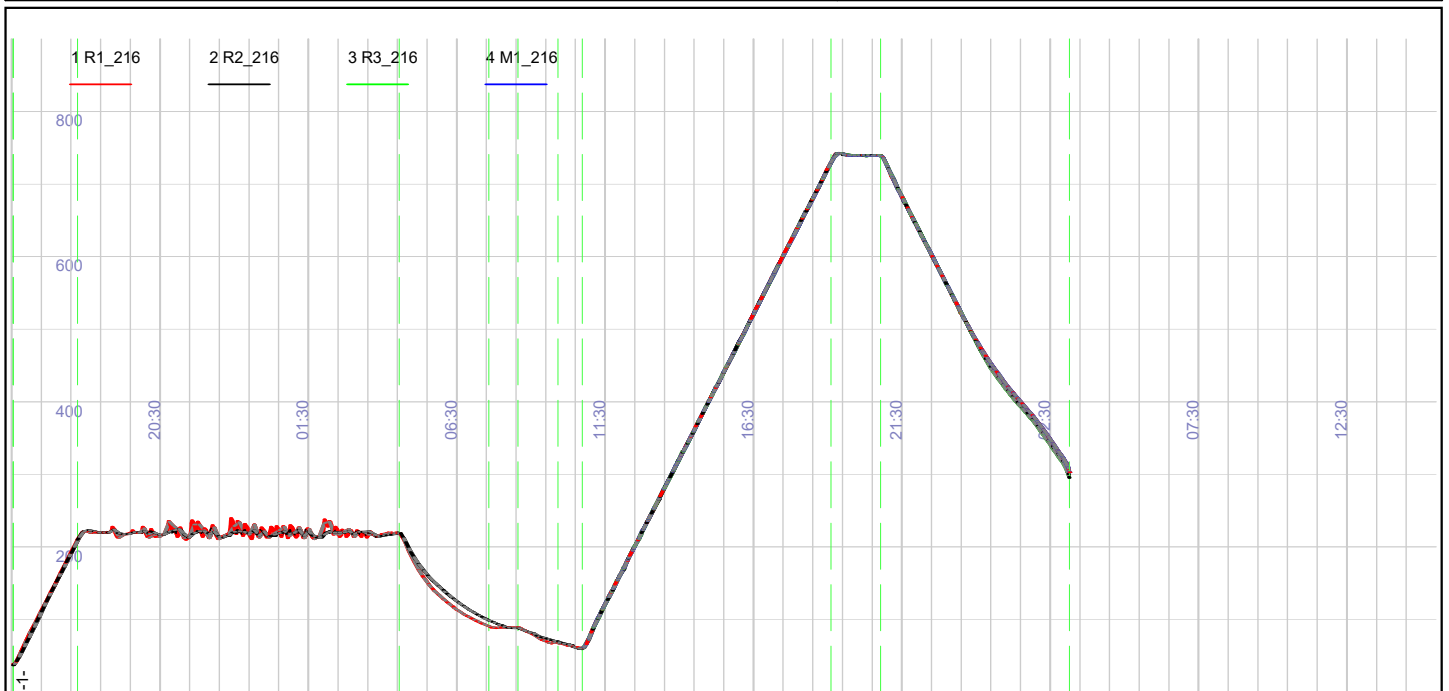
Customer		
Order No.	Order by	Date of Order
·	·	·
Site		
Job No.	Heat Treatment Procedure	Date of Heat Treatment
·	·	22.06.2013 15:33                      24.06.2013 03:09

Item HTS003	Drawing No. DQA 38999	Part No. / Seam No. Pos. 1 Pos. 2	Material ASTMA217 C12A ASTMA387 GR22	Pcs 1
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Type of Heat Treatment	Method of Heat Treatment Odporová
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Consol	ID_216	Controller	216/121	Calib. Date	04.03.13 PG	Sensor	K_TYPE
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Phase	Set Values	Measured Values
1 01 Start	-	38 °C
2 10 Heating	80 °C/h -> 220 °C	79 °C/h -> 210 °C (2h10)
3 20 Holding	220 °C 27h00	220 °C 11h02 (10h51) (210-231 °C)
4 30 Cooling	80 °C/h -> 90 °C	-41 °C/h -> 95 °C (3h00)
5 20 Holding	90 °C 1h00	91 °C 1h31 (1h00) (89-95 °C)
6 30 Cooling	80 °C/h -> 60 °C	-15 °C/h -> 69 °C (1h20)
7 20 Holding	60 °C 2h00	64 °C 0h49 (0h49) (60-69 °C)
8 10 Heating	80 °C/h -> 740 °C	79 °C/h -> 730 °C (8h24)
9 20 Holding	740 °C 1h40	740 °C 1h51 (1h40) (730-743 °C)
10 30 Cooling	80 °C/h -> 300 °C	-69 °C/h -> 299 °C (6h22)
11 60 Finish	-	299 °C



01.02.2016

Stipka