



原材料检验报告

Inspection report of raw material

ZWA(体)-223

型号Type	Ø254mm 817/330.2-01、02					钢种Material	SAE3311					报告日期: Report date	2019.09.07			报告编号: Report No.	190726-003-1.1									
炉号 Heat No.	W1421					来源 Steel factory	铁姆肯钢材上海有限公司 TIMKENSTEEL SHANGHAI Co.,Ltd					执行标准: Standard	GB/T 3203-2016													
交货状态	低倍组织Macrostructure					非金属夹杂物Non-metallic inclusions								碳化物Carbides			显微孔隙 Microcavity	脱碳层 (mm) Decarburization layer depth	退火组织 Microstructure	硬度 (HBW) Hardness	外观质量 Appearance Quality	判定结论 Conclusion				
	中心疏松 Center Porosity	一般疏松 Random Porosity	锭型偏析 Ingot Segregation	中心偏析 Centre Segregation	裂纹 Crack	A		B		C		D		DS	带状 Banding	网状 Network							液析 Eliquation			
标准值 Normal	1	1	1	-	NO	1.5	2.5	0.5	1.5	0	0	0.5	1	2	3	A7	2.5	A10	-	-	-	OK	OK			
实测值 Actual	1	0	0		NO	0	0.5	0	0.5	0	0	0.5	1	0	-	OK	0	OK								
SAE 3311	化学成分(%) Chemical composition(%)															判定结论										
	C	Si	Mn	P	S	Cr	Mo	Ni	Al	Cu	Ti	Pb	Sn													
标准值 Normal	0.10-0.16	0.15-0.35	0.30-0.50	≤0.020	0.005-0.015	1.30-1.60	≤0.15	3.25-3.75	0.012-0.050	≤0.30	≤0.005	≤0.005	≤0.020													
实测值 Actual	0.15	0.27	0.35	0.001	0.01	1.43	0.06	3.63	0.027	0.16	0.0001	0.001	0.001													
	Ca	As	Sb																							
标准值 Normal	≤0.001	≤0.020	≤0.010																							
实测值 Actual	0.0001	0.0001	0.0001																							
检验结论: Ø254.00mm料圆符合GB/T 3203-2016标准要求。 Conclusion: The results for material- Ø254.00mm inspection are fulfilled the requirements of GB/T 3203-2016.																										
检验员 Inspector: 焉举诚					审核 Checked by: 王春雨					批准 Approved by: 杨兴年																

注Remark: 1、本报告仅对送检的试样负责。如有异议, 请在一个月内持本报告来校对。

This report is only responsible for the submission of samples. If you have any questions, please take this report within a month to proofread

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检验报告

Inspection report for final heat treatment

大连光扬轴承制造有限公司

ZWA(体)-228

委托部门 Authorized Dept: 生产 Production	报告编号 Report No.: 190726-003-2
送检品名 Part name: 817/330.2 01/02	送检日期 Submit Date: 2019.10.16
送检目的 Test purpose: 常规 Normal inspect	检验日期 Test date: 2019.10.16
材 质 Material: SAE3311 钢	试样编号 Sample no. : 190726-003

一、来样情况 Sample state:

送套圈试样一块。Cutting sample of one ring.

二、金相检验 Metallographic Examination:

热处理组织检验结果如下 Result as follows:

马氏体组织 2.0 级 (实物见右图) Martensite Grade 2.0

屈氏体 0 级。Troostite Grade 0

网状碳化物 1.0 级. Carbide network Grade 1.0



三、硬度检验 Hardness:

表面硬度 Surface hardness: 61.0-63.0HRC , 心部硬度 Core hardness: 41.0-42.0HRC

硬度 58HRC 距表面 3.10mm; 硬度 52.3HRC 距表面

5.47mm。Hardness 58HRC is got where the distance from surface 3.10mm.

Hardness 52.3HRC is got where the distance from surface 5.47mm

距离 Distance from the surface(mm)	0.5	1.0	1.5	2.0	2.5	3.0	3.5	4.0	4.5	5.0	5.5
硬度 Hardness (HRC)	62.0	61.2	59.5	58.7	58.5	58.1	57.6	56.4	55.8	54.1	52.2

四、脱碳层检验 Decarburization layer:

套圈脱碳层检验结果如下: 脱碳层

0.02mm。五、结论 Conclusion:

该套圈的热处理质量符合 JB/T8881-2011 标准要求。

Final heat treatment quality for the ring conforms to the requirement of standard JB/T8881-2011.

拟制 Inspector: 焉举诚 审核 Checked by: 王春雨 批准 Approved by: 杨兴年



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