

**Brammer Standard Company, Inc.**  
**Certificate of Analysis**

B.S. 68B

**Reference Material for Nitriding 135, AMS 6470 Grade Steel**

	Certified Value <sup>1</sup>	Estimate of Uncertainty <sup>2</sup>		Certified Value <sup>1</sup>	Estimate of Uncertainty <sup>2</sup>
Analysis listed as percent by weight					
<b>C</b>	<b>0.39</b>	0.01	<b>Al</b>	<b>1.08</b>	0.02
<b>Mn</b>	<b>0.52</b>	0.01	<b>Co</b>	<b>0.010</b>	0.001
<b>P</b>	<b>0.010</b>	0.002	<b>N</b>	<b>0.0073</b>	0.0005
<b>S</b>	<b>0.020</b>	0.001	<b>Sn</b>	<b>0.010</b>	0.001
<b>Si</b>	<b>0.26</b>	0.01	<b>Ti</b>	<b>0.005</b>	0.0015
<b>Cu</b>	<b>0.163</b>	0.005	<b>V</b>	<b>0.007</b>	0.0015
<b>Ni</b>	<b>0.165</b>	0.005			
<b>Cr</b>	<b>1.51</b>	0.01			
<b>Mo</b>	<b>0.309</b>	0.007			

<sup>1</sup> The certified value listed is the present best estimate of the true value based on the results of an interlaboratory testing program.

<sup>2</sup> The uncertainties listed are based on value judgments of the material inhomogeneity and possible bias in the determined analytical values. No attempt is made to derive exact statistical measurements of imprecision because several methods were used in the determination of most constituents.

See the following pages for more information.

Replaces Certificate Number REV68B-040892  
**New Certificate Number REV2-68B-012710**

**New Certificate Number REV2-68B-012710 was Revised to show uncertainty values on January 27, 2010**

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Analysis	C	Mn	P	S	Si	Cu	Ni	Cr	Mo
1	0.378	0.507	0.007	0.018	0.252	0.152	0.160	1.490	0.301
2	0.384	0.51	0.008	0.0187	0.255	0.158	0.161	1.49	0.304
3	0.385	0.51	0.008	0.019	0.255	0.160	0.161	1.50	0.304
4	0.388	0.514	0.010	0.019	0.256	0.163	0.161	1.51	0.305
5	0.3895	0.517	0.010	0.0195	0.26	0.163	0.162	1.51	0.310
6	0.391	0.52	0.010	0.020	0.26	0.164	0.163	1.51	0.310
7	0.3917	0.52	0.011	0.020	0.27	0.165	0.166	1.51	0.310
8	0.393	0.53	0.011	0.020	0.27	0.165	0.167	1.51	0.310
9	0.394	0.53	0.011	0.0202	0.28	0.166	0.170	1.514	0.315
10	0.394	0.532		0.0207		0.168	0.172	1.52	0.316
11				0.021		0.17	0.175		0.318
12				0.022					
Average	0.3888	0.519	0.0096	0.0198	0.262	0.1631	0.1653	1.506	0.3094
Std Dev	0.0052	0.009	0.0015	0.0011	0.009	0.0050	0.0051	0.010	0.0055
Certified	0.39*	0.52	0.010	0.020	0.26	0.163	0.165	1.51	0.309
t	2.26	2.26	2.31	2.20	2.31	2.23	2.23	2.26	2.23
C(95%)	0.0037	0.007	0.0012	0.0007	0.007	0.0033	0.0035	0.007	0.0037

continued from above

Analysis	Al	Co	N	Sn	Ti	V
1	1.04	0.008	0.0069	0.008	0.0038	0.0059
2	1.069	0.009	0.0069	0.0089	0.004	0.006
3	1.07	0.0093	0.0074	0.0091	0.005	0.006
4	1.076	0.0097	0.0075	0.0094	0.005	0.006
5	1.079	0.010	0.0077	0.0095	0.0061	0.007
6	1.08	0.011		0.0096	0.007	0.007
7	1.08			0.010		0.0079
8	1.08			0.010		0.008
9	1.10			0.011		0.008
10				0.011		0.009
11						0.010
Average	1.075	0.0095	0.00728	0.0097	0.0052	0.0073
Std Dev	0.016	0.0010	0.00036	0.0009	0.0012	0.0014
Certified	1.08	0.010	0.0073	0.010	0.005	0.007
t	2.31	2.57	2.78	2.26	2.57	2.23
C(95%)	0.012	0.0011	0.00045	0.0007	0.0013	0.0009

$C(95\%) = (t \times sd) / \sqrt{n}$  The half-width confidence interval, where  $t$  is the appropriate Student's  $t$  value,  $sd$  is the interlaboratory standard deviation, and  $n$  is the number of acceptable mean values. For further information regarding the confidence interval for the certified value see ISO Guide 35:2006 section 6.

\* Some carbon segregation was found across the analytical face of the disk. For best results on spark atomic emission instruments, make burns midway between the center and the outside edge of the disk surface and average several burns.

**Analysis:** Chemical analyses were made on millings from cross-sections of the bars. Each individual value listed above is the average of each analyst's results.

**Analytical Methods:** Methods of analysis used were a combination of ASTM Standard Methods E 350, E 415, E 1019, plus additional ICP, and AA spectrometric methods.

**Some of the co-operating laboratories were:**

Alpha Research Laboratory, Stevensville, MI  
Brammer Standard Co., Inc., Houston, TX  
Crucible Specialty Metals, Syracuse, NY  
Hoesch Stahl AG, Dortmund, Germany  
J. Dirats and Co., Inc., Westfield, MA  
Midstates Analytical Labs, Tulsa, OK  
Turret Alloys Ltd., Analytical Services, Sheffield, England  
VHG Laboratories, Inc., Manchester, NH

**Traceability:** The following Certified Reference Materials were used to validate the analytical data listed above: NIST SRM 32e, 125b, 361 to 365; BAM 039-2, 044-1; BCS 455/1, 456/1, 458/1; ECRM 085-1, 088-1, 096-1, 184-1, 481-1; GBW 01402; IMZ 1.22, 1.74

**Homogeneity:** This Reference Material was tested for homogeneity using ASTM Standard Method E 826 and found acceptable with some carbon segregation (see \* note on page 2). It was also examined by spark atomic emission spectrometry and found to be compatible with the following NIST Certified Reference Materials: SRM 1222, 1224, 1225, 1261A to 1265A, 1761 to 1767

**Form:** This Reference Material is machined in the form of a disc, approximately 41 mm diameter and 19 mm thick by Brammer Standard Company. The bar stock used for this material was produced by hot-rolling billets and annealing.

**Certified area:** The entire depth of the disc may be used.

**Caution:** As with any bar material, avoid spark atomic emission spectrometric burns in the center of the disc (5 mm radius), as some segregation may be present.

**Sample Preparation:** For best analytical results, use the same method for preparing the analytical surface on all reference materials as you use for production specimens. Avoid overheating the disc during surface preparation.

**Certificate Number:** The unique identification number for this certificate of analysis is REV2-68B-012710. This BS 68B Certificate of Analysis was revised to show the estimate of uncertainty for the certified values and to add carbon as a certified element.

The first Certificate of Analysis for BS 68B was certified on December 1, 1985. With the additional laboratory testing, a revised Certificate of Analysis, REV68B-040892, was produced on April 8, 1992.

Refer to the "Certificates" section of the Brammer Standard Company website for any revision to this or other Brammer Standard Company's Certificates of Analysis.

**Safety Notice:** A Material Safety Data Sheet (MSDS) is not required for this material. This material will not release or otherwise result in exposure to a hazardous chemical, under normal conditions of use. Inquiries concerning this Reference Material should be directed to:

Brammer Standard Co., Inc. 14603 Benfer Road Houston, Texas 77069-2895 USA	Phone: (281) 440-9396 Fax: (281) 440-4432	website: <a href="http://brammerstandard.com">brammerstandard.com</a> email: <a href="mailto:contact@brammerstandard.com">contact@brammerstandard.com</a>
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Certified by: \_\_\_\_\_ on January 27, 2010.  
Beau R. Brammer

**Certificate Number REV2-68B-012710**

## Referenced Documents

*ASTM documents available from ASTM, 1916 Race Street, Philadelphia, PA, 19103.*

Versions available at the time of interlaboratory testing

E 350 - 90 Standard Test Methods for Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron

E 415 - 85 (Reapproved 1989) Standard Test Method for Optical Emission Vacuum Spectrometric Analysis of Carbon and Low-Alloy Steel

E 826 - 85 (Reapproved 1990) Standard Practice for Testing Homogeneity of Materials for the Development of Reference Materials

E 1019-93 Standard Test Methods for Determination of Carbon, Sulfur, Nitrogen, and Oxygen in Steel and in Iron, Nickel, and Cobalt Alloys

*ISO Guides and Standards available from Global Engineering - [www.global.ihs.com](http://www.global.ihs.com)*

ISO Guide 35 Reference Materials - General and statistical principles for certification