

# BRAMMER STANDARD COMPANY, INC.

## Certificate of Analysis

### BS 690A

Certified Reference Material for Inconel 690 - UNS Number N06690

	Certified Value <sup>1</sup>	Estimate of Uncertainty <sup>2</sup>	<b>Certified Values<sup>3</sup></b>	Certified Value <sup>1</sup>	Estimate of Uncertainty <sup>2</sup>	
<b>Al</b>	<b>0.209</b>	0.003		<b>P</b>	<b>0.0052</b>	0.0004
<b>B</b>	<b>0.0003</b>	0.0001		<b>S</b>	<b>0.0004</b>	0.0001
<b>C</b>	<b>0.0321</b>	0.0007		<b>Si</b>	<b>0.036</b>	0.001
<b>Ca</b>	<b>0.0009</b>	0.0003		<b>Ti</b>	<b>0.340</b>	0.005
<b>Co</b>	<b>0.0056</b>	0.0005		<b>V</b>	<b>0.0095</b>	0.0005
<b>Cr</b>	<b>29.5</b>	0.1		<b>W</b>	<b>0.0011</b>	0.0003
<b>Cu</b>	<b>0.0072</b>	0.0006		<b>Zr</b>	<b>0.0018</b>	0.0004
<b>Fe</b>	<b>9.08</b>	0.05				
<b>Mg</b>	<b>0.0058</b>	0.0003				
<b>Mn</b>	<b>0.214</b>	0.002				
<b>Mo</b>	<b>0.0025</b>	0.0004				
<b>N</b>	<b>0.0069</b>	0.0007				
<b>Nb</b>	<b>0.0039</b>	0.0005				
<b>Ni</b>	<b>60.5</b>	0.2				
<b>O</b>	<b>0.0009</b>	0.0004				

### Informational Values<sup>3,4</sup>

As (0.0004)      Pb (0.0001)      Sb (0.0002)      Sn (0.0003)      Ta (0.0011)

<sup>1</sup> For each element, the certified value listed is the present best estimate of the true value based on the mean of the weighted results of an interlaboratory testing program. See page 4 for more information on its calculation.

<sup>2</sup> For each element, the uncertainty listed is based on a statistical evaluation of the contributions of homogeneity and the interlaboratory testing program. See page 4 for more information on its calculation.

<sup>3</sup> Values are given in weight percent.

<sup>4</sup> Values in parentheses are not certified and are provided for information only.

Trace element information values for Ag, Bi, and Tl are shown on page 4.

The requirements of ISO Guides 31, 34, and 35 were followed for the preparation of this Certified Reference Material and certificate of analysis. This is a Certified Reference Material as defined by ISO Guide 30.

## BS 690A

\* Code for method Certified values listed as weight percent

Analysis	*	Al	*	B	*	C	*	Ca	*	Co	*	Cr	*	Cu	*	Fe
1	10	0.190	5	0.00013	1	0.0287	4	0.00079	10	0.0050	10	29.39	4	0.0067	4	8.92
2	4	0.191	4	0.00020	1	0.0307	4	0.00083	5	0.0052	4	29.43	5	0.0068	3	8.94
3	4	0.198	5	0.00025	1	0.0315	3	0.00092	5	0.0055	10	29.44	8	0.0069	4	9.08
4	5	0.201	4	0.00025	1	0.0320	4	0.00100	8	0.0057	10	29.45	4	0.0075	10	9.10
5	4	0.202	4	0.00029	1	0.0320	4	0.00100	10	0.0060	10	29.47	5	0.0077	10	9.10
6	3	0.203	3	0.00033	1	0.0320			4	0.0060	4	29.50	3	0.0090	4	9.12
7	10	0.204	7	0.00037	1	0.0321			10	0.0063	3	29.54			10	9.13
8	10	0.219			1	0.0328			3	0.0065	13	29.54			10	9.15
9	4	0.221			1	0.0333					3	29.55			4	9.15
10	3	0.222			1	0.0334					4	29.57			3	9.16
11	4	0.223			1	0.0343					4	29.61				
Average		0.2094		0.000264		0.03210		0.00091		0.00563		29.498		0.00723		9.085
Std dev		0.0029		0.000056		0.00059		0.00013		0.00042		0.079		0.00034		0.034
H		0.0029		0.00014		0.00090		0.00020		0.00040		0.17		0.00044		0.056
U <sub>1</sub>		0.0041		0.00015		0.0011		0.00023		0.00058		0.19		0.00056		0.065
t-statistic		2.23		2.45		2.23		2.78		2.36		2.23		2.57		2.26
U <sub>2</sub>		0.0091		0.00037		0.0025		0.00065		0.0014		0.42		0.0014		0.15
U <sub>3</sub>		0.0028		0.00014		0.00074		0.00029		0.00049		0.13		0.00059		0.047
<b>Certified</b>		<b>0.209</b>		<b>0.0003</b>		<b>0.0321</b>		<b>0.0009</b>		<b>0.0056</b>		<b>29.5</b>		<b>0.0072</b>		<b>9.08</b>
<b>Uncertainty</b>		<b>0.003</b>		<b>0.0001</b>		<b>0.0007</b>		<b>0.0003</b>		<b>0.0005</b>		<b>0.1</b>		<b>0.0006</b>		<b>0.05</b>
Tolerance		0.009		0.0003		0.0025		0.0007		0.0014		0.4		0.0014		0.15

Analysis	*	Mg	*	Mn	*	Mo	*	N	*	Nb	*	Ni	*	O	*	P
1	3	0.0048	3	0.200	5	0.0020	2	0.0056	10	0.0023	4	59.90	2	0.0008	5	0.0042
2	5	0.0055	10	0.201	5	0.0021	2	0.0065	4	0.0025	4	60.30	2	0.0009	7	0.0042
3	4	0.0056	4	0.204	4	0.0027	2	0.0071	10	0.0032	10	60.37	2	0.0010	10	0.0050
4	8	0.0058	10	0.210	4	0.0027	2	0.0073	3	0.0035	5	60.47	2	0.0011	10	0.0055
5	5	0.0059	5	0.211	4	0.0030	2	0.0074	4	0.0038	10	60.48			10	0.0058
6	8	0.0060	10	0.213	4	0.0033	2	0.0075	4	0.0047	13	60.50			3	0.0060
7	4	0.0060	10	0.213					10	0.0050	10	60.53			10	0.0063
8	4	0.0063	4	0.215							4	60.56			4	0.0065
9	4	0.0070	3	0.217							3	60.60				
10			8	0.219							3	60.63				
11			4	0.219							4	60.67				
12			4	0.219												
13			4	0.228												
Average		0.00577		0.2144		0.00249		0.00689		0.00393		60.544		0.00094		0.00519
Std dev		0.00021		0.0026		0.00020		0.00049		0.00035		0.090		0.00019		0.00034
H		0.00040		0.0030		0.00028		0.00043		0.00034		0.35		0.00020		0.00038
U <sub>1</sub>		0.00045		0.0039		0.00035		0.00066		0.00049		0.36		0.00028		0.00052
t-statistic		2.31		2.18		2.57		2.57		2.45		2.23		3.18		2.36
U <sub>2</sub>		0.0010		0.0085		0.00089		0.0017		0.0012		0.80		0.00088		0.0012
U <sub>3</sub>		0.00035		0.0024		0.00036		0.00069		0.00045		0.24		0.00044		0.00043
<b>Certified</b>		<b>0.0058</b>		<b>0.214</b>		<b>0.0025</b>		<b>0.0069</b>		<b>0.0039</b>		<b>60.5</b>		<b>0.0009</b>		<b>0.0052</b>
<b>Uncertainty</b>		<b>0.0003</b>		<b>0.002</b>		<b>0.0004</b>		<b>0.0007</b>		<b>0.0005</b>		<b>0.2</b>		<b>0.0004</b>		<b>0.0004</b>
Tolerance		0.0010		0.009		0.0009		0.0017		0.0012		0.8		0.0009		0.0012

**BS 690A** \* Code for method Certified values listed as weight percent

Analysis	*	S	*	Si	*	Ti	*	V	*	W	*	Zr
1	1	0.00020	4	0.032	4	0.319	10	0.0080	5	0.0004	4	0.0014
2	1	0.00025	3	0.032	5	0.320	4	0.0087	5	0.0006	3	0.0015
3	1	0.00027	10	0.033	3	0.322	5	0.0089	5	0.0018	10	0.0020
4	1	0.00030	4	0.036	10	0.323	5	0.0090	10	0.0023	3	0.0021
5	1	0.00047	5	0.037	3	0.333	5	0.0093	4	0.0025	10	0.0022
6	1	0.00050	7	0.037	10	0.340	4	0.0093			4	0.0025
7	1	0.00050	4	0.038	4	0.341	10	0.0100				
8	1	0.00060	10	0.040	10	0.347	7	0.0101				
9			3	0.040	10	0.350	4	0.0112				
10			10	0.043	7	0.354	10	0.0120				
11					4	0.355						
Average		0.000433		0.0357		0.3401		0.00955		0.00112		0.00179
Std dev		0.000068		0.0012		0.0054		0.00041		0.00017		0.00023
H		0.00016		0.0010		0.0041		0.00050		0.00021		0.00025
U <sub>1</sub>		0.00017		0.0016		0.0067		0.00065		0.00027		0.00034
t-statistic		2.36		2.26		2.23		2.26		2.78		2.57
U <sub>2</sub>		0.00041		0.0036		0.015		0.0015		0.00075		0.00087
U <sub>3</sub>		0.00014		0.0011		0.0045		0.00047		0.00034		0.00036
<b>Certified</b>		<b>0.0004</b>		<b>0.036</b>		<b>0.340</b>		<b>0.0095</b>		<b>0.0011</b>		<b>0.0018</b>
<b>Uncertainty</b>		<b>0.0001</b>		<b>0.001</b>		<b>0.005</b>		<b>0.0005</b>		<b>0.0003</b>		<b>0.0004</b>
<b>Tolerance</b>		0.0004		0.004		0.015		0.0015		0.0008		0.0009

**BS 690A** \* Code for method Informational values listed as weight percent

Analysis	*	As	*	Pb	*	Sb	*	Sn	*	Ta
1	5	0.00025	5	0.000020	5	0.000028	5	0.00010	5	0.0002
2	15	0.00030	5	0.000044	5	0.00025	5	0.00010	3	0.0007
3	5	0.00030	5	0.000047			5	0.00012	10	0.0020
4	5	0.00040	5	0.000050			5	0.00025	10	0.0020
5	5	0.00060	5	0.00010			5	0.00040	4	0.0025
6			5	0.00015			10	0.00213		
Average		0.000352		0.000055		0.000165		0.000260		0.00113
Std dev		0.000072		0.000018		0.000085		0.000053		0.00022
H		0.00015		0.00010		0.00013		0.00014		0.00021
U <sub>1</sub>		0.00017		0.00010		0.00015		0.00015		0.00030
t-statistic		2.78		2.57		12.71		2.57		2.78
U <sub>2</sub>		0.00046		0.00027		0.0019		0.00038		0.00084
U <sub>3</sub>		0.00021		0.00011		0.0014		0.00016		0.00038
<b>(Certified)</b>		<b>(0.0004)</b>		<b>(0.0001)</b>		<b>(0.0002)</b>		<b>(0.0003)</b>		<b>(0.0011)</b>
<b>(Uncertainty)</b>		<b>(0.0002)</b>		<b>(0.0001)</b>		<b>(0.0014)</b>		<b>(0.0002)</b>		<b>(0.0004)</b>
<b>(Tolerance)</b>		<b>(0.0005)</b>		<b>(0.0003)</b>		<b>(0.0019)</b>		<b>(0.0004)</b>		<b>(0.0008)</b>

For each element, in accordance with the requirements of ISO Guides 34 and 35, an effort must be made to account for the effects on the certified value of the uncertainty estimate from homogeneity testing (H) and the uncertainties of the contributing laboratories. The average (A) is calculated using a weighted mean where the reciprocal of the square of each laboratory's combined uncertainty (C<sub>L</sub>), calculated from its standard deviation (S<sub>L</sub>) and its uncertainty estimate (U<sub>L</sub>), is used as the weight (W<sub>L</sub>) for its mean (M<sub>L</sub>). The standard deviation (S) is calculated as the square root of the reciprocal of the sum of the weights. U<sub>1</sub> is the combined uncertainty from homogeneity and labs. U<sub>2</sub> is U<sub>1</sub> times the coverage factor (95 % t-statistic). U<sub>3</sub> is U<sub>2</sub> divided by the square root of the number of determinations (n). Thus:

$$C_L = \sqrt{S_L^2 + U_L^2} \quad W_L = \frac{1}{C_L^2} \quad A = \frac{\sum_{i=1}^n W_L M_L}{\sum_{i=1}^n W_L} \quad S = \frac{1}{\sqrt{\sum_{i=1}^n W_L}} \quad U_1 = \sqrt{H^2 + S^2} \quad U_2 = t \times U_1 \quad U_3 = \frac{U_2}{\sqrt{n}}$$

All but the final reported values are taken to two significant figures as determined by each quantity's uncertainty estimate. The final reported Uncertainty is U<sub>3</sub> rounded to one significant figure and represents the half width of the 95 % confidence interval for the **Certified** value. The final reported **Certified** value is A rounded to the same decimal place as the Uncertainty. The Tolerance is the half width of the 95 % confidence interval for measurements rounded to the same decimal place as the Uncertainty. The Uncertainty is a measure of the quality of the **Certified** value. The Tolerance is a measure of the expected performance of an analysis.

For further information regarding the confidence interval for the certified value see ISO Guide 35:2006 section 6.

**BS 690A** \* Code for analytical method Trace analysis listed as mg/kg (ppm)

Analysis *	Ag	* Bi	* TI
1	5 0.019	5 0.012	5 0.005

**Analytical Method Codes:**

- |                           |                           |                           |
|---------------------------|---------------------------|---------------------------|
| 1 Combustion (ASTM E1019) | 7 Photometric             | 13 Titrimetric            |
| 2 Fusion (ASTM E 1019)    | 8 Flame Atomic Absorption | 14 DCP Atomic Emission    |
| 3 Spark Atomic Emission   | 9 GF Atomic Absorption    | 15 HG Atomic Fluorescence |
| 4 ICP Atomic Emission     | 10 X-Ray Fluorescence     |                           |
| 5 ICP Mass Spectrometry   | 11 GD Atomic Emission     |                           |
| 6 Gravimetric             | 12 GD Mass Spectrometry   |                           |

ICP = Inductively Coupled Plasma      GF = Graphite Furnace      GD = Glow Discharge  
 DCP = Direct Current Plasma      HG = Hydride Generation

<u>Laboratory</u>	<u>Location</u>	<u>Registrar</u>	<u>Accreditation</u>
ATI Allvac	Lockport, NY	PRI/Nadcap	AC7101/2
ATI Allvac	Monroe, NC	PRI/Nadcap	AC7101/2
Brammer Standard Company, Inc.	Houston, TX	A2LA	17025, Guide 34
Carpenter Technology Corporation	Reading, PA	A2LA	17025
Dirats Laboratories	Westfield, MA	ACLASS	17025
Elemental Analysis, Inc.	Lexington, KY	A2LA	17025
Laboratory Testing, Inc.	Hatfield, PA	PRI/Nadcap	17025
LECO Corporation	St. Joseph, MI	BSI	9001
NSL Analytical	Cleveland, OH	ACLASS	17025
National Analysis Center For Iron And Steel	Beijing, China	CNAS	17025
Instytut Metalurgii Zelaza	Gliwice, Poland	PCA	AB 554

A2LA = American Association for Laboratory Accreditation  
 ACLASS = ANSI-ASQ National Accreditation Board  
 BSI = British Standards Institution  
 CNAS = China National Accreditation Service  
 Nadcap = National Aerospace and Defense Contractors Accreditation Program  
 PCA = Polish Center For Accreditation  
 PRI = Performance Review Institute

**Analysis:** Chemical analyses were made on solid pieces and chips prepared by an end mill from representative samples of the certified portion of the lot in accordance with ASTM Standard Practice E 1806. The laboratories participating in the testing followed the requirements of ISO Standard 17025. Methods of analysis used were a those listed on page 4.

**Traceability:** The following Certified Reference Materials were used to validate the analytical data listed on pages 2-3 — 215X HB2, 215X HC3, 215X HC5, 23X 80010, 24X 07001, 28X 7183, 28X 71860; 501-505, 501-550, 501-644, 501-673, 501-991, 501-992, 502-348, 502-414, 502-455; BAS 345, 346, 351, 363; BS 600-1, 600-2, 600-4, 600-5, 600B, 600C, 690, CSN-4; IARM 53D, 53E, 68C, 190A, 201A; IMZ 1.27/3, 180, 187; SRM 868, 1097, 1160, 1203, 1204, 1205, 1244, 1245, 1247, 1248C, 1249, 1287C, 2402C, 3101a, 3102a, 3106, 3107, 3109a, 3113, 3114, 3128, 3131a, 3132, 3134, 3149, 3151, 3155, 3156, 3158, 3161a, 3163, 3165, & 3169.

**Homogeneity:** This Certified Reference Material (CRM) was tested for homogeneity using ASTM Standard Method E 826 and found acceptable. It was also examined by spark atomic emission spectrometry and found to be compatible with the following Reference Materials — BAS 351; SRM 865, 867, 1244; IARM 201A; BS CSN 4, CSN 2-1, 600B, 600C, 600-1, 600-2, 600-4, & 600-5

**Validity statement:** ISO Guide 31 states that the certification should contain an expiration date for all materials where instability has been demonstrated or is considered possible, after which the certified value is no longer guaranteed by the certifying body. The certification of BS 690A is valid indefinitely. The certification is nullified if this CRM is damaged, contaminated, or otherwise modified.

**Source:** The bar stock for this CRM was produced by ALLVAC, Monroe, NC.

**Form:** This CRM is machined in the form of a disc, approximately 38 mm in diameter and 19 mm thick by Brammer Standard Company, Inc.

**Use:** This CRM is intended for use in spark atomic emission and x-ray spectrometric methods of analysis. Refer to ISO Guide 33 for information about the use of Certified Reference Materials.

**Certified Area:** The entire depth of the CRM may be used.

Caution: As with any bar material, avoid spark atomic emission spectrometric burns in the center of the CRM (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 sample during surface preparation.

**Certificate Number:** The unique identification number for this certificate of analysis is 690A-101212. You may obtain information on revisions of certificates from the internet at [www.brammerstandard.com](http://www.brammerstandard.com).

**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

Web: [www.brammerstandard.com](http://www.brammerstandard.com)

Fax: (281) 440-4432

Email: [contact@brammerstandard.com](mailto:contact@brammerstandard.com)

Brammer Standard Company, Inc., is accredited by the American Association For Laboratory Accreditation (A2LA) to ISO Guide 34 as a Reference Material Producer for the production of Certified Reference Materials and Reference Materials (Certificate Number 656.02)

Brammer Standard Company's Chemical Laboratory is accredited by A2LA to ISO Standard 17025. (Certificate Number 656.01)

By Certificate Number 10539, the Quality System of Brammer Standard Company, Inc., is registered to ISO 9001:2008 by National Quality Assurance (NQA), U.S.A.

The scopes of accreditation are listed on the website: [www.brammerstandard.com](http://www.brammerstandard.com)

## **References:**

Versions used were those available at the time of testing and characterization

- E 826 Standard Practice for Testing Homogeneity of a Metal Lot or Batch in Solid Form by Spark Atomic Emission Spectrometry
- E 1019 Standard Test Methods for Determination of Carbon, Sulfur, Nitrogen, and Oxygen in Steel, Iron, Nickel, and Cobalt Alloys by Various Combustion and Fusion Techniques
- E 1806 Standard Practice for Sampling Steel and Iron for Determination of Chemical Composition

ISO Standard 17025:2005 General requirements for the competence of testing and calibration laboratories

ISO Standard 9001:2008 Quality Management Systems - Requirements

ISO Guide 30:1992 Terms and definitions used in connection with reference materials + 2008 amendment

ISO Guide 31:2000 Reference materials - Contents of certificates and labels

ISO Guide 33:2000 Uses of certified reference materials

ISO Guide 34:2009 General requirements for the competence of reference material producers

ISO Guide 35:2006 Reference Materials - General and statistical principles for certification

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

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

*Other useful documents available from NIST, U.S. Department of Commerce, Gaithersburg, MD 20899.*

NIST Special Publication 260-100, Handbook for SRM Users

NIST Special Publication 829, Use of NIST Standard Reference Materials for Decisions on Performance of Analytical Chemical Methods and Laboratories

Certified by: \_\_\_\_\_ on October 12, 2012.

Beau R. Brammer