



CERTIFICATE OF QUALITY

Contract No.		2017-08		Qty.		1		Serial number		SWR-08/17.618.1		Description		6-1/8" Sphiro Wire Rope					
Specification		SWR-618B_ 4" IF BOX		Weight		240 Kg		Implementation of the standards				SY/T5084-2017							
Major Parts	Material	Heat No.	Heat-treating lot No.	Chemical Components								Mechanical Testing Report							
				C	Cr	Mo	Si	Mn	P	Ni	S	Tensile Strength	Yield Strength	Elongation A%	Longitudinal Impact Test	Surface Hardness(HBW)			
				%								MPa	MPa	%	J(Size:10×10) 21°C				
Top Sub	4145H	1910500326	B.170-19	0,47	1,19	0,25	0,25	1,06	0,015		0,009	1080	949	18	75 80 86	323	315	313	
Body	4145H	19104000436	B.176-19	0,47	1,19	0,25	0,25	1,06	0,015		0,003	1090	970	18	80 89 93	321	315	312	
Spec.(>178)	—	—	—	—	—	—	—	—	—	—	—	≥963	≥758	≥13	≥54	285~341			
Ultrasonic Inspection (Quenched and tempered)																			
Surface Status	Blanks Machining		Probe Type	<input checked="" type="checkbox"/> 2.5P18*18K0.5 <input checked="" type="checkbox"/> 2.5P13*13K1 <input type="checkbox"/> 2.5P20Z <input type="checkbox"/> 2.25P30Z			Coupling Agent	Industrial Paste	Testing Time	Before Heat Treatment	After Heat Treatment	Surface Compensation	2dB						
Coupon Type	N5notch Groove Through Hole φ3Flat Bottom Hole		Sensitivity	6dB The Outer Groove Height80%Gain6dB			Instrument Type	CTS-1003	Scan Means	Longitudinal Wave	Transverse wave	Flaw Proportion	100%						
ASTME213 Conclusion: It is found to comply of ASTM/E213 without defects																			
Magnetic particle inspection																			
Surface Status	Blanks Machining		Magnetized Model	Magnetic Yoke Coil Contact		Magnetism Liquid (Media)	Oil-based/Water-based	Criteria Coupon Type	<input type="checkbox"/> A1-15/100 <input checked="" type="checkbox"/> A1-30/100 <input type="checkbox"/> A1-60/100		Current	<input type="checkbox"/> DC <input checked="" type="checkbox"/> AC							
Magnetized Current (Lifting Force)	≥45N		Magnetic Powder Type	Fluorescence <input type="checkbox"/> Non Fluorescence		Instrument Type	CDX-I CDW-24000AT	Test Method	<input type="checkbox"/> Dry Method <input checked="" type="checkbox"/> Wet Method		Performance Means	Spray Method							
ASTME709 Conclusion: No defects exceeded the standard, and accord with ASTME709.																			
Visual inspection			Acceptable																
Inspector:			Jack Murray Jr						Director:			Malcolm T		Date :		12-Jul-17			



FACTORY CODE		
618-60-75-135-5SC0-08-17		
Components :		
1. Top Sub 2. Screw Body		
Thread Connection		
Top Sub API 4" IF Box	Middle Body API 4" IF Pinx Box	Lower Body None
Dimension		Wight (Kg)
OD/ID : 155/75mm (6-1/8"/3")		240 Kg
Top Sub : 1,080 mm (42")		
Screw Body : 2,349 mm (93")		
Total Length Overall : 3,429 mm (135")		

TECHNICAL DRAWING - SWR-618B SPIRO WIRE ROPE