



湖南海斯特材料科技有限公司
Hunan Hyster Material Technology Co.,LTD.

成分检测报告 Chemical Composition Test Report

Test Device 检测设备	Spectrometer 光谱仪			Material No. 材料编号			Modified ASTM A532 15/3 CrMo		
Test Standard检测标准 Sample样品规格	Date 检测日期	C	Cr	Mn	Mo	Si	Ni	S	P
		2.0-3.3	14-18	2.0max	3.0max	1.5max	2.5max	0.06max	0.1max
CHOCKY BAR 100, 240*100*15/8mm	2023/3/3	2.695	15.928	0.628	0.918	0.679	/	0.069	0.033
CHOCKY BAR 40, 240*40*15/8mm	2023/3/5	3.019	14.846	1.026	0.777	0.849	/	0.03	0.032
CHOCKY BAR 50, 240*50*15/8mm	2023/3/3	2.89	15.208	0.638	0.819	0.813	/	0.035	0.034
CHOCKY BAR 65, 240*65*15/8mm	2023/3/3	3.011	15.025	1.013	0.777	0.813	/	0.022	0.036
WEAR BUTTON 75, φ 75*17/10mm	2023/1/8	2.846	14.736	0.699	1.029	0.809	/	0.022	0.036
CUTTER KNIFE 300*25*39/12mm	2023/3/7	3.123	15.556	1.088	0.81	0.881	/	0.022	0.031
WEAR BLOCKS DLP 4716 PERFORADO, 318*100*75/25mm	2023/3/6	3.036	15.213	1.152	0.769	0.901	/	0.031	0.032
Conclusion 检测结果	Chemical composition tested are all conform to the test standard, qualified. 此批样品各元素平均含量均在检测标准之内, 合格。								

Checked by
检测人

谢敏

Re-checked by
审核人

刘树强



湖南海斯特材料科技有限公司
Hunan Hyster Material Technology Co.,LTD.

硬度检测报告
Hardness Test Report

Test Device 检测设备	Rockwell Hardness Testor洛氏硬度计							
Heat Treatment 热处理	Quenching 淬火			Acceptable Standard 合格标准			Min 62HRC	
HRC	Furnace No. 炉号	Date 检测日期	1st	2 nd	3 rd	4 th	5 th	Average
CHOCKY BAR 100, 240*100*15/8mm	2023/3/4	2023/3/5	63.1	65.1	64.3	62	64.8	63.9
CHOCKY BAR 40, 240*40*15/8mm	2023/3/7	2023/3/8	62.4	62.1	63	62.7	62.6	62.6
CHOCKY BAR 50, 240*50*15/8mm	2023/3/6	2023/3/7	62.2	63.8	62.8	62.9	62.5	62.8
CHOCKY BAR 65, 240*65*15/8mm	2023/3/4	2023/3/5	62.5	64.7	63.3	62	62.8	63.1
WEAR BUTTON 75, φ 75*17/10mm	2023/1/10	2023/1/11	62	62.5	62.3	62.6	66.9	63.3
CUTTER KNIFE 300*25*39/12mm	2023/3/16	2023/3/17	62.1	64.1	63.9	62	65.5	63.5
WEAR BLOCKS DLP 4716 PERFORADO, 318*100*75/25mm	2023/3/12	2023/3/13	66.6	64.9	67.1	65.9	66.8	66.3
Conclusion 检测结论 The average hardness is all above 62HRC , qualified. 抽检试样洛氏硬度 均大于62HRC , 产品合格								

Checked by
检验员

谢敏

Re-checked by
审核人

刘树强

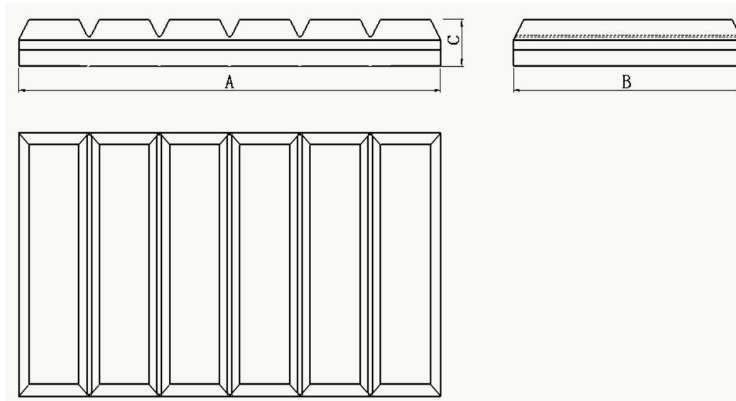


湖南海斯特材料科技有限公司
Hunan Hyster Material Technology Co.,LTD.

尺寸检测报告 Dimension Test Report

Sample 样品名称	CHOCKY BAR 100, 240*100*15/8mm			CHOCKY BAR 40, 240*40*15/8mm			CHOCKY BAR 65, 240*65*15/8mm			CHOCKY BAR 50, 240*50*15/8mm		
Dimension 检测项目	A	B	C	A	B	C	A	B	C	A	B	C
Test Device 检测设备	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺
Drawing dimension 图纸尺寸	240	100	23	240	40	23	240	65	23	240	50	23
Tolerance Required 公差要求	1	1	1	1	1	1	1	1	1	1	1	1
	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1	-1
Actual Tested Max. 实际检测最大值	240.2	100.3	23.5	240.2	40.1	23.5	240.2	65.2	23.5	240.2	50.3	23.5
Actual Tested Min. 实际检测最小值	239.6	99.7	22.6	239.6	39.7	22.6	239.6	64.4	22.6	239.6	49.5	22.6
Conclusion 是否合格	Qualified 合格	Qualified 合格	Qualified 合格	Qualified 合格	Qualified 合格	Qualified 合格	Qualified 合格	Qualified 合格	Qualified 合格	Qualified 合格	Qualified 合格	Qualified 合格
Improvement Measure 改进措施												
Re-checked by 复检												
Conclusion 是否合格												

Picture附图



Checked by 检测人: 谢敏

Re-checked by 审核人: 刘树强

Date 日期: 2023/3/26

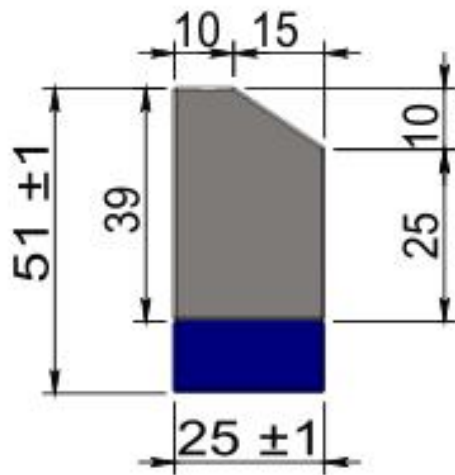


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尺寸检测报告 Dimension Test Report

Sample 样品名称	CUTTER KNIFE 300*25*39/12mm			Test Standard 检测标准		According to drawing				
Dimension 检测项目	A	B	C							
Test Device 检测设备	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺							
Drawing dimension 图纸尺寸	300	25	51							
Tolerance Required 公差要求	1	1	1							
	-1	-1	-1							
Actual Tested Max. 实际检测最大值	300.5	25.6	51.4							
Actual Tested Min. 实际检测最小值	299.4	24.3	50.4							
Conclusion 是否合格	Qualified 合格	Qualified 合格	Qualified 合格							
Improvement Measure 改进措施										
Re-checked by 复检										
Conclusion 是否合格										

Picture附图



Checked by 检测人: 谢敏

Re-checked by 审核人: 刘树强

Date 日期: 2023/3/30

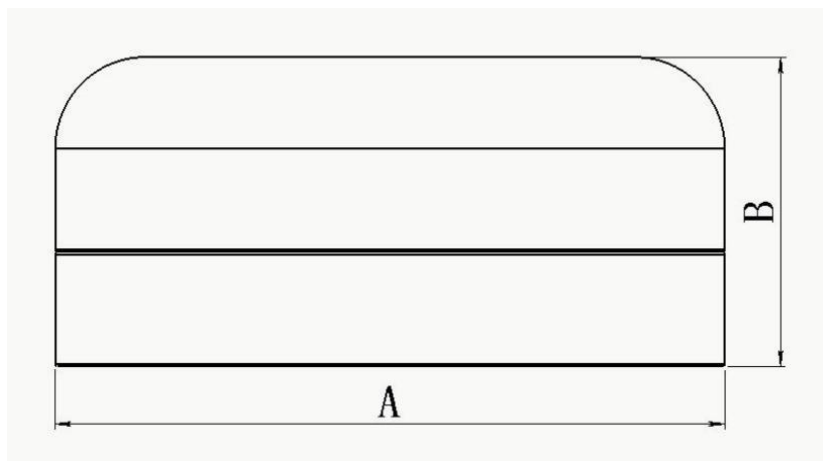


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尺寸检测报告 Dimension Test Report

Sample 样品名称	WEAR BUTTON 75, $\phi 75 \times 17/10\text{mm}$			Test Standard 检测标准		According to drawing				
Dimension 检测项目	A	B								
Test Device 检测设备	Caliper 游标卡尺	Caliper 游标卡尺								
Drawing dimension 图纸尺寸	75	27								
Tolerance Required 公差要求	1	1								
	-1	-1								
Actual Tested Max. 实际检测最大值	75.5	27.2								
Actual Tested Min. 实际检测最小值	74.6	26.6								
Conclusion 是否合格	Qualified 合格	Qualified 合格								
Improvement Measure 改进措施										
Re-checked by 复检										
Conclusion 是否合格										

Picture附图



Checked by 检测人: 谢敏

Re-checked by 审核人: 刘树松

Date 日期: 2023/3/25

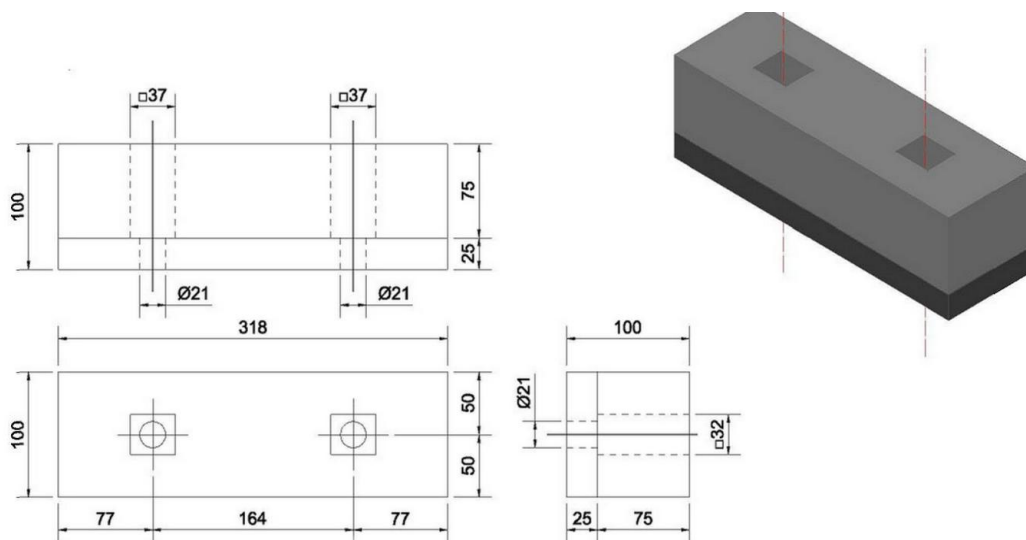


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Hunan Hyster Material Technology Co.,LTD.

尺寸检测报告 Dimension Test Report

Sample 样品名称	WEAR BLOCKS DLP 4716 PERFORADO, 318*100*75/25mm			Test Standard 检测标准		According to drawing				
Dimension 检测项目	A	B	C							
Test Device 检测设备	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺	Caliper 游标卡尺				
Drawing dimension 图纸尺寸	318	100	100	37	77	164				
Tolerance Required 公差要求	1.5	1	1	1	1	1				
	-1.5	-1	-1	-1	-1	-1				
Actual Tested Max. 实际检测最大值	319.5	101	101	38	77.5	164.3				
Actual Tested Min. 实际检测最小值	317	99.4	99.5	37.5	76.8	163.8				
Conclusion 是否合格	Qualified 合格	Qualified 合格	Qualified 合格	Qualified 合格	Qualified 合格	Qualified 合格				
Improvement Measure 改进措施										
Re-checked by 复检										
Conclusion 是否合格										

Picture附图



Checked by 检测人: 谢敏

Re-checked by 审核人: 刘树

Date 日期: 2023/3/31



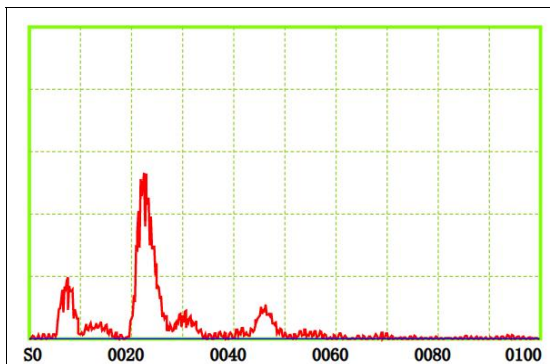
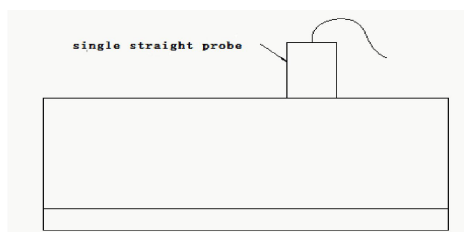
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Hunan Hyster Material Technology Co.,LTD.

焊接质量检测报告 (Welding Quality Report)

检测标准	用音频法和超声波检测焊接质量。每炉随机抽取 1-5%，焊接有效面积不得小于 80%，如有异常，片检。
Test Standard	Sound test and UT, randomly check 1-5% per furnace, the effective brazing area should be > 80%, otherwise 100% full check.

工件名称: Item NO.	CHOCKY BAR 100, 240*100*15/8mm		
探头类型 Probe Type	双直 Twin straight probe	材料声速 Material's sound velocity	5900
晶体尺寸 Crystal Size	14	标称频率 Frequency	2.5
探头前沿 Leading edge	0	标称K值 Nominal K	0
超声仪器型号 UT Instrument Name	欧能达 3600s	定量偏移 Quantitative deviation	-10
判废偏移 Abandoned deviation	-4	测长偏移 Length Deviation	-16

NOTE: 缺陷波幅不超过 1 次底波的 50% (Defect wave amplitude does not exceed 50% of the bottom wave)



缺陷深度 Coordinate (Y):	22.57
缺陷波幅 Amplitude(%):	81.30%
当前增益 Gain:	42

检测结果: 经音频法和超声探测, 该样品焊接有效面积 >80%, 并且表面无明显缺陷, 合格, 允许放行,
Conclusion: The effective brazing area is above than 80%, and there is NO gap on the welding surfaces, no visible porosity, pit, scab or any kind of visible discountinuties, qualified.

检测人
Checked by:

谢敏

审核人
Responsible
Person:

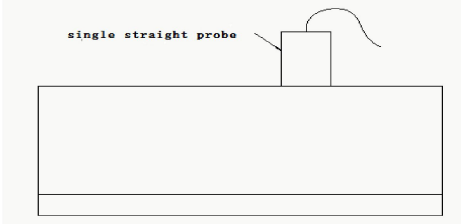
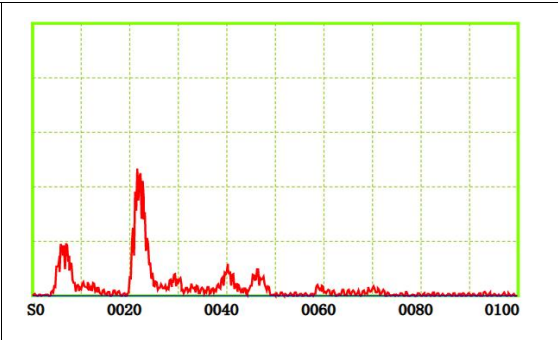
刘树强

检测日期
Checking Date: 2023.3.2



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Hunan Hyster Material Technology Co.,LTD.

焊接质量检测报告 (Welding Quality Report)

检测标准	用音频法和超声波检测焊接质量。每炉随机抽取 1-5%，焊接有效面积不得小于 80%，如有异常，片检。								
Test Standard	Sound test and UT, randomly check 1-5% per furnace, the effective brazing area should be > 80%, otherwise 100% full check.								
工件名称: Item NO.	CHOCKY BAR 50, 240*50*15/8mm								
探头类型 Probe Type	双直 Twin straight probe	材料声速 Material's sound velocity	5900						
晶体尺寸 Crystal Size	14	标称频率 Frequency	2.5						
探头前沿 Leading edge	0	标称K值 Nominal K	0						
超声仪器型号 UT Instrument Name	欧能达 3600s	定量偏移 Quantitative deviation	-10						
判废偏移 Abandoned deviation	-4	测长偏移 Length Deviation	-16						
NOTE: 缺陷波幅不超过 1 次底波的 50% (Defect wave amplitude does not exceed 50% of the bottom wave)									
		 <table><tr><td>缺陷深度 Coordinate (Y):</td><td>22.35</td></tr><tr><td>缺陷波幅 Amplitude(%):</td><td>81.30%</td></tr><tr><td>当前增益 Gain:</td><td>44</td></tr></table>		缺陷深度 Coordinate (Y):	22.35	缺陷波幅 Amplitude(%):	81.30%	当前增益 Gain:	44
缺陷深度 Coordinate (Y):	22.35								
缺陷波幅 Amplitude(%):	81.30%								
当前增益 Gain:	44								
检测结果: 经音频法和超声探测, 该样品焊接有效面积 >80%, 并且表面无明显缺陷, 合格, 允许放行, Conclusion: The effective brazing area is above than 80%, and there is NO gap on the welding surfaces, no visible porosity, pit, scab or any kind of visible discontinuities, qualified.									

检测人
Checked by:

谢敏

审核人
Responsible
Person:

刘树强

检测日期
Checking Date: 2023.3.5



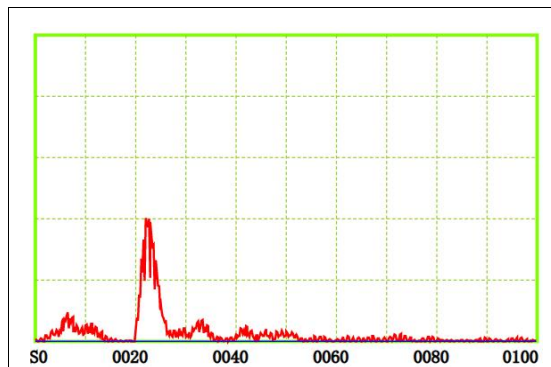
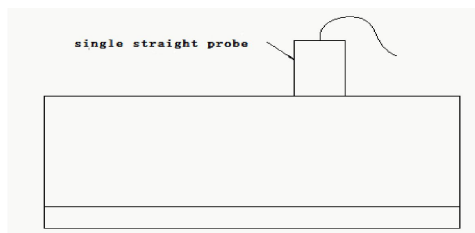
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Hunan Hyster Material Technology Co.,LTD.

焊接质量检测报告 (Welding Quality Report)

检测标准	用音频法和超声波检测焊接质量。每炉随机抽取 1-5%，焊接有效面积不得小于 80%，如有异常，片检。
Test Standard	Sound test and UT, randomly check 1-5% per furnace, the effective brazing area should be > 80%, otherwise 100% full check.

工件名称: Item NO.	CHOCKY BAR 40, 240*40*15/8mm		
探头类型 Probe Type	双直 Twin straight probe	材料声速 Material's sound velocity	5900
晶体尺寸 Crystal Size	14	标称频率 Frequency	2.5
探头前沿 Leading edge	0	标称K值 Nominal K	0
超声仪器型号 UT Instrument Name	欧能达 3600s	定量偏移 Quantitative deviation	-10
判废偏移 Abandoned deviation	-4	测长偏移 Length Deviation	-16

NOTE: 缺陷波幅不超过 1 次底波的 50% (Defect wave amplitude does not exceed 50% of the bottom wave)



缺陷深度 Coordinate (Y):	22.32
缺陷波幅 Amplitude(%):	82.30%
当前增益 Gain:	44

检测结果: 经音频法和超声探测, 该样品焊接有效面积 >80%, 并且表面无明显缺陷, 合格, 允许放行,
Conclusion: The effective brazing area is above than 80%, and there is NO gap on the welding surfaces, no visible porosity, pit, scab or any kind of visible discountinuities, qualified.

检测人
Checked by:

谢敏

审核人
Responsible
Person:

刘树强

检测日期
Checking Date: 2023.3.6

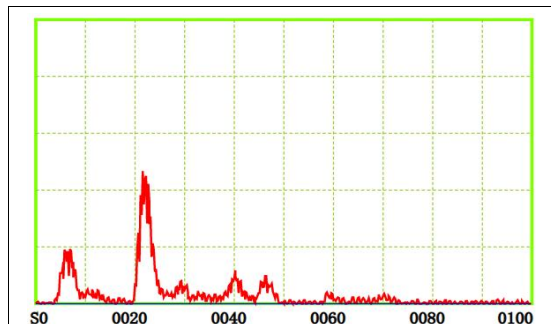
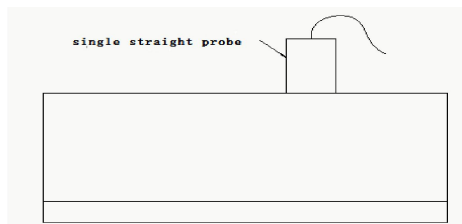


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Hunan Hyster Material Technology Co.,LTD.

焊接质量检测报告 (Welding Quality Report)

检测标准	用音频法和超声波检测焊接质量。每炉随机抽取 1-5%，焊接有效面积不得小于 80%，如有异常，片检。		
Test Standard	Sound test and UT, randomly check 1-5% per furnace, the effective brazing area should be > 80%, otherwise 100% full check.		
工件名称: Item NO.	CHOCKY BAR 65, 240*65*15/8mm		
探头类型 Probe Type	双直 Twin straight probe	材料声速 Material's sound velocity	5900
晶体尺寸 Crystal Size	14	标称频率 Frequency	2.5
探头前沿 Leading edge	0	标称K值 Nominal K	0
超声仪器型号 UT Instrument Name	欧能达 3600s	定量偏移 Quantitative deviation	-10
判废偏移 Abandoned deviation	-4	测长偏移 Length Deviation	-16

NOTE: 缺陷波幅不超过 1 次底波的 50% (Defect wave amplitude does not exceed 50% of the bottom wave)



缺陷深度 Coordinate (Y):	22.54
缺陷波幅 Amplitude(%):	82.50%
当前增益 Gain:	44

检测结果: 经音频法和超声探测, 该样品焊接有效面积 >80%, 并且表面无明显缺陷, 合格, 允许放行,
Conclusion: The effective brazing area is above than 80%, and there is NO gap on the welding surfaces, no visible porosity, pit, scab or any kind of visible discountinuities, qualified.

检测人
Checked by:

谢敏

审核人
Responsible
Person:

刘树强

检测日期
Checking Date: 2023.3.3



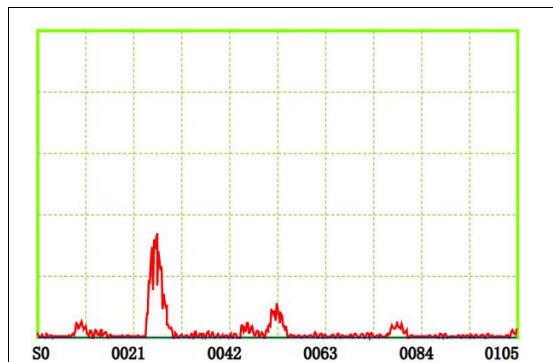
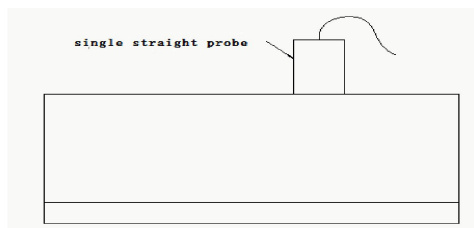
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Hunan Hyster Material Technology Co.,LTD.

焊接质量检测报告 (Welding Quality Report)

检测标准	用音频法和超声波检测焊接质量。每炉随机抽取 1-5%，焊接有效面积不得小于 80%，如有异常，片检。
Test Standard	Sound test and UT, randomly check 1-5% per furnace, the effective brazing area should be > 80%, otherwise 100% full check.

工件名称: Item NO.	WEAR BUTTON 75, $\phi 75 \times 17/10$ mm		
探头类型 Probe Type	双直 Twin straight probe	材料声速 Material's sound velocity	5900
晶体尺寸 Crystal Size	14	标称频率 Frequency	2.5
探头前沿 Leading edge	0	标称K值 Nominal K	0
超声仪器型号 UT Instrument Name	欧能达 3600s	定量偏移 Quantitative deviation	-10
判废偏移 Abandoned deviation	-4	测长偏移 Length Deviation	-16

NOTE: 缺陷波幅不超过 1 次底波的 50% (Defect wave amplitude does not exceed 50% of the bottom wave)



缺陷深度 Coordinate (Y):	26.23
缺陷波幅 Amplitude(%):	81.30%
当前增益 Gain:	38.4

检测结果: 经音频法和超声探测, 该样品焊接有效面积 >80%, 并且表面无明显缺陷, 合格, 允许放行,
Conclusion: The effective brazing area is above than 80%, and there is NO gap on the welding surfaces, no visible porosity, pit, scab or any kind of visible discountinuities, qualified.

检测人
Checked by:

谢敏

审核人
Responsible
Person:

刘树强

检测日期
Checking Date: 2023.1.9

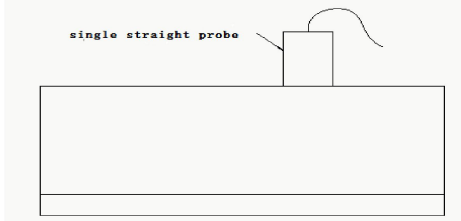
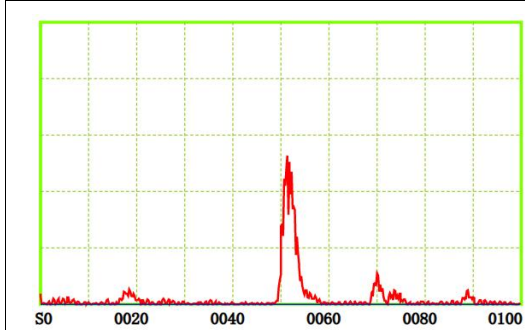


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Hunan Hyster Material Technology Co.,LTD.

焊接质量检测报告 (Welding Quality Report)

检测标准	用音频法和超声波检测焊接质量。每炉随机抽取 1-5%，焊接有效面积不得小于 80%，如有异常，片检。		
Test Standard	Sound test and UT, randomly check 1-5% per furnace, the effective brazing area should be > 80%, otherwise 100% full check.		
工件名称: Item NO.	CUTTER KNIFE 300*25*39/12mm		
探头类型 Probe Type	双直 Twin straight probe	材料声速 Material's sound velocity	5900
晶体尺寸 Crystal Size	14	标称频率 Frequency	2.5
探头前沿 Leading edge	0	标称K值 Nominal K	0
超声仪器型号 UT Instrument Name	欧能达3600s	定量偏移 Quantitative deviation	-10
判废偏移 Abandoned deviation	-4	测长偏移 Length Deviation	-16

NOTE: 缺陷波幅不超过 1 次底波的 50% (Defect wave amplitude does not exceed 50% of the bottom wave)

		
	缺陷深度 Coordinate (Y):	51.46
	缺陷波幅 Amplitude(%):	80.50%
	当前增益 Gain:	50.3

检测结果：经音频法和超声探测，该样品焊接有效面积 >80%，并且表面无明显缺陷，合格，允许放行，
Conclusion: The effective brazing area is above than 80%, and there is NO gap on the welding surfaces, no visible porosity, pit, scab or any kind of visible discountinuities, qualified.

检测人
Checked by:

谢毅

审核人
Responsible
Person:

刘树良

检测日期
Checking Date: 2023.3.15



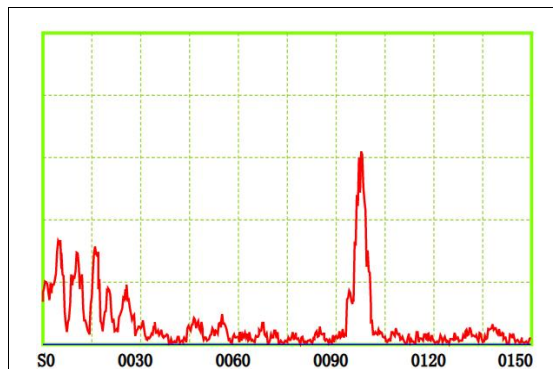
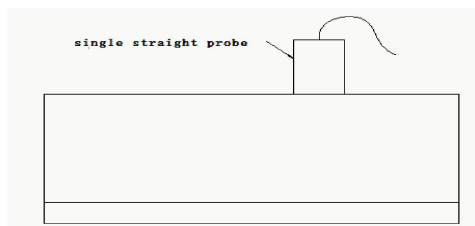
湖南海斯特材料科技有限公司
Hunan Hyster Material Technology Co.,LTD.

焊接质量检测报告 (Welding Quality Report)

检测标准	用音频法和超声波检测焊接质量。每炉随机抽取 1-5%，焊接有效面积不得小于 80%，如有异常，片检。
Test Standard	Sound test and UT, randomly check 1-5% per furnace, the effective brazing area should be > 80%, otherwise 100% full check.

工件名称: Item NO.	WEAR BLOCKS DLP 4716 PERFORADO, 318*100*75/25mm		
探头类型 Probe Type	双直 Twin straight probe	材料声速 Material's sound velocity	5900
晶体尺寸 Crystal Size	14	标称频率 Frequency	2.5
探头前沿 Leading edge	0	标称K值 Nominal K	0
超声仪器型号 UT Instrument Name	欧能达 3600s	定量偏移 Quantitative deviation	-10
判废偏移 Abandoned deviation	-4	测长偏移 Length Deviation	-16

NOTE: 缺陷波幅不超过 1 次底波的 50% (Defect wave amplitude does not exceed 50% of the bottom wave)



缺陷深度 Coordinate (Y):	99.8
缺陷波幅 Amplitude(%):	80.60%
当前增益 Gain:	67

检测结果: 经音频法和超声探测, 该样品焊接有效面积 >80%, 并且表面无明显缺陷, 合格, 允许放行,
Conclusion: The effective brazing area is above than 80%, and there is NO gap on the welding surfaces, no visible porosity, pit, scab or any kind of visible discountinuties, qualified.

检测人
Checked by:

谢敏

审核人
Responsible
Person:

刘树华

检测日期
Checking Date: 2023.3.11

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