



**WEGUSTA
HOLLAND**

**PRODUCT TEST AND ANALYSIS REPORT
(EN 10204 3.1)**

CUSTOMER	: WEGUSTA HOLLAND	TYPE OF PATTERN	: WOODEN
ORDER NUMBER	: 70220426	TYPE OF CASTING	: STEEL CASTING
PART NAME	: WHEEL WH5255 Drawing No:2022010-001		
CASTING NUMBER)	: 22.0834 1-2-3-4	DATE OF CASTING	: 27.10.2022
MATERIAL	: Gs26CrMo4 QT / EN 10293	REPORT NUMBER	: 22/690

RESULTS OF CHEMICAL ANALYSIS

	C %	Si %	Mn %	P %	S %	Cr %	Mo %	Ni %	Cu %	V %	Mg %
min.	0,22	-	0,50	-	-	0,80	0,15				
Bulunan (Obtained)	0,26	0,34	0,80	0,013	0,020	1,16	0,25				
max.	0,29	0,60	0,80	0,025	0,020	1,20	0,30				

MECHANICAL PROPERTIES

	TENSILE STRENGTH	% 0,2 PROOF STRENGTH	ELONGATION	HARDNESS
Required	650-800 MPa	min. 400 MPa	min %8	190-240 HB
ObtaineD)	771,8	648,6	20,0%	220-230 HB

METALLOGRAPHICAL PROPERTIES

MARTENSITIC

NOTES :

The tensile test specimen was cut from the 15 mm inside of the cast part.

RESULT

ACCEPTED

V

ACCEPTED COND

REJECTED

TESTED BY	DATE OF TEST	APPROVED BY	DATE OF APPROVAL
(QUALITY CONTROL CHIEF) 	27.10.2022	(QUALITY MANAGER)	27.10.2022

FORM NO : FKS/45

REVIZYON NO : 01



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**PRODUCT TEST AND ANALYSIS REPORT
(EN 10204 3.1)**

CUSTOMER	: WEGUSTA HOLLAND	TYPE OF PATTERN	: WOODEN
ORDER NUMBER	: 70220426	TYPE OF CASTING	: STEEL CASTING
PART NAME	: WHEEL WHS255 Drawing No:2022010-001		
CASTING NUMBER)	: 22.0834 5-6-7-8	DATE OF CASTING	: 26.11.2022
MATERIAL	: Gs26CrMo4 QT / EN 10293	REPORT NUMBER	: 22/715

RESULTS OF CHEMICAL ANALYSIS

	C %	Si %	Mn %	P %	S %	Cr %	Mo %	Ni %	Cu %	V %	Mg %
min.	0,22	-	0,50	-	-	0,80	0,15				
Obtained	0,25	0,32	0,60	0,012	0,024	0,96	0,22				
max.	0,29	0,60	0,80	0,025	0,020	1,20	0,30				

MECHANICAL PROPERTIES

	TENSILE STRENGTH	% 0,2 PROOF STRENGTH	ELONGATION	HARDNESS
Required	650-800 MPa	min. 400 MPa	min %8	190-240 HB
ObtaineD)	792	680,1	18,0%	220-230 HB

METALLOGRAPHICAL PROPERTIES

MARTENSITIC

NOTES :

RESULT

ACCEPTED

V

ACCEPTED COND

REJECTED

TESTED BY	DATE OF TEST	APPROVED BY	DATE OF APPROVAL
(QUALITY CONTROL CHIEF) 	26.11.2022	(QUALITY MANAGER)	26.11.2022

FORM NO : FKS/45

REVIZYON NO : 01



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(EN 10204 3.1)**

CUSTOMER	: WEGUSTA HOLLAND	TYPE OF PATTERN	: WOODEN
ORDER NUMBER	: 70220426	TYPE OF CASTING	: STEEL CASTING
PART NAME	: WHEEL WH5255 Drawing No:2022010-001		
CASTING NUMBER)	: 22.0834 9-10-11-12	DATE OF CASTING	: 2.12.2022
MATERIAL	: Gs26CrMo4 QT / EN 10293	REPORT NUMBER	: 22/679

RESULTS OF CHEMICAL ANALYSIS

	C %	Si %	Mn %	P %	S %	Cr %	Mo %	Ni %	Cu %	V %	Mg %
min.	0,22	-	0,50	-	-	0,80	0,15				
Obtained	0,25	0,33	0,67	0,020	0,018	0,97	0,22				
max.	0,29	0,60	0,80	0,025	0,020	1,20	0,30				

MECHANICAL PROPERTIES

	TENSILE STRENGTH	% 0,2 PROOF STRENGTH	ELONGATION	HARDNESS
Required	650-800 MPa	min. 400 MPa	min %8	190-240 HB
Obtained)	782,2	666,7	17,0%	220-230 HB

METALLOGRAPHICAL PROPERTIES

MARTENSITIC

NOTES :

RESULT

ACCEPTED

V

ACCEPTED COND

REJECTED

TESTED BY	DATE OF TEST	APPROVED BY	DATE OF APPROVAL
(QUALITY CONTROL CHIEF) 	2.12.2022	(QUALITY MANAGER)	2.12.2022

FORM NO : FKS/45

REVIZYON NO : 01



**WEGUSTA
HOLLAND**

**PRODUCT TEST AND ANALYSIS REPORT
(EN 10204 3.1)**

CUSTOMER	: WEGUSTA HOLLAND	TYPE OF PATTERN	: WOODEN
ORDER NUMBER	: 70220426	TYPE OF CASTING	: STEEL CASTING
PART NAME	: WHEEL WH5255 Drawing No:2022010-001		
CASTING NUMBER)	: 22.0834 13-14-15-16	DATE OF CASTING	: 9.12.2022
MATERIAL	: Gs26CrMo4 QT / EN 10293	REPORT NUMBER	: 22/781

RESULTS OF CHEMICAL ANALYSIS

	C %	Si %	Mn %	P %	S %	Cr %	Mo %	Ni %	Cu %	V %	Mg %
min.	0,22	-	0,50	-	-	0,80	0,15				
Obtained	0,26	0,25	0,69	0,013	0,018	0,93	0,20				
max.	0,29	0,60	0,80	0,025	0,020	1,20	0,30				

MECHANICAL PROPERTIES

	TENSILE STRENGTH	% 0,2 PROOF STRENGTH	ELONGATION	HARDNESS
Required	650-800 MPa	min. 400 MPa	min %8	190-240 HB
ObtaineD)	768	642	20,0%	220-230 HB

METALLOGRAPHICAL PROPERTIES

MARTENSITIC

NOTES :

RESULT

ACCEPTED

V

ACCEPTED COND

REJECTED

TESTED BY	DATE OF TEST	APPROVED BY	DATE OF APPROVAL
(QUALITY CONTROL CHIEF) 	9.12.2022	(QUALITY MANAGER)	9.12.2022

FORM NO : FKS/45

REVIZYON NO : 01

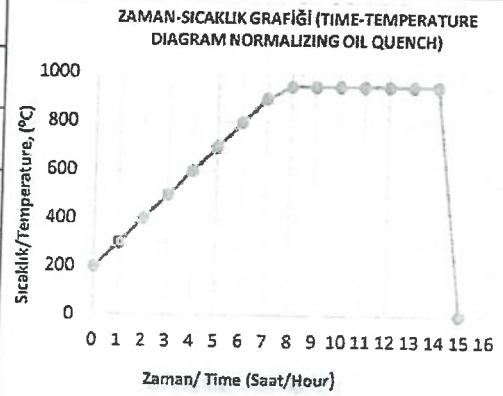
**WEGUSTA HOLLAND****HEAT TREATMENT REPORT**

CUSTOMER :	TYPE OF CASTING : STEEL CASTING
PART NAME : WHELL	DATE OF PROCESS : 2.12.2022
PART NUMBER : Drw.No:2022010	CASTING NUMBER : 22.0834
MATERIAL : Gs26CrMo4 QT2	WEIGHT OF CAST : 4+4+4+4 PCS
ORDER NO: 70220426	REPORT NUMBER : 22/078

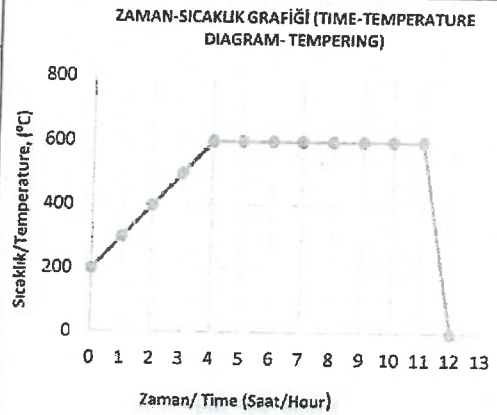
ISIL İŞLEM TÜRÜ (TYPE OF HEAT TREATMENT)

STRESS RELIEVING ☐	NORMALIZING ☒	TEMPERING ☒	CYCLE ANNEALING ☐
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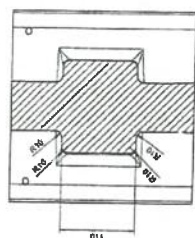
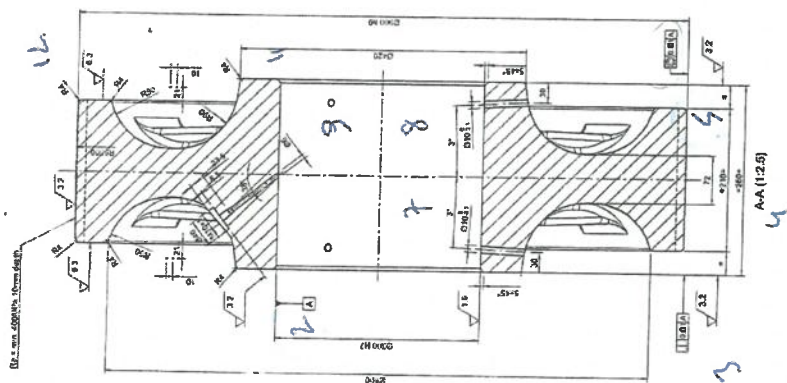
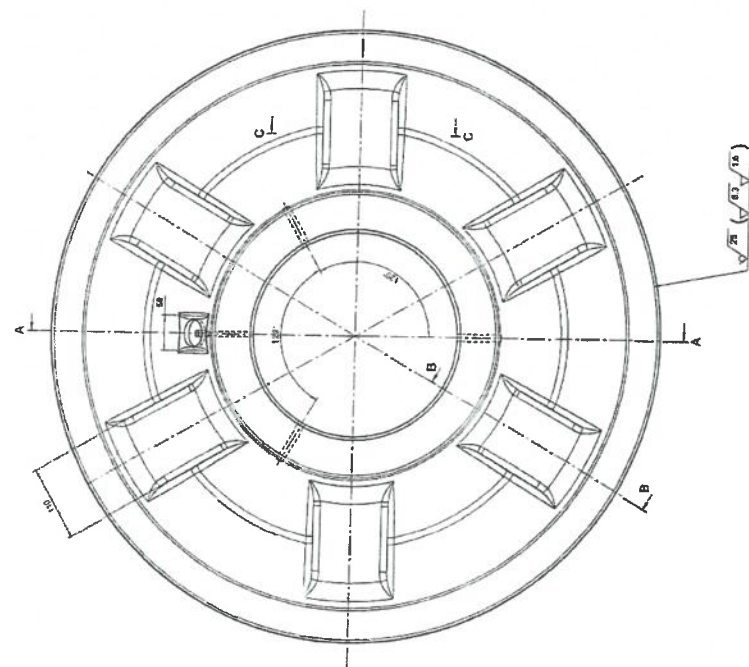
	(Description)	(Required)	Tolerance	Applied
1	STARTING TEMPERATURE	max.300	-	200
2	(HEATING RATE)	max.100	-	100
3	(HOLDING TEMPERATURE)	950	± 10	950
4	(HOLDING TIME)	min.3	-	6
5	(COOLING RATE)	WATER	-	WATER
6	(FINISHING TEMPERATURE)	-	-	-



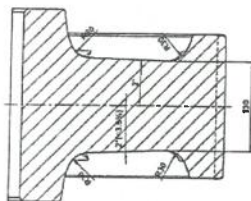
	(Description)	Required	Tolerance	Applied
1	STARTING TEMPERATURE	max.300	-	200
2	(HEATING RATE)	max.100	-	100
3	HOLDING TEMPERATURE	600-650	± 10	600
4	HOLDING TIME	min.3	-	7
5	COOLING RATE	AIR	-	AIR
6	FINISHING TEMPERATURE	-	-	-

**(NOTES)**

(PREPARED BY)	(DATE)	APPROVED BY	DATE
(QUALITY CONTROL CHIEF)	2.12.2022	(QUALITY MANAGER)	2.12.2022



C-C (1:2.5)



B-B (1:2.5)

Material: GS 26CrMo4 (1.7221) +QT
 DIN EN 10293
 Re= min. 400 Mpa 10mm depth
 After hardening, tempering should be carried out at low temperature

Mechanical characteristics:
 Re = min. 400 MPa
 Rm = 650 - 800 MPa
 A5 = min. 8 %
 After hardening, tempering should be carried out at low temperature

Casting Technology: DIN EN 12542:2010-11

Wiel	WHS205
2	15.22

APPROVED BY
QUALITY MANAGER