

Heat treatment site:	SIA Madesta, Rencēnu iela 8, Riga, LV-1073
Positions of the df in the furnace:	Horizontal at center of the hot zone and stacked one upon another
Type of furnace:	Model type: CDO-16.45.12/10 type: Electric 500.0 kW.5 Furnace Temperature range: 40-1000 °C.

Process start time	06.01.2021
HEAT TREATMENT PROCEDURE	GI-8.5/09

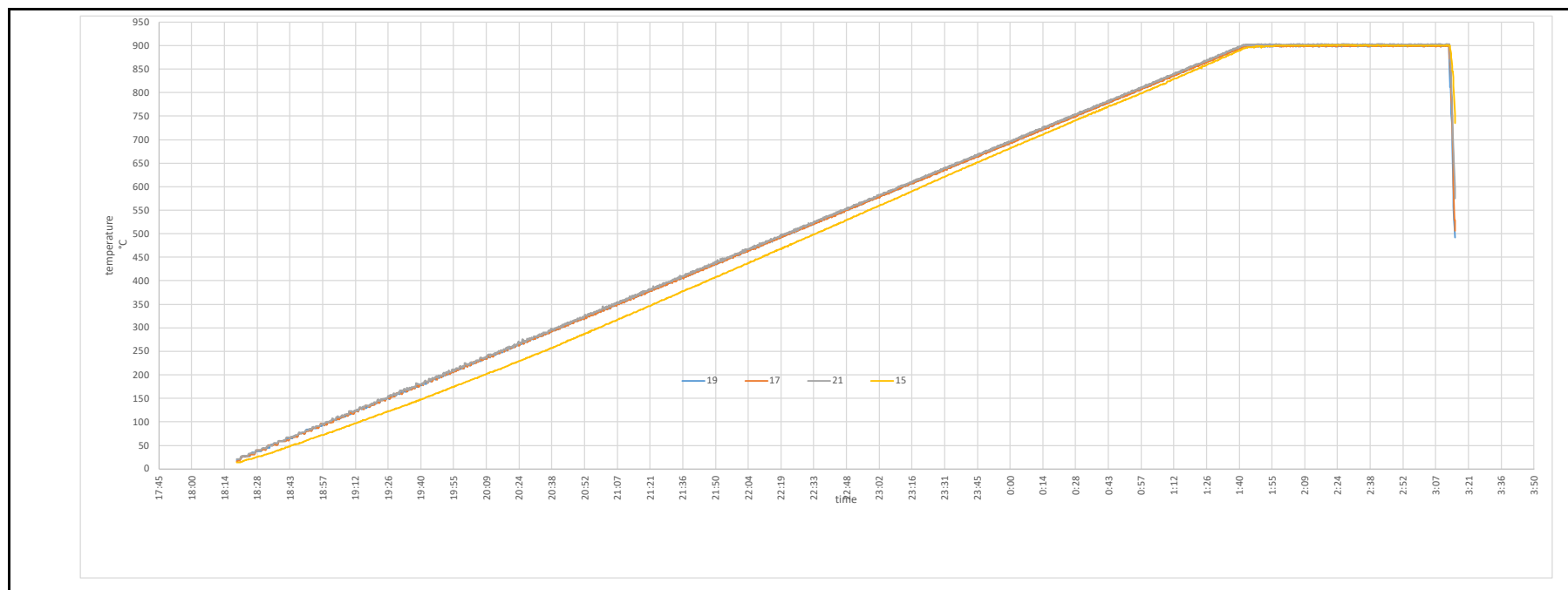
	Part list	Material
1	Madesta 2021 4272	S355NL+Z25
2	Madesta 2021 4273	S355NL+Z25
3	Madesta 2021 4274	S355NL+Z25

Weight
2824

Qty
5

VT inspection report
Madesta 2021 4272-2020

	samp no	heat no	part no	list no	
4	8766	664975	164599	1	S355NL+Z25
5	8767	664975	164599	1	S355NL+Z25



Set parameters
150 °C/h
910 °C ±5°C / minimum 15min
free air < 250 °C

Measured parameters
144 °C/h
909 °C (902,4°C - 913,6°C)
-104 °C

Phase	Time
Heating	7h 32min
Holding	119min
Cooling	7h 44min

N. Smirnov

