



Tungsten Iridium Stream Mouth Standard YS/T 854—2012

The Chinese standard working now is YS/T 854-2012 Tungsten Iridium Stream Mouth under the nonferrous metal industry standard issued by the Ministry of Industry and Information Technology of the People's Republic of China.

1.0 Range

This standard rules the requirements, testing method, inspection rules, label, packing, transportation, storage, quality certificate and contract content.

The product under the standard is made by powder metallurgy and used in aluminosilicate refractory fiber manufacture industry.

2.0 Standards Applied

The standard with year is used the one updated in the year and if without year, the latest updated one is applied.

GB/T 3458—2006 Tungsten Powder

GB/T 3850 Impermeable sintered metal materials and hardmetals – Determination of density

YS/T 790—2012 Iridium Tube

3.0 Requirements

3.1 Category

There are two specifications of tungsten body and seven of iridium tube. See table 1 (unit: mm).

Table 1 Specifications

Tungsten Body	Iridium Tube		
	OD	L	T
Ø66x100 Ø88x80	5.5	27±1	0.6/0.7/0.8
	6.0		
	6.5		
	7		
	8		
	10		
	12		

(Customized specifications can be offered.)



3.2 Raw material

The raw material of tungsten body should be matched with the requirements of FW-1 of GB/T 3458—2006 and iridium tube of YS/T 790—2012.

3.3 Shape, dimensions and tolerances

3.3.1 Refer to attachment 2.

3.3.2 Dimensions and tolerances see table 2 (Unit: mm).

Table 2 Dimensions and Tolerances

Specification of Tungsten Body	φ66x100	φ88x80
OD	66±3	88±5
ID	58±2	72±2
R on Top	10~15	20~25
θ	36°	45°
H (Total)	100±2	80±2
H1	55±2	46±2
H2	24±1	24±1

3.4 Density of tungsten body

The density of tungsten should be $\geq 17.7\text{g/cm}^3$.

3.5 Bonding strength

The bonding strength of tungsten and iridium tube should pass the testing of keeping iridium tube 10s without dropping under 1000g weight.

3.6 Appearance

3.6.1 The product appearance should be clean, smooth, no breakage, no holes, no deformation and other drawbacks.

3.6.2 The inner side of iridium tube should be smooth, no holes, no breakage and other drawbacks.

4.0 Testing method

4.1 Dimensions and tolerances should use the related accurate measures to measure.

4.2 The density is tested according to GB/T 3850.



4.3 The bonding strength is testing according to Attachment A.

4.4 Appearance is tested by visual inspection.

5. Inspection Rules

5.1 Inspection and acceptance

5.1.1 The products inspection is performed by the Seller. After the products are approved according to the standard and contracts, the supplier should provide the certificate of quality.

5.1.2 The products should be inspected after the receipt by the Buyer according to the standard. If there are differences from the certificate of quality, the buyer should issue within 3 months and negotiate with the Seller.

5.2 Lots

Products should be inspected in the same lot. Each lot owns the same grade, production method, specification and heat number.

5.3 Inspection Items and Sampling

The inspection items and sampling should be matched as table 3.

Table 3 Inspection Items and Sampling

Inspection Item	Sample Quantity	Standard of Requirements	Standard of Inspection
Dimensions	All	3.3	4.1
Density	10x10x10 mm	3.4	4.2
Bonding Strength	All	3.5	4.3
Appearance	All	3.6	4.4

5.4 Inspection Result

5.4.1 If the density is lower than 17.7g/cm³, the whole lot is rejected.

5.4.2 If the dimensions, bonding strength and appearance are not passed, the one with discrepancy is rejected.

6. Label, packing, transportation, storage and certificate of quality

6.1 Label

Approved products should be labeled with information of the Seller, product name, specification and lot number.

6.2 Packing

the product should be packed with white paper first, and pack in boxes in one layer. Each box cannot excess 6pcs.



6.3 Transportation and Storage

the products should be prevented from shaking, striking and strong pressing during transportation and storage.

6.4 Certificate of quality

The certificate of quality should be provided with each lot, and with the information followed:

6.4.1 The seller

6.4.2 Product name and specification

6.4.3 Lot number and quantity

6.4.4 Inspection result and signature from quality department

6.4.5 Standard number

6.4.6 Packing date

7.0 Contract or order content

The information is required when to order the stream mouth based on this standard:

7.1 Product name

7.2 Specification

7.3 Quantity

7.4 Standard number

7.5 Others

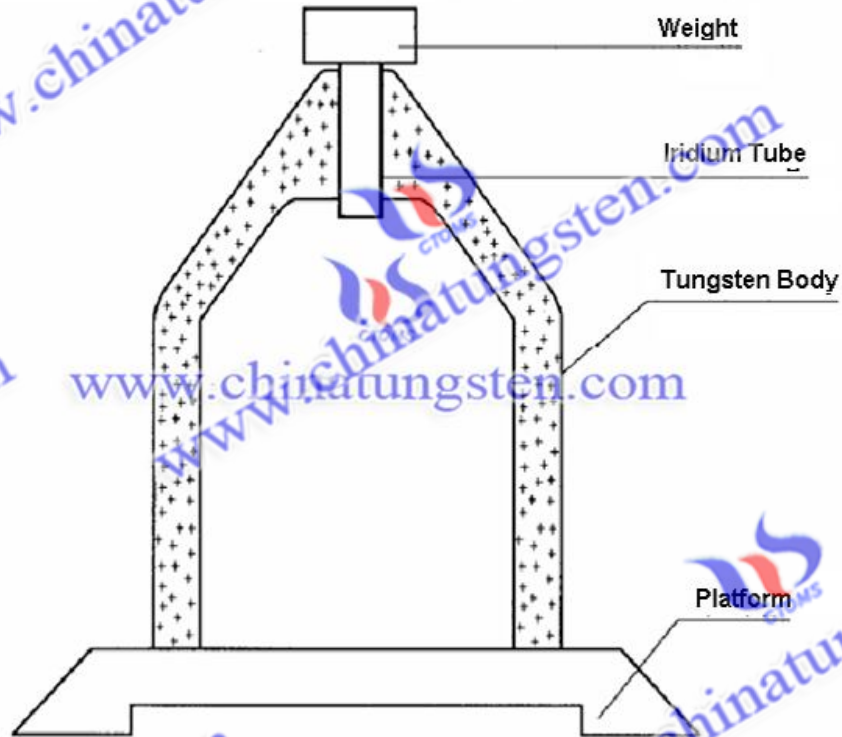


Attachment A

Testing Method of Tungsten Body and Iridium Tube Bonding Strength

A. 1 Testing Process

A.1.1 Put the finished stream mouth on the platform as following, mouth is on the surface of platform.



A. 1 Inspection Method of Bonding Strength of Tungsten Body and Iridium Tube

A.1.2 Add 1000g weight on the top of iridium tube, and keep the weight 10s.