

Information about the content

<b>Scope:</b>	Plansee SE	<b>Prepared/Updated:</b>	Abenthung Peter
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This document is subject to electronic version control – confirm revision status before using.

*This specification covers the most significant properties of Tungsten rods in fixed length including packaging.*

The specification is valid for the following products:

Material	Diameter [mm]	Product Specification
S-WVMW	25,0 - 40,0	PSE-610-PS-155
WVMW	15,0 - 30,0	PSE-610-PS-125
WL-S	5,0 - 10,0	PSE-610-PS-172

## 1 Dimensions and tolerances

### 1.1 Diameter and guaranteed product tolerances

Diameter [mm]	Diameter tolerance [mm]
5,0 - < 16,0	± 0,015
16,0 - < 25,0	± 0,015
25,0 - < 35,0	± 0,050
35,0 - < 40,0	± 0,060
40,0	± 0,10



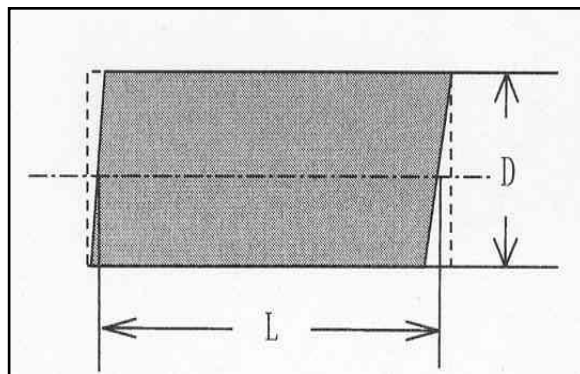
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### 1.2 Guaranteed length tolerances

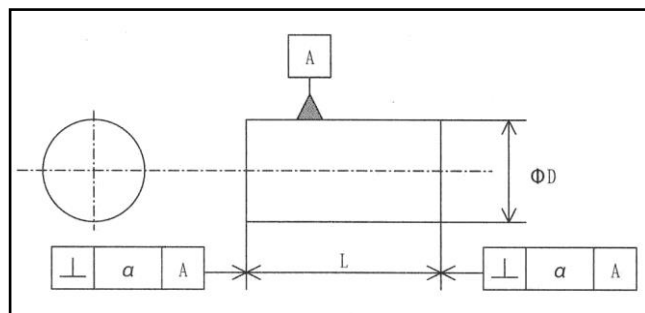
Length [mm]	Tolerance [mm]
15,0 - 120,0	L <sup>a)</sup> ± 0,30
> 120,0 - 200,0	L <sup>a)</sup> ± 0,50
> 200,0 - 1000	L <sup>a)</sup> ± 1,20

a) L ≡ Nominal Length



### 1.3 Angle of cut surface

Diameter "D" [mm]	Tolerance "α" [mm]
5,0 – 10,0	< 0,10
> 10,0 – 20,0	< 0,20
> 20,0 – 40,0	< 0,30



## 2 Physical and mechanical product properties

According to actually valid Product Specification:

Material	Product Specification
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WVMW	PSE-610-PS-125
WL-S	PSE-610-PS-172



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## 2.1 Surface condition

The lateral surface is centerless ground

Diameter [mm]	Ra-value [µm] (centerless ground)
5,0 - 30,0	< 1,0
> 30,0 - 40,0	< 1,2

## 2.2 Defects

See catalogue of defects – inspection of cut W-rods

## 2.3 Test frequency for final inspection

Sampling acc. to ANSI/ASQC Z1.4 - single sampling - general inspection level II

Material	Feature			
	Diameter	Length	Angle	Visual inspection
S-WVMW	AQL 0.4 <sup>a)</sup>	100 %	100 %	100 %
WVMW	AQL 0.4 <sup>a)</sup>	AQL 0.4 <sup>a)</sup>	AQL 0.4 <sup>a)</sup>	AQL 0.4 <sup>a)</sup>
WL-S	AQL 0.4 <sup>a)</sup>	AQL 0.4 <sup>a)</sup>	AQL 0.4 <sup>a)</sup>	100 %

a) 100% inspection in case of the detection of one or more defective samples

## 3 Chemical composition

According to actually valid Product Specification:

Material	Product Specification
S-WVMW	PSE-610-PS-155
WVMW	PSE-610-PS-125
WL-S	PSE-610-PS-172



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## PRODUCT SPECIFICATION

## 4 Packaging, labelling, storage and certification

### 4.1 Packaging, labelling and storage

#### *Standard individual packing:*

##### **General rule:**

The type of packaging is chosen in order to protect the rods sustainably against damage, contamination and impurity.  
Each packing unit is marked with a Plansee-standard label, containing all information for the traceability of the material.

#### *Special packing:*

##### **On request:**

Packaging will be done in safe and stable plastic boxes with suitable filling material.

- A label is put on every box.
- The declarations are printed in Japanese and in English language.



Empty plastic box for Tungsten rods including filling material and label



## 4.2 Inspection documents

Following inspection documents will be supplied upon customer request according to EN 10 204:

### *Test report 2.2*

Plansee confirms with this test report that the delivered product meets the specification and gives details of the material properties according to ongoing production surveillance, not directly related to the particular production batch.

### *Inspection certificate 3.1* (extra costs will be invoiced)

An inspection officer from Plansee confirms with this inspection certificate that the delivered product meets the specification and gives test results related to the particular production batch.

## 5 Order instructions

Please quote following information when ordering:

- Product description
- Quality (the number of this specification must be mentioned)
- Surface condition
- Dimension
- Quantity in m or kg
- Required certificate and content in case of a 3.1 inspection certificate
- *For special packing:* Specification of packaging

For further information on our delivery possibilities, please look into our <http://www.plansee.com>

## 6 Referenced standards

The standards applied for the test methods are listed in the Plansee standard InfoBase and are made available upon request.

### **PSE Documents:**

PSE-610-PS-xxx      PSE Product Specifications  
PSE-610-CD-195      Catalogue of Defects

### External Documents:

DIN ISO 2859-1      AQL Sampling schemes



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**Changes to last version:**

Replacement for PS-MPR-173

- New Document numbering key
- New Document layout
- Description
- Dimensions updated
- WT20 and WVMWT removed
- Section 4: Color marking removed



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