

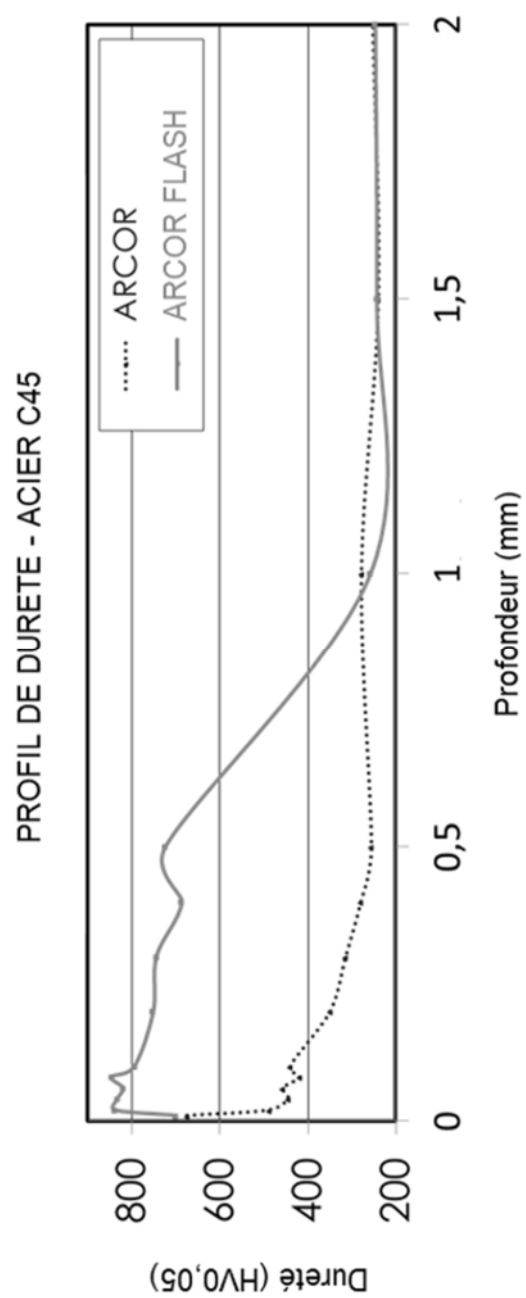


FIGURE 1

Essais	E1	E2	E3	E4	E5	E6	E7	E8	E9	E10	E11	E12	E13
Acier													
Fréquence (kHz)	10	100	100	100	100	50	400	50	400	C10	C10	C70	42CD4
Puissance (kW)	300	100	100	100	100	100	100	100	100	100	100	100	100
Vitesse de défilement (mm/min)	1250	1250	1400	1300	1000	1250	1250	1100	1100	1000	1250	1250	1100
Vitesse de défilement (mm/s)	21	21	23	22	17	21	21	18	18	17	21	21	18
Inverse de la vitesse de défilement (s/mm)	0,048	0,048	0,043	0,046	0,060	0,048	0,048	0,055	0,055	0,060	0,048	0,048	0,055
Energie E (Px) en Joule (W.s) par mm	14,4	4,8	4,3	4,6	6,0	4,8	4,8	5,5	5,5	6,0	4,8	4,8	5,5
Qualité couche de combinaison après Induction	NOK	OK	OK	OK	NOK	OK	OK	OK	OK	NOK	OK	OK	OK
Dureté couche de combinaison après Induction (HV0,05)	300	600	600	600	300	600	600	600	600	300	400	800	800
Profondeur d'induction (mm)	2,9	0,6	0,45	0,5	0,65	0,6	0,6	0,6	0,6	0,7	0,5	0,65	0,55
Dureté de surface (HRC)	60	60	45	50	60	60	60	60	60	55	55	65	62
Tenue corrosion BS (h)	24	120	120	120	24	96	144	120	144	24	96	120	120
HV à cœur	250	250	250	250	250	250	250	250	250	200	200	300	280
HV ≥ HV+100 à 0,5mm de profondeur	775	750	250	350	750	750	750	750	750	650	325	775	500
HV ≥ HV+350 à 0,25mm de profondeur	825	800	750	800	800	800	800	800	800	700	700	875	900

FIGURE 2

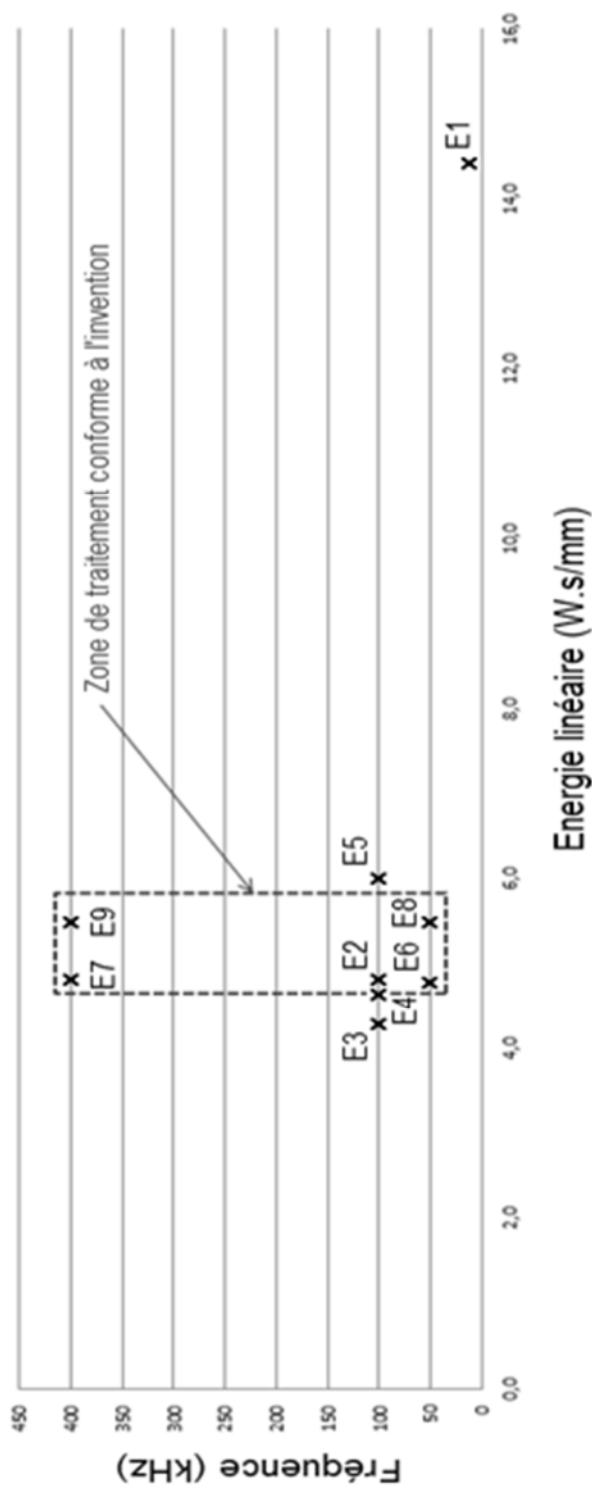


FIGURE 3

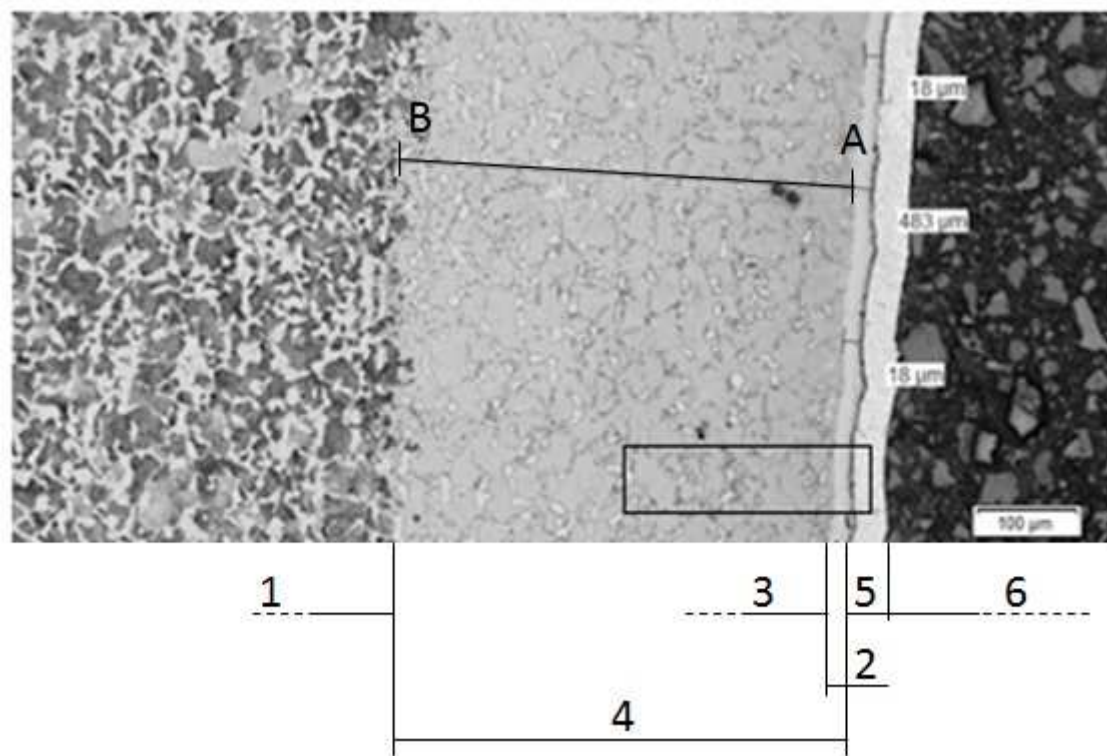


FIGURE 4

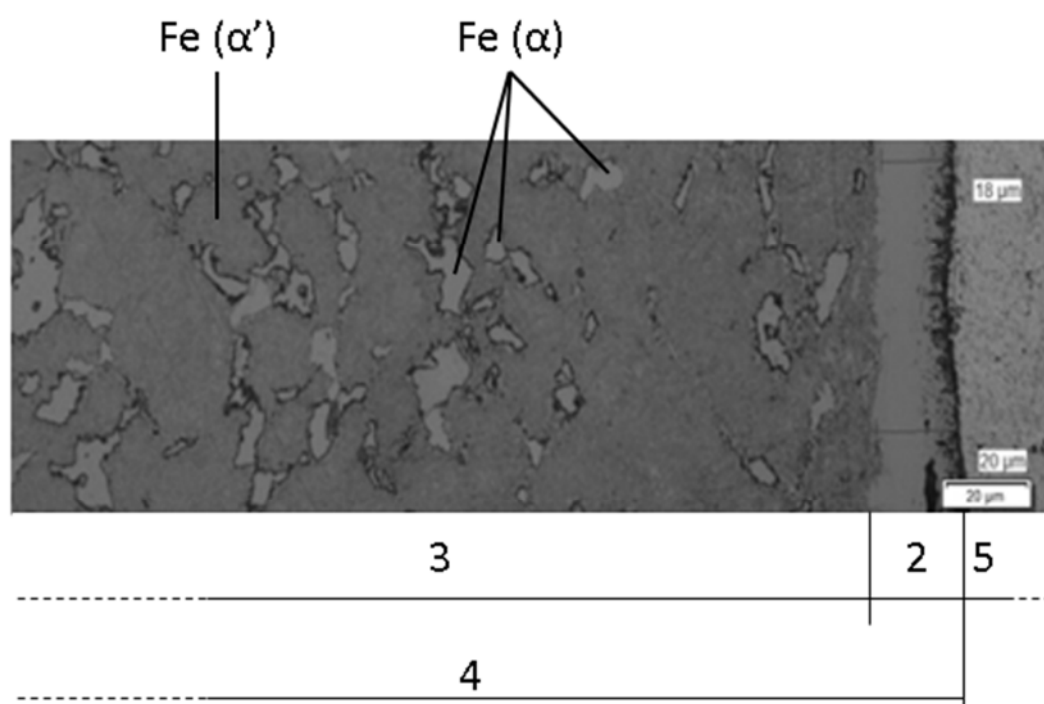


FIGURE 5

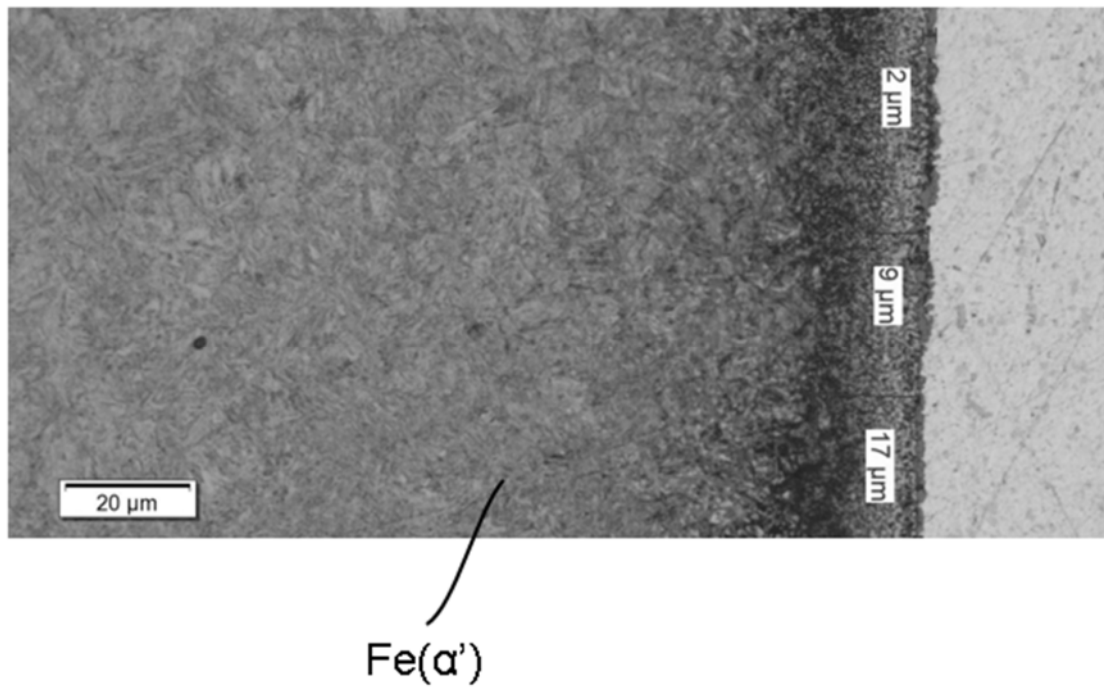


FIGURE 6

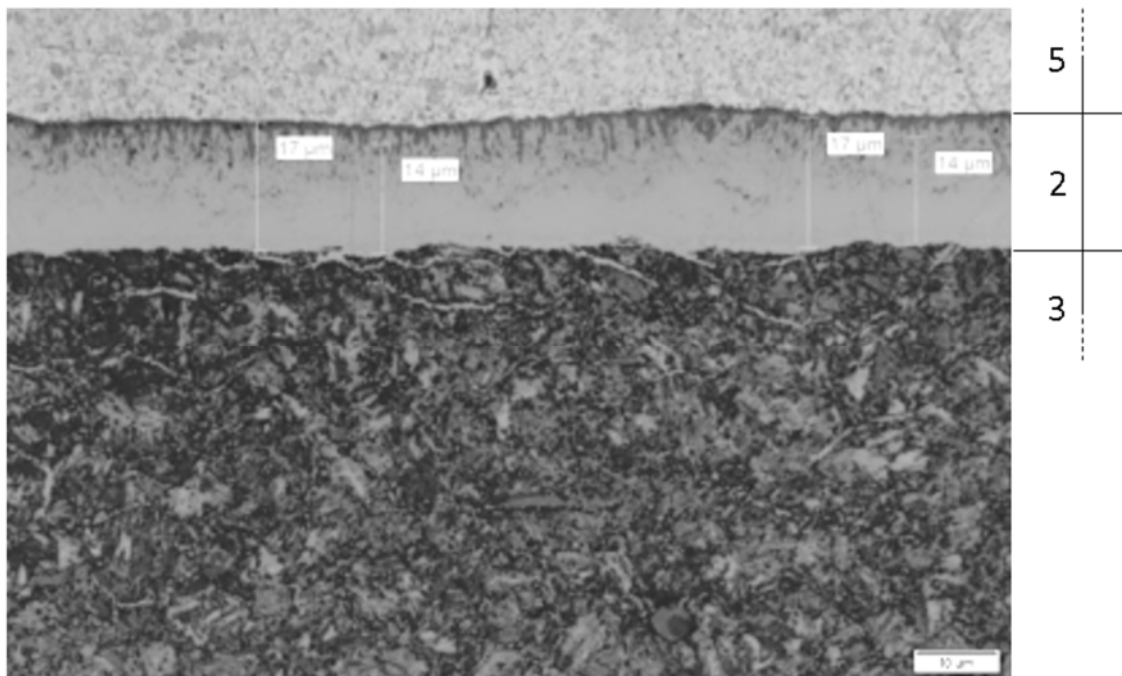


FIGURE 7

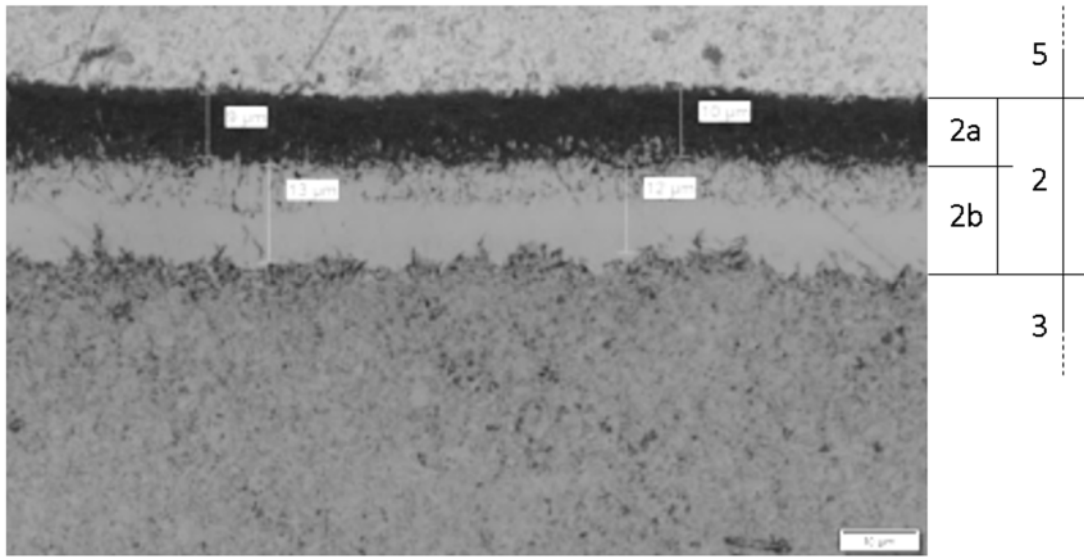


FIGURE 8

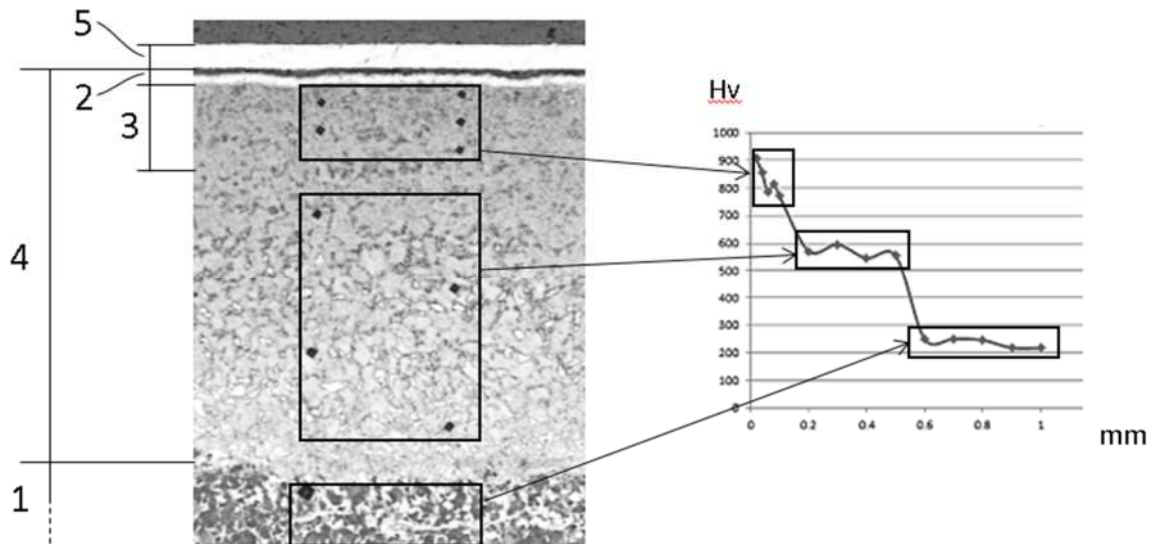


FIGURE 9

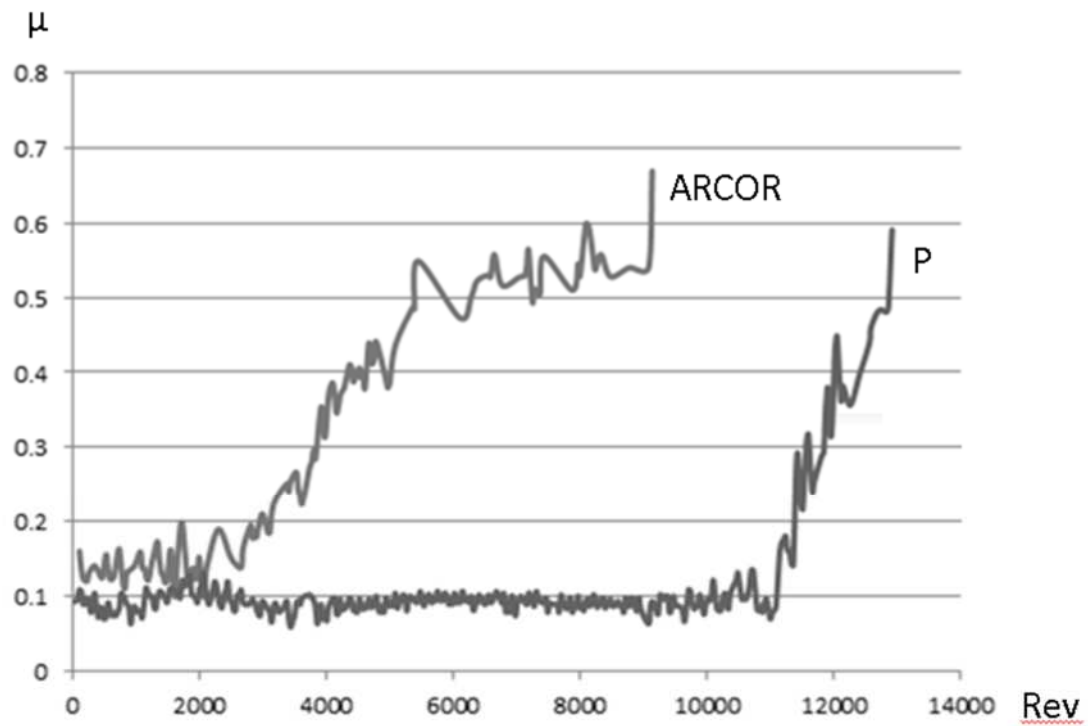


FIGURE 10

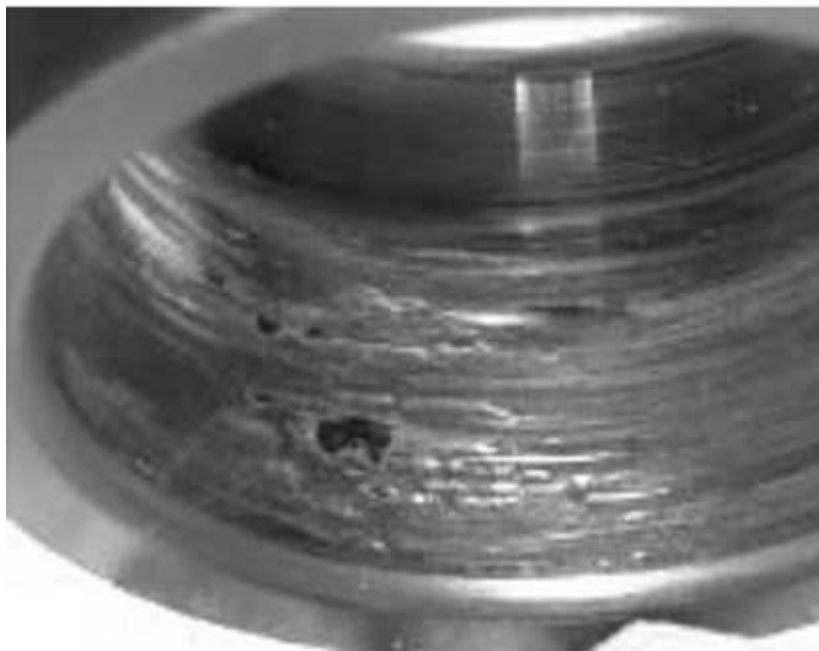


FIGURE 11

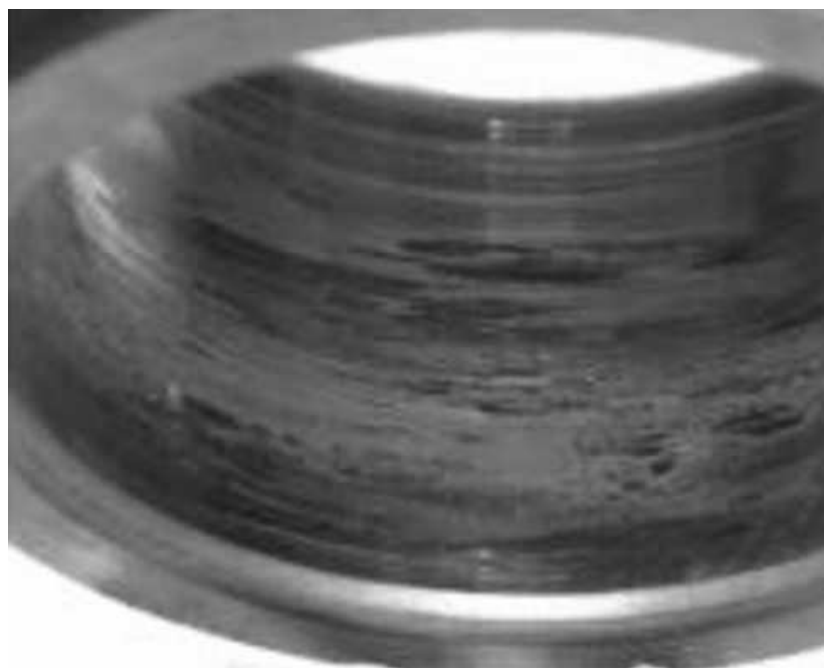


FIGURE 12

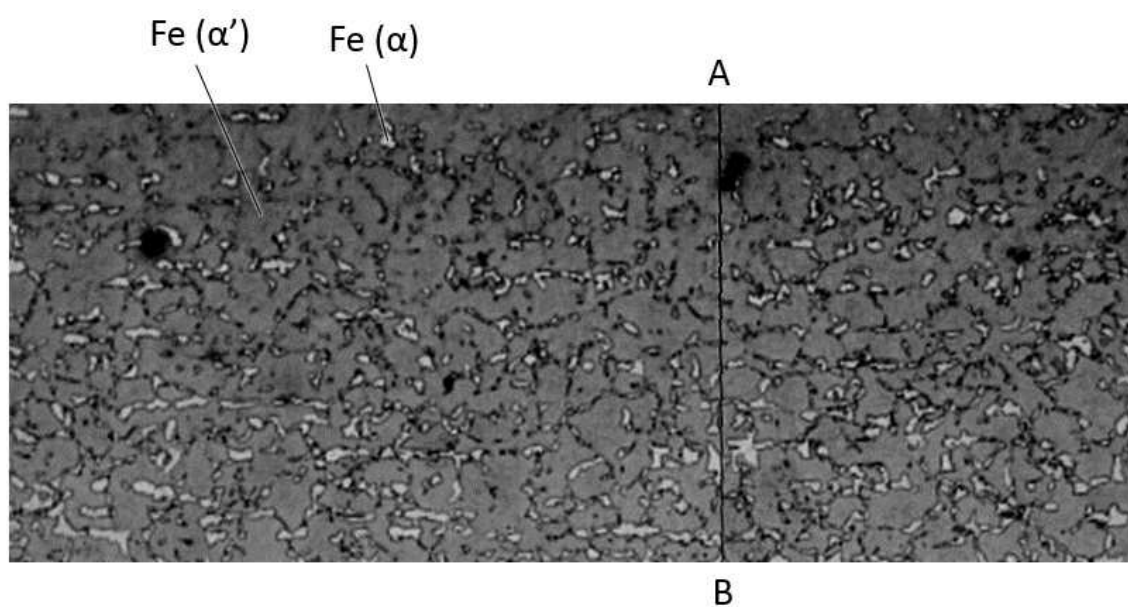


FIGURE 13