



INTYG

Nr. A/09-919267 Rev 00
Datum 2009-11-25 Sida 1/2KONTROLLINTYG enligt
EN 10 204 3.1Processkontroll Items AB
Box 2088
444 02 STORA HÖGA
SWEDENINSPEKTIONSSTÄMPEL
QA-TUBE

Kundreferenser 708053 SÖDERSTRÖM 003-00991 ITEMS		Sandvik Referenser <table><tr><td>Order Nr.</td><td>Subs Nr.</td><td>ABSMT Packnota</td></tr><tr><td>175036</td><td>156015</td><td>38625/54</td></tr><tr><td>ABSMT Nr.</td><td>Int.Kod</td><td></td></tr><tr><td>300-12472</td><td>46</td><td></td></tr></table>	Order Nr.	Subs Nr.	ABSMT Packnota	175036	156015	38625/54	ABSMT Nr.	Int.Kod		300-12472	46																																																																													
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Materialbeskrivning SÖMLÖSA ROSTERIA KALLBEARBETADE HYDRAULRÖR Smältmetod Elektrisk ugn		Stål/materialbeteckningar <table><tr><td>Sandvik</td><td>SS</td></tr><tr><td>3R60</td><td>2353</td></tr></table>	Sandvik	SS	3R60	2353																																																																																				
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LEVERANSOMFATTNING <table><tr><th>Pos</th><th>Produktbeteckning</th><th>Charge</th><th>AO</th><th>Antal</th><th>Kg</th><th>M</th></tr><tr><td>01</td><td>THT-3R60-25-3 25.00 X 3.00</td><td>047271</td><td>92102</td><td>10</td><td>99.0</td><td>60.00</td></tr><tr><td colspan="4"></td><td>Summa</td><td>10</td><td>99.0 60.00</td></tr></table> NYCKEL TILL CHARGE <table><tr><td>Charge kod</td><td>Charge Nr.</td></tr><tr><td>047271</td><td>521935</td></tr></table> NYCKEL TILL AO <table><tr><td>Ao kod</td><td>Ao Nr.</td></tr><tr><td>92102</td><td>4842978/1-1</td></tr></table> PROVNINGSRESULTAT Kemisk sammansättning (vikts%) <table><tr><th>Charge</th><th>C</th><th>Si</th><th>Mn</th><th>P</th><th>S</th><th>Cr</th><th>Ni</th><th>Mo</th></tr><tr><td>047271</td><td>0.018</td><td>0.39</td><td>1.60</td><td>0.029</td><td>0.008</td><td>17.34</td><td>13.11</td><td>2.53</td></tr><tr><td colspan="9">N</td></tr><tr><td>047271</td><td>0.044</td><td colspan="7"></td></tr></table> Dragprovning vid rumstemperatur <table><tr><th rowspan="2">Ao</th><th colspan="2">Sträckgräns</th><th>Brottgräns</th><th>Förlängning</th></tr><tr><th>MPa</th><th>MPa</th><th>MPa</th><th>%</th></tr><tr><td rowspan="2">92102</td><td>Rp0.2</td><td>Rp1.0</td><td>Rm</td><td>A</td></tr><tr><td>249</td><td>277</td><td>583</td><td>54</td></tr><tr><td></td><td>250</td><td>279</td><td>580</td><td>54</td></tr></table>			Pos	Produktbeteckning	Charge	AO	Antal	Kg	M	01	THT-3R60-25-3 25.00 X 3.00	047271	92102	10	99.0	60.00					Summa	10	99.0 60.00	Charge kod	Charge Nr.	047271	521935	Ao kod	Ao Nr.	92102	4842978/1-1	Charge	C	Si	Mn	P	S	Cr	Ni	Mo	047271	0.018	0.39	1.60	0.029	0.008	17.34	13.11	2.53	N									047271	0.044								Ao	Sträckgräns		Brottgräns	Förlängning	MPa	MPa	MPa	%	92102	Rp0.2	Rp1.0	Rm	A	249	277	583	54		250	279	580	54
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Följande kontroller/provningar har utförts med tillfredställande res:

- Ringvidgningsprov
- PMI-provning.
- Interkristallin korrosionsprovning enligt EN ISO3651-2, Metod A.
- Täthetsprovning: Induktivprovning enl SS 114301/114305 E1
- Visuell inspektion och dimensionskontroll.

Värmebehandling:

Upplösningsbehandlat och släckt.

Antalet prover är baserat på A0-storlek före ev.delning.

De levererade produkterna uppfyller specifikationer och krav i ordern.

Materialet är tillverkat enligt ett kvalitetssystem,
godkänt och certifierat mot ISO 9001.

Intyget är ADB-framställt och giltigt utan underskrift.

PROVNINGSRESULTATEN ÖVERFÖRDA FRÅN CERTIFIKAT NR A090961



CERTIFICATE

No. A/09-919267 Rev 00
Date 2009-11-25 Page 1/2INSPECTION CERTIFICATE acc to
EN 10 204 3.1Processkontroll Items AB
Box 2088
444 02 STORA HÖGA
SWEDENINSPECTION STAMP
QA-TUBE

Customer References 708053 SÖDERSTRÖM 003-00991 ITEMS		Customer order 2009-11-23	Sandvik References Order No. 175036 Subs No. 156015 ABSMT No. 300-12472 C.Code 46 ABSMT Dispatch note 38625/54																																																																																									
Material description SEAMLESS STAINLESS COLD FINISHED HYDRAULIC TUBING Steel making process Electric furnace			Steel/material Designations Sandvik SS 3R60 2353																																																																																									
Technical requirements SS 219713 Condition No -24																																																																																												
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Following controls/tests have been satisfactorily performed:

- Ring expansion test
- PMI-test.
- Intergranular corrosion test acc. to EN ISO3651-2, Method A.
- Leak test: Eddy current test acc to SS 114301/114305 E1
- Visual inspection and dimensional control.

Heat Treatment:

Solution annealed and quenched.

The number of tests are based on the size of the manufacturing lot before cutting to finished lengths.

The delivered products comply with the specifications and requirements of the order.

The material is manufactured according to a Quality system, approved and registered to ISO 9001.

The certificate is produced with EDP and valid without signature.

TEST RESULTS TRANSFERRED FROM CERTIFICATE NO A090961