

Type of inspection document : Inspection certificate acc. to EN 10204 / 3.1	A02	Internal order No.: 10056964 - 50	A08
Purchaser : ALLEIMA BENELUX B.V. . AMUNDSENWEG 4 5928 LT VENLO THE NETHERLANDS	A06	Purchase order No. : 800758 Purchaser's reference : 800758 Project Id. : 4003352	A07
Product : Seamless cold finished tube	B01/B04	Steel designation : 3R60 / 3R60	B02
Dimension (OD x WT) : 9,53 x 1,24AW mm	B09/B10	Melting process : AOD	C70
Technical requirements : ASME SA213/SA213M-2021 ASTM A213/A213M-2022 ASTM A269/A269M-2015a (Reap.2019) EN 10216-5 TC1 2021 EN 10305-1 (Only Tolerances-Table 5) PED 2014/68/EU Alleima SPEC S-08921 AD 2000 Merkblatt W2 2022 AD 2000 W10 - 2019 NACE MR0175-2021/ISO 15156-3:2020 NACE MR0103/ISO 17945:2015			B03
Supplementary information : Manufacturing of stainless steel tubes in grade 3R60 / TP316L / UNS S31603 / 1.4435 from steel origin: Alleima Tube AB, Sweden. The qualified pre-material supplier is mentioned in the section "Extent of material delivery". Tube lenght 6000 mm (-0/+5 mm)			B14
The products, covered by this certificate, comply with specification and requirements of the order.			Z01
Originator of the document : QA - AC	A05/Z02	Inspector's stamp:	Z03

Chemical composition (Heat analysis)

Heat	C [%]	Si [%]	Mn [%]	P [%]	S [%]
567589	max 0.030 0,019	max 1.000 0,380	max 2.000 1,700	max 0.040 0,030	max 0.015 0,007

Heat	Cr [%]	Ni [%]	Mo [%]	N [%]
567589	17.000-18.000 17,190	12.500-14.000 13,110	2.500-3.000 2,610	max 0.100 0,040

Type of inspection document :

A02

Inspection certificate acc. to EN 10204 / 3.1

Internal order No.:

A08

10056964 - 50

Product check analysis

Heat	Lot	C [%]	Si [%]	Mn [%]	P [%]	S [%]
		max 0.030	max 1.000	max 2.000	max 0.040	max 0.015
567589	2091981-11	0,016	0,380	1,740	0,026	0,007

Heat	Lot	Cr [%]	Ni [%]	Mo [%]	N [%]
		17.000-18.000	12.500-14.000	2.500-3.000	max 0.100
567589	2091981-11	17,230	12,990	2,550	0,045

Extent of material delivery

Heat	Lot	Hollow supp.	No. of HTcycles ¹⁾	Pieces	Total length [m]	Total weight [kg] ²⁾
567589	2091979-11	ALLEIMA SE	1	584	3 504.000	897.024
567589	2091980-11	ALLEIMA SE	1	589	3 534.000	904.704
567589	2091981-11	ALLEIMA SE	1	591	3 546.000	907.776

Note : ¹⁾ Number of heat treatment cycles performed on the tubes.

²⁾ Weight quantity is theoretically calculated, it might differ compared to shipping documents.

Chomutov, date : 28.3.2023

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Inspection certificate acc. to EN 10204 / 3.1

Internal order No.:

A08

10056964 - 50

Flaring test in acc. with ASTM A 1016

Heat	Lot	ST	Test result [pass/fail]
			pass
567589	2091979-11		pass
567589	2091979-11		pass
567589	2091980-11		pass
567589	2091980-11		pass
567589	2091981-11		pass
567589	2091981-11		pass

Flaring test in acc. with EN 10216-5

Heat	Lot	ST	Test result [pass/fail]
			pass
567589	2091979-11		pass
567589	2091980-11		pass
567589	2091981-11		pass

Flattening test in acc. with ASTM A 1016

Heat	Lot	ST	Test result [pass/fail]
			pass
567589	2091979-11		pass
567589	2091979-11		pass
567589	2091980-11		pass
567589	2091980-11		pass
567589	2091981-11		pass
567589	2091981-11		pass

Hardness test (HRB/HRC) in acc. with E18/S-08921/NACE

Heat	Lot	ST	Hardness [HRB]	Hardness $\leq 22\text{HRC}$ [yes/no]
			max 80,000	yes
567589	2091979-11		79,000	yes
567589	2091979-11		80,000	yes
567589	2091980-11		79,000	yes
567589	2091980-11		80,000	yes
567589	2091981-11		79,000	yes
567589	2091981-11		80,000	yes

Intergranular corrosion testing in acc. with ASTM A262E

Heat	Lot	ST	Test result [pass/fail]
			pass
567589	2091979-11		pass
567589	2091980-11		pass
567589	2091981-11		pass

Type of inspection document :

A02

Inspection certificate acc. to EN 10204 / 3.1

Internal order No.:

A08

10056964 - 50

Intergranular corrosion testing in acc. with EN ISO 3651-2/A

Heat	Lot	ST	Test result [pass/fail]
			pass
567589	2091979-11		pass
567589	2091980-11		pass
567589	2091981-11		pass

Longitudinal tensile test in acc. with A370 / EN ISO 6892-1

Heat	Lot	ST	Rp0,2 [MPa]	Rm [MPa]	A2" [%]	A5 [%]	Rp1,0 [MPa]
			min 220,000	515,000-690,000	min 35,000	min 40,000	min 250,000
567589	2091979-11		317,900	572,400	55,000	60,000	349,200
567589	2091980-11		304,900	566,300	55,200	60,000	337,000
567589	2091981-11		314,000	586,600	56,400	62,800	346,100

Microstructure evaluation and Grain size WI-3815/ASTM E112

The structure is free from grain boundary chromium carbide precipitations.

Heat	Lot	ST	G.B.Cr.Carbides [No/Yes]	Grain size [(G)]
			No	5,000-14,000
567589	2091979-11		No	6,000
567589	2091980-11		No	6,000
567589	2091981-11		No	7,000

Dimensional check

Test results comply with specified criteria.

HT - Final heat treatment of straight tubes

Bright annealing at 1150°C with min. 0,25 minute holding time.

Quenched by forced cooled inert gas.

Inside cleanliness check

Test results comply with specified criteria.

NDT - Eddy current flaw detection in acc. ASTM E426

Test results comply with specified criteria.

NDT - Visual inspection

Test results comply with specified criteria.

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A08

10056964 - 50

PMI - 100% positive material identification

Test results comply with specified criteria.

Statement

The raw material is free from radioactive contamination.

Statement

Material free from mercury and asbestos contamination.

Statement

The material have been manufactured within the scope of certified Quality Management System maintained in accordance with EN ISO 9001:2015.

Straightness check

Test results comply with specified criteria.