

Type of inspection document : Inspection certificate acc. to EN 10204 / 3.1	A02	Internal order No.: 10062609 - 40	A08
Purchaser : ALLEIMA BENELUX B.V. . AMUNDSENWEG 4 5928 LT VENLO THE NETHERLANDS	A06	Purchase order No. : 800777 Purchaser's reference : 800777 Project Id. : 4003435	A07
Product : Seamless cold finished tube	B01/B04	Steel designation : 3R60 / 3R60	B02
Dimension (OD x WT) : 8,00 x 1,50AW 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) AD 2000 W2 Einbaurohre - 2022 AD 2000 W10 - 2019 NACE MR0175-2021/ISO 15156-3:2020, NACE MR0103/ISO 17945-1:2015 Alleima SPEC S-08921 PED 2014/68/EU			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 length 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 [%]
568033	max 0.030 0,019	max 1.000 0,400	max 2.000 1,650	max 0.040 0,028	max 0.015 0,007

Heat	Cr [%]	Ni [%]	Mo [%]	N [%]
568033	17.000-18.000 17,300	12.500-14.000 13,330	2.500-3.000 2,620	max 0.100 0,049

Type of inspection document :

A02

Inspection certificate acc. to EN 10204 / 3.1

Internal order No.:

A08

10062609 - 40

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
568033	2099135-11	0,018	0,390	1,680	0,028	0,008

Heat	Lot	Cr [%]	Ni [%]	Mo [%]	N [%]
		17.000-18.000	12.500-14.000	2.500-3.000	max 0.100
568033	2099135-11	17,400	13,100	2,580	0,046

Extent of material delivery

Heat	Lot	Hollow supp.	No. of HTcycles ¹⁾	Pieces	Total length [m]	Total weight [kg] ²⁾
568033	2099135-11	ALLEIMA SE	1	1 023	6 138.000	1 491.534
568033	2099136-11	ALLEIMA SE	1	864	5 184.000	1 259.712
568033	2099137-11	ALLEIMA SE	1	905	5 430.000	1 319.490
568033	2099138-11	ALLEIMA SE	1	966	5 796.000	1 408.428

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 : 27.6.2023

Type of inspection document :

A02

Internal order No.:

A08

Inspection certificate acc. to EN 10204 / 3.1

10062609 - 40

Flaring test in acc. with ASTM A 1016

Heat	Lot	ST	Test result [pass/fail]
			pass
568033	2099135-11		pass
568033	2099135-11		pass
568033	2099136-11		pass
568033	2099136-11		pass
568033	2099137-11		pass
568033	2099137-11		pass
568033	2099138-11		pass
568033	2099138-11		pass

Flaring test in acc. with EN 10216-5

Heat	Lot	ST	Test result [pass/fail]
			pass
568033	2099135-11		pass
568033	2099136-11		pass
568033	2099137-11		pass
568033	2099138-11		pass

Flattening test in acc. with ASTM A 1016

Heat	Lot	ST	Test result [pass/fail]
			pass
568033	2099135-11		pass
568033	2099135-11		pass
568033	2099136-11		pass
568033	2099136-11		pass
568033	2099137-11		pass
568033	2099137-11		pass
568033	2099138-11		pass
568033	2099138-11		pass

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

Heat	Lot	ST	Hardness [HRB]	Hardness \leq 22HRC [yes/no]
			max 80,000	yes
568033	2099135-11		75,000	yes
568033	2099135-11		74,000	yes
568033	2099136-11		76,000	yes
568033	2099136-11		76,000	yes
568033	2099137-11		78,000	yes
568033	2099137-11		76,000	yes
568033	2099138-11		78,000	yes
568033	2099138-11		78,000	yes

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Intergranular corrosion testing in acc. with ASTM A262E

Heat	Lot	ST	Test result [pass/fail]
			pass
568033	2099135-11		pass
568033	2099136-11		pass
568033	2099137-11		pass
568033	2099138-11		pass

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

Heat	Lot	ST	Test result [pass/fail]
			pass
568033	2099135-11		pass
568033	2099136-11		pass
568033	2099137-11		pass
568033	2099138-11		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
568033	2099135-11		270,100	571,600	57,600	64,000	303,200
568033	2099136-11		275,600	565,600	57,000	65,000	306,700
568033	2099137-11		262,600	562,600	58,000	64,700	297,100
568033	2099138-11		273,300	548,600	59,800	64,700	304,700

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
568033	2099135-11		No	7,000
568033	2099136-11		No	7,000
568033	2099137-11		No	7,000
568033	2099138-11		No	6,000

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.

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A02

Internal order No.:

10062609 - 40

A08

NDT - Eddy current flaw detection in acc. ASTM E426

Test results comply with specified criteria.

NDT - Visual inspection

Test results comply with specified criteria.

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.