

<b>Type of inspection document :</b> Inspection certificate acc. to EN 10204 / 3.1	A02	<b>Internal order No.:</b> 10075345 - 30	A08
<b>Purchaser :</b> ALLEIMA BENELUX B.V.  AMUNDSENWEG 4 5928 LT VENLO THE NETHERLANDS	A06	<b>Purchase order No. :</b> 800816  <b>Purchaser's reference :</b> 800816  <b>Project Id. :</b> 4003661	A07
<b>Product :</b> Seamless cold finished tube	B01/B04	<b>Steel designation :</b> 3R60 / 3R60	B02
<b>Dimension (OD x WT) :</b> 12,70 x 1,24AW mm	B09/B10	<b>Melting process :</b> AOD	C70
<b>Technical requirements :</b> ASME SA213/SA213M-2023 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
<b>Supplementary information :</b> Manufacturing of stainless steel tubes in grade 3R60 / TP316/316L / 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
<b>Originator of the document :</b> QA - AC	A05/Z02	<b>Inspector's stamp:</b>	Z03

**Chemical composition (Heat analysis)**

Heat	C [%]	Si [%]	Mn [%]	P [%]	S [%]
569289	max 0.030 0,019	max 1.000 0,400	max 2.000 1,680	max 0.040 0,029	max 0.015 0,009

Heat	Cr [%]	Ni [%]	Mo [%]	N [%]
569289	17.000-18.000 17,210	12.500-14.000 13,220	2.500-3.000 2,640	max 0.100 0,040

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**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
569289	2115284-11	0,018	0,400	1,720	0,029	0,009

Heat	Lot	Cr [%]	Ni [%]	Mo [%]	N [%]
		17.000-18.000	12.500-14.000	2.500-3.000	max 0.100
569289	2115284-11	17,160	13,030	2,590	0,057

**Extent of material delivery**

Heat	Lot	Hollow supp.	No. of HTcycles <sup>1)</sup>	Pieces	Total length [m]	Total weight [kg] <sup>2)</sup>
569289	2115248-11	ALLEIMA SE	1	458	2 748.000	972.792
569289	2115249-11	ALLEIMA SE	1	424	2 544.000	900.576
569289	2115250-11	ALLEIMA SE	1	461	2 766.000	979.164
569289	2115251-11	ALLEIMA SE	1	468	2 808.000	994.032
569289	2115283-11	ALLEIMA SE	1	472	2 832.000	1 002.528
569289	2115284-11	ALLEIMA SE	1	464	2 784.000	985.536
569289	2115285-11	ALLEIMA SE	1	328	1 968.000	696.672

**Note :** <sup>1)</sup> Number of heat treatment cycles performed on the tubes.

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

**Chomutov, date :** 8.12.2023

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**Flaring test in acc. with ASTM A 1016**

Heat	Lot	ST	Test result [pass/fail]
			pass
569289	2115248-11		pass
569289	2115248-11		pass
569289	2115249-11		pass
569289	2115249-11		pass
569289	2115250-11		pass
569289	2115250-11		pass
569289	2115251-11		pass
569289	2115251-11		pass
569289	2115283-11		pass
569289	2115283-11		pass
569289	2115284-11		pass
569289	2115284-11		pass
569289	2115285-11		pass
569289	2115285-11		pass

**Flaring test in acc. with EN 10216-5**

Heat	Lot	ST	Test result [pass/fail]
			pass
569289	2115248-11		pass
569289	2115249-11		pass
569289	2115250-11		pass
569289	2115251-11		pass
569289	2115283-11		pass
569289	2115284-11		pass
569289	2115285-11		pass

**Flattening test in acc. with ASTM A 1016**

Heat	Lot	ST	Test result [pass/fail]
			pass
569289	2115248-11		pass
569289	2115248-11		pass
569289	2115249-11		pass
569289	2115249-11		pass
569289	2115250-11		pass
569289	2115250-11		pass
569289	2115251-11		pass
569289	2115251-11		pass
569289	2115283-11		pass
569289	2115283-11		pass
569289	2115284-11		pass
569289	2115284-11		pass
569289	2115285-11		pass
569289	2115285-11		pass

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

Heat	Lot	ST	Hardness	Hardness ≤22HRC
			[HRB]	[yes/no]
			max 80,000	yes
569289	2115248-11		77,000	yes
569289	2115248-11		78,000	yes
569289	2115249-11		78,000	yes
569289	2115249-11		79,000	yes
569289	2115250-11		78,000	yes
569289	2115250-11		79,000	yes
569289	2115251-11		79,000	yes
569289	2115251-11		78,000	yes
569289	2115283-11		79,000	yes
569289	2115283-11		78,000	yes
569289	2115284-11		79,000	yes
569289	2115284-11		78,000	yes
569289	2115285-11		78,000	yes
569289	2115285-11		78,000	yes

**Intergranular corrosion testing in acc. with ASTM A262E**

Heat	Lot	ST	Test result
			[pass/fail]
			pass
569289	2115248-11		pass
569289	2115249-11		pass
569289	2115250-11		pass
569289	2115251-11		pass
569289	2115283-11		pass
569289	2115284-11		pass
569289	2115285-11		pass

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

Heat	Lot	ST	Test result
			[pass/fail]
			pass
569289	2115248-11		pass
569289	2115249-11		pass
569289	2115250-11		pass
569289	2115251-11		pass
569289	2115283-11		pass
569289	2115284-11		pass
569289	2115285-11		pass

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

Heat	Lot	ST	Rp0,2	Rm	A2"	A5	Rp1,0
			[MPa]	[MPa]	[%]	[%]	[MPa]
			min 220,000	515,000-690,000	min 35,000	min 40,000	min 250,000
569289	2115248-11		301,900	575,800	59,800	63,000	328,800
569289	2115249-11		300,100	567,000	59,200	61,200	329,300
569289	2115250-11		301,400	570,200	58,400	59,000	330,400
569289	2115251-11		312,600	586,300	58,400	62,500	343,500
569289	2115283-11		299,400	572,600	59,800	61,500	327,800
569289	2115284-11		288,400	554,500	64,000	62,200	315,200
569289	2115285-11		298,900	576,600	58,200	62,200	327,600

**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	Grain size
			[No/Yes]	[(G)]
			No	5,000-14,000
569289	2115248-11		No	6,000
569289	2115249-11		No	6,000
569289	2115250-11		No	5,000
569289	2115251-11		No	6,000
569289	2115283-11		No	6,000
569289	2115284-11		No	5,000
569289	2115285-11		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.

**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.

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**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.