

Type of inspection document : Inspection certificate acc. to EN 10204 / 3.1		A02	Internal order No.: 50009884 - 10		A08
Purchaser : ALLEIMA BENELUX B.V. . AMUNDSENWEG 4 5928 LT Venlo THE NETHERLANDS		A06	Purchase order No. : Purchaser's reference : Project Id. : 3000309		A07
Product : Seamless cold finished tube		B01/B04	Steel designation : 3R60 / 3R60		B02
Dimension (OD x WT) : 12,00 x 2,00AW mm		B09/B10	Melting process : AOD		C70
Technical requirements : 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
Supplementary information : 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 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 [%]
571178	max 0.030 0,019	max 1.000 0,380	max 2.000 1,670	max 0.040 0,031	max 0.015 0,010

Heat	Cr [%]	Ni [%]	Mo [%]	N [%]	Co [%]
571178	17.000-18.000 17,100	12.500-14.000 13,100	2.500-3.000 2,630	max 0.100 0,039	info 0,150

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Heat	Ti [%] info
571178	<0,003

Product check analysis

Heat	Lot	C [%] max 0.030	Si [%] max 1.000	Mn [%] max 2.000	P [%] max 0.040	S [%] max 0.015
571178	2149350-11	0,019	0,380	1,730	0,027	0,006

Heat	Lot	Cr [%] 17.000-18.000	Ni [%] 12.500-14.000	Mo [%] 2.500-3.000	N [%] max 0.100
571178	2149350-11	17,370	13,160	2,660	0,039

Extent of material delivery

Heat	Lot	Hollow supp.	No. of HTcycles ¹⁾	Pieces	Total length [m]	Total weight [kg] ²⁾
571178	2149350-11	ALLEIMA SE	1	494	2 964.000	1 479.036
571178	2149351-11	ALLEIMA SE	1	450	2 700.000	1 347.300

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 : 11.09.2024

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Flaring test in acc. with ASTM A 1016

Heat	Lot	ST	Test result [pass/fail]
			pass
571178	2149350-11		pass
571178	2149350-11		pass
571178	2149351-11		pass
571178	2149351-11		pass

Flaring test in acc. with EN 10216-5

Heat	Lot	ST	Test result [pass/fail]
			pass
571178	2149350-11		pass
571178	2149351-11		pass

Flattening test in acc. with ASTM A 1016

Heat	Lot	ST	Test result [pass/fail]
			pass
571178	2149350-11		pass
571178	2149350-11		pass
571178	2149351-11		pass
571178	2149351-11		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
571178	2149350-11		76,000	yes
571178	2149350-11		78,000	yes
571178	2149351-11		77,000	yes
571178	2149351-11		79,000	yes

Intergranular corrosion testing in acc. with ASTM A262E

Heat	Lot	ST	Test result [pass/fail]
			pass
571178	2149350-11		pass
571178	2149351-11		pass

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

Heat	Lot	ST	Test result [pass/fail]
			pass
571178	2149350-11		pass
571178	2149351-11		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
571178	2149350-11		280,500	575,000	57,800	57,100	308,700
571178	2149351-11		264,000	568,200	57,200	58,700	301,200

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
571178	2149350-11		No	6,000
571178	2149351-11		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. E426/EN ISO 10893-1

Test results comply with specified criteria.

NDT - Visual inspection

Test results comply with specified criteria.

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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.