



INSPECTION CERTIFICATE acc to  
EN 10 204 3.1

Processkontroll Items AB  
Box 2088  
444 02 STORA HÖGA  
SWEDEN

INSPECTION STAMP  
QA-TUBE

Customer References		Sandvik References		
709341	Customer order 2010-11-03	Order No.	Subs No.	ABSMT Dispatch note
		219126	190238	21281/54
		ABSMT No.	C.Code	
003-00991	ITEMS	300-31868	15	

Material description	Steel/material Designations
SEAMLESS STAINLESS COLD FINISHED HYDRAULIC TUBING	Sandvik SS 3R60 2353 AISI AFNOR TP316/TP316L Z2CND17-13 W.nr DIN 1.4435 X 2 CRNIMO 18 14 3 EN no 1.4436/1.4435
<b>Steel making process</b> Electric furnace	

Technical requirements
PED/23/EC, EN 10216-5 TC1 SS 219711, DIN 17458 TC1, NFA 49-117-09/85 ASTM A-213-09A AW, ASME SA-213-ED-07 AD-09B AW, ASTM A-269-08 NACE MR0175/ISO 15156-3:2003, HRB Max 80

EXTENT OF DELIVERY						
It	Product designation	Heat	Lot	Pieces	Kg	M
02	THT-3R60-18-2 18.00 X 2.00	525942	18451	3	14.0	18.00
				Total	3	14.0 18.00

TEST RESULTS								
Chemical composition (weight%)								
Heat	C	Si	Mn	P	S	Cr	Ni	Mo
525942	0.017	0.39	1.63	0.030	0.009	17.24	13.10	2.55
	N							
525942	0.042							
Chemical composition, product (weight%)								
Heat	C	Si	Mn	P	S	Cr	Ni	Mo
525942	0.018	0.39	1.63	0.030	0.009	17.21	13.02	2.55
	N							
525942	0.045							

Quality assurance - Per Eriksson/ QA-manager Tube & Pipe  
MTC Service / Certificates

**Tensile test at room temperature**

Lot	Yield strength		Tensile strength	Elongation	
	MPa	MPa	MPa	%	%
	Rp0.2	Rp1.0	Rm	A	2"
18451	275	316	584	54	56
	275	316	588	54	56

**Hardness test**

Lot	Min	Max
	HRB	HRB
18451	75	78

**Following controls/tests have been satisfactorily performed:**

- Flattening test.
- Flaring test
- PMI-test.
- Intergranular corrosion test acc to ASTM A-262 PR.E
- Intergranular corrosion test acc. to EN ISO3651-2, Method A.
- Leak test: Eddy current test acc to EN 10246-2, ASME SA-1016.
- Visual inspection and dimensional control.

**Heat Treatment:**

Solution annealed and quenched.

**Marking:**

SANDVIK 3R60 ASTM/ASME A/SA-213AW A-269 NFA 49-117 EN 10216-5 TC1 SS 2353-22 W NR 1.4435 Z2CND17-13 EN 1.4435 TP316/316L M S PK1 NDE 18.00 X 2.00 MM HT 52594 2 SS LOT 18451 DIN 2391/EN 10305-1 COLD \*QA-TUBE\*

Approved acc. AD 2000-Merkblatt W0 and certified acc. to Pressure Equipment Directive (97/23/EC) by TUEV NORD GmbH; notified body, reg.no. 0045.

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.