

Type of inspection document : Inspection certificate acc. to EN 10204 / 3.1	A02	Internal order No.: 50006002 - 10	A08
Purchaser : ALLEIMA BENELUX B.V. . AMUNDSENWEG 4 5928 LT Venlo THE NETHERLANDS	A06	Purchase order No. : Purchaser's reference : Project Id. : 3000075	A07
Product : Seamless cold finished tube Dimension (OD x WT) : 6,00 x 1,00AW mm	B01/B04	Steel designation : 3R60 / 3R60 Melting process : AOD	B02 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 [%]
	max 0.030	max 1.000	max 2.000	max 0.040	max 0.015
570078	0,018	0,380	1,680	0,028	0,008
570344	0,018	0,370	1,640	0,031	0,010

Heat	Cr [%]	Ni [%]	Mo [%]	N [%]	Co [%]
	17.000-18.000	12.500-14.000	2.500-3.000	max 0.100	info
570078	17,320	13,090	2,640	0,038	0,097
570344	17,160	13,070	2,620	0,044	0,110

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Heat	Ti [%] info
570078	<0,003
570344	<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
570078	2148619-11	0,017	0,390	1,700	0,025	0,007
570344	2148618-11	0,017	0,380	1,670	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
570078	2148619-11	17,470	13,120	2,560	0,039
570344	2148618-11	17,120	13,070	2,550	0,024

Extent of material delivery

Heat	Lot	Hollow supp.	No. of HTcycles ¹⁾	Pieces	Total length [m]	Total weight [kg] ²⁾
570078	2148619-11	ALLEIMA SE	1	909	5 454.000	681.750
570344	2148618-11	ALLEIMA SE	1	1 843	11 058.000	1 382.250

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 : 09.09.2024

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Flaring test in acc. with ASTM A 1016

Heat	Lot	ST	Test result [pass/fail]
			pass
570078	2148619-11		pass
570078	2148619-11		pass
570344	2148618-11		pass
570344	2148618-11		pass

Flaring test in acc. with EN 10216-5

Heat	Lot	ST	Test result [pass/fail]
			pass
570078	2148619-11		pass
570344	2148618-11		pass

Flattening test in acc. with ASTM A 1016

Heat	Lot	ST	Test result [pass/fail]
			pass
570078	2148619-11		pass
570078	2148619-11		pass
570344	2148618-11		pass
570344	2148618-11		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
570078	2148619-11		75,000	yes
570078	2148619-11		76,000	yes
570344	2148618-11		76,000	yes
570344	2148618-11		75,000	yes

Intergranular corrosion testing in acc. with ASTM A262E

Heat	Lot	ST	Test result [pass/fail]
			pass
570078	2148619-11		pass
570344	2148618-11		pass

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

Heat	Lot	ST	Test result [pass/fail]
570078	2148619-11		pass
570344	2148618-11		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]
570078	2148619-11		319,500	569,300	50,400	68,000	345,800
570344	2148618-11		287,400	572,000	50,600	69,500	345,600

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 [No/Yes]	Grain size [(G)]
570078	2148619-11		No	6,000
570344	2148618-11		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.