VOLZHSKY TRUBNY

"VOLZHSKY PIPE PLANT"
OJSC

404119, Volzhsky, Volgograd region, Russia

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MANUFACTURER:

VOLZHSKY PIPE PLANT OJSC
404119, VOLZHSKY
VOLGOGRAD REGION
RUSSIA

MILL TEST CERTIFICATE

Spec 1393/72/TMK PO№ 09-0005
DESCRIPTION OF GOODS:
CARBON STEEL SEAMLESS PIPES ACCORDING TO API SPEC. 5L PSL1 (44TH EDITION/YEAR 2007)X42,B/ASTM A106/A 106M (2006 EDITION)B/C/ASTM A53/A 53M (2006 EDITION) B/C/ASME SA 106(2004 EDITION)/ASME SA53 (2004 EDITION), BEVELLED ENDS. HARDNESS TEST MAX. 22 HRC AS PER NACE MR01-75.
10 3/4" ∅ 1.000" (273.1 x 25.4 mm)

"AMERICAN PIPING PRODUCTS"
707 SPIRIT 40 PK DR. STE 118
CHESTERFIELD MO 63005, USA.

CERTIFICATE # 440 DATE OF ISSUE 31.03.2009

SIZE	HEAT No / HEAT TREATMENT LOT No	LOT No	QUANTITY, PIPES	LENGTH, FEET	NET WEIGHT TONS	CHEMICAL COMPOSITION, % C x100	Si x100	Mn x100	P x1000	S x1000	Cr x100	Ni x100	Cu x100	Mo x100	Ti x100	Nb x100	MILL CONTROL PROT. No	ORIENTATION	TENSILE TEST: TEST SPECIMEN	GL. 'C': TS psi	UTS psi	EL. %	HARDNESS TEST HRC	IMPACT TEST: ORIENTATION	NOTCH	SIZE	TEST TEMP °C	IMPACT VALUE	FRACTURE %	HEAT TREATMENT	NDT	HYDROSTATIC TEST: DURATION (SECONDS)	PRESSURE MT/CM2 (MPa)	NOTE
						* 1	28 max	10 min	29 min 106 max	30 max	30 max	40 max	40 max	40 max	15 max			* 2	* 3	* 4	min 42100	min 70000	min 22.0	max 22.00	* 3	* 5	* 6	* 7			* 8	* 9 * (10)	min 5	min 468.00 (65.90)	
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38
GRADE X42/B 10.75x1.000" 273.1x25.4MM API 5L/ISO 3183 ,PSL1 GRADE B/C ASTM A106 / A106M / A53/ A53B / ASME SA-106/SA-53	290580	3-0281	69	2374.82	112.460	H 16 P 16 P 16	26 27 27	66 64 65	6 6 6	1 4 3	14 14 14	17 16 17	26 26 26	3 3 3	0 0 0	0 0 0	6688 6688 6688	L	B	52836	74667	34.1	1.0							O&T	N & UT (12)	G	G	CARBON STEEL SEAMLESS PIPES ACCORDING TO API 5L (2007) ASTM A106(2006) ASTM A53(2006) ASME SA-106(2006) ASME SA-53(2004) LENGTH: MIN 80'-38-41 FT MAX 70'-36-38 FT MINIMUM HYDROSTATIC PRESSURE P= 4660 PSI HARDNESS TEST MAX.22 HRC IS IN ACCORDANCE WITH NACE MR01'75.
	11																1583	L															

PLEASA ANAHUAC Y CIAS. S.A. DE C.V.
CONTROL DE CALIDAD
FECHA 03 May 2010
E-680
FIRMA E. RUIZ

DESCRIPTION OF TESTS	VISUAL AND DIMENSIONS	BEVELING INSPECTION	END'S PROTECTORS	NONDESTRUCTIVE INSPECTION	COATING			FLATTENING TEST	MARKING: STENCILLING	STEEL MAKING PROCESS - ELECTRIC FURNACE
	G	G	G	G	G			G	G	

NOTES: G: GOOD
*1: M: HEAT ANALYSIS, P: PRODUCT ANALYSIS, C: CONTROL ANALYSIS, R: RECHECK ANALYSIS
*2: L: LOT TEST, H: HEAT CONTROL TEST, A: ADDITION TEST, R: RECHECK TEST
*3: L: LONGITUDINAL, T: TRANSVERSE
*4: STRIP G: 1/2 in, N: 1 in, K: 1 1/2 in, S: 12 mm, RING H: 1/2 in.
*5: V: 2mm V, U: 2mm U, B: 3mm C, C: 4mm U, K: 2mm U PASE NOTCH, P: 2mm V PASE NOTCH
*6: F: 10x10mm, 7: 10x7.5mm, 6: 10x6.7mm, 5: 10x5mm, 3: 10x3.3mm, 2: 10x2.5mm
*7: E - EACH VALUE, A - AVERAGE VALUE
*8: HEAT TREATMENT, QNT: QUENCHED & TEMPERED
*9: M: WET FLUORESCENT MAGNETIC PARTICLE TEST, EMI: ELECTROMAGNETIC TEST.UT: ULTRASONIC TEST
UTB: PIPE BODY UT FOR LAMINATION, UTE: PIPE ENDS UT FOR LAMINATION
UTS: PIPE WALL THICKNESS UT
*10: 5 - NOTCH 5%, 12 - NOTCH 12.5%

TOTAL: QUANTITY OF PIPES 69 PCS NET WEIGHT 112.460 T LENGTH 2374.82 ft.

WE CONFIRM THAT PIPES HAS NO CONTAMINATION BY MERCURY AND NO REPAIR BY WELDING HAS BEEN CARRIED OUT.
ITC COMPLY WITH THE STANDARD EN 10204.3.1B.

OTK
ВОЛЖСКИЙ ТРУБНЫЙ ЗАВОД

MANAGER - INSPECTION
VOLZHSKY PIPE PLANT
DATE: 31.03.09