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Reg. No.
12 100 3054

Abnahmeprüfzeugnis Inspection Certificate EN 10204 - 3.1

Zeugnisnummer [certificate no.]

033241/10-SD

Rev.

Datum
[date]
31/08/2010

Ihre Bestellnummer [your order no.]
8809

Unsere Auftrags.Nr. [our order no.]
123014TD-0070

Kunde [customer]
Plesa Anahuac Y Cias, S.A. de C.V.
Valle de las Alamedas 66-O

Ihre Artikelnummer [your item no.]

Schmelze Nr [heat no.]
190368

Ident Nr. [ident no.]

Menge [quantity] Artikelbezeichnung [designation]

4

elbows
LR-90-S-WPB-24"-S80

Anforderungen [requirements]
ASME B16.9-2007 LR,WPB,ASME Sect. II part D table Y-1,ASTM A 234/A 234M-10,ASME SA-234/SA-234M-Ed.07/A08a,NACE MR0175/ISO15156-2:2003A.2,NACE MR0103-2003 2.1 and 4,M0803-05,EN 10204/3.1,Millstandard,Seamless

Col. San Francisco Chilpan
MEX-54940 Tultitlan, Edo. de Mexico

Vormaterial [base material] Rohrzeugnisnr. [tube work's cert.no.]
74571RP09

Hersteller [manufacturer]
V&M

Dichtheitsprüfung [leakage test]

| Analyse [analysis] | Schmelze Nr. [heat no.] | Erschmelzungsart [melting process] 1 = Schmelzanalyse [heat analysis] | | | | | | | | | | J-Faktor (Si + Mn) * (P + Sn) * 10000 CEQ [CEQ]: C + (Mn / 6) + (Cr + Mo + V) / 5 + (Cu + Ni) / 15 | | | | | | | |
|--------------------|-------------------------|--|------|------|-------|-------|------|------|------|------|-------|---|-------|--------|-------|--------|------|------|---------|
| Index | | C | Si | Mn | P | S | Cr | Mo | Ni | Cu | V | Nb | Al | B | Ti | N | Ceq | CEQ | J-Fact. |
| 1 | 190368 | 0.17 | 0.21 | 1.00 | 0.008 | 0.001 | 0.07 | 0.06 | 0.11 | 0.14 | 0.003 | 0.001 | 0.025 | 0.0001 | 0.014 | 0.0050 | 0.38 | 0.38 | |

Mech.-technologische Prüfung [mech. technological test]

| Proben Nr. [test no.] | Zugversuch [tensile test] | | | | | | Kerbschlagbiegeversuch [notched bar impact test] Form: | | | | Härteprüfung [hardness test] | |
|-----------------------|---------------------------|--------|----------------------------|-------|---------------------------------------|-----------------------------|---|-------|--------------------------|--------------------------------------|---|--|
| | Pr.-Lage [pos. of sample] | Temp. | Dehng. [yield str.] ReH | Re0.2 | Zugfestigkeit [tensile str.] Rm (MPa) | Dehnung [elongation] 4D (%) | Pr.-Lage [pos. of sample] | Temp. | Querschnitt [cross sec.] | Kerbschlagarbeit [impact values] (J) | | |
| 4396_09 | QNZ | +20 °C | 401 | 371 | 501 | 31,5 | | | | | 148-154 HB | |
| | | | | | | | | | | | Wärmebehandlung [heat treatment] | |
| | | | | | | | | | | | formed under normalizing cond. temperature 840 °C - 890 °C Cooling in still air | |

Kennzeichnung [marking] AUSTRIA / WPB / 190368 / 24" / S80

Zusatzmarkierung [add. mark.]

Besichtigung und Ausmessung [visual inspection and dimensional check] o.B./o.K.

Die gelieferten Produkte entsprechen den Anforderungen der Bestellung (einschließlich Herstellung, Probennahme, Testen und Prüfen). [The supplied products comply with the requirements of the order (including manufacturing, sampling, testing and inspections).]
Der Werkseachverständige [the Works Inspector]

Bemerkungen [remarks]
hot formed over mandrel
Hardness test and stamping acc. to NACE MR-01-75. Stamped with round nosed tools. Hardness test, visual and dimensional test are checked on 10%.

31/08/10 Scheibenstock Daniel -323
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