Tubacero
Ave. Guerrero
No. 3729 nte.
Col. Del Norte
Monterrey N.L. México
CP.64500
TEL:3055655
FAX:3055680

CONSTANCIA DE INSPECCION

INSPECTION CONSTANCY

No. CONSTANCIA (constancy No.): **101484**

CLIENTE(customer): PLESA ANAHUAC Y CIAS., S.A. DE C.V.

DIRECCION(address): AV. VALLE DE LAS ALAMEDAS # 66 - O COL. SAN FCO. CHILPAN TULTITLAN, EDO. DE MEXICO C.P.54940

O.T. (order no.)	DIAMETRO (outside diam.)	ESPESOR (thickness)	GRADO (grade)	ESPECIFICACION (specification)	PROCESO (process)	PEDIDO (contract)	O. PREPARACION (preparation order)	PROVEEDOR (supplier)	FECHA (date)
33442	10.750"	0.225"	X42/5LB PSL1/A53B	API 5L 43 ED./A.S.T.M.	ERW	9495	B-165-2010	TERNIUM	03/12/2010

TUBO (pipe) O SERIE (SERIAL)	COLADA (heat)	TYPE	LOC	PRUEBA DE TENSION(tensile test) UNIDADES: (units) PSI (Y.S.)	ORIENTACION (orientation) 1 (T.S.)	TAMAÑO: (size) 3 % EL.	Y S/T S	BEND	HARDNESS	PRUEBA DE IMPACTO (impact test) °C ORIENTACION °F (orientation) ENERGY (lbs/ft) 1	2	3	AVG	TAMAÑO (size) SHEAR AREA 1	2	3	AVG	DWTT SHEAR AREA 1	2	AVG	GRAIN SIZE
			6		80900																
23	273035	H	7	46700	63700	37	0.73														
			6		69900																
69	471206	H	7	52500	67700	40	0.77														
			6		60900																
179	273038	H	7	55000	70000	37	0.78														
			6		76000																
267	462348	H	7	52700	68100	35	0.77														
			6		75100																
291	172968	H	7	54400	70100	38	0.77														
			6		68800																
397	273039	H	7	55000	71100	35	0.77														

(%)ANALISIS QUIMICO / chemical analysis (%)

TUBO (pipe) O SERIE (SERIAL)	TYPE	LOC	C	Mn	P	S	Si	Al	Cu	Cr	Ni	Mo	Ti	Nb	B	V	N	Als	Ca	PCM	CE
	H	7	0.15	0.60	0.014	0.006	0.095	0.032	0.010	0.020	0.020	0.003	-	-	-	-	-	-	-	-	0.26
23	P	7	0.22	0.60	0.018	0.009	0.111	0.040	0.008	0.018	0.024	0.001	0.001	0.002	0.0004	0.001	-	-	0.002	0.26	0.33
	P	7	0.22	0.60	0.019	0.008	0.109	0.038	0.011	0.018	0.024	0.001	0.001	0.002	0.0003	0.001	-	-	0.001	0.25	0.32
	H	7	0.15	0.61	0.018	0.010	0.090	0.035	0.020	0.030	0.030	0.004	-	-	-	-	-	-	-	-	0.26
69	P	7	0.19	0.60	0.022	0.012	0.105	0.041	0.017	0.030	0.029	0.001	0.001	0.002	0.0004	0.001	-	-	0.002	0.23	0.30
	P	7	0.19	0.60	0.020	0.013	0.104	0.039	0.018	0.029	0.027	0.001	0.001	0.002	0.0003	0.001	-	-	0.002	0.23	0.30
	H	7	0.16	0.58	0.018	0.010	0.122	0.042	0.020	0.040	0.030	0.006	-	-	-	-	-	-	-	-	0.27
179	P	7	0.22	0.57	0.020	0.013	0.130	0.051	0.020	0.036	0.026	0.001	0.002	0.002	0.0004	0.001	-	-	0.002	0.26	0.33
	P	7	0.22	0.57	0.019	0.015	0.127	0.044	0.018	0.036	0.026	0.001	0.002	0.003	0.0003	0.001	-	-	0.002	0.26	0.33
	H	7	0.15	0.60	0.010	0.015	0.102	0.040	0.020	0.020	0.030	0.005	-	-	-	-	-	-	-	-	0.26
267	P	7	0.19	0.58	0.018	0.018	0.118	0.046	0.016	0.023	0.028	0.001	0.001	0.002	0.0003	0.001	-	-	0.001	0.23	0.29
	P	7	0.19	0.58	0.013	0.014	0.120	0.051	0.019	0.024	0.030	0.001	0.001	0.002	0.0003	0.001	-	-	0.001	0.23	0.30
	H	7	0.16	0.60	0.021	0.007	0.104	0.041	0.010	0.020	0.020	0.003	-	-	-	-	-	-	-	-	0.27
291	P	7	0.21	0.60	0.025	0.007	0.120	0.046	0.005	0.019	0.022	0.001	0.001	0.002	0.0004	0.001	-	-	0.001	0.25	0.32
	P	7	0.21	0.60	0.023	0.009	0.120	0.045	0.008	0.020	0.022	0.001	0.001	0.003	0.0003	0.001	-	-	0.002	0.25	0.32
	H	7	0.15	0.57	0.016	0.009	0.099	0.030	0.030	0.030	0.030	0.005	-	-	-	-	-	-	-	-	0.26
397	P	7	0.21	0.57	0.018	0.010	0.127	0.045	0.025	0.034	0.028	0.001	0.002	0.002	0.0004	0.001	-	-	0.003	0.24	0.31
	P	7	0.22	0.57	0.018	0.011	0.121	0.042	0.023	0.033	0.026	0.001	0.002	0.002	0.0004	0.001	-	-	0.002	0.26	0.32

CRITERIOS DE ACEPTACION: (Acceptance criteria)	MIN:	42000	60000	25	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	MAX:	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	0.26	1.20	0.030	0.030	-	-	0.500	0.400	0.400	0.150	0.040	-	-	0.080	-	-	-	-	0.43
	PROMEDIO (AVG.)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

PRUEBA HIDROSTATICA: (hidrostatic test) PRESION: (pressure) 1500 Psi TIEMPO: (time) 10 sec

ULTRASONIDO(U.T.): (ultrasonic) STANDARD DE REFERENCIA: (REFERENCE STANDARD) J

PRUEBA DE APLASTAMIENTO: (flattening test) 0° OK 90° OK

NORMALIZADO DE SOLDADURA: (heat treatment weld) TEMPERATURA (temperature): 1600° F MIN (NO UNTEMPERED MARTENSITE REMAINS)

ESTANDAR DE REFERENCIA (REFERENCE STANDARD) F: U.T. DRILLED HOLE 1/16", G: U.T. DRILLED HOLE 1/8", I: U.T. NOTCH N-5, J: U.T. NOTCH N-10 L: RT HOLE 1/16", N: RT HOLE 2-2T O: RT HOLE 2-4T
Barreno (Drilled Hole)=H Muesca (Notch)=N

ORIENTACION(orientation):
1. TRANSVERSAL (transverse)
2. LONGITUDINAL (longitudinal)

TAMAÑO (size)
3.RECTANGULAR(rectangular)
4.CILINDRICA(round bar) 0.500"
5.CILINDRICA(round bar) 0.350"

LOCALIZACION (location)

6. SOLDADURA (weld)
7. METAL BASE (base metal)
8. ZONA AFECTADA (h.a.z.)
9. LINEA DE FUSION (fusion line)

TIPO DE PRUEBA (type)
H: COLADA (heat)
P: PRODUCTO (product)
R: REMUESTREO (recheck)
T: UNIDAD DE PRUEBA (Test unit)

HACEMOS CONSTAR QUE EL MATERIAL DESCRITO HA SIDO FABRICADO, MUESTREADO, PROBADO E INSPECCIONADO DE ACUERDO CON LA ESPECIFICACION MENCIONADA, Y QUE LOS RESULTADOS SON COMO APARECEN EN LOS REGISTROS DE LA EMPRESA.
(WE HEREBY VERIFY THAT MATERIAL DESCRIBED HEREIN HAS BEEN MANUFACTURED, SAMPLED, TESTED AND INSPECTED IN ACCORDANCE WITH THE SPECIFICATION MENTIONED AND THAT THESE TEST RESULTS ARE AS THE PAPERWORK RECORDS OF THE COMPANY).

Control de Calidad (Quality Control)
Ing. Samuel Rodríguez Laguna.

TUBACERO, S.A. DE C.V.
CONTROL DE CALIDAD
04