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TEL.: 3055655
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CONSTANCIA DE INSPECCION

INSPECTION CONSTANCY

No. CONSTANCIA (constancy No.):

120805

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.) 23135	DIAMETRO (outside diam.) 24.000"	ESPESOR (thickness) 0.375"	GRADO (grade) X42/5LB PSL1/A53B	ESPECIFICACION (specification) API 5L 43 ED/A.S.T.M.	PROCESO (process) SAWL	PEDIDO (contract) 13736	O. PREPARACION (preparation order) SB-076-2012	PROVEEDOR (supplier) AHMSA	FECHA (date) 14/08/2012
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TUBO (pipe) O SERIE (SERIAL)	COLADA (heat)	T Y P E	L O C	PRUEBA DE TENSION (tensile test)				BEND	HARDNESS HRB	PRUEBA DE IMPACTO (impact test)									DWTT	GRAIN SIZE	ANALISIS QUIMICO (chemical analysis %)																								
				UNIDADES (units)		TAMAÑO (size)				°C ORIENTACION (orientation)			TAMAÑO (size)			ENERGY (lbs./ft.)					SHEAR AREA			SHEAR AREA			C	Mn	P	S	Si	Al	Cu	Cr	Ni	Mo	Ti	Nb	B	V	N	Als	Ca	PCM	CE
				PSI (Y.S.)	1 (T.S.)	3	% EL			Y.S.T.S.	1	2	3	AVG	1	2	3	AVG			1	2	3	AVG	1	2																			
135	272141	H	6 7	68800 65400	34	0.70												H P P	7 7 7	0.18 0.17 0.15	0.62 0.60 0.58	0.020 0.018 0.016	0.010 0.010 0.009	0.102 0.105 0.110	0.050 0.045 0.050	0.020 0.018 0.018	0.040 0.038 0.035	0.030 0.028 0.026	0.006 0.005 0.004	0.004 0.002 0.003	0.004 0.002 0.003	0.004 0.0001 0.002	0.004 0.004 0.003	- - -	0.005 0.004 0.002	- - -	- - -	- - -	0.002 0.001 0.001	0.21 0.19 0.21	0.28 0.26 0.28				
131	272138	H	6 7	67200 64500	37	0.73												H P P	7 7 7	0.18 0.15 0.17	0.60 0.60 0.58	0.017 0.015 0.014	0.008 0.005 0.006	0.114 0.110 0.115	0.041 0.040 0.038	0.020 0.018 0.020	0.040 0.038 0.042	0.030 0.028 0.027	0.006 0.005 0.004	0.004 0.003 0.002	0.004 0.002 0.002	0.004 0.0001 0.002	0.004 0.004 0.002	- - -	0.005 0.004 0.001	- - -	- - -	- - -	0.001 0.001 0.001	0.19 0.21 0.21	0.26 0.28 0.28				
165	272144	H	6 7	67000 64300	32	0.70												H P P	7 7 7	0.17 0.16 0.14	0.63 0.60 0.58	0.023 0.020 0.018	0.009 0.007 0.004	0.113 0.112 0.110	0.048 0.042 0.040	0.050 0.048 0.048	0.050 0.048 0.040	0.050 0.048 0.045	0.013 0.010 0.012	0.004 0.003 0.002	0.004 0.003 0.002	0.004 0.0002 0.000	0.004 0.004 0.003	- - -	0.005 0.004 0.004	- - -	- - -	- - -	0.001 0.002 0.002	0.20 0.18 0.19	0.28 0.25 0.27				
45	272145	H	6 7	73300 75500	34	0.77												H P P	7 7 7	0.17 0.15 0.17	0.62 0.60 0.58	0.023 0.020 0.018	0.008 0.006 0.005	0.114 0.110 0.108	0.049 0.045 0.040	0.060 0.050 0.048	0.050 0.043 0.048	0.021 0.018 0.015	0.004 0.003 0.005	0.004 0.002 0.002	0.004 0.0002 0.0001	0.004 0.004 0.001	- - -	0.004 0.002 0.001	- - -	- - -	- - -	0.002 0.002 0.001	0.19 0.19 0.21	0.27 0.27 0.29					
73	272144		6				OK																																						
145	272141		6				OK																																						
165	272144		6				OK																																						
CRITERIOS DE ACEPTACION (Acceptance criteria)				MIN:	42000	60000	28	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
PROMEDIO (AVG)				MAX:	-	-	0.93	-	100	-	-	-	-	-	-	-	-	-	-	-	0.26	1.20	0.030	0.030	-	-	0.500	0.400	0.400	0.150	0.040	-	-	-	-	-	-	-	0.080	-	-	-	-	-	0.43
				* No se Aceptan grietas >1/8"																																									

PRUEBA HIDROSTATICA (hydrostatic test)	PRESION (pressure): 1180 Psi	TIEMPO (time): 10 sec
ULTRASONIDO (U.T.) (ultrasonic)	STANDARD DE REFERENCIA (REFERENCE STANDARD): F	
RAYOS-X (RT) (x-ray)	PENETROMETRO (penetrometer): N° 12 A.S.T.M.	
NORMALIZADO DE SOLDADURA (heat treatment weld)	TEMPERATURA (temperature): N/A	(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):	6. SOLDADURA (weld)
1. TRANSVERSAL (transverse)	7. METAL BASE (base metal)
2. LONGITUDINAL (longitudinal)	8. ZONA AFECTADA (h.a.z.)
TAMAÑO (size):	9. LINEA DE FUSION (fusion line)
3. RECTANGULAR (rectangular)	TIPO DE PRUEBA (type)
4. CILINDRICA (round bar) 0.500"	H: COLADA (heat)
5. CILINDRICA (round bar) 0.350"	P: PRODUCTO (product)
LOCALIZACION (location)	R: REMUESTRO (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 OBTENIDOS APARECEN EN LOS REGISTROS DE LA COMPANIA.

(WE HEREBY VERIFY THAT MATERIAL DESCRIBED HEREAFTER HAS BEEN MANUFACTURED, SAMPLED, TESTED AND INSPECTED IN ACCORDANCE WITH THE SPECIFICATION MENTIONED AND THAT THESE TEST RESULTS ARE AS THEY APPEAR IN RECORDS OF THE COMPANY.)

[Signature]
Control de Calidad (Quality Control)
Ing. Samuel Montoya Laguna.

TUBACERO, S. DE RL. DE C.V.
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