



天津市联众钢管有限公司
TIANJIN UNITED STEEL PIPE CO., LTD



PRODUCTION CERTIFICATE
产品质量证明书

CODE(编码): LZ/CX14-JL07D

NO. (编号): 1506958779

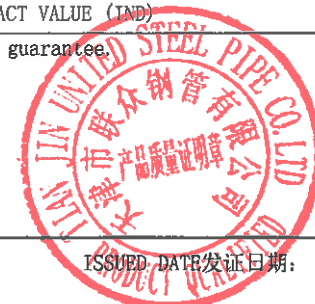
| | | | | | | | | | | | | | |
|------------------|----------------------|--|----------------|--|--|--|--|--|--|--|-------|------------------------|---------|
| CUSTOMER 订货单位 | E-STEEL, INC. | We here by certify that the material described here in has been manufactured and tested in accordance with above specifications and the results of all are acceptable. 兹为您单位制造之钢管, 经本公司质量管理部门标准技术条件及合同检验合格, 特发此证。 | | | | | | | | | | CERTIFICATE NO. 质检字 | QC01 |
| PRODUCT 货物名称 | ERW ROUND STEEL PIPE | | | | | | | | | | | CAR NO. 车号 | - |
| M. P 制造工艺 | HFW | STANDARD 检查依据 | ASTM A53 GR. B | | | | | | | HEAT TREATMENT OF WELDING SEAM 焊缝热处理 | (√) M | CONTRACT No. 合同号 | RU15076 |

| STEEL GRADE 钢级 | HEAT NO. 炉号 | SPECIFICATION 规格 (mm) | WEIGHT MT (吨) | PCS (支) | CHEMICAL COMPOSITION管坯化学成份(%) | | | | | | | | | | | | | | | | | | | |
|-------------------|----------------|-----------------------------|------------------|------------|-------------------------------|------|------|-------|-------|-------|-------|-------|-------|-------|-------|----|-------|---|-------|----|----|-------|-------------------|-------------------|
| | | | | | C | Si | Mn | P | S | Cu | Ni | Cr | Mo | Ti | V | Al | Nb | N | B | Sn | Ce | Ca | CE _{PCM} | CE _{ITW} |
| B | 1505011 | Φ219.1*5.56*6150 | 32.053 | 178 | 0.18 | 0.20 | 0.34 | 0.021 | 0.023 | 0.020 | 0.011 | 0.011 | 0.012 | 0.001 | 0.005 | - | 0.022 | - | 0.000 | - | - | 0.000 | - | - |
| B | 1505011 | Φ219.1*6.35*6150 | 107.777 | 526 | 0.18 | 0.20 | 0.34 | 0.021 | 0.023 | 0.020 | 0.011 | 0.011 | 0.012 | 0.001 | 0.005 | - | 0.022 | - | 0.000 | - | - | 0.000 | - | - |
| B | 1504260 | Φ219.1*6.35*6150 | 56.757 | 277 | 0.18 | 0.21 | 0.30 | 0.025 | 0.021 | 0.014 | 0.010 | 0.012 | 0.011 | 0.001 | 0.004 | - | 0.021 | - | 0.000 | - | - | 0.000 | - | - |

| MECHANICAL PROPERTY OF PIPE BODY 管体物理性能 | | | | MECHANICAL PROPERTY OF WELDING SEAM 钢管焊缝物理性能 | | | (√) UT超声波探伤 | (-) EMAT 电磁超声波 | HYDROSTATIC TEST 水压试验 | | |
|--|--|-------------------------------|------------------------|---|--|------------------------|------------------------|-------------------------------------|--------------------------|------------------------------|-------------------------|
| Y. S. (R _{10.5}) 屈服强度 MPa | T. S. (R _m) 抗拉强度 MPa | E. L. (A) 伸长率 A50mm (%) | IMP 冲击功 (J) - °C | FLATTENING 压扁 | T. S. (R _m) 抗拉强度 MPa | IMP 冲击功 (J) - °C | WELDING SEAM 焊缝100% | DELAMINATION OF PIPE END 管端分层 | PIPE BODY 管体 | TEST PRESSURE 试验压力 MPa | DELAY TIME 保压时间 秒 |
| 330 | 436 | 31.0 | - | OK | 447 | - | OK | - | - | 7.4 | 6s |
| 340 | 446 | 30.0 | - | OK | 450 | - | OK | - | - | 8.4 | 6s |
| 331 | 440 | 30.0 | - | OK | 441 | - | OK | - | - | 8.4 | 6s |

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|--|-------------|--|---|
| SIGN/SEAL OF THE THIRD PARTY DETECTION 第三方检验签章处 | NOTES 注释 | Y. S=YIELD STRENGTH E. L=ELONGATION | T. S=TENSILE STRENGTH IMP=IMPACT VALUE (IND) |
|--|-------------|--|---|

| | |
|--|---|
| <p>1. Pressure pipes used with ordinary pipes will be regarded as ordinary ones. 承压管与一般管混用时, 一律按一般管保证。</p> <p>3. Any changes by handwriting is invalid. 本证明任何手写或改动均无效。</p> | <p>2. Quality defects occurred in transmit is beyond our guarantee. 运输装卸中造成的产品缺陷不予保证。</p> <p>4. This certificate should be proved valid with seal. 本证明未加盖产品质量证明章无效。</p> |
|--|---|



INSPECTOR检验员: 张世格

CONSIGNOR发货员: 陈培

ISSUED DATE发证日期: 2015年6月4日



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|----------------------|----------------|-----------------------------|------------------|------------|-------------------------------|------|------|-------|-------|-------|-------|-------|-------|-------|-------|----|-------|---|-------|----|----|-------|-------------------|-------------------|
| | | | | | C | Si | Mn | P | S | Cu | Ni | Cr | Mo | Ti | V | Al | Nb | N | B | Sn | Ce | Ca | CE _{PCA} | CE _{ITW} |
| B | 525407 | Φ219.1*8.18*6150 | 117.231 | 448 | 0.17 | 0.16 | 0.32 | 0.025 | 0.022 | 0.014 | 0.020 | 0.011 | 0.011 | 0.002 | 0.001 | - | 0.002 | - | 0.001 | - | - | 0.001 | - | - |
| B | 525308 | Φ219.1*8.18*6150 | 43.177 | 165 | 0.18 | 0.17 | 0.33 | 0.024 | 0.021 | 0.014 | 0.021 | 0.010 | 0.014 | 0.003 | 0.005 | - | 0.001 | - | 0.001 | - | - | 0.001 | - | - |

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| 386 | 462 | 33.0 | - | OK | 497 | - | OK | - | - | 10.8 | 6s |
| 375 | 456 | 31.0 | - | OK | 468 | - | OK | - | - | 10.8 | 6s |

| | | | |
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