



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



CODE(编码): LZ/CX14-JL07D

PRODUCTION CERTIFICATE  
产品质量证明书

NO. (编号): 1506958779

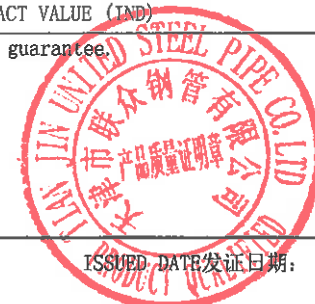
CUSTOMER 订货单位	E-STEEL, INC.	We here by certify that the material described here in has been manufactured and tested in accordance with above specifications and the results of all are acceptable. 兹为您单位制造之钢管, 经本公司质量管理部门标准技术条件及合同检验合格, 特发此证。										CERTIFICATE NO. 质检字	QC01
PRODUCT 货物名称	ERW ROUND STEEL 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 <sub>PCM</sub>	CE <sub>ITW</sub>
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 <sub>10.5</sub> ) 屈服强度 MPa	T. S. (R <sub>m</sub> ) 抗拉强度 MPa	E. L. (A) 伸长率 A50mm (%)	IMP 冲击功 (J) - °C	FLATTENING 压扁	T. S. (R <sub>m</sub> ) 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	

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)
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<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>
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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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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 <sub>PCA</sub>	CE <sub>ITW</sub>
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

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)
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