

R EMPRESAS RIGA, S.A de C.V.

CONEXIÓN SOLDABLE

CARR. MTY-LAREDO KM. 24.2

APARTADO POSTAL 43 C.P. 65550 CIÉNEGA DE FLORES, N.L., MÉXICO

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CERTIFICADO DE CALIDAD No.: 9379 CERTIFIED TEST REPORT:	LISTA DE EMPAQUE: 5551 PACKING LIST:	FECHA: OCTUBRE 18 de 2002 DATE:
VENDIDO A: TUBOS CONEXIONES Y TANQUES, S.A. DE C.V. SOLD TO: VALLE DE LAS ALAMEDAS 66-C COL., SAN FCO. CHILPAN TULTITLAN, EDO. DE MEXICO	PEDIDO DEL CLIENTE No. CUSTOMERS ORDER No.	EMBARCADO A: SHIP TO: LOS MISMOS
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PRUEBAS MECANICAS/MECHANICAL TEST

CANTIDAD QUANTITY	COLADA HEAT CODE	DESCRIPCION DESCRIPTION	PRODUCTO FINAL/FINISHED PRODUCT				
			ESF. DE CEDENCIA YIELD STRENGTH	ESF. RUPTURA TENSILE STRENGTH	ELONGACION ELONGATION	DUREZA HARDNESS	IMPACTO 0°C IMPACT TEST 0°C
			(PSI)	(PSI)	% 2"	HB	X (JOULES)
1	EX5	CODO 14 X 45 CED STD	45366	69834	45	140	N/A
1	EY5	CODO 14 X 45 CED STD	48623	73732	44	136	N/A
7	IU5	CODO 14 X 45 CED STD	46418	69877	45	137	N/A
1	BH5	CODO R.L. 14 X 90 CED STD	45838	66968	31	144	N/A
1	EB5	CODO R.L. 14 X 90 CED STD	53331	75700	34	139	N/A
2	EX5	CODO R.L. 14 X 90 CED STD	45366	69834	45	140	N/A
27	IU5	CODO R.L. 14 X 90 CED STD	46418	69877	45	137	N/A
5	JM5	CODO R.L. 14 X 90 CED STD	45465	70275	42	137	N/A
300	JN5	CODO 2 X 45 CED STD	50472	73309	35	128	N/A
1000	JN5	CODO R.L. 2 X 90 CED STD	50472	73309	35	128	N/A
199	JH5	CODO R.L. 2 X 90 CED XS	47709	70545	36	128	N/A

ANALISIS QUIMICO/CHEMICAL ANALYSIS

COLADA HEAT CODE	COLADA/HEAT M.P./MOTHER PIPE	C.E.	C	Mn	P	S	Si	Cr	Cu	Mo	Ni	V	Nb
	EX5	0.305	0.170	0.650	0.006	0.004	0.270	0.050	0.076	0.046	0.040	0.000	0.000
	EY5	0.340	0.180	0.800	0.007	0.003	0.290	0.050	0.070	0.045	0.040	0.000	0.000
	IU5	0.312	0.180	0.660	0.008	0.002	0.270	0.040	0.072	0.031	0.040	0.000	0.000
	BH5	0.311	0.180	0.660	0.006	0.002	0.250	0.040	0.066	0.029	0.040	0.000	0.000
	EB5	0.330	0.180	0.780	0.008	0.002	0.280	0.040	0.070	0.018	0.050	0.000	0.000
	EX5	0.305	0.170	0.650	0.006	0.004	0.270	0.050	0.076	0.046	0.040	0.000	0.000
	IU5	0.312	0.180	0.660	0.008	0.002	0.270	0.040	0.072	0.031	0.040	0.000	0.000
	JM5	0.303	0.170	0.680	0.006	0.002	0.270	0.040	0.072	0.022	0.040	0.000	0.000
	JN5	0.334	0.180	0.810	0.010	0.001	0.290	0.040	0.040	0.030	0.030	0.001	0.001
	JN5	0.334	0.180	0.810	0.010	0.001	0.290	0.040	0.040	0.030	0.030	0.001	0.001
	JH5	0.316	0.180	0.700	0.010	0.001	0.280	0.050	0.040	0.020	0.030	0.001	0.001

LOS PRODUCTOS MANUFACTURADOS POR EMPRESAS RIGA, S.A. de C.V. ESTAN CONFORME A LAS SIGUIENTES ESPECIFICACIONES:
 PRODUCTS MANUFACTURED BY EMPRESAS RIGA, S.A. de C.V. ARE CONFORMING TO FOLLOWING SPECIFICATIONS:
 MATERIA PRIMA T S/C / STARTING MATERIAL SEAMLESS PIPE: ASTM A 106 GRADE B.ACORDING TO DIN 50049/3.1. B/EN 10204/3.1. B.
 MATERIAL CONFORME A:
 MATERIAL CONFORM TO: ASTM A 234 WPB, ASME SA 234 WPB, ASME II PART A ED. 2001, ASME B16.9, ASME B16.28 AND TO NACE MR 01.75 ED 2001.
 CONEXIONES SIN COSTURA, FORJADO EN CALIENTE (ENFRIADO AL AIRE) O NORMALIZADO (TEMPERATURA 920°C MAX PERMANENCIA 10').
 SEAMLESS FITTINGS, HOT FORMED (COOLED IN STILL AIR) OR NORMALIZED (TEMPERATURE IE 920°C MAX AND HOLDING TIME IE 10').
 INSPECCION VISUAL Y DIMENSIONAL CONFORME A STANDARDS APLICABLES.
 VISUAL AND DIMENSIONAL TEST CONFORM TO THE APPLICABLE STANDARD.

GERENTE DE ASEGURAMIENTO DE CALIDAD:
 QUALITY ASSURANCE MANAGER:

ING. JOSE MARTINEZ MACIAS.

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