

# 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.: 9380	LISTA DE EMPAQUE : 5551	FECHA: OCTUBRE 18 de 2002	
CERTIFIED TEST REPORT:	PACKING LIST:	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	KH4	CODO R.L. 2 X 90 CED XS	52668	67415	33	128	N/A
528	IP5	CODO R.L. 3 X 90 CED STD	46690	70690	41	131	N/A
107	J15	CODO 4 X 45 CED STD	51574	77730	30	137	N/A
43	LC5	CODO 4 X 45 CED STD	52279	70446	36	136	N/A
456	LC5	CODO R.L. 4 X 90 CED STD	52279	70446	36	136	N/A
288	JP5	CODO 6 X 45 CED STD	46290	69436	43	136	N/A
200	JP5	CODO R.L. 6 X 90 CED STD	46290	69436	43	136	N/A
60	DZ5	CODO R.L. 6 X 90 CED XS	46433	69421	40	140	N/A
60	KK5	CODO 8 X 45 CED STD	47656	70716	39	137	N/A
60	JK5	CODO R.L. 8 X 90 CED STD	43971	70759	38	137	N/A
60	KK5	CODO R.L. 8 X 90 CED STD	47656	70716	39	137	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
	KH4	0.303	0.188	0.628	0.003	0.000	0.340	0.022	0.056	0.007	0.001	0.002	0.000
	IP5	0.320	0.180	0.750	0.011	0.001	0.290	0.030	0.040	0.020	0.030	0.001	0.001
	J15	0.358	0.200	0.850	0.010	0.002	0.260	0.040	0.040	0.020	0.020	0.001	0.000
	LC5	0.316	0.180	0.690	0.010	0.001	0.280	0.040	0.052	0.037	0.030	0.000	0.000
	LC5	0.316	0.180	0.690	0.010	0.001	0.280	0.040	0.052	0.037	0.030	0.000	0.000
	JP5	0.321	0.180	0.680	0.006	0.001	0.260	0.060	0.077	0.040	0.040	0.000	0.000
	JP5	0.321	0.180	0.680	0.006	0.001	0.260	0.060	0.077	0.040	0.040	0.000	0.000
	DZ5	0.323	0.180	0.690	0.007	0.003	0.280	0.050	0.078	0.049	0.040	0.000	0.000
	KK5	0.312	0.180	0.660	0.007	0.004	0.270	0.050	0.063	0.024	0.040	0.000	0.000
	JK5	0.345	0.180	0.840	0.006	0.001	0.260	0.050	0.067	0.035	0.050	0.000	0.000
	KK5	0.312	0.180	0.660	0.007	0.004	0.270	0.050	0.063	0.024	0.040	0.000	0.000

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 ACCORDING 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.**  
 e-mail imartinez@empresasriga.com

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