

**CERTIFICADO DE CALIDAD
INSPECTION CERTIFICATE**
(DIN EN 10204 3.1.B - ISO 10474 3.1.B)

Empresas Riga, S.A.
Carr. Mty-Laredo Km 24.2
Apartado Postal 43
(65550) C. de Flores, N.L. Mex.
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Vendido a:	PLESA ANAHUAC Y CIA., S. A.	Pedido del Cliente No:	100000806, 641,	Lista de Empaque:	7283	Fecha/Date:	20 de Enero de 2005
Sold to:		Customers Order No:		Packing List:		Factura/Invoice:	Bocas / Ends
Dimensiones y tolerancias / Dimension and tolerances							Biselado / Bevelled ends

DESCRIPCION DE MATERIAL / MATERIAL DESCRIPTION				PRUEBAS MECANICAS / MECHANICAL TEST				PRUEBA DE IMPACTO 0°C / IMPACT TEST 0°C				
ART. ITEM	COLADA HEAT CODE	CANTIDA QUANTITY	DESCRIPCION / DESCRIPTION	ESF. CEDENCIA YIELD STRENGTH (Mpa)	ESF. RUPTURA TENSILE STRENGTH (Mpa)	ELONG. % ²	DUREZA HARDNESS HB	DIMENSIONES SAMPLE DIM mm	1 Joules	2 Joules	3 Joules	PROMEDIO AVERAGE Joules
1	TI9193	163	ELLS 6" X 90° L.R. SCH-STD.	306	470	40	116					
2	TI9194	33	CONC. RED. 6" X 3" SCH-STD.	294	459	44	110					
3	TI9195	60	ELLS 8" X 90° L.R. SCH-STD.	306	469	42	123					
4	TI9866	1049	ELLS 4" X 90° L.R. SCH-STD.	338	465	37	122					
5	TI9908	18	ELLS 12" X 90° L.R. SCH-STD.	339	492	43	95					
6	TEAS	2	RED. TEE 8" X 6" SCH-XH.	309	477	30	146					
7	TKK6	1	TEE 6" SCH-STD.	313	481	44	141					
8	TKK5	3	RED. TEE 8" X 6" SCH-XH.	256	473	38	144					

ANALISIS QUIMICO / CHEMICAL ANALYSIS														
PROCESO PROCESS	COLADA HEAT CODE	COLADA/HEAT M.P/MOTHER PIPE	%C.E.	%C	%Mn	%P	%S	%SI	%Cr	%Cu	%Mo	%Ni	%V	%Nb
HF	TI9193	19193	0.316	0.180	0.650	0.006	0.001	0.280	0.060	0.080	0.039	0.040	0.000	0.000
CF	TI9194	19194	0.308	0.170	0.670	0.008	0.003	0.260	0.050	0.064	0.045	0.040	0.000	0.000
HF	TI9195	19195	0.308	0.170	0.680	0.009	0.003	0.270	0.050	0.064	0.041	0.040	0.000	0.000
HF	TI9866	19866	0.320	0.180	0.670	0.006	0.002	0.270	0.050	0.076	0.051	0.040	0.000	0.000
HF	TI9908	19908	0.321	0.180	0.710	0.011	0.003	0.290	0.050	0.064	0.031	0.030	0.000	0.000
CF	TEAS	95768	0.323	0.180	0.660	0.008	0.004	0.270	0.070	0.060	0.057	0.050	0.000	0.000
CF	TKK6	16432	0.323	0.180	0.700	0.013	0.001	0.260	0.070	0.069	0.030	0.030	0.000	0.000
CF	TKK5	96453	0.326	0.157	0.822	0.007	0.005	0.262	0.050	0.079	0.080	0.011	0.001	0.000

Certificamos que los resultados de los Analisis Quimicos y Pruebas Mecanicas son verdaderos o una copia fiel de los certificados enviados por el Fabricante y/o el proveedor de Materia Prima conforme ASTM A106/Grade B con N°.

We certify that result of chemical analysis and mechanical test are true and correct copy of the test certificate issued by the manufacturer and/or supplier Raw material certs conform to ASTM A106 Grade B N°.

04027372 04026477 04025847
04028625 05000165 02007230
04009336 02008104

Este material cumple con los requerimientos especificados en la orden.
The material of this certificate heat number mentioned above is in compliance with the requirements specified in the order.

Notes:
Formado en caliente a 780°C-940°C, enfriado al aire, Formado en frío normalizado a 840°C max.
Hot formed fittings in a range from 780°C to 940°C, cooled in still air.
Cold formed normalized at 840°C max.
Timeo de permeancia 10'.
Holding time 10'.
Inspeccion Dimensional: Satisfactoria.
Visual dimensionalcheck: Satisfactory
#F: FORMADO EN CALIENTE/HOT FORMED #P: FORMADO EN FRIJO/COLD FORMED

Jefe de Aseguramiento de Calidad:
Quality Assurance Coordinator

ING. JOSE MARTINEZ MACIAS

CC-008