



Empresas Riga, S.A. De C.V.
Carr. Mty-Laredo Km. 24.2
Ciéneiga de Flores, N.L. 65550
Tel: (81) 83-44-88-60
Fax: (81) 83-44-88-01

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

Vendido a: **PIESA AMAHUAC**
Sold to:

Numero: **14924**
Pagina/Page: **1 DE 1**

Lista de Empaque: **7783**
Fecha/Date: **12 de Octubre de 2005**

Numero: **451**
Factura/Invoice: **Bocas / Ends**

Pedido del Cliente No: **451**
Biselado / Bevelled ends

Dimensiones y tolerancias / Dimension and tolerances
ASME B 16.9 and ASME B 16.28 edition 2001

ART. ITEM	COLADA HEAT CODE	CANTIDA QUANTITY	DESCRIPCION / DESCRIPTION	PRUEBAS MECANICAS / MECHANICAL TEST			PRUEBA DE IMPACTO 0°C / IMPACT TEST 0°C					
				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	S31802	20	ELLS 3 X 45 SCH-XH	369	523	50	133					
2	S32536	10	ELLS 3 X 90 S.R. SCH-STD	327	488	50	102					
3	T22635	5	ELLS 5 X 90 L.R. SCH-XH	308	492	44	119					
4	S37673	25	CONC. RED. 4 X 2 SCH-STD	335	497	29	106					
5	T19982	10	CONC. RED. 6 X 3 1/2 SCH-STD	312	473	42	98					
6	S32202	50	CONC. RED. 2 1/2 X 2 SCH-STD	344	497	50	150					
7	T22407	25	CONC. RED. 6 X 4 SCH-STD	302	476	42	124					
8	T21272	20	ELLS 8 X 45 SCH-STD	328	479	39	124					
9	T19066	10	ELLS 10 X 45 SCH-STD	328	489	43	112					

PROCESO PROCESS	COLADA HEAT CODE	COLADA/HEAT M.P./MOTHER PIPE	ANALISIS QUIMICO / CHEMICAL ANALYSIS											
			%C	%Mn	%P	%S	%Si	%Cr	%Cu	%Mo	%Ni	%V	%Nb	
HF	S31802	31802	0.320	0.180	0.770	0.009	0.002	0.330	0.030	0.034	0.010	0.014	0.001	0.001
HF	S32536	32536	0.338	0.190	0.820	0.009	0.001	0.300	0.020	0.031	0.020	0.018	0.001	0.001
HF	T22635	22635	0.309	0.170	0.680	0.009	0.000	0.270	0.050	0.069	0.044	0.030	0.000	0.000
CF	S37673	37673	0.323	0.180	0.770	0.010	0.001	0.300	0.030	0.039	0.020	0.020	0.002	0.001
CF	T19982	19982	0.337	0.190	0.670	0.007	0.003	0.280	0.070	0.074	0.068	0.040	0.000	0.000
CF	S32202	32202	0.329	0.190	0.300	0.010	0.001	0.300	0.400	0.044	0.020	0.021	0.001	0.001
CF	T22407	22407	0.306	0.170	0.690	0.010	0.002	0.270	0.050	0.055	0.025	0.030	0.000	0.000
HF	T21272	21272	0.312	0.170	0.680	0.005	0.003	0.270	0.040	0.089	0.061	0.040	0.000	0.000
HF	T19066	19066	0.347	0.190	0.800	0.009	0.001	0.330	0.050	0.065	0.037	0.030	0.000	0.000

Notas:
Formado en caliente a 760°C-840°C, enfriado al aire. Formado en frío normalizado a 840°C max.
Tiempo de permeación 10"
Inspección Dimensional: Satisfactoria.
WF FORMADO EN CALIENTE/OT FORMED

Notas:
Hot formed fittings in a range from 760°C to 840°C, cooled in air.
Cold formed normalized at 840°C max.
Holding time 10"
Visual dimensioncheck: Satisfactory
CF FORMADO EN FRIOCOLD FORMED

Certificamos que los resultados de los Analisis Quimicos y Pruebas Mecanicas son verdaderos o una copia fiel de los certificados enviados por el Fabricante. We el proveedor de Materia Prima conforme ASTM A106GradeB 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°. 207944 207922 05012740 05012940 04028896 207960 05010778 05005328 05001557

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.

Jefe de Aseguramiento de Calidad:
Quality Assurance Coordinator

ING. JOSE MARTINEZ MACIAS

CC-008