Tubacero

Ave. Gobernador
No. 3720 ote.
Col. Del Norte
Monterrey N.L. México
CP.64540
TEL.:
FAX:

CERTIFICADO DE TUBERIA

PIPE CERTIFICATE

No. CERTIFICADO(certificate No.): **030259**

CLIENTE(customer): TUBOS, CONEXIONES Y TANQUES, S.A. DE C.V.

DIRECCION(address): VALLE DE LAS ALAMEDAS # 66-C COL. SAN FCO.CHILPAN

O.T. (order no.)	DIAMETRO (outside diam.)	ESPESOR (thickness)	GRADO (grade)	ESPECIFICACION (specification)	PROCESO (process)	PEDIDO (contract)	O. PREPARACION (preparation order)	PROVEEDOR (supplier)	FECHA (date)
33240	12.750"	0.250"	A-53-B	ASTM	ERW	5725	B-030-2003	AHMSA	19/06/03

TUBO (pcs)	COLADA (heat)	TYPE	LOC	PRUEBA DE TENSION (tensile test) UNIDADES (units)	ORIENTACION (orientation)	TAMAÑO (size)			BEND	WELDERS	PRUEBA DE IMPACTO (impact test) °C ORIENTACION TAMAÑO 1:1 °C (orientation) (size) ENERGY (ft-lb) 1 2 3 AVG	SHEAR AREA % 1 2 3 AVG	DWTT SHEAR AREA 1 2 AVG	SEAM SCC	TYPE	LOC	CHEMICAL ANALYSIS (%) C	Mn	P	S	Si	Al	Cu	Cr	Ni	Mo	Ti	Nb	B	V	N	Als	Ca	PCM	CE
			6		80691																														
488	430050	H	7	61015	74530	33	0.82									P	7	0.15	0.45	0.019	0.015	0.007	0.050	0.09	0.25	0.015	0.010	0.002	0.001	-	0.003	-	-	-	-	-
			6		74622																														
1438	230525	H	7	45876	65222	34	0.70									P	7	0.18	0.46	0.015	0.015	0.009	0.050	0.04	0.19	0.042	0.010	0.002	0.010	-	0.002	-	-	-	-	-
			6		79612																														
393	230607	H	7	51024	68727	32	0.74									P	7	0.16	0.46	0.018	0.013	0.007	0.031	0.05	0.21	0.019	0.008	0.002	0.003	-	0.001	-	-	-	-	-
			6		74957																														
655	230601	H	7	50927	65478	33	0.77									P	7	0.16	0.48	0.013	0.011	0.010	0.042	0.04	0.15	0.033	0.008	0.002	0.001	-	0.002	-	-	-	-	-
			6		72062																														
730	430077	H	7	50761	68890	36	0.73									P	7	0.17	0.45	0.018	0.012	0.011	0.038	0.05	0.50	0.032	0.015	0.002	0.001	-	0.002	-	-	-	-	-
			6		74052																														
53	430076	H	7	62026	77331	30	0.79									P	7	0.16	0.47	0.017	0.009	0.011	0.042	0.04	0.35	0.055	0.025	0.002	0.001	-	0.002	-	-	-	-	-
			6		75428																														
280	230602	H	7	50618	66839	32	0.76									P	7	0.17	0.46	0.013	0.010	0.012	0.050	0.06	0.27	0.024	0.009	0.002	0.001	-	0.002	-	-	-	-	-
			6		81210																														
565	230521	H	7	51879	68451	33	0.75									P	7	0.16	0.47	0.019	0.015	0.013	0.048	0.03	0.24	0.030	0.005	0.001	0.001	-	0.002	-	-	-	-	-
			6		78709																														
960	230522	H	7	43814	67292	33	0.65									P	7	0.17	0.51	0.012	0.013	0.011	0.034	0.02	0.58	0.040	0.010	0.003	0.001	-	0.003	-	-	-	-	-
			6		73041																														
250	230603	H	7	50922	66445	33	0.77									P	7	0.15	0.46	0.015	0.011	0.012	0.049	0.03	0.17	0.022	0.003	0.001	0.001	-	0.002	-	-	-	-	-
			6		77581																														
115	230606	H	7	49299	66150	32	0.74									P	7	0.15	0.46	0.017	0.013	0.012	0.043	0.05	0.36	0.028	0.011	0.002	0.001	-	0.002	-	-	-	-	-

PRUEBA HIDROSTATICA (hidrostatic test): PRESION (pressure): 820 Psi TIEMPO (time): 10 SEC

ULTRASONIDO(U.T.) (ultrasonic): STANDARD DE REFERENCIA / REFERENCE STANDARD: G

RAYOS-X (RT) (X-ray): PENETROMETRO (penetrometer): N/A

NORMALIZADO DE SOLDADURA (heat treatment weld): TEMPERATURA (temperature): 1600° F.

REFERENCE STANDARD: F: U.T. DRILLED HOLE 1/16", G: U.T. DRILLED HOLE 1/8", I: U.T. NOTCH N-S, J: U.T. NOTCH V-10 L: RT HOLE 1/16", M: RT HOLE 2-2T O: RT HOLE 2-4T

ORIENTACION(orientation):
1. TRANSVERSAL (transverse)
2. LONGITUDINAL (longitudinal)
TAMAÑO (size)
3.RECTANGULAR(rectangular) 1½"
4.CILINDRICA(round bar) 0.500"
5.CILINDRICA(round bar) 0.350"
LOCALIZACION (location):

6. SOLDADURA (weld)
7. METAL BASE (base metal)
8. ZONA AFECTADA (h.a.z.)
9. LINEA DE FUSION (fusion line)
TIPO DE PRUEBA (type)
H: COLADA (heat)
P: PRODUCTO (product)
R: REMUESTREO (recheck)

CERTIFICAMOS QUE EL MATERIAL DESCRITO HA SIDO HECHO DE ACUERDO CON LA ESPECIFICACION MENCIONADA, Y QUE LOS RESULTADOS ASENTADOS APARECEN EN LOS REGISTROS DE LA COMPAÑIA

(WE HEREBY CERTIFY THAT MATERIAL DESCRIBED HEREIN HAS BEEN MADE IN ACCORDANCE WITH THE SPECIFICATION MENTIONED AND THAT THE TEST RESULT ARE AS THEY APPER IN RECORDS OF THE COMPANY)

Control de Calidad (Quality Control)

CONTROL DE CALIDAD 04

REV.1 Sep-99

F-TUME-013