Tubacero

Ave. Guerrero
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CERTIFICADO DE TUBERIA

PIPE CERTIFICATE

No.CERTIFICADO(certificate No.): **070254**

CLIENTE(customer): PLESA ANÁHUAC Y CÍAS; S.A. DE C.V.

DIRECCION(address): AV. VALLE DE LAS ALAMEDAS # 66 O COL. SAN FCO. CHILPAN TULTITLÁN, EDO. DE MÉXICO C.P. 54940

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)
33429	12.750"	0.225"	X-42/5LB/ A53B	API 5L 43 ED/A.S.T.M.	ERW	2640	B-054-2007	APM	10/03/2007

TUBO (pipe)	COLADA (heat)	TYPE	LOC	PRUEBA DE TENSION(tensile test) UNIDADES: (units) PSI (Y.S.)	ORIENTACION: (orientation) 1 (T.S.)	TAMAÑO: (size) 3 % EL.	Y.S/T.S.	BEND	HARDNESS	PRUEBA DE IMPACTO (Impact test) °C ORIENTACION °F (orientation) TAMAÑO: (size) ENERGY (lbs/ft) 1	2	3	AVG	SHEAR AREA 1	2	3	AVG	DWTT SHEAR AREA 1	2	AVG	GRAIN SIZE
			6		74900																
687	NA6563916	H	7	52300	69400	40	0.75														
			6		73700																
1226	0613608	H	7	53900	70200	39	0.77														
			6		78400																
1209	0613609	H	7	58100	75400	36	0.77														
			6		69900																
1581	0613610	H	7	52400	70400	41	0.74														
			6		70200																
162	NA1563913	H	7	50600	67300	41	0.75														
			6		75100																
411	0633046	H	7	51900	70200	39	0.74														
			6		72700																
593	NA0563919	H	7	52800	69100	40	0.77														

(%)ANALISIS QUIMICO / chemical analysis (%)

TYPE	LOC	C	Mn	P	S	Si	Al	Cu	Cr	Ni	Mo	Ti	Nb	B	V	N	Als	Ca	PCM	CE
H	7	0.18	0.67	0.014	0.015	0.160	0.046	-	-	-	-	-	-	-	-	-	-	-	-	-
P	7	0.15	0.65	0.013	0.014	0.158	0.042	0.012	0.010	0.020	0.002	0.001	0.001	0.0001	0.001	-	-	0.001	0.19	0.26
P	7	0.16	0.64	0.012	0.013	0.155	0.042	0.011	0.012	0.018	0.001	0.002	0.001	0.0002	0.002	-	-	0.001	0.20	0.27
H	7	0.20	0.71	0.012	0.006	0.157	0.028	-	-	-	-	-	-	-	-	-	-	-	-	-
P	7	0.23	0.71	0.014	0.005	0.170	0.060	0.010	0.010	0.008	0.001	0.002	0.002	0.0003	0.001	-	-	0.002	0.27	0.35
P	7	0.21	0.71	0.014	0.005	0.170	0.050	0.011	0.010	0.008	0.001	0.002	0.002	0.0004	0.001	-	-	0.002	0.25	0.33
H	7	0.18	0.71	0.011	0.007	0.157	0.026	-	-	-	-	-	-	-	-	-	-	-	-	-
P	7	0.16	0.70	0.014	0.005	0.174	0.060	0.010	0.010	0.009	0.001	0.002	0.002	0.0002	0.001	-	-	0.001	0.20	0.28
P	7	0.18	0.72	0.012	0.005	0.175	0.076	0.010	0.010	0.009	0.001	0.003	0.002	0.0004	0.001	-	-	0.001	0.23	0.30
H	7	0.20	0.69	0.011	0.005	0.158	0.034	-	-	-	-	-	-	-	-	-	-	-	-	-
P	7	0.18	0.65	0.010	0.003	0.152	0.032	0.010	0.015	0.015	0.002	0.002	0.001	0.0001	0.001	-	-	0.001	0.22	0.29
P	7	0.17	0.64	0.010	0.002	0.150	0.031	0.010	0.018	0.018	0.002	0.002	0.001	0.0001	0.001	-	-	0.001	0.21	0.28
H	7	0.18	0.70	0.014	0.015	0.180	0.052	-	-	-	-	-	-	-	-	-	-	-	-	-
P	7	0.16	0.70	0.012	0.014	0.175	0.050	0.010	0.020	0.021	0.002	0.005	0.001	0.0002	0.001	-	-	0.001	0.20	0.28
P	7	0.15	0.68	0.013	0.014	0.174	0.049	0.010	0.020	0.022	0.001	0.005	0.001	0.0002	0.001	-	-	0.001	0.19	0.27
H	7	0.19	0.72	0.011	0.004	0.179	0.032	-	-	-	-	-	-	-	-	-	-	-	-	-
P	7	0.18	0.70	0.010	0.003	0.175	0.030	0.010	0.020	0.021	0.002	0.003	0.001	0.0002	0.001	-	-	0.001	0.22	0.30
P	7	0.18	0.70	0.010	0.002	0.173	0.030	0.010	0.020	0.018	0.001	0.002	0.001	0.0002	0.001	-	-	0.001	0.22	0.30
H	7	0.18	0.71	0.013	0.014	0.170	0.042	-	-	-	-	-	-	-	-	-	-	-	-	-
P	7	0.15	0.68	0.012	0.012	0.168	0.040	0.010	0.014	0.015	0.002	0.002	0.001	0.0002	0.002	-	-	0.001	0.19	0.27
P	7	0.14	0.67	0.011	0.012	0.164	0.041	0.010	0.013	0.015	0.002	0.002	0.001	0.0001	0.002	-	-	0.001	0.18	0.26

PRUEBA HIDROSTATICA: (hidrostatic test)	PRESION: (pressure) 1260 Psi	TIEMPO: (time) 10 sec
ULTRASONIDO(U.T.): (ultrasonic)	STANDARD DE REFERENCIA: REFERENCE STANDARD	J
RAYOS-X (RT): (x-ray)	PENETROMETRO (penetrometer):	N/A
NORMALIZADO DE SOLDADURA: (heat treatment weld)	TEMPERATURA (temperature):	1600° F. MIN.
REFERENCE STANDARD	F: U.T. DRILLED HOLE 1/16", G: U.T. DRILLED HOLE 1/8", I: U.T. NOTCH N-5, J: U.T. NOTCH V-10 L: RT HOLE 1/16", N: RT HOLE 2-2T O: RT HOLE 2-4T	

ORIENTACION(orientation):
1. TRANSVERSAL (transverse)
2. LONGITUDINAL (longitudinal)

TAMAÑO (size)
3.RECTANGULAR(rectangular)
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 SON COMO 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 THESE TEST RESULT ARE AS THEY APPEAR IN RECORDS OF THE COMPANY).

Control de Calidad (Quality Control)

REV.1 Sep-99

F-TUME-013