



U. S. Steel Košice, s.r.o. A01  
 Vstupný areál U. S. Steel  
 044 54 Košice  
 Slovak Republic

Inspection certificate No.:  
 EN 10 204:2004/3.1

2442 / 2024

A02-A03

A06 Purchaser :

A05 Producer :  
 U.S. Steel Košice, s.r.o , Rúrovňa

Z02 Date :  
 23.05.2024

B01 Product : SPIRALLY WELDED STEEL PIPES – SAWH

B01 According : EN 10217-5/19

B03 Specification : LOGSTOR , Material Specification 0001-001;  
 rev. 27 (25.02.2020)

A07 Purchaser's order No.: 4501148056

B02 Steel designation:  
 P265GH TC1

A08 Manufacturer's work order number: XR450273

A10 Packing Sheet/ Item No.: 124R0100501

C70 Steelmaking process:  
 B O F

A09 Purchaser article number: 6T6C5CI401

B06 Marking:  
 Outside: USS Kosice•SAWH•EN 10217-5•P265GH TC1•Pipe No. •TK 1-23  
 Inside: -

B08 No. of Pieces:	B12 Th. Mass:	B14 Total length:	B09 Dimensions, Pipe No.:
11	17165 kg	132.05 m	Ø 610 x 8.8 mm ; 12.00 m ; - 0 + 15 mm

B10 Pipe No.:	B07 Heat No.:	C00 Test No.:
		C71 C00
24-3254512-01-01,-05,-07,-09,-11	32545	684
24-3254601-01-02,-03,-04	32546	685
24-4386602-01-01	43866	420
24-5327608-01-03,-07	53276	421

D01

Visual inspection	Satisfactory
Dimensional inspection: EN 10217-5/19	Satisfactory
Hydrostatic pressure test: 5,4 MPa – 10 s	Satisfactory
Welding procedures are prepared and approved acc.to: EN 15614-1	
Operators and Welders are certified acc.: EN ISO 14732 and EN ISO 9606-1	
Requirements: Weld factor: V=1,0	
Manufacturer of coils: U.S.Steel Košice; s.r.	

Non-destructive testing :	D02
100% weld test by UT acc. to EN ISO 10893-11:2011, class U3H or by RT acc. to EN ISO 10893-7:2019, class A	Satisfactory
Weld seam ends (100mm) test by RT acc. to EN ISO 10893-7:2019, class A	Satisfactory
100% coil end welds test by RT acc. to EN ISO 10893-7:2019, class B	Satisfactory
15mm zone adjacent to the coil end welds test by UT acc. to EN ISO 10893-8:2011, Annex A, class U2	Satisfactory
NDT Operators are certified acc. to EN ISO 9712	Satisfactory



Test Results

Chemical composition: %

Heat No.	Product Analysis	C71													
		C max	Mn max	Si max	P max	S max	Al min	Cu max	Ni max	Cr max	Ti max	V max	Nb max	Mo max	Cu+Ni+Cr+Mo max 0.70
32545	-	0.14	0.66	0.19	0.015	0.012	0.037	0.023	0.009	0.017	0.001	0.001	0.002	0.002	0.05
32546	-	0.13	0.65	0.18	0.014	0.008	0.035	0.020	0.010	0.020	0.001	0.001	0.002	0.002	0.05
43866	-	0.12	0.65	0.20	0.013	0.011	0.034	0.012	0.010	0.017	0.001	0.001	0.002	0.002	0.04
53276	-	0.12	0.65	0.20	0.014	0.008	0.035	0.016	0.010	0.017	0.001	0.001	0.002	0.002	0.04

Mechanical tests

C00 - C50

Test No.	Dimensions		Tensile test							Impact test - pipe body *		Impact test - seam weld *		Impact test - HAZ *		
	(mm)		(MPa)							(J)		(J)		(J)		
	C40	C41	C02	C03	C11	C12	C13	C14	C50	C42	C43	C51	C42	C43	C42	C43
	a0	b0	Specimen	Test temper.	Yield strength	Tensile strength	Elongation	Ratio	Bend test	Single values	Average value	DWTT	Single values	Average value	Single values	Average value
Requirements				REH	Rm	A5	REH/Rm			KV	Σ/ 2		KV		KV	
EN 10217-5/19				min 265	410-570(2) min 410(3)	min 21	%	%	mm	(10,0x8,0 mm)	%		(10,0x8,0 mm)		(10,0x8,0 mm)	

Results

684	S	S	2		308	445	33									
684	S	S	3			470										
684	S	S	3						Satisfactory							
685	S	S	2		315	447	30									
685	S	S	3			467										
685	S	S	3						Satisfactory							
420	S	S	2		296	437	30									
420	S	S	3			453										
420	S	S	3						Satisfactory							
421	S	S	2		304	445	30									
421	S	S	3			463										
421	S	S	3						Satisfactory							

S-Size acc. to standard ;1-Pipe body-Longitudinal ;2-Pipe body:Transverse ;3-Seam weld-Transverse ;4-Heat-affected zone (HAZ) ;5-Coil end weld

\*If test element is less than 10,00 mm, is made by impact test values KV calculation. Values are recalculated in accordance with standard.

\*\*Unless, if not specified alternatively, test must be performed at ambient temperature (23°C +/- 5°C).

Z05

Manufacturer is certified according to EN ISO 9001, EN ISO 14001, EN ISO 50001 and approved according to AD 2000 - Merkblatt W0 and certified according to the Pressure Equipment Directive 2014/68/EU by TÜV-Thüringen e.V. ; NoBo reg.no. 0090



U. S. Steel Košice, s.r.o. A01  
Vstupný areál U. S. Steel  
044 54 Košice  
Slovak Republic

A02-A03

Inspection certificate No.: 2442 / 2024  
EN 10 204:2004/3.1

ZETOM/National Declaration Research and Certification Institute in Katowice sp.z o.o AC005,  
National Certificate of Conformity:  
No. 005-UWB-130  
National Declaration of Performance Properties: USSK-02/2023

Z01

The Declaration of Performance (DoP), see here:<http://www.usske.sk/en/products/spiral-welded-pipes/declaration-of-conformity>

We hereby confirm that the above product has been manufactured and tested in accordance with the requirements of the contract.  
Document valid also without signature.

Z04



09  
Zetom-Katowice  
AC 005

Z02

Location: Košice

Date: 23.05.2024

Martin Milota

Inspection representative



U. S. Steel Košice, s.r.o. A01  
 Vstupný areál U. S. Steel  
 044 54 Košice  
 Slovak Republic

Inspection certificate No.:  
 EN 10 204:2004/3.1

3066 / 2024

A02-A03

A06 Purchaser :

A05 Producer :  
 U.S. Steel Košice, s.r.o , Rúrovňa

Z02 Date :  
 25.06.2024

B01 Product : SPIRALLY WELDED STEEL PIPES – SAWH

B01 According : EN 10217-5/19

B03 Specification : LOGSTOR , Material Specification 0001-001;  
 rev. 27 (25.02.2020)

A07 Purchaser's order No.: 4501148070

B02 Steel designation:  
 P265GH TC1

A08 Manufacturer's work order number: XR450274

A10 Packing Sheet/ Item No.: 124R0129701

C70 Steelmaking process:  
 B O F

A09 Purchaser article number: 6T6C5CJ401

B06 Marking:  
 Outside: USS Kosice•SAWH•EN 10217-5•P265GH TC1•Pipe No. •TK 1-23  
 Inside: -

B08 No. of Pieces:	B12 Th. Mass:	B14 Total length:	B09 Dimensions, Pipe No.:
12	14206 kg	144.1 m	Ø 508 x 8.0 mm ; 12.00 m ; - 0 + 15 mm

B10 Pipe No.:	B07 Heat No.:	C00 Test No.:
		C71 C00
24-3254304-01-03,-05	32543	857
24-3254306-01-08	32543	857
24-3254308-01-11	32543	857
24-3254312-01-05,-06,-07,-08	32543	861
24-4518102-01-02,-06	45181	863
24-4518104-01-03	45181	863
24-5420502-01-56	54205	860

D01

Visual inspection	Satisfactory
Dimensional inspection: EN 10217-5/19	Satisfactory
Hydrostatic pressure test: 5,8 MPa – 10 s	Satisfactory
Welding procedures are prepared and approved acc.to: EN 15614-1	
Operators and Welders are certified acc.: EN ISO 14732 and EN ISO 9606-1	
Requirements: Weld factor: V=1,0	
Manufacturer of coils: U.S.Steel Košice; s.r.	

Non-destructive testing :	D02
100% weld test by UT acc. to EN ISO 10893-11:2011, class U3H or by RT acc. to EN ISO 10893-7:2019, class A	Satisfactory
Weld seam ends (100mm) test by RT acc. to EN ISO 10893-7:2019, class A	Satisfactory
100% coil end welds test by RT acc. to EN ISO 10893-7:2019, class B	Satisfactory
15mm zone adjacent to the coil end welds test by UT acc. to EN ISO 10893-8:2011, Annex A, class U2	Satisfactory
NDT Operators are certified acc. to EN ISO 9712	Satisfactory



**Test Results**

Chemical composition: %

Heat No.	Product Analysis	C71													
		C max	Mn max	Si max	P max	S max	Al min	Cu max	Ni max	Cr max	Ti max	V max	Nb max	Mo max	Cu+Ni+Cr+Mo max 0.70
32543	-	0.14	0.66	0.19	0.013	0.009	0.030	0.021	0.010	0.018	0.001	0.001	0.002	0.002	0.05
45181	-	0.13	0.64	0.20	0.013	0.006	0.035	0.022	0.020	0.024	0.001	0.001	0.002	0.003	0.07
54205	-	0.13	0.65	0.20	0.014	0.007	0.034	0.025	0.029	0.036	0.001	0.001	0.002	0.004	0.09

**Mechanical tests**

C00 - C50

Test No.	Dimensions			Tensile test						Impact test - pipe body *			Impact test - seam weld *		Impact test - HAZ *	
	(mm)		(°C)	(MPa)						(J)			(J)		(J)	
	C40	C41	C02	C03	C11	C12	C13	C14	C50	C42	C43	C51	C42	C43	C42	C43
	a0	b0	Specimen	Test temper.	Yield strength	Tensile strength	Elongation	Ratio	Bend test	Single values	Average value	DWTT	Single values	Average value	Single values	Average value
Requirements				REH	Rm	A5	REH/Rm		KV	Σ/ 2	KV		KV		KV	
EN 10217-5/19				min 265	410-570(2)	min 21		Ø 24.0	(10,0x8,0 mm)	%	(10,0x8,0 mm)		(10,0x8,0 mm)		(10,0x8,0 mm)	

**Results**

857	S	S	2		311	452	30									
857	S	S	3						Satisfactory							
861	S	S	2		321	449	30									
861	S	S	3						Satisfactory							
863	S	S	2		328	451	34									
863	S	S	3						Satisfactory							
860	S	S	2		298	431	29.5									
860	S	S	3						Satisfactory							

S-Size acc. to standard ;1-Pipe body-Longitudinal ;2-Pipe body:Transverse ;3-Seam weld-Transverse ;4-Heat-affected zone (HAZ) ;5-Coil end weld

\*If test element is less than 10,00 mm, is made by impact test values KV calculation. Values are recalculated in accordance with standard.

\*\*Unless, if not specified alternatively, test must be performed at ambient temperature (23°C +/- 5°C).

Z05

Manufacturer is certified according to EN ISO 9001, EN ISO 14001, EN ISO 50001 and approved according to AD 2000 - Merkblatt W0 and certified according to the Pressure Equipment Directive 2014/68/EU by TÜV-Thüringen e.V. ; NoBo reg.no. 0090

ZETOM/National Declaration Research and Certification Institute in Katowice sp.z o.o AC005,  
 National Certificate of Conformity:  
 No. 005-UWB-130  
 National Declaration of Performance Properties: USSK-02/2023

Z01

The Declaration of Performance (DoP), see here:<http://www.usske.sk/en/products/spiral-welded-pipes/declaration-of-conformity>

We hereby confirm that the above product has been manufactured and tested in accordance with the requirements of the contract.  
 Document valid also without signature.



U. S. Steel Košice, s.r.o. A01  
Vstupný areál U. S. Steel  
044 54 Košice  
Slovak Republic

A02-A03

Inspection certificate No.:  
EN 10 204:2004/3.1

3066 / 2024

Z04



09  
Zetom-Katowice  
AC 005

Z02

Location: Košice

Date: 25.06.2024

Martin Milota

Inspection representative