



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

1789 / 2024

A02-A03

A06 Purchaser :	A05 Producer :	U.S. Steel Košice, s.r.o , Rúrovňa	Z02 Date :	12.04.2024
	B01 Product :	SPIRALLY WELDED STEEL PIPES – SAWH		
	B01 According :	EN 10219-1/06; EN 10217-1/2019; EN 10217-5/2019		
	B03 Specification :	-		

A07 Purchaser's order No.:	K12/03/2024/	B02 Steel designation:	S235JRH / P235TR2 / P235GH TC1
A08 Manufacturer's work order number:	XR430362		
A10 Packing Sheet/ Item No.:	124R0071402	C70 Steelmaking process:	B O F
A09 Purchaser article number:	6T6XTB1402		

B06 Marking:	
Outside:	USS Kosice•EN 10219-1,2•S235JRH•SAWH EN 10217-1,5•P235TR2 P235GH TC1•Pipe No. •TK 1-23
Inside:	-

B08 No. of Pieces:	B12 Th. Mass:	B14 Total length:	B09 Dimensions, Pipe No.:
1	4286 kg	12.00 m	Ø 1219 x 12.0 mm ; 12.00 m ; - 0 + 50 mm

B10 Pipe No.:	B07 Heat No.:	C00 Test No.:
24-5267502-01-04	52675	85

D01

Visual inspection	Satisfactory
Dimensional inspection: EN 10219-2:2019; EN 10217-1/19; EN 10217-5/19	Satisfactory
Hydrostatic pressure test: 3,4 MPa – 10s	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.o	

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
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