



A02-A03

Inspection certificate No.: 2341/04-21/Si
EN 10 204:2004/ 3.1

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NIMFA – COM SRL
STR. RACARI Nr. 12A, BL.43, Sc.A
031827 BUCURESTI – SECTORUL 3
ROMANIA

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

Date:	07.04.2021
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B01	Product:	SPIRALLY WELDED STEEL PIPES – SAWH
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B01

According: EN 10217-5 /19

Specification : -

B02	C70
Steelmaking process:	BOF

A07 A09

Purchaser's order No.: 6T6C6AB1 / 02 – 104/17.12.20

A10

Packing Sheet / Item No.:

121/R00643

B08

Marking :

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

Inside : -

Item No	B08 No. of Pieces	B12 Th. mass	B14 Total length	B09- B11 Dimensions, Pipe No.		B07 Heat No.	C00 Test No.	
							C71	C00-C50
1	5	12 024 kg	60,18 m	Ø 820 x 10,00 mm; 12000,0 mm; +50 mm		44552	-	2025
				20-4455208-01	-56, -57			

D01

Visual inspection:	Satisfactory
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Dimensional inspection: EN 10217-5/19	Satisfactory
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Hydrostatic pressure test: 4.3 MPa – 10 s	Satisfactory
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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

Non-destructive testing:

D02

100% weld test by UT acc. to EN ISO 10 893-11:2011, class U3H or by RT acc. to EN ISO 10 893-7:2019, class A	Satisfactory
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100% coil end welds test by RT acc. to EN ISO 10 893-7:2019, class B	Satisfactory
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15mm zone adjacent to the coil end welds test by UT acc. to EN ISO 10 893-8:2011, Annex A, class U2	Satisfactory
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NDT Operators are certified acc. to EN ISO 9712