



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

2461 / 2024

A02-A03

A06 Purchaser : Corporation „ Energoresurs -Invest „ str. Zelena 131 79035 LVOV Ukraine	A05 Producer : U.S. Steel Košice, s.r.o , Rúrovňa	Z02 Date : 24.05.2024
B01 Product : SPIRALLY WELDED STEEL PIPES – SAWH		
B01 According : EN 10217-5/19		
B03 Specification : -		

A07 Purchaser's order No.:	130/04032024	B02 Steel designation:	P265GH TC1
A08 Manufacturer's work order number:	XR430326		
A10 Packing Sheet/ Item No.:	124R0101601	C70 Steelmaking process:	B O F
A09 Purchaser article number:	6T6C5C3401		
B06 Marking:	USS Kosice•SAWH•EN 10217-5•P265GH TC1•Pipe No.•TK 1-23		
Outside:			
Inside:			

B08 No. of Pieces:	B12 Th. Mass:	B14 Total length:	B09 Dimensions, Pipe No.:
16	19842 kg	192.66 m	Ø 530 x 8.0 mm ; 12.00 m ; - 0 + 50 mm

B10 Pipe No.:	B07 Heat No.:	C00 Test No.:
		C71 C00
24-1363610-01-50,-52,-54,-55,-57,-58	13636	660
24-1363706-01-06	13637	661
24-1363805-01-03,-04,-05,-06,-08,-09	13638	656,662
24-1363806-01-01,-02	13638	662
24-3254505-01-54	32545	657

Visual inspection	Satisfactory
Dimensional inspection: EN 10217-5/19	Satisfactory
Hydrostatic pressure test: 5,6 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.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



Test Results

Chemical composition: %

Heat No.	Product Analysis	C max 0.20	Mn max 1.40	Si max 0.40	P max 0.025	S max 0.020	Al min 0.020	Cu max 0.30	Ni max 0.30	Cr max 0.30	Ti max 0.03	V max 0.02	Nb max 0.01	Mo max 0.08	Cu+Ni+Cr+Mo max 0.70
13636	-	0.14	0.66	0.18	0.016	0.010	0.034	0.021	0.010	0.021	0.001	0.001	0.002	0.002	0.05
13637	-	0.14	0.64	0.20	0.017	0.010	0.031	0.028	0.012	0.023	0.001	0.001	0.002	0.002	0.06
13638	-	0.13	0.66	0.20	0.019	0.009	0.032	0.024	0.012	0.021	0.001	0.001	0.002	0.002	0.06
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

Mechanical tests

Test No.	Dimensions		C02 Specimen	C03 Test temper.	Tensile test				C50 Bend test	Impact test - pipe body *		C51 DWTT	Impact test - seam weld *		Impact test - HAZ *	
	(mm)				(MPa)					(J)			(J)		(J)	
	C40 a0	C41 b0			C11 Yield strength	C12 Tensile strength	C13 Elongation	C14 Ratio		C42 Single values	C43 Average value		C42 Single values	C43 Average value	C42 Single values	C43 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 Ø 24.0	(10,0x8,0 mm)	%	(10,0x8,0 mm)	(10,0x8,0 mm)

Results																
660	S	S	2		343	484	29									
660	S	S	3			492										
660	S	S	3						Satisfact ory							
661	S	S	2		331	474	28									
661	S	S	3			501										
661	S	S	3						Satisfact ory							
656	S	S	2		317	455	27									
656	S	S	3			463										
656	S	S	3						Satisfact ory							
662	S	S	2		303	466	30									
662	S	S	3			492										
662	S	S	3						Satisfact ory							
657	S	S	2		310	450	34.5									
657	S	S	3			456										
657	S	S	3						Satisfact ory							

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).



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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

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



Z02

Location: Košice

Date: 24.05.2024

Martin Milota

Inspection representative