







MARCEGAGLIA SPECIALTIES  
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Type Inspection Certificate 3.1 EN 10204  
 WELDING PROCESS QUALIFICATION: ALL THE LASER WELDING PROCESS ARE QUALIFIED ACCORDING EUROPEAN PRESSURE EQUIPMENT DIRECTIVE PED 97/23/EC BY THE NOTIFIED BODY N. 1233 EUROPED WITH WELDING PROCEDURE QUALIFICATION WPOR N° PM907A001 Registration no. 10M203 AND WPOR N° PM507A002 Registration no. 11M017. STILL VALID UNDER PED 2014/68/EU PER ARTICLE 48 CLAUSE 3.

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Number 10521770228  
 Issued On

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Customer  
 THYSENKRUPP MATERIALS POLAND  
 U.L. GRUDZIADZKA 159  
 87100 TORUN PL

Code: 0000035410

Consignee  
 THYSENKRUPP MATERIALS POLAND S.A.  
 U.L. TORUNSKA, 7  
 41303 DABROWA GóRNICZA PL

Delivery Nn  
 OF  
 Delivery note nr  
 1005012719

Quality Control  
 O.M. D.J.M. S. Toscano  
 Plant Of Forli

Order Nr  
 1191358847/20  
 Client Order  
 Z121001867

Material  
 TXT012

Description  
 TXT012 16x1,2x6000 TP304 HF SZ  
 Stainless steel grade: TP 304 1.4301 X5CrNi18-10

Welding process  
 HIGH FREQUENCY INDUCTION WELDING

Part Number

Item	Identification Nr	Heat	Quantity MTL	Quantity KG	Quantity PZZ
1	21K2010910	8800019	546	478	91
2	21K2010911	8800019	546	470	91

Identification Nr	Chemical Type	C (%)	Si (%)	Mn (%)	P (%)	S (%)	N (%)	Cr (%)	Ni (%)
21K2010910	RAW MATERIAL	0.07	1	2	0.045	0.015	0.11	17	8
21K2010911	RAW MATERIAL	0.022	0.370	1.620	0.300	0.010	0.570	18.080	8.020

Identification Nr	Type of mechanical test	Rp 0.2 [MPa]	Rp 1.0 [MPa]	Rm [MPa]	AS (%)
21K2010910	TUBE	283	313	622	50.7
21K2010911	TUBE	283	313	622	50.7

Identification Nr	Chemical Type	C (%)	Si (%)	Mn (%)	P (%)	S (%)	N (%)	Cr (%)	Ni (%)
21K2010910	RAW MATERIAL	0.07	1	2	0.045	0.015	0.11	17	8
21K2010911	RAW MATERIAL	0.022	0.370	1.620	0.300	0.010	0.570	18.080	8.020

Identification Nr	Type of mechanical test	Rp 0.2 [MPa]	Rp 1.0 [MPa]	Rm [MPa]	AS (%)
21K2010910	TUBE	283	313	622	50.7
21K2010911	TUBE	283	313	622	50.7

Delivery conditions  
 Remarks  
 BRUSHED

WE CERTIFY THAT THE ABOVE MENTIONED PRODUCTS COMPLY WITH THE TERMS OF ORDER CONTRACT AND THE STANDARDS RECALLED IN THE PRESENT TEST CERTIFICATE

NON DESTRUCTIVE TESTS  
 ANTIRAINING TEST ACCORDING TO EN 10204-2:2004 AND EN 10204-2:2006. CONFORM  
 VISUAL INSPECTION AND DIMENSIONAL CONTROL. CONFORM

DESTRUCTIVE TESTS  
 DRIFT EXPANDING TEST ACCORDING TO EN ISO 8430:2006. CONFORM  
 FLATTENING TEST ACCORDING TO EN ISO 6432:2004. CONFORM  
 TENSILE TEST ACCORDING TO EN ISO 6892:1:2009

MARCEGAGLIA SPECIALTIES FOR LAMPOROLI PLANT SYSTEM CERTIFICATIONS QUALITY SYSTEM CERTIFIED ACCORDING TO EN 9001:2015 AND DATE 16/04/2016 AND ISO 9001:2008 AND A SAFETY SYSTEM CERTIFIED ACCORDING TO OHSAS 18001:2007 AND AN ENVIRONMENTAL SYSTEM CERTIFIED ACCORDING TO ISO 14001:2015. MARCEGAGLIA SPECIALTIES FOR LAMPOROLI PRODUCT CERTIFICATIONS DWG ACCORDING TO GWSM LASER AND TG WELDED TUBES STAINLESS STEEL GRADE 1.4404 DIA FROM 15.00 TO 108.00MM AND GRADE 1.4521 FROM 15.00 TO 54.00MM. TUV A02000 W2W10 AND PED ANNEX I. PARACRASH 4.3 LASER AND TG WELDED TUBES STAINLESS STEEL GRADE 1.4301, 1.4306, 1.4307, 1.4401, 1.4404, 1.4541, 1.4571. DAIRY TUBES TXT003, TXT014, TXT015. EUROPEAN DIRECTIVE 94/92/EC FOR

MARCEGAGLIA SPECIALTIES FOR LAMPOROLI PLANT SYSTEM CERTIFICATIONS QUALITY SYSTEM CERTIFIED ACCORDING TO EN 9001:2015 AND DATE 16/04/2016 AND ISO 9001:2008 AND A SAFETY SYSTEM CERTIFIED ACCORDING TO OHSAS 18001:2007 AND AN ENVIRONMENTAL SYSTEM CERTIFIED ACCORDING TO ISO 14001:2015. MARCEGAGLIA SPECIALTIES FOR LAMPOROLI PRODUCT CERTIFICATIONS DWG ACCORDING TO GWSM LASER AND TG WELDED TUBES STAINLESS STEEL GRADE 1.4404 DIA FROM 15.00 TO 108.00MM AND GRADE 1.4521 FROM 15.00 TO 54.00MM. TUV A02000 W2W10 AND PED ANNEX I. PARACRASH 4.3 LASER AND TG WELDED TUBES STAINLESS STEEL GRADE 1.4301, 1.4306, 1.4307, 1.4401, 1.4404, 1.4541, 1.4571. DAIRY TUBES TXT003, TXT014, TXT015. EUROPEAN DIRECTIVE 94/92/EC FOR





MARCEGAGLIA SPECIALTIES

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Tel: +38 - 0423 470 111 Fax: +38 - 0423 470 105

Code: 0000023130

Type Inspection Certificate 3.1 EN 10204  
WELDING PROCESS QUALIFICATION: ALL THE LASER WELDING PROCESS ARE QUALIFIED ACCORDING EUROPEAN PRESSURE EQUIPMENT DIRECTIVE PED 97/23/EC BY THE NOTIFIED BODY N.1233 EUROPED WITH WELDING PROCEDURE QUALIFICATION WPOR N° PM0907A001 Registration no. 10M203 AND WPOR N° PM907A002 Registration no. 11M017. STILL VALID UNDER PED 2014/68/EU PER ARTICLE 48 CLAUSE 3.

Consignee  
Investa Sp. z o.o.  
Smolice 1g, Tulipan Park - Hal  
95010 Stryków PL

Delivery N° 8042239011  
Delivery note nr 1005000044  
Quality Control O.M.D./O.M. S.Toscana  
Plant Of Port

Number 10517001322  
Issued On  
Pages 7/17

Customer  
INVESTA SPOLKA Z.O.O.  
UL ZASTAWNA 27  
83000 PRUSZESZ GDANSKI PL

Material  
59004735  
Description  
TX1003 50,8x1,2x6000 TP304L LAS LZ

Stainless steel grade: TP 304L 1.4307/1.4301 X2CrNi18-9/X5CrNi18-10

Welding process  
LASER WELDING

Order N° 1161151991/60  
Part Number  
Client Order CZZ16/01644

Item	Identification Nr	Heat	Quantity MTL	Quantity KG	Quantity PZZ	Delivery conditions	Remarks
1	16W4001483	SE88250	324	575	54	WZp CD	BRUSHED

Identification Nr	C (%)	Si (%)	Mn (%)	P (%)	S (%)	N (%)	Cr (%)	Ni (%)
16W4001483	0.03	1	2	0.045	0.015	0.11	17.5	8
							19.5	10

Identification Nr	Rp 0.2 [MPa]	Rp 1.0 [MPa]	Rm [MPa]	A5 (%)
16W4001483	399	439	649	43.5

MARCEGAGLIA SPECIALTIES FOR LAMPOLI PLANT SYSTEM CERTIFICATIONS QUALITY SYSTEM CERTIFIED ACCORDING TO EN 9001:2008 AND ISO/TS 16949:2009 AND ISO 9001:2008 AND A SAFETY SYSTEM CERTIFIED ACCORDING TO CHASAS 18001:2007 AND AN ENVIRONMENTAL SYSTEM CERTIFIED ACCORDING TO ISO 14001:2004. MARCEGAGLIA SPECIALTIES FOR LAMPOLI PRODUCT CERTIFICATIONS DWG ACCORDING TO GMA41 LASER AND TIG WELDED TUBES STAINLESS STEEL GRADE 1.4404 DIA FROM 15.00 TO 108.00MM AND GRADE 1.4521 FROM 15.00 TO 54.00MM. TUV AD2000 WZ/W10 AND PED ANNEX I PARAGRAPH 4.3 LASER AND TIG WELDED TUBES STAINLESS STEEL GRADE 1.4301, 1.4306, 1.4307, 1.4401, 1.4404, 1.4541, 1.4571, 1.4435, 1.4439 THICKNESS FROM 0.80 TO 4.00MM AND DIAMETRS FROM 6.00 TO 283.00 MM. EHEDG FOR DAIRY TUBES TX1015, TIFQ - EUROPEAN DIRECTIVE 1935/2004 FOR DAIRY TUBES TX1003, TX1014, TX1015.

NON DESTRUCTIVE TESTS  
EDDY CURRENT TEST FOR THE VERIFICATION OF HYDRAULIC LEAKTIGHTNESS ACCORDING TO EN ISO 10893-1:2011: CONFORM  
EDDY CURRENT TEST FOR THE DETECTION OF IMPERFECTIONS ACCORDING TO EN ISO 10893-2:2011: CONFORM  
ANTIMIXING TEST: CONFORM  
VISUAL INSPECTION AND DIMENSIONAL CONTROLS: CONFORM  
ROUGHNESS Ra VALUES MEASURED FOR RAW MATERIAL MAX 0.9 um AND INTERNAL WELDING AREA MAX 1.0 um ACCORDING TO EN 10357: CONFORM

DESTRUCTIVE TESTS  
DRIFT EXPANDING TEST ACCORDING TO EN ISO 8493:2006: CONFORM  
FLATTENING TEST ACCORDING TO EN ISO 8492:2004: CONFORM  
RING EXPANDING TEST ACCORDING TO EN ISO 8495:2004: CONFORM  
TENSILE TEST ACCORDING TO EN ISO 6892-1:2009  
INTERGRANULAR CORROSION TEST ACCORDING TO EN ISO 3651-2:1998: CONFORM

Remarks:  
CHEMICAL COMPOSITION ACCORDING TO EN 10028-7 TUBE TO EN 10217-3 TCI1 DN11892 AND DIRECTIVE 2014/68/EU (PED)  
WELDING FACTOR V=1

