



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

A01

A02-A03

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

729 / 2023

A06 Purchaser :

NIMFA-COM SRL

**STR.RACARI Nr.12A,BL.43,Sc.A
031827 BUCURESTI - SECTORUL 3
Romania**

A05 Producer :

U.S. Steel Košice, s.r.o , Rúrovňa

Z02 Date :

16.02.2023

B01 Product :

SPIRALLY WELDED STEEL PIPES – SAWH

B01 According :

EN 10217-5/19

B03 Specification :

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A07 Purchaser's order No.:

10.11.2022

A08 Manufacturer's work order number:

XR310008

B02 Steel designation:

P235GH TC1

A10 Packing Sheet/ Item No.:

123R0025203

C70 Steelmaking process:

B O F

A09 Purchaser article number:

6T6C6B0203

B06 Marking:

Outside:

USS Kosice•SAWH•EN 10217-5•P235GH TC1•Pipe No.•TK 1-23

Inside:

-

B08 No. of Pieces:

9

B12 Th. Mass:

8503 kg

B14 Total length:

108.34 m

B09 Dimensions, Pipe No.:

Ø 406.4 x 8.0 mm ; 12.00 m ; - 0 + 50 mm

B10

Pipe No.:

23-4781804-01-55,-56,-57,-58,-59,-60,-61

B07

Heat No.:

47818

23-4781805-01-50,-51

47818

C00

Test No.:

C71

C00

184

184

D01

Visual inspection

Satisfactory

Dimensional inspection: EN 10217-5/19

Satisfactory

Hydrostatic pressure test: 6,5 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 0.16	Mn max 1.20	Si max 0.35	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
47818	-	0.13	0.63	0.19	0.015	0.010	0.031	0.023	0.009	0.016	0.001	0.001	0.002	0.002	0.05

C71

Mechanical tests

C00 - C50

Test No.	Dimensions		C02	C03	Tensile test				C50	Impact test - pipe body *		C51	Impact test - seam weld *		Impact test - HAZ *	
	a0	b0			Yield strength	Tensile strength	Elongation	Ratio		Single values	Average value		Single values	Average value	Single values	Average value
Requirements					REH (Rp02)	Rm	A5	Rp02/Rm		KV		Σ / 2	KV		KV	
EN 10217-5/19					min 235	360-500(2)	min 23	%	mm	(10,0x8,0 mm)		%	(10,0x8,0 mm)		(10,0x8,0 mm)	

Results																
184	S	S	2		332	480	29									
184	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

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

Z02

Location: Košice

Date: 16.02.2023

Martin Milota
Inspection representative