



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

A01

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

A02-A03

67 / 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 :

10.01.2023

B01 Product :

SPIRALLY WELDED STEEL PIPES – SAWH

B01 According :

EN 10217-5/19

B03 Specification :

-

A07 Purchaser's order No.:

10.11.2022

A08 Manufacturer's work order number:

XR2C0037

B02 Steel designation:

P235GH TC1

A10 Packing Sheet/ Item No.:

123R0001501

C70 Steelmaking process:

B O F

A09 Purchaser article number:

6T6C6B0201

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:

21407 kg

B14

Total length:

108.16 m

B09

Dimensions, Pipe No.:

Ø 813 x 10.0 mm ; 12.00 m ; - 0 + 50 mm

B10

Pipe No.:

22-5645806-01-01,-02,-03,-04,-05,-06,-07

B07

Heat No.:

56458

C00

Test No.:

C71

C00

1753

22-5645808-01-01,-02

56458

1753

D01

Visual inspection

Satisfactory

Dimensional inspection: EN 10217-5/19

Satisfactory

Hydrostatic pressure test: 4,0 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



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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
56458	-	0.13	0.63	0.18	0.014	0.012	0.037	0.043	0.014	0.028	0.001	0.001	0.002	0.002	0.09

C71

Mechanical tests

C00 - C50

Test No.	Dimensions			** (°C)	Tensile test					Impact test - pipe body *	Impact test - seam weld *		Impact test - HAZ *			
	(mm)				(MPa)						(J)		(J)			
	C40	C41	C02		C11	C12	C13	C14	C50		C42	C43	C42	C43	C42	C43
	a0	b0	Specimen	Test temper.	Yield strength	Tensile strength	Elongation	Ratio	Bend test	Single values	Average value	Single values	Average value	Single values	Average value	
Requirements						REH (Rp02)	Rm	A5	Rp02/ Rm		KV		KV		KV	
EN 10217-5/19						min 235	360- 500(2) min 360 (3)	min 23		mm Ø 30.0	(10,0x8,0 mm)		(10,0x8,0 mm)		(10,0x8,0 mm)	

Results

1753	S	S	2		302	451	31.5									
1753	S	S	3			461										
1753	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



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Location: Košice

Date: 10.01.2023

Martin Milota

Inspection representative