



A06 Purchaser :

„ V Z O R „

A05 Producer :
 U.S. Steel Košice, s.r.o , Rúrovňa

Z02 Date :
 01.03.2024

B01 Product : SPIRALLY WELDED STEEL PIPES – SAWH

B01 According : EN 10217-5/19

B03 Specification : -

A07 Purchaser's order No.: XX

B02 Steel designation:
 P265GH TC1

A08 Manufacturer's work order number: XX

A10 Packing Sheet/ Item No.: XX

C70 Steelmaking process:
 B O F

A09 Purchaser article number: XX

B06 Marking:
 Outside: USS Kosice•SAWH•EN 10217-5•P265GH TC1•Pipe No. TK 1-23
 Inside: -

B08 No. of Pieces:	B12 Th. Mass:	B14 Total length:	B09 Dimensions, Pipe No.:
	kg	m	Ø 508 x 8.0 mm ; 12.00 m ; - 0 + 50 mm

B10 Pipe No.:	B07 Heat No.:	C00 Test No.:	
		C71	C00

Visual inspection	Satisfactory	D01
Dimensional inspection: EN 10217-5/19	Satisfactory	
Hydrostatic pressure test: X,x 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

C71

Mechanical tests

C00 - C50

Test No.	Dimensions			Test temper. (°C)	Tensile test					Bend test	Impact test - pipe body *			Impact test - seam weld *		Impact test - HAZ *	
	C40	C41	C02		C11	C12	C13	C14	C50		C42	C43	C51	C42	C43	C42	C43
	a0	b0	Specimen		Yield	Tensile	Elongation	Ratio		Single values	Average	DWTT	Single values	Average	Single values	Average	

Requirements																	
				REH	Rm	A5	REH/Rm		KV			Σ/ 2	KV		KV		
				min 265	410-570(2)	min 21	%	%	mm	(10,0x8,0 mm)			%	(10,0x8,0 mm)		(10,0x8,0 mm)	
EN 10217-5/19									Ø 24.0								

Results																
	S	S	2													
	S	S	3													

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



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

xxx / 2024

A02-A03

Z02

Location: Košice

Date: 01.03.2024

Martin Milota

Inspection representative