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Reg. No.
12 100 3054

Abnahmeprüfzeugnis Inspection Certificate EN 10204 - 3.1

Artikelbezeichnung [designation]
elbows
LR-45-S-WPB-4"-XXS

Kunde [customer]
Industrial Valco

3135 E. Ana Street
USA-90221 Rancho Dominguez, CA

Zeugnis Nr. [cert. no.]
047958/14-PD
Rev.
Datum [date]
07/11/2014
Code-Nr. [code no.]
VVJ11
Ident Nr. [ident no.]
Unsere Auftrags.Nr./Art.Nr. [our order no./item no.]
167220UN-0050 / 003401
Ihre Bestell Nr. [your order no.]
EF104HA
Menge [quantity]
15

Anforderungen der Bestellung [requirements of the order]
ASME B16.9-2012 LR, material:WPB, TR-fitting:ASTM A 234/A 234M-13, ASME SA-234/SA-234M-13, TR-addit fitting:NACE MR0175/ISO15156-2:2009A.2, NACE MR0103-2012 2.1 and 4, certificate:EN 10204/3.1, rust protection:Millstandard, execution:Seamless

Vormaterial
[base material]

seamless pipe

Analyse [analysis]	Schmelze Nr. [heat code]	Erschmelzungsart [melting process]	1 = Schmelzanalyse [heat analysis]										J-Faktor [J-Factor]: (Si + Mn) * (P + Sn) * 10000 CEQ [CEQ]: C + (Mn / 6) + (Cr + Mo + V) / 5 + (Cu + Ni) / 15								
Index		C	Si	Mn	P	S	Cr	Mo	Ni	Cu	V	Nb	Al	B	Ti	N	Ceq				
1	344735	0.11	0.19	1.27	0.016	0.005	0.05	0.01	0.03	0.07	0.01	0.008	0.022	0.0004	0.014	0.003	0.34				

Mech.-technologische Prüfung [mech. technological test]

Proben Nr. [test no.]	Zugversuch [tensile test]						Kerbschlagbiegeversuch [notched bar impact test]				Härteprüfung [hardness test]	
	Pr.-Lage [pos. of sampel]	Temp.	Dehng. [yield str.] Rp 0.2	Zugfestigkeit [tensile str.] Rm (MPa)	Dehnung [elongation] 4D (%)		PR-Lage [pos. of sampel]	Temp.	Querschnitt [cross sec.] (mm²)	Kerbschlagarbeit [impact values] (J)		
75T_901	L	+22 °C	333	459	34						130-139	
											Wärmebehandlung [heat treatment]	
											formed under normalizing cond. temperature 840 °C - 890 °C Cooling in still air	

Kennzeichnung [marking] e OS AUSTRIA / WPB / VVJ11 / 4" / XXS

Zusatzmarkierung [add. mark.]

Besichtigung und Ausmessung [visual inspection and dimensional check] o.B./o.K.

Die gelieferten Produkte erfüllen die in der Bestellung festgelegten Anforderungen.
[The products supplied are in compliance with the requirements of the order].
The products were manufactured, sampled, tested and inspected in accordance with the specifications and were found to meet the requirements.

Bemerkungen [remarks]
hot formed over mandrel

Abnahmebeauftragter [inspection representative]
07/11/14 Pape Dijana - 323

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