

Lal Baba Seamless Tubes Pvt. Ltd.

[AN IATF16949:2016, ISO 9001:2015,
ISO 14001:2015, ISO 45001:2018 Certified Company]

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CIN No. U27310WB2006PTC110060



DOC. No: LBST/QAR/15 Rev.05 Dt: 06.01.2021

MILL TEST CERTIFICATE

CERTIFICATE ACCORDING TO EN 10204 :3.1

PURCHASER NAME :				TEST CERTIFICATE No.:	1261/2022
PURCHASER ORDER No. :		322866HOU	Date :	14-06-2022	TEST CERTIFICATE Date :
WORK ORDER No. :		EXP/22-23/15	Date :	02-07-2022	INVOICE NO:
NAME OF STEEL SUPPLIER :		RASHTRIYA ISPAT NIGAM LIMITED, VISAKHAPATNAM, A.P, IND		INVOICE Date :	
STEEL MAKING METHOD :		BOF-LF/IRUT-CCM-ROUND METHOD, Fully Killed			
PROCESS OF PIPE MANUFACTURE :		CDS / CS / PIPES			
MANUFACTURE PROCESS ROUTE :		PM-HI-STP-CD-HT-Finishing-NDT-P&F-Dispatch.	CUSTOMER UID NO	PO. SL. NO. 8	
SPECIFICATION & GRADE :		ASTM A53 GR.B(Ed.2012)//ASME SA53 GR.B(Ed.2019)//ASTM A106 GR.B(Ed.2015)//ASME SA106 GR.B(Ed.2019)/NACE MR0103(EDT- 2015) / NACE MR0175(EDT- 2015) / ISO15156			

Sr. No.	LBST HEAT NO	SUPPLIER HEAT NO	SIZE				Quantity			General	
			OD (INCH)	ID (INCH)	WT (INCH)	Length (FEET)	Nos.	FEET.	MT.	End Condition Square with Chamfer	Coating
1	18R187	22D02181	1.9" x 0.145" x 21 Feet Long.				1491	31311.98	-	-	Black Paint

Sr. No.	HEAT NO	CHEMICAL COMPOSITION (%)											
		REQUIRED	%C	%MN	%SI	%S	%P	%Cr	%Ni	%Cu	%Mo	%V	%C.E
1	22D02181	Min	-	0.40	0.10	-	-	-	-	-	-	-	-
		Max	0.30	1.35	-	0.025	0.025	0.30	0.40	0.40	0.12	0.08	-
	18R187	L/A	0.18	0.61	0.16	0.003	0.021	0.012	0.000	0.000	0.000	0.000	0.283
		P1/A	0.18	0.61	0.16	0.003	0.021	0.012	0.005	0.003	0.002	0.001	0.284
		P2/A	0.18	0.61	0.16	0.003	0.021	0.012	0.004	0.004	0.002	0.002	0.284

Sr. No.	HEAT NO	REQUIRED	MECHANICAL PROPERTIES			HARDNESS	IMPACT TEST	BEND TEST	FLARING TEST	GRAIN SIZE
			YIELD STRENGTH (PSI)	TENSILE STRENGTH (PSI)	ELONGATION (%)					
			G.L = 50 mm, Tube tested on full section							
		Min	35000	60000	30	-	-	-	-	-
		Max	-	-	-	99	-	-	-	-
1	18R187		46962	72248	35.84	73 - 74	NA	OK	NA	7.0

Sr. No.	HEAT NO	STRAIGHTNESS	NON-DESTRUCTIVE TEST			SURFACE QUALITY			
			HYDRO-STATIC TEST as Per ASTM A530 (100%)	E.C.T. as Per ASTM E-309 (100%)	U.T. AS PER ASTM E-213 (100%)	VDI	IN SIDE / OUT SIDE	RA VALUE	PMI
1	18R187	Satisfactory	2500 PSI ,OK	OK	NA	Satisfactory	Satisfactory	NA	Satisfactory

Heat Treatment : Heat Treated Above 650°C (1200°F)

MARKING: LBST / CDS / ASTM A106B ASME SA106B ASTM A53B ASME SA53B NACE MR 0175/NACE MR0103 ISO 15156 / OD 1.9",STD/SCH 40 X WT 0.145" X LG 21 FEET / HEAT NO. 18R187 / NDE / HYD 2500 PSI / PO NO. 322866HOU / MADE IN INDIA

REMARKS: 1. All materials are Lead (Pb) & Mercury (Hg) Free.
2. Country of manufacturer- India & country of melt source - India.
3. We hereby certify that the material herein described has been Manufactured, Sample tested & Inspected in accordance with above standard, specification & P.O requirement & result found satisfactory.

Legends : 1. L/A - Ladle Analysis, P1/A - Product Analysis One, P2/A - Product Analysis Two, 2. CDS= Cold Drawn Seamless ,3. CS = Carbon Steel 4. PM - Piercing Mill, 5. HI - Hollow Inspection, 6. STP - Surface Treatment Plant, 6. HT - Heat Treatment, 7. NDT - Non Destructive Testing, 8. P&F - Packing & Forwarding, 9. VDI= Visual Dimension Inspection.

For, LAL BABA SEAMLESS TUBES PVT. LTD.

ISSUED BY: Atanu Pachhal ENGINEER (QA/QC)	 COMPANY SEAL	 Rakesh Kr. Sahoo Asst. Manager (QA/QC)
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